

REQUEST FOR QUOTATION	<b>TROY SCHOOL DISTRICT</b> <b>1140 RANKIN, TROY, MICHIGAN 48083</b> <b>248-823-4027</b> <b>FAX: 248-823-4077</b>	REQUISITION
No. <b>9722</b>		
DUE DATE <b>NO LATER THAN</b> <b>01/27/12</b> 3 p.m.		DATE <b>01/06/12</b>

**REQUEST FOR QUOTE – NOT AN ORDER**

THIS FORM MUST BE UTILIZED WHEN RESPONDING TO THIS REQUEST  
 BID ENVELOPE ENCLOSED

**THE RFQ NUMBER MUST APPEAR ON ALL QUOTATIONS AND RELATED CORRESPONDENCE, THIS IS NOT AN ORDER**

Quantity	DESCRIPTION	UNIT PRICE	AMOUNT
	<p>Please supply us with your bid to furnish the Troy School District with <b>BAND UNIFORMS – TROY HIGH SCHOOL.</b></p> <p style="text-align: center;"> <b>Copies of the bid are available at:</b>  <a href="http://www.troy.k12.mi.us/purchasing/items_out_for_bid.htm">www.troy.k12.mi.us/purchasing/items_out_for_bid.htm</a> </p> <p style="text-align: center;"> <b>Bid recaps will be available at:</b>  <a href="http://troy.k12.mi.us/purchasing/index.htm">troy.k12.mi.us/purchasing/index.htm</a> </p> <p style="text-align: center;"><b><u>FACSIMILE BID IS NOT ACCEPTABLE</u></b></p> <p>Bids will not be accepted if submitted after the deadline specified (local time) in the advertisement to bid or in the information to bidders. The late submission of a bid makes the bid nonrepsonsive and is a material defect which shall not be waived by the Board of Education. Delays in the mail will not be considered. All Late bids in the mail will be returned to the bidder unopened.</p> <p>Proposal for the submission of alternatives by vendors will be accepted and reviewed. However, if any substitution or departure is not clearly noted and described, it will be understood that the bid intends to exactly meet the specifications.</p> <p>The Board of Education shall be the sole judge as to whether the proposed goods are "equal" or "approved". Quotations must be mailed or delivered to the Purchasing Office, 1140 Rankin, Troy, MI 48083 no later than 3 p.m. on the date shown above. Michigan State Sales and Use Taxes and Federal Excise Taxes do not apply unless otherwise indicated. Exemption certificates will be furnished when necessary. This request imposes no obligations on the buyer. The Board of Education reserves the right to accept or reject any or all bids or to split awards by items or to accept bids, which will best serve the Board of Education.</p>		

**THIS AREA MUST BE FILLED IN**

DELIVERY TIME	PRICES FIRM FOR	NAME OF COMPANY	TELEPHONE NO.
TERMS		NO. & STREET	FAX #
FOB DELIVERED	ALL DELIVERY CHARGES MUST BE INCLUDED IN PRICES SHOWN	CITY, STATE & ZIP CODE	E-MAIL
CONTACT PERSON (PLEASE PRINT)		SIGNATURE	DATE



**TROY SCHOOL DISTRICT  
BID 9722 BAND UNIFORMS  
TROY HIGH SCHOOL**

**1. BID INVITATION AND GENERAL CONDITIONS**

- A. Sealed bid responses for furnishing the items and quantities listed in the attached specifications are hereby being requested from your company. You are asked to return the bid form page(s) with your response.
- B. All bids or proposals are sealed and delivered to:  
Sara Konieczka  
Purchasing Supervisor  
Troy School District  
1140 Rankin  
Troy MI 48083

on or before January 27, 2012, and will be opened and read in an open session as said place, hour and date. The envelope containing the bid should be marked on the outside "SEALED BID – BAND UNIFORMS". All bids received after the hour and/or date established above will be returned to the sender unopened.

**2. DEVIATIONS FROM SPECIFICATIONS**

- A. Any deviation from these specifications must be documented on the enclosed deviation form. It is the intent of the school for the uniform to be manufactured strictly adhering to these construction and design specifications and deviations are not expected. If deviations are not documented fully, the bidder may be disqualified.
- B. It is the intention of the buyer to offer equal opportunity to all bidders. The use of company names when referring to styles are for descriptive purposes only and are not intended to be restrictive. Materials and items referred to in these specifications are available to all firms.

**3. BUYER'S RIGHTS**

The buyer reserves the right to award the contract to the Bidder offering the best value, and not necessarily to the firm bidding the lowest price. The reputation of the manufacturer and representative, over-all appearance, style and fit of the uniform, quality of trims and accessories, plus special features a particular manufacturer may have that make the uniform more practical or serviceable will be major factors in awarding the contract. Right is reserved by the Buyer to accept or reject any or all proposals, and waive informalities.

**4. SAMPLE REQUIREMENTS**

- A. No sample is required at this time.
- B. All bidders must submit liberal sized swatches of the materials to be used in the final product in the color and mill-weight listed in the Uniform Specifications.

**5. AREA REPRESENTATIVE**

Bidder must agree to provide a factory-trained representative to handle all details of the order. Said representative will be responsible for designing, measuring and servicing the order throughout the initial purchase and on a continuing basis. Bidders must list name, address and telephone number of the representative in their response.

**6. CUSTOMER INSTRUCTION MANUAL**

The successful bidder will supply a booklet containing a printout showing each uniform in sequence from smallest size to largest. The printout will indicate wearer identification number, original wearer and key measurements of uniform, i.e. height, weight, hat, chest, waist and outseam. The successful bidder will also supply recommended dry cleaning instructions for the uniforms and all accessory items; specifying precise details on care and cleaning that are to be utilized in future upkeep and maintenance of the items in this bid.

**7. SHIPPING**

Each uniform is to be thoroughly inspected before shipment. Imperfections shall be corrected before the uniforms are shipped. Uniforms are to be shipped complete with hangers (plastic) in containers. Each wardrobe container shall be marked on exterior to indicate the wearer number of each uniform enclosed. The uniforms will be ready to wear without cleaning or pressing. In the case of damaged shipment, it shall be the responsibility of the receiver to make an appropriate written notice when signing the carrier documents. The receiver shall inventory the damage and advise the uniform manufacturer in detail. Accessories such as sashes, drops, etc., as well as trousers, will be bulk packed unless otherwise specified.

**8. FABRIC SPECIFICATIONS**

Dacron/Wool blend fabrics must be cold water and alcohol sponged, decated and inspected. The Certification of Proof of Sponging provided with this proposal should be completed and returned with your bid. Since this process is critical in the avoidance of excessive shrinkage, failure to submit this certification in writing will be cause for disqualification of the bidder.

Examine all specifications carefully. It is the intent of the buyer to audit each sample for strict compliance to the specifications. These specifications encompass methods and materials yielding only the highest quality garment, through specifying only the highest quality materials, components, accouterments and designate only time-proven tailoring of the highest standard. Make note that some methods and materials have been judged inferior and unacceptable and are so noted herein. These standards are so stated to insure a garment having a functional lifetime retention period of at least 8 to 10 years, with normal care and maintenance being exercised.

- A. **WOOLEN MATERIALS:** Mill and Mill-Weight, are listed in the Uniform Specifications with required shades. When specified, this refers to Premium Quality 100% all wool fine wale whipcord:
1. Having been specially treated with the exclusive double dyeing process using CHROME BOTTOM DYES, applied in the most effective manner known, insuring color consistency in lot after lot.

2. London cold-water sponged and live steam shrunk, meeting United States Standard Shrinkage Specifications of not more than 1%.
  3. Treated with water-repellent finish by the immersion method, thus imparting water repellency by yielding to not less than a 100-spray rating, and insuring additional resistance to wear by abrasion. Spraying treatment not acceptable.
  4. Treated with nationally known and recognized process insuring COMPLETE GUARANTEE against moth or silverfish damage. This process must be applied by the immersion method and no spray-on treatments will be acceptable.
- B. **DACRON-WOOL MATERIALS:** Mill, Mill-Weight and specific shades are found in the Uniform Specifications. This material, when specified, refers to material containing 55% Dacron Polyester and 45% Wool. As with all woolen materials, this will be first quality with no flaws or imperfections allowed. This material must be finished with S.E.T. or Zepel scientifically engineered Crease Retention and Stain Resistant treatments, thus protecting the material against both oil and water-based stains, as well as assuring the best possible crease retention. The material is to be permanently moth-proofed and guaranteed in the same manner as the all-wool material above. Water repellency to be insured by proper treatment.
- C. **POLYESTER MATERIALS:** Mill, Mill-Weight and specific shades are found in the Uniform Specifications and as with all-wool and Dacron wool materials, will be first quality with no flaws or imperfections. The material is, by its nature, a water and stain repellent fabric, thus eliminating the need for a special treatment. Because there is no wool content, moth-proofing this fabric is not necessary.

**IMPORTANT:** ALL BIDDERS are to submit, along with their bids, a certificate stating that the fabrics used in the manufacture of the uniforms will be exact materials called for in the specifications and will be FIRST QUALITY. This certificate must be signed by an official of the Company. BIDDERS NOT FURNISHING THIS CERTIFICATE WILL BE DISQUALIFIED. NO FABRIC DEVIATIONS ACCEPTABLE.



## NON-COLLUSIVE BIDDING CERTIFICATION

By submission of this bid or proposal, the bidder certifies that:

- A. This bid or proposal has been independently arrived at without collusion with any other bidder or with any competitor;
- B. This bid or proposal has not been knowingly disclosed and will not be knowingly disclosed, prior to the opening of the bids, or proposals for this project, to any other bidder, competitor or potential competitor;
- C. No attempt has been or will be made to induce any other person, partnership or corporation to submit or not to submit a bid or proposal;
- D. The person signing this bid or proposal certifies that he has full informed himself regarding the accuracy of the statements contained in this certification, and under the penalties being applicable to the bidder as well as to the person signing in its behalf.

