

INVITATION TO BID

Your company is hereby invited to submit a BID QUOTATION ON THE ITEMS AND QUANTITY, AS DESCRIBED FURTHER IN THIS WRITTEN INVITATION. PLEASE RETURN THE bid form page(s) with your official bid. If you are unable to submit a bid quotation at this time, and if you wish to remain on our list of potential suppliers, simply send us a written explanation.

The deadline for our receipt of your bid is: **Friday, February 11th, 2022 at 11:00 A.M.**

Whereas considerable time and expense has gone into the preparation of the enclosed specifications, deviations are NOT anticipated. DEVIATIONS MUST BE DOCUMENTED. Unless fully documented, such deviations may DISQUALIFY a bidder at the discretion of the BUYER.

In setting forth these specifications, it is the intention of the buyer to offer equal opportunity to all bidders. Styles referred to by number and the company name are for descriptive purposes only and are not restrictive. The buyer believes those specified styles, materials, linings and sundry items are equally available to all reputable manufacturers.

Bidder is to furnish itemized quotations showing the cost of each item, the total price per uniform, and the total price of the entire order. Any allowance or cash discount for payment within a certain period before or after delivery is to be indicated on the bid; otherwise, it is presumed that payment is to be made based on net 30 days.

The buyer reserves the right to accept or reject any or all bids in the best interest of the buyer. Factors to be considered when determining the best value for the buyer are to be quality of the garment, service and responsibility of the company and their representative, as well as price. Low bid will not necessarily be the basis for awarding the contract.

Bidder must furnish a full time sales representative to handle all details of the order. This includes measuring and servicing, "after the sale". Bidder is to provide name, address and telephone number of representative or representatives who are to be responsible for handling the order.

In submitting your bid, specify the time required for delivery of the complete order after receipt of all details.

SAMPLES - Your bid, to be considered, is to be accompanied by a completed sample uniform in accordance to the exact specifications. Each bidder's interest in meeting these specifications is to be reflected in their willingness to manufacture this pilot sample and to make it available at the school prior to the time and date of the official bid opening. Please do not submit multiple samples, they will cause confusion and disqualification. District policy requires an exact sample, do not write or call to complain about this request. If the exact sample has any deviations from the specifications, please list them in detail on the deviation form. Any deviations found in the bidder's exact sample and not listed on the deviation form will be cause for disqualification. A bidder's sample will, also, be disqualified if deviations are found in the sample, and the word "none" is written on the deviation form. Exact samples are also required to ensure that the district can expedite this purchase soon after the award. The sample uniform provided is to be a male size 38 or 40 regular.

The buyer reserves the right to inspect the workmanship of the sample, its inner construction in particular, and for this purpose will open the lining if necessary.

CONSTRUCTION AND MANUFACTURING SPECIFICATIONS

A. GENERAL

Coats, trousers, blouses and all major parts of the uniform shall fit the nearest stock size from the information supplied by the company representative. This provides a better year to year fitting program and allows fitting flexibility. Exceptions on unusual sizes wherein the garment is cut and produced to the measurements taken by the company representative shall be made.

B. SHIPPING

Uniforms are to be shipped on wishbone style hangers. Hangers are to be hard plastic, not wood. Wooden hangers have a tendency to pick and pull the basic fabric, and they are not acceptable. The hangers must be bent and rounded at the top to allow the shoulder area of the garment to be spread and hung properly. Each uniform is to be delivered in its own clear polyethylene bag to prevent soiling. Uniforms must be delivered in 200 lb. Test cardboard wardrobe containers, opening from the front, and having a metal bar reinforcement at the top with clasp to prevent hangers from disengaging from the metal structure. Each carton will be properly marked on the outside with the identification numbers of the uniforms contained in that specific carton.

C. IDENTIFICATION

Each major garment item is to have identification numbers sewn into the individual pieces to allow for quick and easy issuing. Coats, trousers, and blouses are to have numbers and barcodes included. Trousers are to include inseam and waist information for future reference; coats shall have chest size and length indicated on a linen ticket. The original order is to include a bound booklet with the numbers of each uniform corresponding to the particular size of uniform, arranged from the smallest to the largest. Size information shall include chest size, height, weight, and inseam for each uniform. Bound in the identification record shall be a size chart for use as reference for purchase of future uniforms.

D. INSPECTION

All garments are to be carefully inspected before final packing and shipment. All thread ends to be picked and cut and specifications, trim and details to be critically checked for each individual garment before shipment. Buttons to be applied and sewn at that time.

E. WARRANTY

Uniforms and accessories shall include a lifetime warranty.

F. 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.

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:

- a. 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.
- b. London cold-water sponged and live steam shrunk, meeting United States Standard Shrinkage Specifications of not more than 1%.
- c. 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.
- d. 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.

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.

POLYESTER MATERIALS: 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.