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COMPANY SUBMITTING BID

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AUTHORIZED SIGNATURE

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TITLE

**TROY SCHOOL DISTRICT  
BID 9722 BAND UNIFORMS  
TROY HIGH SCHOOL**

**Styling Specifications**

**BANDSMAN COAT**

**Fabric:** 14-14.5 oz. Dacron/Wool, Lot 7744

**Style:** Hard collar waistcoat cut 2" shorter in length than standard. Front and rear to be cut straight at bottom.

**Rear Closure:** Center back concealed brass zipper to zip down. Concealed zipper flap to close with 3 snaps.

**Pockets:** None

**Special Details:** One 24L, nickel smooth long shank button under each shoulder strap, attached with ring and disk. An additional 24L nickel smooth long shank button attached with ring and disk will be placed under the wearer's right shoulder strap and Gray Velcro loop will be placed at the lower left coat bottom.

**Front Trim:** Front of coat is 7744-6605 Gray. Five rows of evenly spaced  $\frac{3}{4}$ " stripes of 960-91 White that graduate in length, longest to shortest, from top to bottom. Three 36L regular shank chrome dome buttons, attached with rings and disks, set on each row, one at center and one at each end.

**Back & Tail Trim:** Back of coat is 7744-6605 Gray.

**Collar:** Collar is 960-91 White. Collar lining and liner are Xtreme Dri Raven Black. The top of the collar is bound with 7744-Black binding, leaving  $\frac{1}{2}$ " of black showing.

**Shoulder Straps:** Straps are 960-91 White. Set flush to edge all around,  $\frac{1}{2}$ " stripe of 7744-Black. Button is 24L long shank chrome dome, attached with ring and disk.

**Upper Sleeves:** Sleeves are 7744-6605 Gray. Set straight on both sleeve heads, 1" plain block "TROY" of white direct Swiss embroidery.

**Cuffs:** No trim.

**BANDSMAN SHOULDER DRAPE**

Reversible pleated drape, side one 7744-Black, side two Silver Metallic Glamour. Drape to attach with a 5" button tab of 7744-Black with two buttonholes.



**BANDSMAN COAT FRONT SLASH with MIRROR**

The front slash is 3 ½” wide of 960-91 White. It is self lined and fused with heavy fusing for stability. Slash to attach to coat with two buttonholes at top and white Velcro hook at bottom. Bind top and bottom edge with 7744-Black binding, leaving approximately 2 ½” of white to show. Silver rectangular mirror, approximately 2 ½” wide by 3 ½” long, to attach to front slash thru metal grommets/eyelets with a two-pin attachment. Mirror should be centered on slash and placed diagonally to assimilate a buckle.

**BANDSMAN GAUNTLET CUFFS:**

Seven inch cuffs are white grained vinyl with lining of 1933 White backed with heavy fusing. Set flush to top on both, a 1” stripe of Black grained vinyl. Set vertically below Black stripe on the upper portion of each opening edge are three 36L chrome dome regular shank buttons attached with rings and disks. Closure edges to be turned back ½” with 1” wide White Velcro sewn on top to edge of closure. Closure edges must be turned back the same amount so that sizes will be accurate. A 3” wide piece of 1933-White will be stitched all along the inside edge of the Velcro Loop and Hook to prevent Velcro from coming in contact with sleeve.

**BANDSMAN JUMPSUIT**

Jumpsuit is 7744-Black and the cuffs will be hemmed. The front will close with a full length zipper and two pockets will be incorporated as part of the inside fly. There will be no waist darts, front or back. The shoulder straps of jumpsuit fabric will be 1 ¼” wide with nylon slides. The center back of the jumpsuit will allow for a 3” let out. Each leg will have a 1” stripe of 960-91 White.

**BANDSMAN SHAKO**

<b>Style:</b>	Flat top military shako
<b>Plume holder:</b>	Center front
<b>Top:</b>	Black grained vinyl
<b>Sides:</b>	7744-6605 Gray
<b>Bands:</b>	Both Black grained vinyl
<b>Front chain:</b>	Silver with chain hooks
<b>Visor:</b>	Black
<b>Chinstrap:</b>	Black with silver buckle
<b>Buttons:</b>	45L nickel dome
<b>Ornament:</b>	S-100 nickel eagle

## **PLUME**

14" White French fountain

## **ACCESSORIES**

**Shako Box:** Black Shako-Mate style per the attached construction specifications.

**Garment Bag:** 44" Black 200 Denier nylon with center zipper, identification window and shoe pouch.

**Parka:** Parka to be manufactured of 200 denier black nylon and will include a single, one color imprint. Nylon will be coated on inside with ¾ oz. polyurethane. Lining will be 5 oz. quilt. Double needle construction throughout. Each parka will have two large lower patch pockets with flaps. The parka will close with five black machine snaps.

## **PERCUSSION COAT**

**Fabric:** 14-14.5 oz. Dacron/Wool, Lot 7744

**Style:** Hard collar waistcoat cut 2" shorter in length than standard. Front and rear to be cut straight at bottom.

**Rear Closure:** Center back concealed brass zipper to zip down. Concealed zipper flap to close with 3 snaps.

**Pockets:** None

**Special Details:** One 24L, nickel smooth long shank button under each shoulder strap, attached with ring and disk. An additional 24L nickel smooth long shank button attached with ring and disk will be placed under the wearer's right shoulder strap and Black Velcro loop will be placed at the lower left coat bottom.

**Front Trim:** Front of coat is 7744-Black. Five rows of evenly spaced ¾" stripes of 7744-Black that graduate in length, longest to shortest, from top to bottom. Three 36L regular shank chrome dome buttons, attached with rings and disks, set on each row, one at center and one at each end.

**Back & Tail Trim:** Back of coat is 7744-Black.

**Collar:** Collar is 7744-Black. Collar lining and liner are Xtreme Dri Raven Black. The top of the collar is bound with 7744-Black binding, leaving ½" of black showing.

**Shoulder Straps:** Straps are 7744-Black. Set flush to edge all around, ½" stripe of 7744-Black. Button is 24L long shank chrome dome, attached with ring and disk.

**Upper Sleeves:** Sleeves are 7744-Black. Set straight on both sleeve heads, 1" plain block "TROY" of white direct Swiss embroidery.

**Cuffs:** No trim

**PERCUSSION SHOULDER DRAPE**

Reversible pleated drape, side one 7744-Black, side two Silver Metallic Glamour. Drape to attach with a 5" button tab of 7744-Black with two buttonholes.

**PERCUSSION COAT FRONT SLASH with MIRROR**

The front slash is 3 1/2" wide of 7744-Black. It is self lined and fused with heavy fusing for stability. Slash to attach to coat with two buttonholes at top and white Velcro hook at bottom. Bind top and bottom edge with 7744-Black binding, leaving approximately 2 1/2" of white to show. Silver rectangular mirror, approximately 2 1/2" wide by 3 1/2" long, to attach to front slash thru metal grommets/eyelets with a two-pin attachment. Mirror should be centered on slash and placed diagonally to assimilate a buckle.

**PERCUSSION JUMPSUIT**

Jumpsuit is 7744-Black and the cuffs will be hemmed. The front will close with a full length zipper and two pockets will be incorporated as part of the inside fly. There will be no waist darts, front or back. The shoulder straps of jumpsuit fabric will be 1 1/4" wide with nylon slides. The center back of the jumpsuit will allow for a 3" let out. Each leg will have a 1" stripe of 7744-Black.

**PERCUSSION SHAKO**

<b>Style:</b>	Flat top military shako
<b>Plume holder:</b>	Center front
<b>Top:</b>	Black grained vinyl
<b>Sides:</b>	7744-Black
<b>Bands:</b>	Both Black grained vinyl
<b>Front chain:</b>	Silver with chain hooks
<b>Visor:</b>	Black
<b>Chinstrap:</b>	Clear chinstrap w/silver buckle plus silver chin chain
<b>Buttons:</b>	45L nickel dome
<b>Ornament:</b>	S-100 nickel eagle

## **PERCUSSION PLUME**

14" Black French Fountain

## **DRUM MAJOR COAT**

**Fabric:** 14-14.5 oz. Dacron/Wool, Lot 7744

**Style:** Hard collar waistcoat cut 2" shorter in length than standard. Front and rear to be cut straight at bottom.

**Rear Closure:** Center back concealed brass zipper to zip down. Concealed zipper flap to close with 3 snaps.

**Pockets:** None

**Special Details:** One 24L, nickel smooth long shank button under each shoulder strap, attached with ring and disk. An additional 24L nickel smooth long shank button attached with ring and disk will be placed under the wearer's right shoulder strap and Black Velcro loop will be placed at the lower left coat bottom.

**Front Trim:** Front of coat is 7744-Black. Five rows of evenly spaced  $\frac{3}{4}$ " stripes of 960-91 White that graduate in length, longest to shortest, from top to bottom. Three 36L regular shank chrome dome buttons, attached with rings and disks, set on each row, one at center and one at each end.

**Back & Tail Trim:** Back of coat is 7744-Black.

**Collar:** Collar is 960-91 White. Collar lining and liner are Xtreme Dri Raven Black. The top of the collar is bound with 7744-6605 Gray binding, leaving  $\frac{1}{2}$ " of gray showing.

**Shoulder Straps:** Straps are 960-91 White. Set flush to edge all around,  $\frac{1}{2}$ " stripe of 7744-6605 Gray. Button is 24L long shank chrome dome, attached with ring and disk.

**Upper Sleeves:** Sleeves are 7744-Black. Set straight on both sleeve heads, 1" plain block "TROY" of white direct Swiss embroidery.

**Cuffs:** No trim.

## **DRUM MAJOR SHOULDER DRAPE**

Reversible pleated drape, side one 960-91 White, side two Silver Metallic Glamour. Drape to attach with a 5" button tab of 7744-Black with two buttonholes.

## **DRUM MAJOR COAT FRONT SLASH with MIRROR**

The front slash is  $3\frac{1}{2}$ " wide of 960-91 White. It is self lined and fused with heavy fusing for stability. Slash to attach to coat with two buttonholes at top and white Velcro hook at bottom. Bind top and bottom edge with 7744-6605 Gray binding, leaving approximately  $2\frac{1}{2}$ " of white to show.