- G. *COAT SPECIFICATIONS*
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 ensure 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.

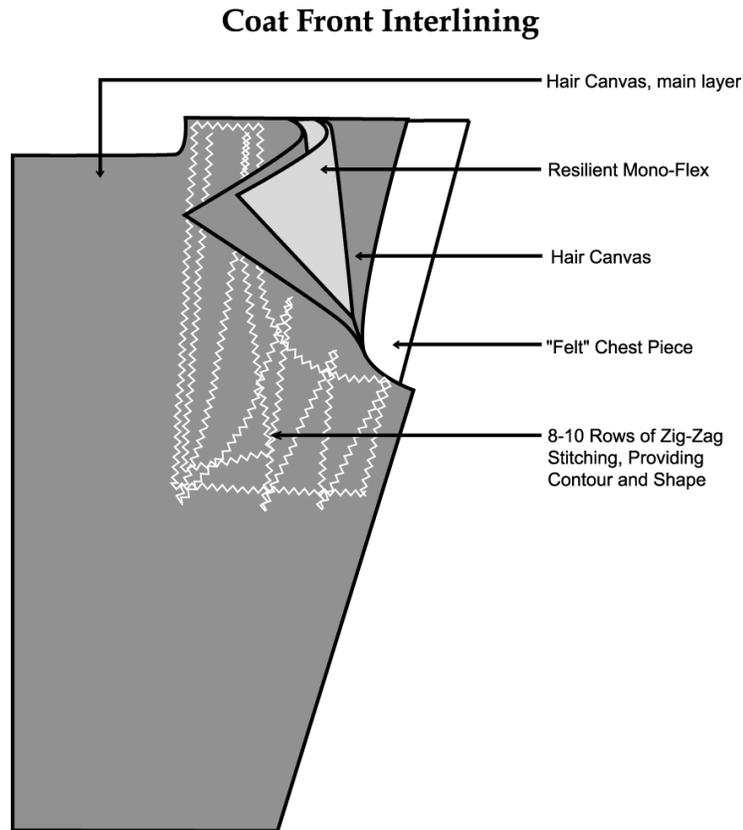
NOTE: “Patterned” linings of mens fashions fabrics are not durable in the heavy duty uniform usage.

- 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. 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).



- 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 or loss of rigidity. The layer extends the complete length of the coat front, from shoulder seam down to the coat bottom.

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- 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 ¾” 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 ¼” 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 ¼” apart. This section shall be hand shaped and a ¾” cotton bridle tape shall be applied by two rows of blind stitch to insure body contour, permanent lapel shape and reinforcement to prevent stretching.

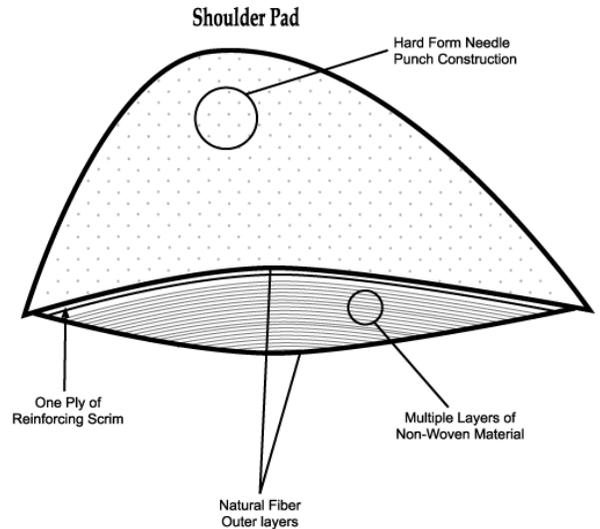
NOTE: The above construction is a time proven, traditional procedure. Under no circumstances are the haircloth and sewing operations to be substituted with a fusing or gluing operation. Certain areas of the coat should have a small reinforcement piece of pellon fused to the outer fabric. These will be 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.

6. 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.

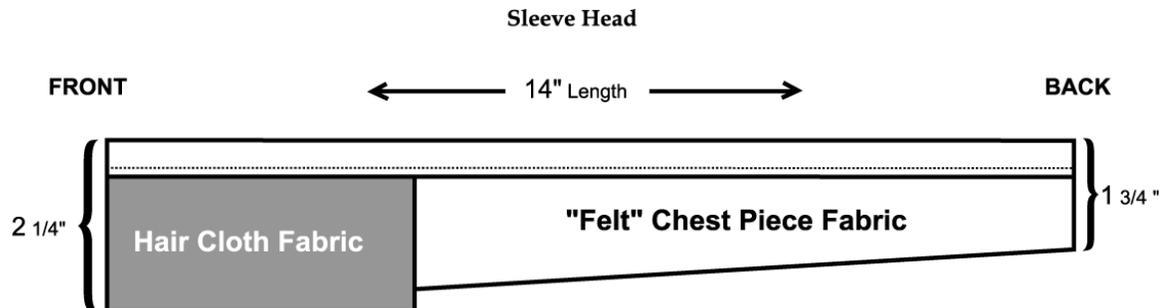
- c. Shoulder pads are a "hardform" construction, consisting of several layers of non-woven material. The layers are permanently attached together with a "needlepunch" process. Among the layers, near the top side, is a reinforcing ply of scrim, which adds dimensional stability to the assembly. A final 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.

7. 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.



8. 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 ¼” 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.

9. 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

10. SLEEVE STITCHING

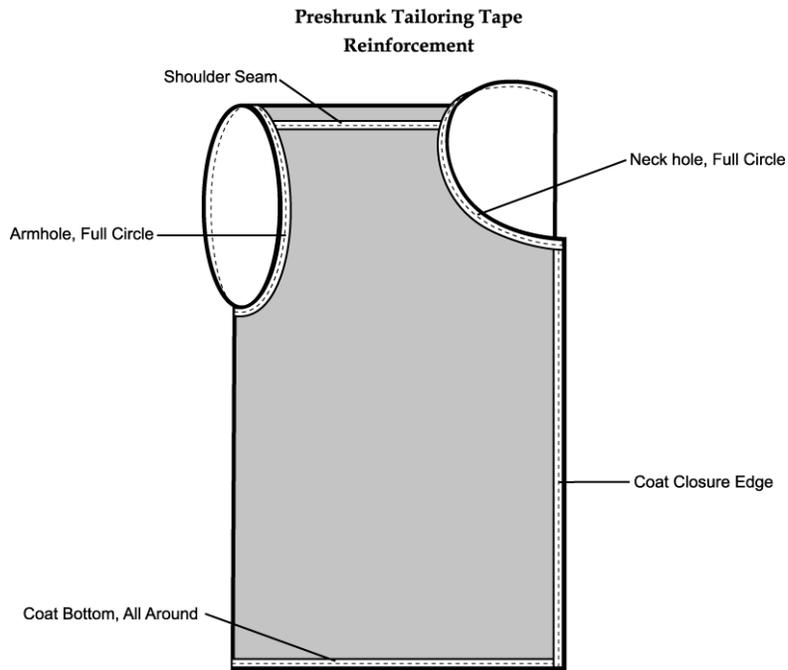
- a. Sleeves shall be set with machine lock stitch to insure proper distribution of fullness and durability.
- b. Fullness shall be sheered in by top-feed sewing machines.

11. 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.

12. 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.



13. SLEEVE CUFF TURN UP

- a. Sleeves 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.

14. SLEEVE CUFFS

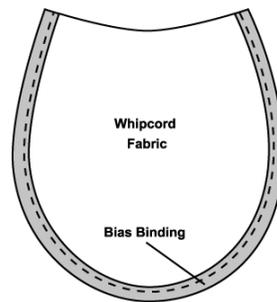
- a. Sleeve cuffs without trim in the cuff area are reinforced with a 5” width of non-woven material, bonded permanently to the inside of the coat fabric. As the sleeve is then turned back to form the let-out feature, this non-woven layer is equally divided to finish 2 ½” in the outside cuff edge, and 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.

15. 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.



16. 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).



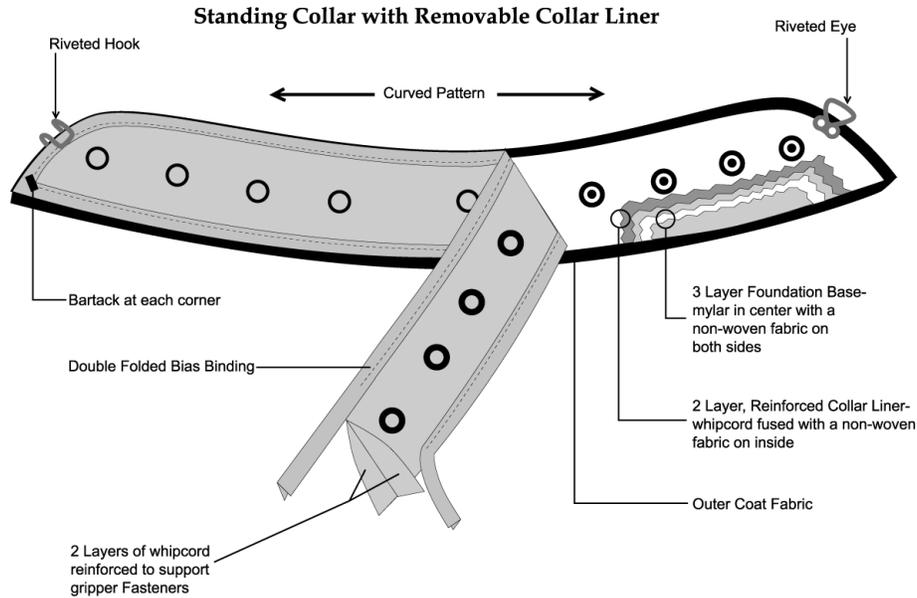
17. STANDING HARD COLLAR

- 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.