Silver rectangular mirror, approximately 2 ½" wide by 3 ½" long, to attach to front slash thru metal grommets/eyelets with a two-pin attachment. Mirror should be centered on slash and placed diagonally to assimilate a buckle.

### **DRUM MAJOR GAUNTLET CUFFS**

Seven inch cuffs are white grained vinyl with lining of 1933 White backed with heavy fusing. Set flush to top on both, a 1" stripe of 7744-6605 Gray grained vinyl. Set vertically below Black stripe on the upper portion of each opening edge are three 36L chrome dome regular shank buttons attached with rings and disks. Closure edges to be turned back ½" with 1" wide White Velcro sewn on top to edge of closure. Closure edges must be turned back the same amount so that sizes will be accurate. A 3" wide piece of 1933-White will be stitched all along the inside edge of the Velcro Loop and Hook to prevent Velcro from coming in contact with sleeve.

### **DRUM MAJOR JUMPSUIT**

Jumpsuit is 7744-6605 Gray and the cuffs will be hemmed. The front will close with a full length zipper and two pockets will be incorporated as part of the inside fly. There will be no waist darts, front or back. The shoulder straps of jumpsuit fabric will be 1 ¼" wide with nylon slides. The center back of the jumpsuit will allow for a 3" let out. Each leg will have a 1" stripe of 960-91 White.

### **DRUM MAJOR SHAKO**

<b>Style:</b>	Flat top military shako
<b>Plume holder:</b>	Center front
<b>Top:</b>	7744-6605 Gray
<b>Sides:</b>	7744-Black
<b>Bands:</b>	Both 7744-6605 Gray
<b>Front chain:</b>	Silver with chain hooks
<b>Visor:</b>	Black
<b>Chinstrap:</b>	Clear chinstrap w/silver buckle plus silver chin chain.
<b>Buttons:</b>	45L nickel dome
<b>Ornament:</b>	S-100 nickel eagle

### **DRUM MAJOR PLUME**

14" Black French Fountain

**DRUM MAJOR CITATION CORD**

White with silver metal tips.

## COAT SPECIFICATIONS

### Hard and Soft Collar

#### 1. **GENERAL**

Due to the unique requirements of a band coat (relative to the number of different wearers, minimum care received, wearing conditions and life expectancy), special patterns, materials, design and construction methods must be applied.

#### 2. **PATTERNS**

- A. Coat patterns are special band uniform patterns with additional “ease” to allow for freedom of movement, wearing of clothing underneath and the convenient re-issue from year-to-year. Fashion or standard patterns do not allow enough room. Merely up-grading to oversized patterns will result in an unsightly and cumbersome fit.
- B. Computer generated patterns will provide proper fit for all male and female band members, with no restrictions or limitations as to chest size. Likewise, sizes will be assigned in needed “lengths” from XXS through XXL. Coats will be patterned for EACH even numbered chest size, rather than just generic S, M, L, etc.
- C. Patterns are to be marked and graded using a computerized system to insure accuracy and updated patterns.

#### 3. **SIZING**

- A. Measurements will be taken by a factory-trained representative.
- B. Sizes are analyzed by a sizing computer system assigning the closest standard proportion size to each wearer in order to permit re-issuing in subsequent years and to provide a reasonable fit for the initial wearer.
- C. In the event the initial wearer cannot wear a standard proportion size, a special pattern will be employed to insure a reasonable fit.

#### 4. **COAT**

- A. Coat linings are cut from a separate set of patterns designed to fit each specific coat size and style. Linings are not cut from coat shell patterns then cut down to try and fit.
- B. Linings are “FIRST” quality polyester twill, non-toxic, perspiration resistant and preshrunk to washable standards. Linings will have no less than 124 x 72, 150 Denier in both the warp and fill, meeting government specifications.

**NOTE:** “Patterned” linings of men’s fashions fabrics are not durable in the heavy duty uniform usage.

- C. The coat lining has a ½” vertical pleat running up the center back. This allows fullness, fit and comfort to the overall performance of the coat.
- D. In the armhole area, the coat lining is machine stitched to an ensemble including the outer coat fabric, shoulder pad and sleevehead. Hand sewing or felling does not provide the durability required for armhole construction.
- E. Linings are sewn to the coat bottom edge, and reinforced with pre-shrunk tailoring tape. Straight cut long coats will have an additional ½” lining pleat all around the coat bottom.

5. **BRAID** (see #25-B)

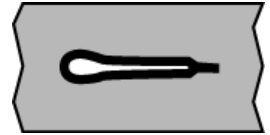
Only first quality braid shall be used for trim. Braid trim ¼" or wider, is sewn down with two rows of stitching on looped trims as well as straight line. In addition, looped trim is reinforced with a layer of non-woven fabric, permanently bonded to the inside coat fabric surface to inhibit puckering tendencies.

6. **BUTTONS**

High-quality metal buttons shall be used where specified and they shall be attached by sewing, ring and washer or toggle and washer.

7. **BUTTONHOLES**

All coat buttonholes are made with a CUT-FIRST automatic buttonhole machine. The hole is cut first, the edges covered with gimp, then completely sewn to "close" the buttonhole. The buttonhole back is secured and closed with bartack reinforcement. Gimp is 100% cotton glazed #8 and approximately 8 oz., color matched to the buttonhole thread.



8. **ZIPPERS**

A. Zipper to be heavy duty YKK, 9/16" tape, autolocking pull-slide of brass, or equal.

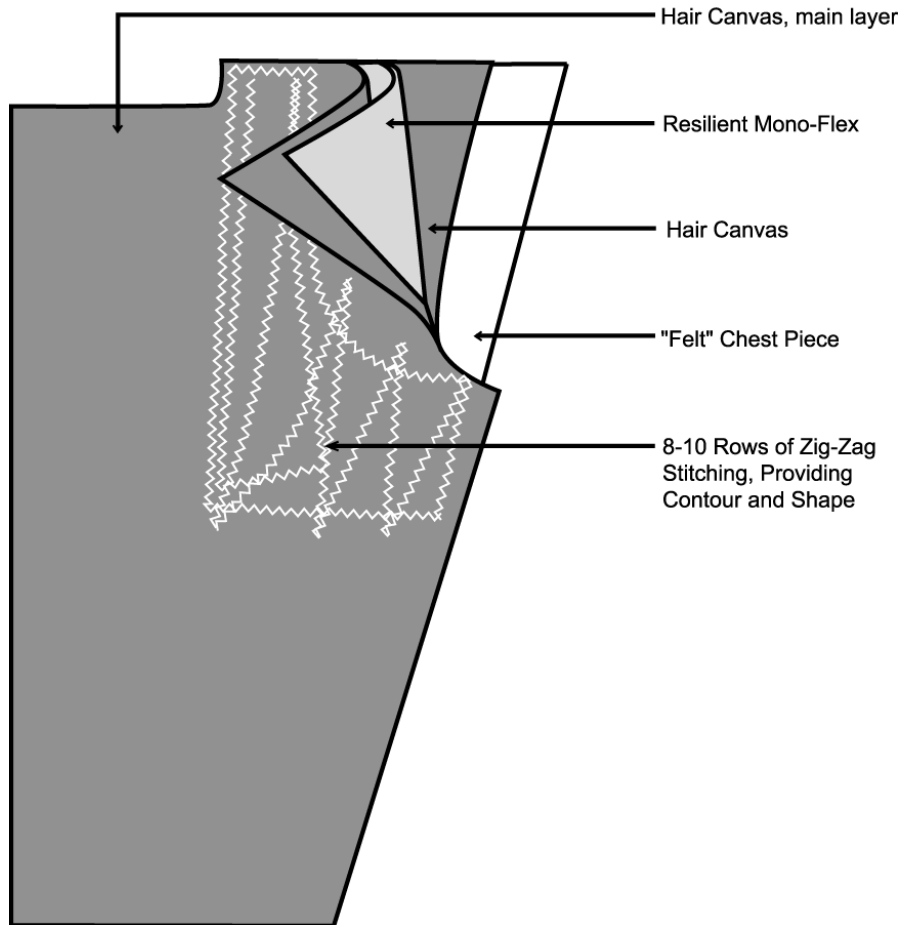
B. Coat zipper tape shall be bar-tacked top and bottom and sewn to the surface of the facing, not sandwiched in between shell fabric and facing.

9. **INTERLINING**

A. The interlining has optimum four-layer construction. More than four layers creates "STIFFNESS" in the coat fronts, resulting in difficult and uncomfortable arm lift maneuvers in marching bands. Less than four layers results in flimsy construction and therefore a rumpled appearance and reduced durability. In keeping with individual patterns for coat shell fabrics and the linings, higher quality control and an elevated level of haircloth quality is obtained by these multi-layered interlinings being patterned, cut and assembled "IN HOUSE" at the uniform manufacturers facility. This basic construction practice enhances the fit and comfort of the individual uniform (as opposed to "making do" in purchasing these multilayered ensembles and cutting them down to fit the "hundreds" of patterns required for each coat style and chest size).



## Coat Front Interlining



- B. The main layer of the interlining is a Hymo haircloth. This "hair canvas" is 35% genuine natural hair, 47% rayon and 18% polyester fibers. It is sanforized and double pre-shrunk with A.V.S. water repellent application. This canvas is 100% soakable with no shrinkage nor loss of rigidity. The layer extends the complete length of the coat front, from shoulder seam down to the coat bottom.
- C. The second layer is a resilient 27.6% rayon/72.4% polyester canvas "MONO-FLEX" chest piece 4.2 oz in weight. Its dimensions are 6" wide x 6 <sup>3</sup>/<sub>4</sub>" long and extends downward from the upper chest area.
- D. The third layer is another piece of hair canvas (as per "B" above) 8" wide and 12" long, extending downward from the upper chest area, and completely covering the MONO-FLEX.
- E. The fourth layer is a 1/4" thick padding of 3.6 ounce 100% polyester non-woven material that is soakable and non-shrinkable. This white chestpiece pad extends approximately 6" below the armhole.

**NOTE:** In white coats and other light color fabric shades, a piece of thin Poly-sil white curtain is added to prevent "shadowing" of the haircloth interliner through the outer coat fabric.

- F. This entire multilayered interliner shall be sewn together with a series of eight to ten rows (depending on chest size) of zig zag stitching spaced approximately 1" apart. This is the optimum number of rows as recommended by the garment industry standards. Too many rows will reduce the flexibility, comfort and fit. Too few rows will limit durability and lifetime.
- G. The interliner is then secured to the coat shell fabric and coat lining, in the neckhole, armhole, bottom front and along the coat closure edge. A tailoring tape is included in these seams for added durability. The interliner is NOT sewn into the shoulder seam nor the side of the coat. This allows flexibility and "give" to the entire coat front construction.

**NOTE:** All tailoring tape is 100% PIMA cotton and triple cold water shrunk. Fused front interliners are not acceptable.

- H. On soft collar concert/blazer coats the lapel portion of the canvas shall be padded to the lapel section of the coat with a series of multi-rows of blind stitching at close intervals no more than 1/4" apart. This section shall be hand shaped and a 3/4" cotton bridle tape shall be applied by two rows of blind stitch to insure body contour, permanent lapel shape and reinforcement to prevent stretching.

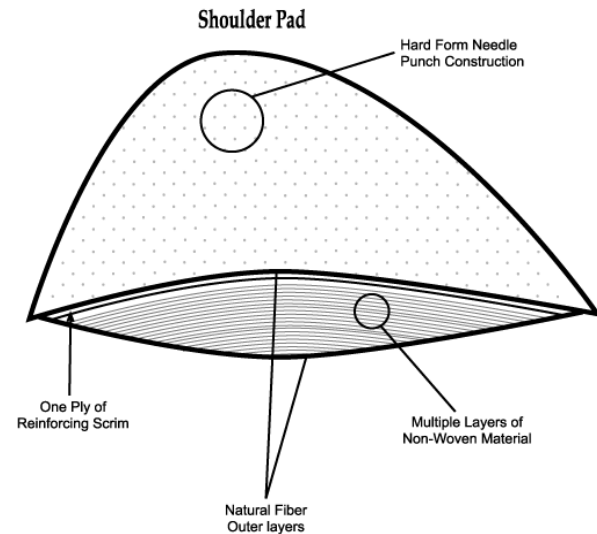
**NOTE:** The above construction is a time proven, traditional procedure. Under no circumstances are the haircloth and sewing operations to be substituted with a fusing or gluing operation. Certain areas of the coat should have a small reinforcement piece of pella fused to the outer fabric. These will be designated and detailed later; they serve as essential parts in the overall durability and appearance of the garment. However, as previously stated, the large chest pieces and foundation interlining must NOT be fused.

## 10. ARMHOLES

- A. Armholes shall be oval shaped and allow sleeve to be pitched forward 3-4 degrees to maximize comfort and ease of movement with minimum distortion to the coat.
- B. The armhole shall be reinforced with 1/4" pre-shrunk cotton tape all around to prevent stretching in the armhole.
- C. The entire armhole shall employ machine lock stitching. Hand or machine "felling" will not be accepted.

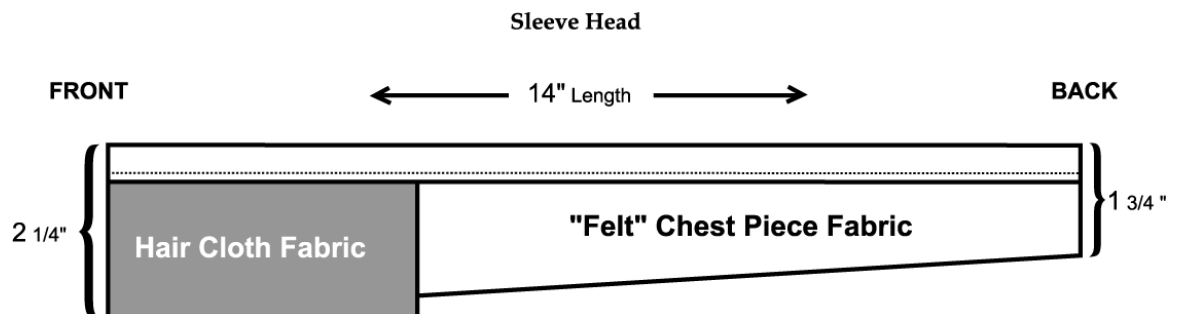
## 11. SHOULDER PADS

- A. Shoulder pads shall be high quality, dry-cleanable and non-absorbent.
- B. Shoulder pad size shall be minimum 9" long x 4 1/2" wide on regular width coat styles. Special "extended width" shoulder coats will have a larger shoulder pad measuring 9" long x 6 1/2" wide.
- C. Shoulder pads are a "hardform" construction, consisting of several layers of non-woven material. The layers are permanently attached together with a "needlepunch" process. Among the layers, near the top side, is a reinforcing ply of scrim, which adds dimensional stability to the assembly. A final layer of natural fiber is applied as a covering. The shoulder pads are guaranteed for the lifetime of the garment. Dry cleaning is recommended, but the shoulder pad is also compatible with water.
- D. Shoulder pads consisting merely of PIMA cotton covered with a porous fabric and held together with loose basting stitches, will not endure the many years of dry cleaning, exposure to the elements and the demands of marching band wear. The tendency is for a "wadding" of the cotton core. This type of shoulder pad is NOT acceptable.



## 12. SLEEVE HEADS

This provides fullness and shape to the top of the sleeve as it is sewn to the coat body. It consists of a separate strip of material used for the white chestpiece pad of the interliner (9E). The sleeve head has a length of 14" and is equally positioned over the shoulder, to the front and back of the upper sleeve seam. The finished width is 2 1/4" at lower front, and tapers to a 1 3/4" width at lower back. The construction consists of a 3/4" turnback on the armhole edge, and has a seam spaced 1/2" from the edge. Sewn into the lower front portion of the white pad strip, is a 2 1/2" x 4 1/2" piece of "haircloth" as described in the Interliner section (9B). The result of this "IN HOUSE" manufactured sleeve head is a substantially improved "body" in the entire sleeve/shoulder area, particularly when lettering or other embroidery trim is specified.



### 13. SLEEVE STITCHING

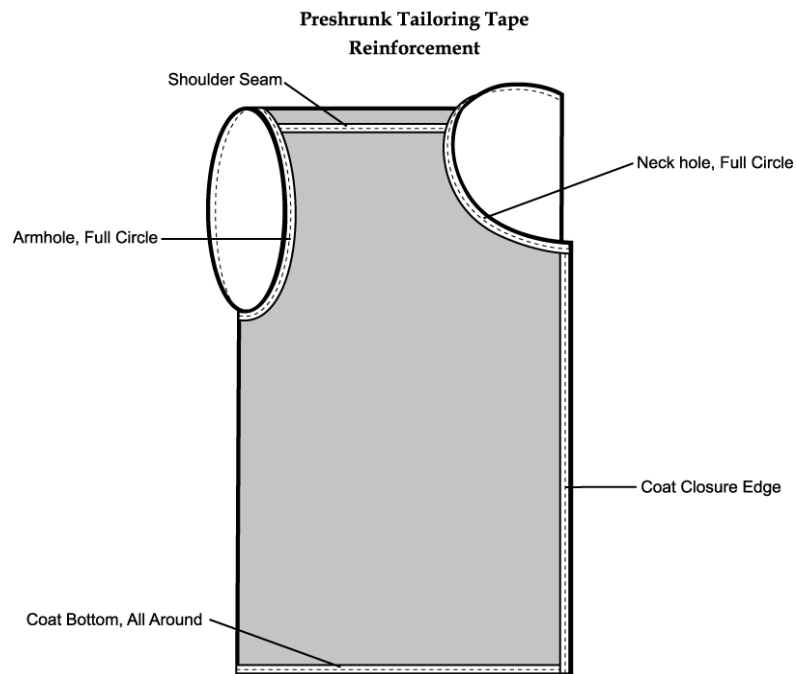
- A. Sleeves shall be set with machine lock stitch to insure proper distribution of fullness and durability.
- B. Fullness shall be sheered in by top-feed sewing machines.

### 14. ARMHOLE LINING FINISH

- A. The bottom of the sleeve armhole shall be lock-stitched through two layers of lining, two layers of fabric and armshield.
- B. The top shall be sewn through the coat lining, sleeve fabric, sleeve head, shoulder pad and shoulder strap with lock stitching.
- C. The entire armhole has tailoring tape all around.
- D. "Felling" by hand or machine is not acceptable when closing the armhole.

### 15. TAPING

- A. All seams in high stress areas are reinforced with tailoring tape to prevent stretching, and add durability to the seam. These tapes are pre-shrunk.
- B. Areas of this taping procedure include the following:
  - 1. All around the neck opening where collar joins the coat.
  - 2. Coat closure edges and completely around the bottom.
  - 3. Complete circumference of the armhole.
  - 4. Shoulder seams from collar (neck opening) to sleeve seam - except canopy coats.



## **16. POCKETS**

- A. All inside pockets shall be constructed with a pocket welter and shall be reinforced with a non-woven fabric.
- B. Pocketing material shall be 80/20 poly cotton, 100% poly fill, pre-cured finish, 3.05 YPP, 78/54 twill weave.
- C. Upper and lower welt of the inside breast pocket is to be 100% polyester material and pellon backed.
- D. Pocket bag shall be constructed on one piece of pocketing with no open seams at the bottom.
- E. There shall be a tack at each end of pocket opening through all layers of pocketing. Tacks shall be concealed.
- F. Pockets made of lining or lightweight material shall not be acceptable.

## **17. SLEEVE CUFF TURN UP**

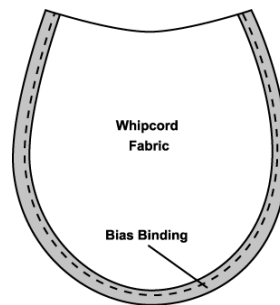
- A. Sleeve cuffs will have an approximate 2 ½" turnup, which incorporates both the coat sleeve fabric and lining. This turnback includes a 3/8" binding at the top edge.
- B. Sleeve length alterations are accomplished by removing the blindstitch and re-sewing at the desired length.