18. 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.

19. "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.

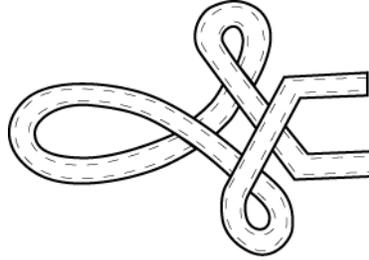


20. SOFT COLLAR

- a. Soft collar lapel coats shall have $\frac{3}{4}$ " 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 $\frac{1}{2}$ " 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 $\frac{1}{4}$ " 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 $\frac{1}{8}$ " from edges as with welt pockets and pocket flaps.

21. 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 $\frac{1}{4}$ " 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.



22. 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.

23. SEAMS

The center back seam and side body seams shall be 5/8”. Seams are to be plain with a minimum of 1 ½” total outlet in the side body seams and ¾” 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 ¼”. Thread breaks of all stitch types must be secured by stitching back from break ½” 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.

24. 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.

25. BRAID (see #21-B)

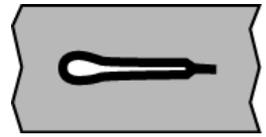
Only first quality braid shall be used for trim. Braid trim ¼” or wider, is sewn down with two rows of stitching on looped trims as well as straight line. In addition, looped trim is reinforced with a layer of non-woven fabric, permanently bonded to the inside coat fabric surface to inhibit puckering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

26. BUTTONS

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

27. 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.



28. 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.