## **18. SLEEVE CUFFS**

- A. Sleeve cuffs without trim in the cuff area are reinforced with a 5" width of non-woven material, bonded permanently to the inside of the coat fabric. As the sleeve is then turned back to form the let-out feature, this non-woven layer is equally divided to finish 2 ½" in the outside cuff edge, and 2 ½" on the inside. This procedure provides body to the sleeve cuff bottom edge, and maintains a full rounded finish.
- B. Sleeves with extensive cuff trim (appliques, inserts, looped braid designs, embroidery) are given the same reinforcement layer of non-woven material, but this layer is extended an additional 12" up toward the elbow area. This addition prevents puckering tendencies created by use of fabrics, braids, etc. which each have different coefficient of stretching.
- C. Shoulder lettering and embroidered logo trim have a reinforced backing layer on the inside of the sleeve.

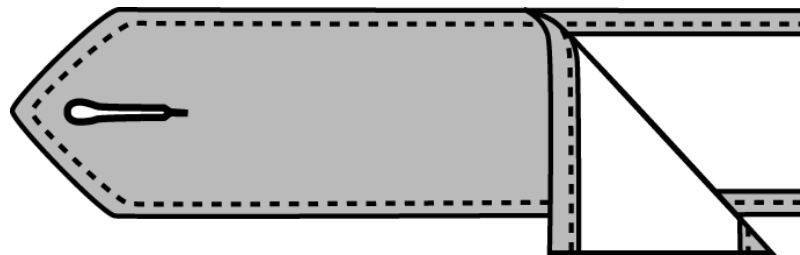
## 19. ARMSHIELDS

- A. The armshield is engineered to minimize the long-term effects of perspiration over the lifetime of the garment. Perspiration consists of moisture, salts, weak organic acids and body oils. A whipcord fabric having WICKING properties is specified for use as the armshield. (“Felt-like” fabrics that retain perspiration are not in the best interest of the garment). In addition to the wicking property, this whipcord shield has soil release, high permeability for airflow, and exhibits rapid evaporation.
- B. The armshield is approximately 4” x 4” in dimension, bound with double folded bias rayon on both sides and the bottom, then machine sewn into the armhole.
- C. Tensile strength and resistance to abrasion are additional advantages of whipcord armshields as compared to a “felt-like” material. The minimum abrasion quality is 10,000 on the STROLL FLAT test.



## 20. SHOULDER STRAPS

- A. Both the upper and lower layers of the shoulder strap are innerlined with permanently bonded, non-woven material. This four layer ensemble is secured with an inside hidden stitch then top-stitched all around the edge, set in approximately 1/4". These layers are die-cut to insure exact conformity in shape and size, throughout the lifetime of the garment.
- B. Buttonholes are the CUT-FIRST style, having all raw edges reinforced with gimp, then solid stitching as described earlier in the Buttonhole section (item 7).



## 21. STANDING HARD COLLAR

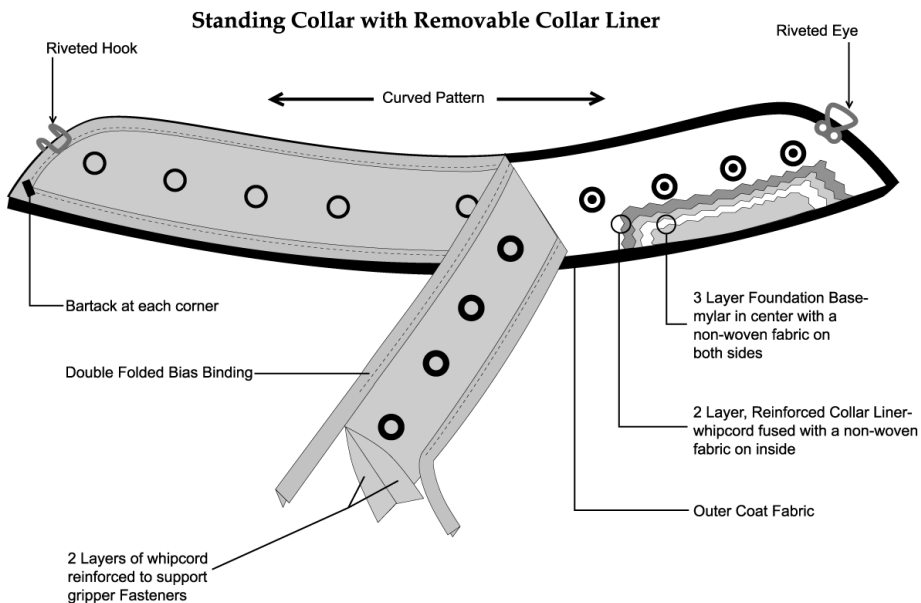
- A. Collars are one of the highest stress areas in the coat. The following construction process and features are the standard for the industry. Deviations and shortcuts will exhibit a lesser quality. The collar and matching removable collar liner are cut from curved patterns. This allows a front “drop” to fit the downward front slope of natural human body configuration. These items are NOT to be cut in a straight pattern.

- B. From the inner collar lining to the outer coat fabric, there is a total of six layers in this quality collar construction. From inboard to outboard, these layers are:
1. Collar lining of whipcord fabric-same as the Armshield section (item 19) for durability, wicking and tensile strength.
  2. Non-woven material, permanently bonded to inside of collar lining, allowing a double layer for reinforcing the nine gripper fastener posts.
  3. The next three layers consist of the heavy-duty mylar foundation base, which has a layer of non-woven, permanently bonded fabric to **EACH** side of the mylar. This triple layer foundation base is bound all across the top edge with a double folded, non-woven fabric tape, with stitching through and through.
  4. The sixth layer is the outer coat fabric, which is that portion of the collar being readily visible.
- C. The remaining three layers of the collar assembly consists of collar lining, bonded non-woven reinforcing layer and the outer coat shell fabric. These layers are sewn to the top edge of the triple layer foundation base. The outer coat fabric layer is cut to allow a double beaded fold over, along the top edge of the collar.

**NOTE:** All stitching and seams are “internal” and NOT visible.

- D. A heavy duty, nickel hook and eye hardware set, is permanently riveted through the inner five layers of the collar assembly (omitting the outer coat fabric), the hook at the right front with the eye at the left. This hardware is set at an angle to establish “tension” which keeps the hardware in a closed position, secured by its own weight.

**NOTE:** The entire sewing operation in the construction of the collar is “machine-sewn”. Hand sewing simply cannot insure the required durability.



## **22. COLLAR LINER (REMOVABLE)**

- A. This removable liner is constructed of two layers of whipcord fabric having a double folded bias binding tape all around the entire liner. A bartack is added at each end. This liner fabric is the same as used to make the armshields and collar lining. That is, it has properties of soil release, wicking, durability and breathability. The positioning of the gripper snap sets, provide for the liner to extend 1/8" above the top edge of the collar. This affords protection from perspiration, cosmetics, etc. getting into the collar fabric.
- B. There are nine, nickel plated gripper fastener rings set into the removable collar liner. These are positioned to match nine gripper fastener posts built into the inside collar lining. The collar and liner are patterned having the top edge of the collar with a smaller circumference arc than the bottom edge of the collar. This results in an engineered curve to the collar ensemble, to better fit the shape of the neck and chest "drop" of the human body.
- C. Each collar liner is cut from its own sized pattern, to fit the intended coat size. Since the collar liner is washable, a "laundry-proof" permanent number is imprinted on the inside back portion of the liner. The number matches the identification number of the coat.

## **23. "WRAP" COAT COLLAR**

The standing collar on the wrap style coat is "soft", in that there is no inner layer of stiff mylar. This collar generally measures 1 3/4" finished width. The inside lining is a coat shell whipcord having a permanently bonded layer of non-woven fabric to reinforce the collar. The outer layer of the collar is also a coat shell whipcord, having a reinforcing layer of monoflex (resilient canvas of 27.6% rayon/72.4% polyester – 4.2 oz. weight) stitched in. This results in a reinforced "soft" collar having four layers. All exposed edges are turned inward with an invisible row of stitching. A visible row of topstitching is added all around the edge. There are no exposed, rough edges.



## **24. SOFT COLLAR**

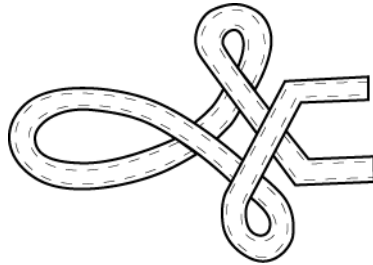
- A. Soft collar lapel coats shall have 3/4" non-bias bridle tape blind stitched to the canvas and through the back side of the outer shell of the garment so the lapel will roll and stay in a permanent position. The bridle tape will be worked in approximately 1/2" to give proper curvature over the chest area.



- B. Lapel coats are to have not less than seven (7) rows of blind stitching, catching the canvas and outer shell, applied under curved tension, giving fullness to the lapel for proper roll and permanent shape.
- C. Non-bias ¼" cotton tape shall be applied on the leading edge extending from the base of the collar down the front and around to the edge of the canvas.
- D. One-half inch 2-way fusible tape shall be used to secure facing to coat front for added stability and appearance.
- E. The under collar is to be made of a double-thickness under-collar cloth.
- F. All edges shall be topstitched (with the exception of satin lapels) through and through, from the facing edge through coat front lapels and collar to the opposite edge. Topstitching shall be 1/8" from edges as with welt pockets and pocket flaps.

## **25. COAT TRIM**

- A. All trim must be sewn to the outer coat fabric before the lining and interlining are joined to the coat. Trim sewn through the interlining and lining is not acceptable.
- B. Braid trim of ¼" or wider is sewn down with two rows of stitching. This includes looped trims as well as straight line. In addition, looped trim is reinforced with a layer of non-woven fabric, permanently bonded to the inside coat fabric surface, to inhibit puckering tendencies.



## **26. SPECIAL COAT STYLES**

- A. Certain coat styles will require a "Memory Recovery" system across the upper back and shoulders. This includes coat backs with bi-swing pleats in each upper back sleeve seam, and an inverted pleat style having a bi-folded expansion "pocket" in the center back seam, at the upper shoulder level. The seamless canopy style coat also requires this "Memory Recovery" system, due to the under construction across each shoulder.
- B. The Memory Recovery system is a 2 ½" wide panel of heavy duty light weight elastic, made of 90% (70 denier) nylon and 10% (140 denier) Spandex. It is sewn into each sleeve seam in the coat back area, and extends fully across the coat back. When the wearer of this coat style is in an arms down position, the system is relaxed. During an arm lift maneuver the entire coat back experiences stress and pulling across the shoulders. The Memory Recovery system brings the various fabrics, folds and coat parts, back to the original "EASE" position when arms return downward. This entire process prevents unsightly bulging. The durable elastic panel is included in the manufacturers warranty.

**27. SEAMS**

The center back seam and side body seams shall be 5/8". Seams are to be plain with a minimum of 1 1/2" total outlet in the side body seams and 3/4" in the back seams. Coat is to be completely machine stitched except in areas where tailoring or appearance necessitates other methods. The ends of all seams and stitching shall be back-stitched not less than 1/4". Thread breaks of all stitch types must be secured by stitching back from break 1/2" to 1". Coat is to be tailored with a four-piece back, comprised of a center back seam and two additional back body seams curving from sleeve seam downward and running out the coat bottom. Two-piece backs are also available as a buyers option, for a "sack" style coat.

**28. THREAD**

There shall be different types of thread used in various operations depending upon the need for strength, fullness, elasticity and smoothness. Padding of lapels and sewing of the bridle tape is to be done with three-cord cotton mercerized thread. Other sewing operations use perma cord size 50, two-cord thread. All threads used are to be heat resistant, vat dyed, sunfast, dry cleanable and moisture proof. In areas of multiple color trim panels, a monofilament thread may be indicated. This thread is a 330 denier and has a .008 diameter rating. The manufacturers warranty includes all threads used throughout the uniform construction.

## JUMPSUIT/BIBBER SPECIFICATIONS

### 1. GENERAL

Jumpsuits/bibbers are special marching band construction and design, and shall not employ fashion tailoring techniques, materials or patterns that will not withstand the rigorous end use of band uniforms. Fashion pocketing, waistband material and construction, lightweight snaps and hooks are not acceptable.

### 2. PATTERNS

- A. The patterns and style must be in keeping with the end use of marching, with maximum capability to be adjusted for fitting a variety of wearers from year-to-year.
- B. They must have ample room for movement and be nonrestrictive for marching, in the seat, thigh and ankle area. The dimensions of a jumpsuit/bibber for a 38 regular male, shall not be less than 20 1/2" circumference at cuff and 26" at thigh.
- C. There are both male and female patterns.
- D. There are two (2) rear waist darts to reduce fullness from the seat to the waist. Seat shaping is accomplished by the pattern, not extended waist darts. Front darts are optional.

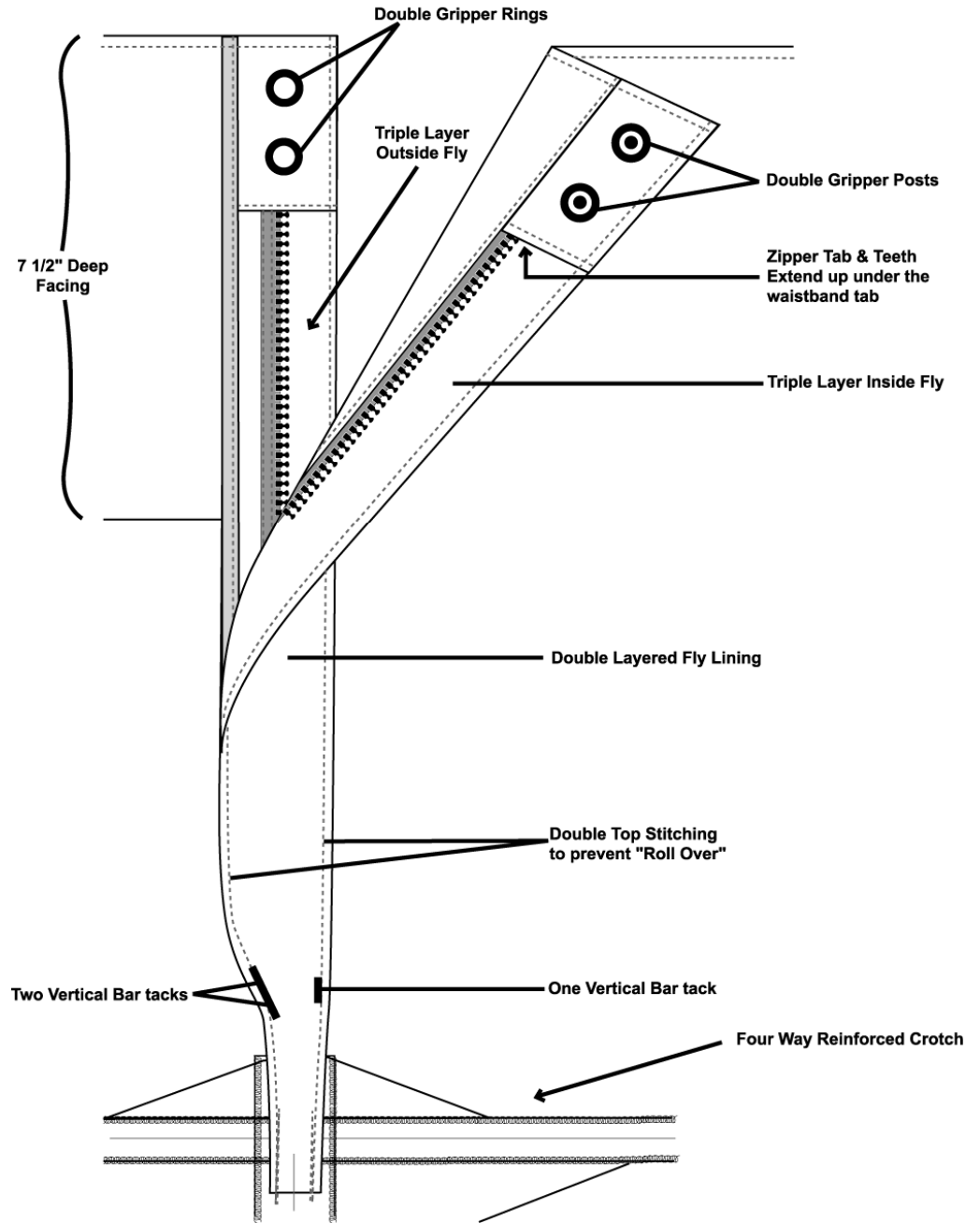
### 3. FRONT CLOSURE

- A. There are two stainless snaps at the top of the fly. Jumpsuits/bibbers with merely one (1) snap at closure are unacceptable.
- B. The fly zipper is brass "Y.K.K." with a double locking slide. There is a metal stop at the base of the fly zipper. The fly teeth will extend completely up under the waistband to prevent the slide from coming off the top of the zipper. Short zippers with teeth not extending under waistband are not acceptable.
- C. The outside fly consists of the outer shell fabric, an inner layer of shell fabric, and a middle reinforcing layer of non-woven fabric. The lateral edge of shell fabric on the inside of this fly assembly is completely bound with a polyester bias tape.
- D. The inside fly is constructed with a layer of outer shell fabric having two layers of "four way" fabric sewn to the inside. The "four way" material is 80/20 polycotton, 100% poly fill, 3.5 yards per pound, with a pre-cured finish. This inside fly extends down into the four-way crotch and finishes approximately 1 1/4" beyond the four-way. This fly lining is stitched down on both edges, to prevent "rolling".

**NOTE:** Both the outside fly and the inside fly have three layer construction.

- E. There are two vertical bar tacks on the inside fly lining and one vertical bar tack on the outside of the base of the fly 3/4" up from the bottom of the fly. The purpose of the outside bar tack is to eliminate stress on the zipper track and to prevent tearing when the trousers are being put on. This bar tack is vertical to insure maximum number of stitches on the seam, and positioned to be not noticeable.
- F. The outside, three layered front fly measures 1 3/4" in width. The inside, three layered front fly measures 2" in width.

# Jumpsuit/Bibber Inside View



#### 4. CROTCH REINFORCEMENT

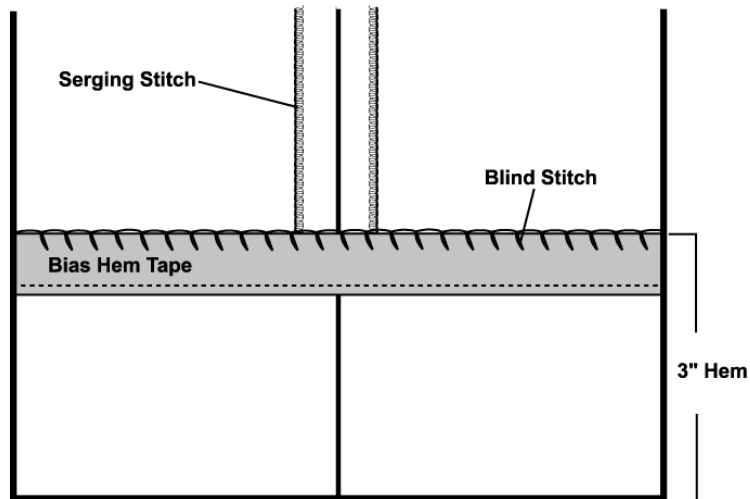
- There is a "four-way" crotch reinforcement consisting of 80/20 poly cotton, 100% poly fill, 3.5 yard per pound, pre-cured finish fabric.
- There are four, two ply sections, one on each side of the intersection of the fly, seat seam and inseams.
- Crotch area is clean finished with no pieces extending from top of inseams.