H. 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.

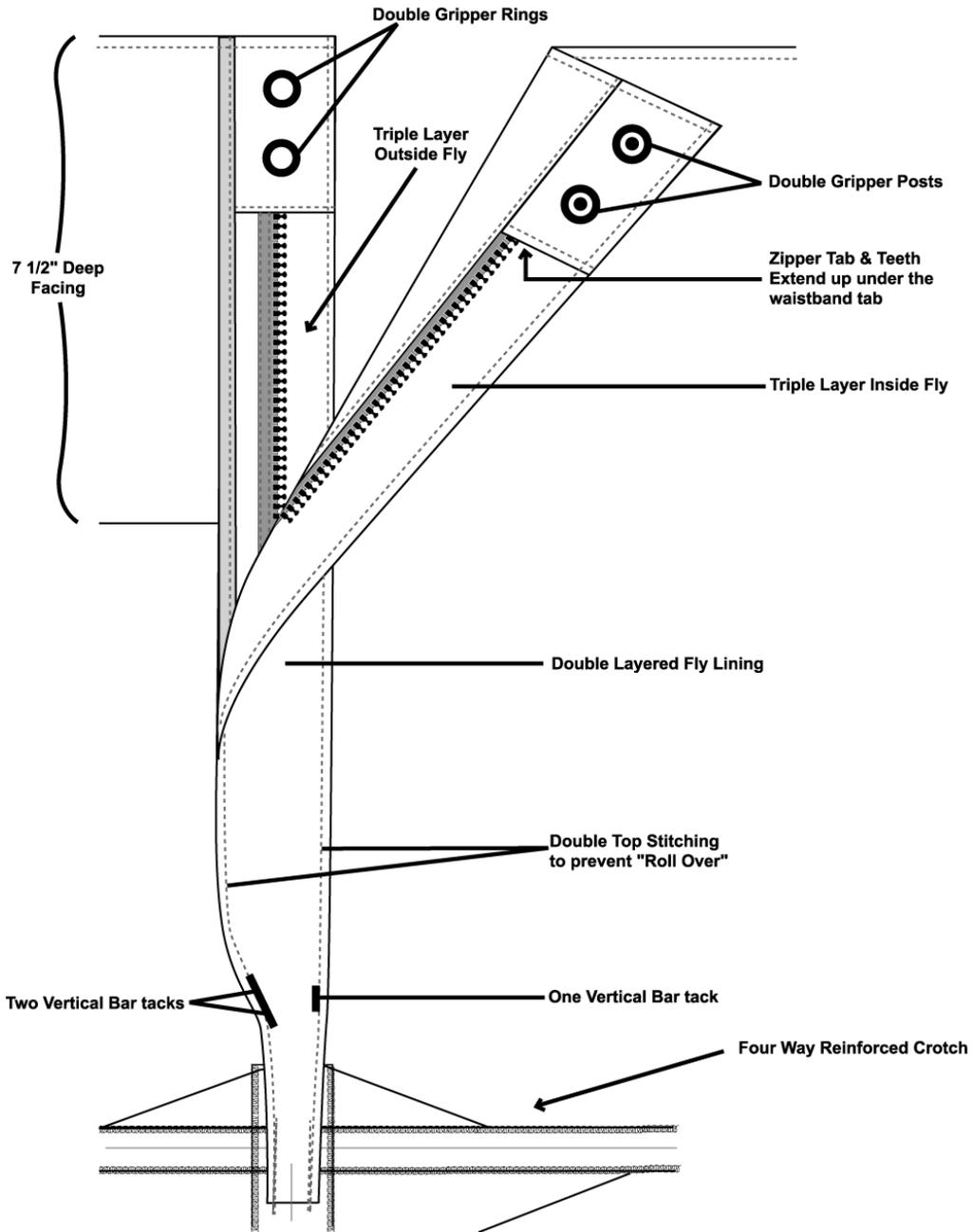
3. FRONT CLOSURE

- 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

- a. 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.

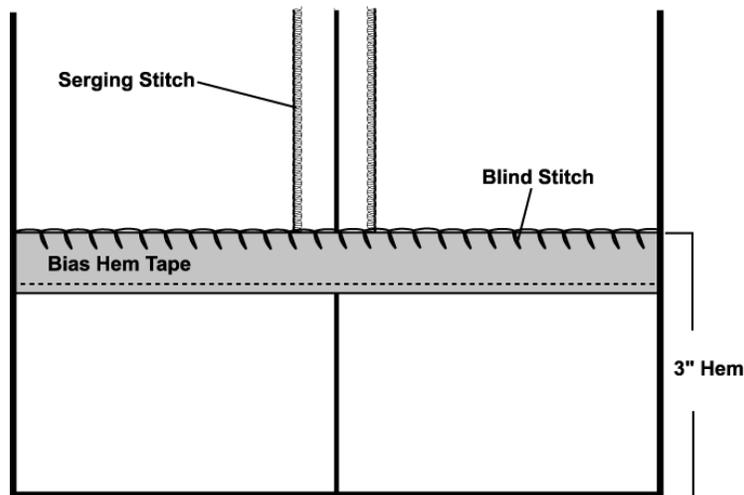
- b. There are four, two ply sections, one on each side of the intersection of the fly, seat seam and inseams.
- c. Crotch area is clean finished with no pieces extending from top of inseams.

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”

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

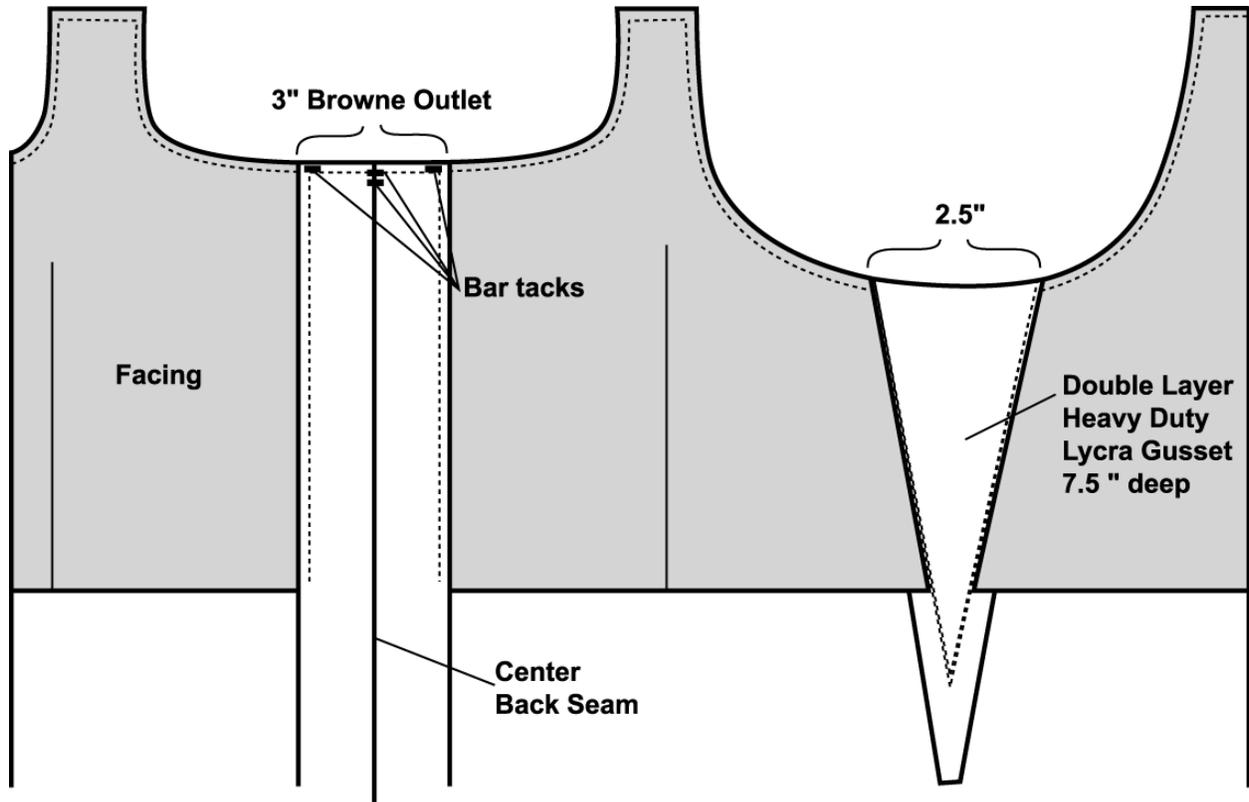
- a. Suspenders are made of whipcord fabric. Color shall match jumpsuits/bibbers. Nylon webbing shall not be used because the adjusting slide will not remain in set position under tension from movement.
- b. Suspenders are two-ply, topstitched, and have interlining for body. This will insure the adjustable 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 pellow.

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, 2½” 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 manufacturers 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 ½" Deep
Underarm	5" Deep
Back Shoulder Strap Extension	11" Deep
Front Shoulder Strap Extension	9" Deep

I. SHAKO CONSTRUCTION SPECIFICATIONS

1. GENERAL

It is important that the shakos be made by the manufacturer of the uniforms. This will insure that all the manufacturer's quality control practices will be followed. The practices include (but are not limited to), workmanship consistent with uniform, fabric matching, and timely delivery.

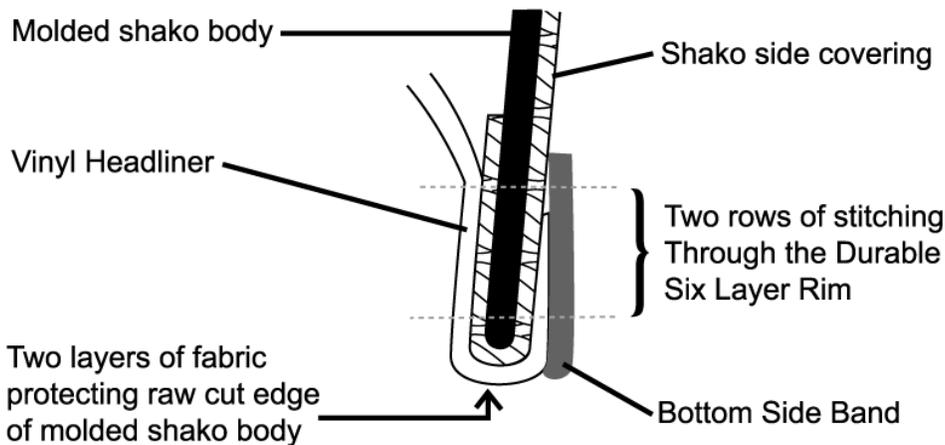
2. BODY

- a. Shako body is vacuum-formed high impact styrene .135” gauge white plastic and has high rubber content to prevent cracking. Body is pliable and flexible to conform to wearer’s head, in an “oval” shape, rather than circular or round.
- b. There is a separate shell size for each head size.
- c. Each hat has a clear ident-a-peek pocket in the inside top with the size imprinted in ¼” letters for ease of issue. Each ident-a-peek contains a card to identify the wearer. A size sticker is also applied to the inside top.

3. COVERING

- a. The fabric side covering is pulled down to the bottom edge of the shako body, then turned back 1 ½” up inside the shell. Two rows of stitching secures the side covering to the molded shell. One row is polycore poly wrap thread, lock stitched. The second row is Telex 135 poly tex thread, also lock stitched. 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 TURNBACK and VINYL HEADLINER TURNBACK.