5. **POCKETS**

- A. Pants pocketing is high grade; acceptable for use by government agencies, 80/20 poly/cotton, 100% textured poly fill, pre-cured finish, 3.5 yards per pound.
- B. Pockets are “bag” construction, consisting of one piece of pocketing turned and stitched. There are no seams at the bottom of the pocket and no exposed serging stitches.
- C. If standard exposed hip pockets are used, they shall be double welt construction and reinforced with interlining.

6. **CUFF HEM – “EASY ALTER”**

- A. The bottom of the trouser leg has a 3” turnback on the inside, including a binding of flat polyester bias hem tape. This tape is a total width of 1 ½” before being applied to the trouser cut edge. It is folded over the cut edge and sewn down leaving a finished width of ¾”. This hem is now blindstitched back to the inside of the trouser leg.



7. **SEAMS**

- A. The center back, seat seam is sewn with two rows of locked chain stitching. There is a 3” Browne outlet along this center back seam.
- B. Inseams are sewn with a highly durable expansion stitch, allowing flexibility in this stress area. These seams are constructed with 5/8” seam allowances, and are of the “flat” style. Outseams are double folded over with the edges sewn together.

**NOTE:** Jumpsuits/bibbers with the expandable gusset option are constructed with the inseam having the “flat” style seam with 5/8” allowance.

8. **TRIM**

- A. All jumpsuit/bibber stripes shall continue the full length of the leg through the turn-up and are covered with tape at the raw edge of cuff.
- B. Stripes are set no more than 1/8” from side edge of adjustable “V” to minimize stripe distortion.
- C. All straight fabric stripes are double thickness to prevent shadowing and pressing marks.

- D. Trim shall be centered on and will cover the side seam for aesthetics and seam reinforcement.

**9. PERMANENT SUSPENDERS**

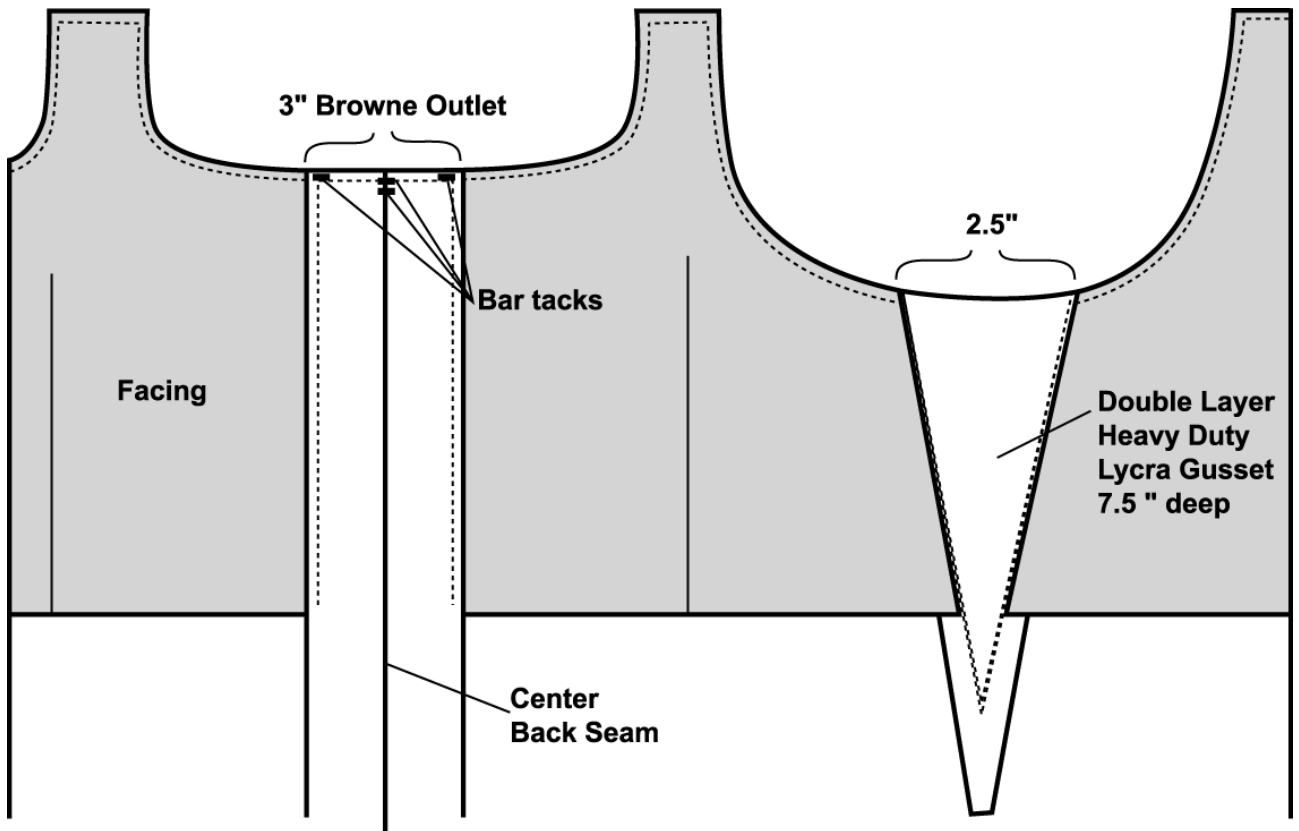
- A. Suspenders are made of whipcord fabric. Color shall match jumpsuits/bibbers. Nylon webbing shall not be used because the adjusting slide will not remain in set position under tension from movement.
- B. Suspenders are two-ply, topstitched, and have interlining for body. This will insure the adjustable slide remaining in set position; suspenders will dry clean as well as jumpsuit.
- C. All hardware is unbreakable nylon as used in parachutes and life vests; unbreakable, unbendable and not subject to tarnishing or rusting. It will not cause undue abrasion on jumpsuit during dry clean tumbling.
- D. Suspenders are self faced and interlined with pellon.

**10. PERIMETER SERGING**

- A. All exposed "raw" edges not covered with tape are serged with a "serging stitch of no less than 10 per inch, tight to edge, to prevent fraying.
- B. Serging thread is polyester.

**11. UNDERARM GUSSETS**

When an underarm gusset is specified for adjustability features, a heavy duty two-layer color matched lycra wedge is sewn into the upper portion of the pant outseam. This gusset is cut into an elongated diamond shaped pattern 19 ½" long and 3 ½" at its widest point. The two elongated points are matched together, allowing the double layer of lycra to be sewn into a proportionate V shaped notch. This results in a gusset, double layers, 2 ½" wide at the top of the jumpsuit in the "underarm" area, and extending downward to a finished length of 7 ½". This adjustable feature will allow up to 3" larger fit around the torso. The manufacturer's warranty includes this lycra feature.



## 12. UPPER FACINGS

Inside upper facings are essential in providing body and dimensional stability to the curved cut all around the upper edge of the jumpsuit/bibber trouser, extending upwards to accommodate the shoulder strap. The following dimensions are standard:

Center Back Seam	7 1/2" Deep
Underarm	5" Deep
Back Shoulder Strap Extension	11" Deep
Front Shoulder Strap Extension	9" Deep

## SHAKO CONSTRUCTION SPECIFICATIONS

### 1. GENERAL

The materials, component items and the finished hat shall meet or exceed the minimum requirements as specified. The range of sizes is to follow national standard men's hat sizes as follows: XXS (6-3/8) thru XXL (8).

### 2. BODY

A. Shako body shall be made of ABS (Acrylonitrile Butadine Styrene) material, gray in color. This material will be G. S. Grade for Hi-Impact properties and maximum resistance to ultraviolet light.

B. There is a separate shell size for each head size.

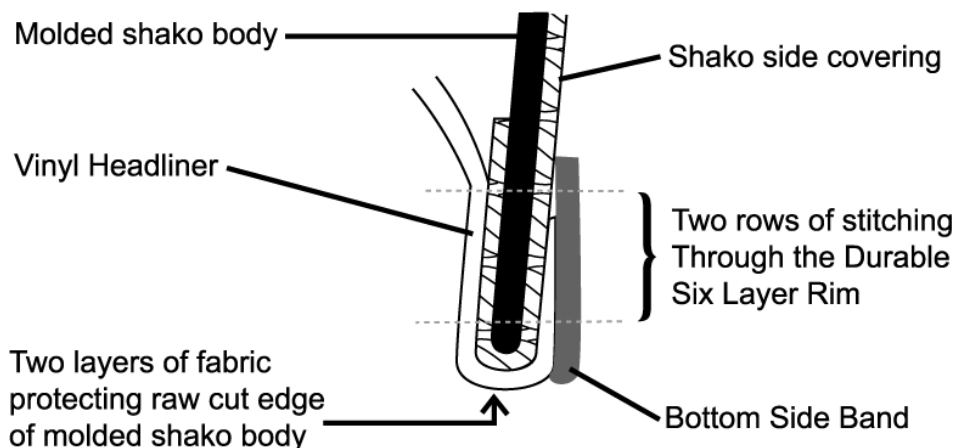
C. Each hat will have a woven label indicating size and offering cleaning instructions attached to the sweatband. An identification number sticker is also applied to the inside top of the hat body.

### 3. COVERING

A. The fabric side covering is pulled down to the bottom edge of the shako body, then is turned back 1 1/2" up inside the shell. Two rows of stitching secure the side covering to the molded shell. Thread weight to sew covers shall be super-strong nylon thread, at least .007 in diameter. This sewing operation extends all around the entire bottom edge of the molded shako body.

B. The two rows of stitching described in section A. above, secure a total of six layers for maximum durability. These layers, from the outside to inside, are: BOTTOM SIDE BAND, VINYL HEADLINER, SIDE COVERING, MOLDED SHAKO BODY, SIDE COVERING TURN BACK and VINYL HEADLINER TURN BACK.