Shako Cross Section

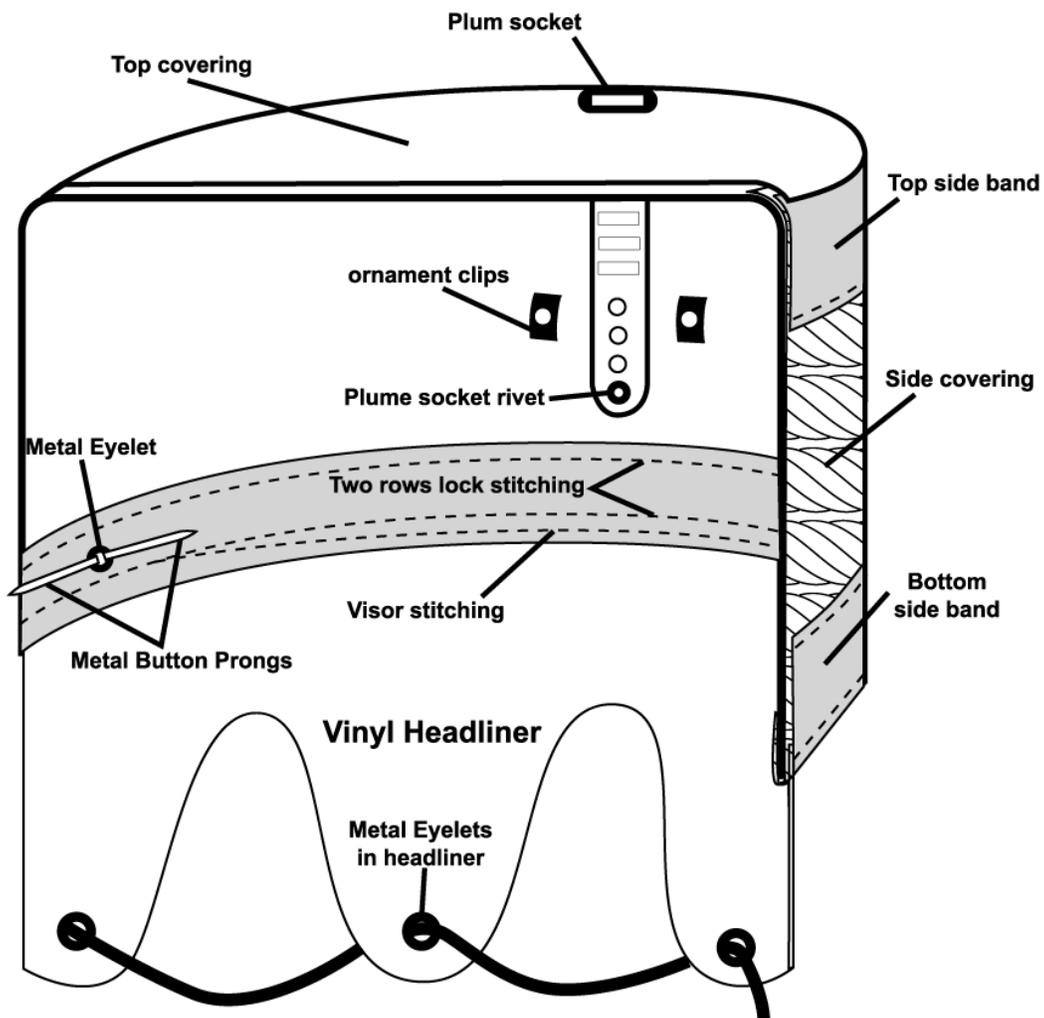


4. HEADLINER AND SPECIAL FEATURES

- a. Headliner shall be cotton 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 a lockstitch in such a manner to allow for adjustability.

- 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. There is a metal eyelet on each side of the hat body where the button prong passes through plastic.
- e. High density polyethylene plume sockets are included and riveted to the body.
- f. A metal spacer is used to affix the front chain to each side button.

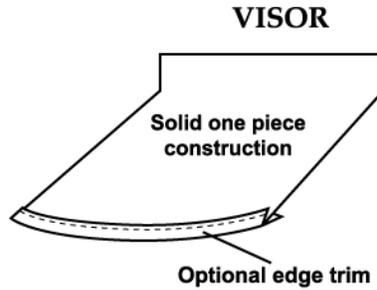
Shako Construction



5. VISOR

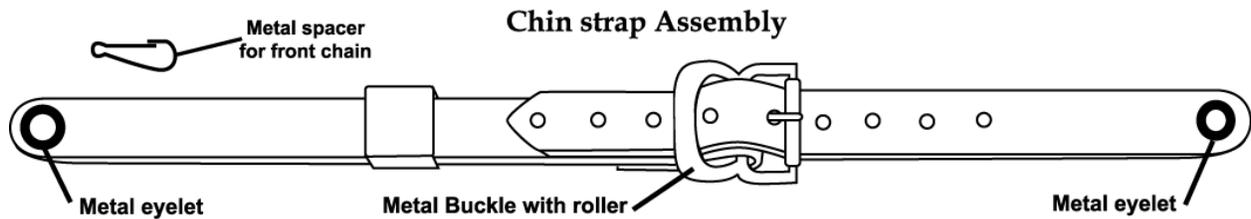
- a. Visor is non-breakable one-piece plastic, not laminated. It is secured to the shako body with lock-stitch safety sewing.

- b. Visor color is molded through entire body of visor. The material is an engineering grade copolymer with low-temperature toughness, stain proof, fade and discoloration proof, impervious to ultraviolet light (sunlight).



6. CHINSTRAP

- a. Chinstrap is $\frac{3}{4}$ " pliable plastic with metal buckle and roller, and has a $\frac{1}{2}$ " keeper.
- b. There are metal eyelets at chinstrap ends where button attaches (to prevent strap from being torn by button shank).
- 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 face plate. Side buttons are metal with spread prongs. Plastic buttons are not acceptable.