## Shako Cross Section

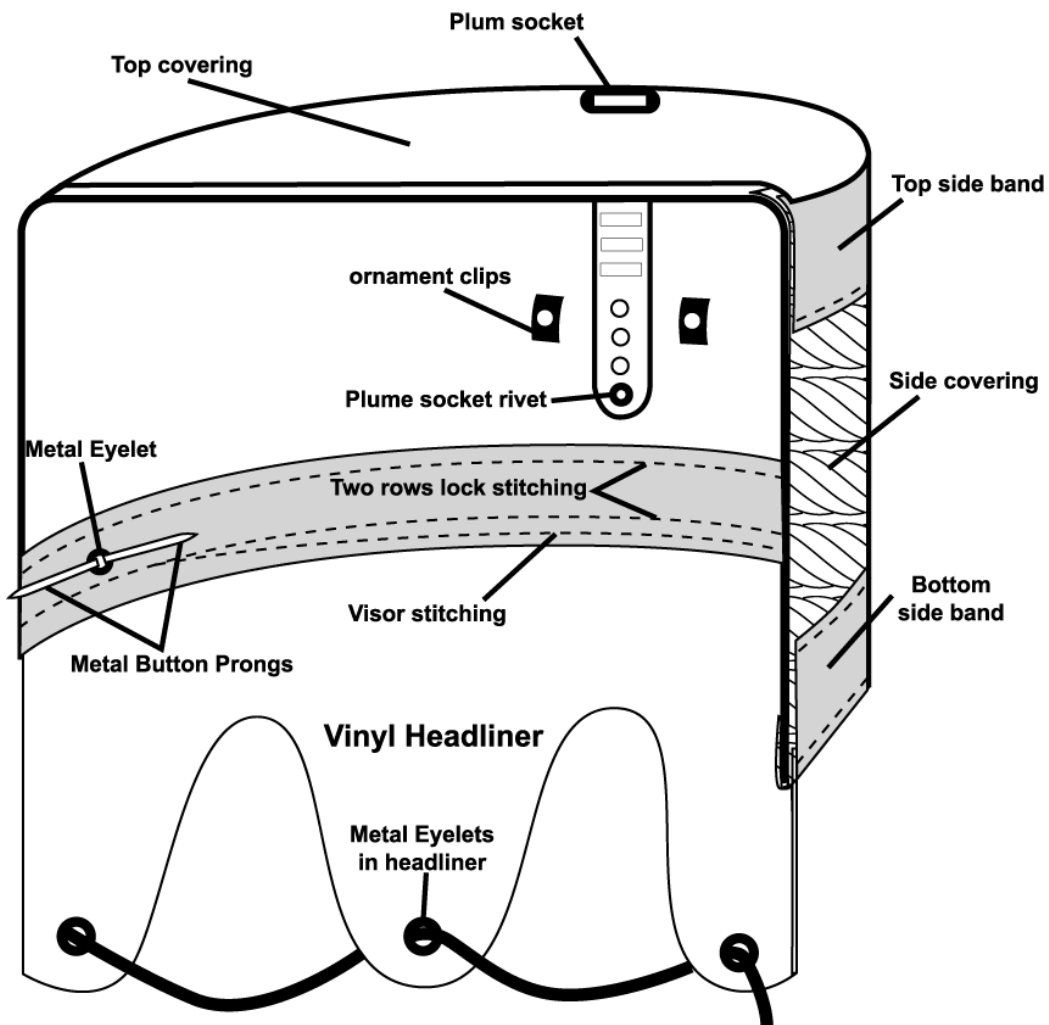




**4. HEADLINER AND SPECIAL FEATURES**

- A. Headliner shall be cloth backed, expanded vinyl with embossed finish. There are six scallops with metal eyelets to receive drawstring for adjustability.
- B. Headliner is turned and sewn with No. 12 cord, lock stitched in such a manner as to allow for adjustability. Stitches shall not contact wearer's head. Headliner shall be perforated with flow-through ventilation holes.
- C. Headliner extends around the bottom edge of the plastic body, and stitched through. This results in two layers of material (outer fabric and vinyl headliner) to secure and protect the bottom edge of the shako shell body.
- D. Headband shall have reinforcing metal grommets at lace holes.

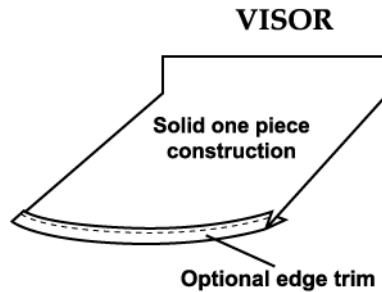
**Shako Construction**



- E. High density polyethylene plume sockets are included and are riveted to the body.
- F. A metal spacer is used to affix the front chain to each side button.

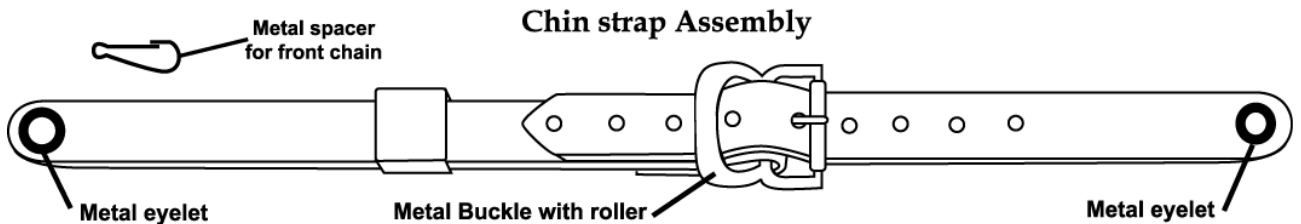
5. **VISOR**

- A. Visor is non-breakable one-piece plastic, not laminated. It is secured to the shako body with lock-stitch safety sewing.
- B. Visor color is molded through entire body of visor. The material is an engineering grade copolymer with a low-temperature tolerance. It is stain proof, fade and discoloration proof, and impervious to ultraviolet light (sunlight).



6. **CHINSTRAP**

- A. Chinstrap is  $\frac{3}{4}$ " pliable plastic (Ethyl Vinyl Acetate) with metal buckle and roller, and has a  $\frac{1}{2}$ " keeper.
- B. A reinforcing rib will extend completely around each end of the strap.
- C. There is a  $\frac{3}{4}$ " nickel-plated brass chinstrap hook at the rear of the shako, attached with a metal clip.



7. **BUTTONS**

- A. Side buttons are three-piece metal.
- B. Buttons consist of prongs, base plate, and faceplate. Side buttons are metal with spread prongs. Plastic buttons are not acceptable.

# Shako & Helmet Carry Case Specifications

Headwear carry case is “Shako-Mate” or equivalent.

## **MATERIAL**

Co-Poly Polypropylene. This material is heat resistant to prevent melting and cold resistant to prevent breakage due to the material becoming brittle.

## **DIMENSIONS**

2” x 12” x 8” to accommodate headgear and various accessory items.

## **HANDLE**

The handle is rounded with the latch placed behind the handle. Boxes with the handle on top, preventing ease in removal from stacked position, are unacceptable.

Shako-Mate has a black pebble grain finish to compliment appearance and prevent scratching.

Shako-Mate is stackable to allow for storage. Stacking nodes are to be on underside of container with receiving units on top.

Inside of Shako-Mate will be reinforcement flanges to allow for stability and to aid in stacking.

**Troy School District  
Troy High School Band Uniforms  
Bid #9722**

		Fruhauf Co.		Orefice Ltd.		Stanbury Uniforms Inc.	
QTY	Item	Unit Cost	Total Cost	Unit Cost	Total Cost	Unit Cost	Total Cost
	<b>Bandsman Uniforms</b>						
190	Coat	\$ 183.86	\$ 34,933.40	\$ 287.75	\$ 54,672.50	\$ 192.00	\$ 36,480.00
190	Plume	\$ 17.95	\$ 3,410.50	included	included	\$ 16.25	\$ 3,087.50
190	Front slash with mirror	\$ 37.00	\$ 7,030.00	included	included	\$ 37.05	\$ 7,039.50
190	Shoulder drape	\$ 40.02	\$ 7,603.80	included	included	\$ 42.10	\$ 7,999.00
190	Gauntlets	\$ 27.08	\$ 5,145.20	included	included	\$ 33.30	\$ 6,327.00
	<b>Drum Major Uniforms</b>						
6	Coat	\$ 183.86	\$ 1,103.16	\$ 297.60	\$ 1,785.60	\$ 320.70	\$ 1,924.20
6	Plume	\$ 17.95	\$ 107.70	included	included	included	included
6	Front slash with mirror	\$ 37.00	\$ 222.00	included	included	included	included
6	Shoulder drape	\$ 40.02	\$ 240.12	included	included	included	included
6	Gauntlets	\$ 27.08	\$ 162.48	included	included	included	included
6	Citation cord	\$ 10.95	\$ 65.70	included	included	included	included
	<b>Percussion Uniforms</b>						
32	Coat	\$ 183.86	\$ 5,883.52	\$ 272.25	\$ 8,712.00	\$ 287.50	\$ 9,200.00
32	Plume	\$ 17.95	\$ 574.40	included	included	included	included
32	Front slash with mirror	\$ 37.00	\$ 1,184.00	included	included	included	included
32	Shoulder drape	\$ 40.02	\$ 1,280.64	included	included	included	included
	<b>QTY Item</b>						
228	Jumpsuits	\$ 91.01	\$ 20,750.28	\$ 161.70	\$ 36,867.60	\$ 84.00	\$ 19,152.00
228	Shakos	\$ 46.51	\$ 10,604.28	included	included	\$ 40.40	\$ 9,211.20
228	Shako boxes	\$ 9.00	\$ 2,052.00	included	included	\$ 9.30	\$ 2,120.40
228	Nylon garment bags	\$ 13.50	\$ 3,078.00	included	included	\$ 10.40	\$ 2,371.20
	Shipping		\$ -		\$ 6,122.00		\$ -
	<b>Total:</b>		\$ 105,431.18		\$ 108,159.70		\$ 104,912.00
228	Parkas			\$ 54.25	\$ 12,369.00	\$ 59.00	\$ 13,452.00
	Shipping				\$ 750.00		
	<b>Total:</b>				\$ 121,278.70		\$ 118,364.00
							4% prepayment discount

DeMoulin: No Bid  
Band Shoppe: No Response  
Fred J. Miller Inc: No Response