UNIFORM DESIGN SPECIFICATIONS

COAT:

FABRIC: Nightscape Navy and Divine White
100% Synthetic Xtreme Dri Fabric

STYLE: Full construction waist length coat that has a special notched front and back cut straight.

CLOSURE: Full length butted back YKK heavy duty Vislon zipper in navy that zips down.

MIRROR ATTACHMENT: Velcro set on left chest.

SPECIAL DETAILS: Athletic fit patterning. Fully constructed coat that allows the coat to be professionally laundered/machine washed or professionally dry cleaned. The coat has performance-wear "Aerocool" lining for maximum breathability and comfort for the wearer. "Aerocool" lining is woven to absorb and evaporate moisture rapidly by capillary effect. The absorption, diffusion and evaporation system of this lining is designed to maintain cool body temperature and excellent comfort for the wearer. The coat also utilizes performance-wear canvas that is fully machine-washable. The coat has snap tape (***manufactured in-house for quality control***) at the cuffs to allow for adjustable hems without the necessity of sewing. The sleeves are a special pattern that allow freedom of movement for the wearer. There are special pre-molded (3/4" thick) firm foam shoulder pads with nylon tricot covering measuring 5" wide x 9" long at each shoulder. The "Comfort Collar" utilizes eight layers of construction. The collar lining is Xtreme Dri fabric and has a non-woven material, permanently sewn and bonded to the inside. It is sewn directly to the inboard surface of this tandem collar lining construction, centered on the lining and running the circumference of the collar are two layers of 1/2" horse-hair braid reinforcement. The outer collar shell, also made of Xtreme Dri, has a non-woven material permanently sewn and bonded to the inside. Both the collar lining construction and the outer collar shell construction are sewn to two base layers of heavy duty Pellon forming the finished comfort collar. Each coat has an identification number, as well as a barcode. ***Special welted opening in coat lining that allows access for button removal/replacement.***

FRONT TRIM: Special sublimated custom design of navy, gold, white and blue. Set on each shoulder will be a 4" stripe of Xtreme Dri Divine White that matches up with the sleeve stripe. Set on lower left front will be three 24L Gilt Dome regular shank buttons. Buttons are attached with a disc and ring method. These buttons can be accessed from the welted opening in the coat lining. Set on upper portion there will be a vertical stripe of Midnight Navy Stan Twill extending from bottom of right collar running into insert seam. There will be a second vertical stripe of Midnight Navy Stan Twill set on lower left portion of coat-extending from the insert seam and running off coat bottom to be cut at an angle.

BACK TRIM: Nightscape Navy with no trim. Butted zipper in navy nylon that initiates in the collar to avoid the need for a hook and eye to close the collar.

COMFORT COLLAR: Right side of collar is Divine White and left side of collar is Midnight Navy Stan Twill. Collar lining is Nightscape Navy. Special fold over style with left side having a slightly smaller fold over than the right. Set on the left fold over is one 30L Gilt Dome tack back button.

SHOULDER STRAPS: None.

SLEEVES: 50/50 patterned sleeves of Nightscape Navy. There is a wide stripe of Divine White material set on top of sleeve to match the stripe at the shoulders.

DESIGN SPECIFICATIONS

JUMPSUIT:

**FOR: Norwin High School
Irwin, PA**

FABRIC: Nightscape Navy 100% Synthetic Xtreme Dri Fabric

STRIPE: None

SPECIAL FEATURES AND DETAILS: Special Racer Back style with athletic fit pattern. Identification numbers and barcode. 1 ¼" shoulder straps of matching jumpsuit fabric with nylon slides and black elastic in back of suspenders for wearer's comfort. Inseam sewn with 5/8" seams for let out. 4-way reinforced crotch. 3" let-out in center back. Snap tape is on back of seam allowance on the out seam and it is on the front side of the seam allowance on the inseam. Stitched permanent crease. Welted pocket on right front.

ACCESSORIES:

GAUNTLET CUFFS: Both cuffs to be Xtreme Dri Divine White with self-lining. The outer layer is fused and there is a non-fusible interlining to give support. One 30L Gilt Dome tack back button set on point of each cuff. Regular Velcro closure. "L" shaped Velcro not acceptable. Special gusset of matching fabric on each opening edge to prevent the Velcro from contacting the coat sleeve.

SHAKO WRAP: The right is Midnight Navy Stan Twill with the left being a custom sublimated design on Xtreme Dri Divine White. The back is 4" wide black elastic. Vertical splits approximately at each side button. Lap left over right and then stitched down. Wrap will extend upward from left vertical split and will stand approximately 4" taller than the shako at the tallest point. The entire shako wrap is lined with Xtreme Dri Nightscape Navy. Set on center right portion will be a stripe of Midnight Navy Stan Twill. Set on left edge of stripe will be three 24L Gilt Dome tack back.

SHAKO: Flat top design with plume holder center front that is reinforced with a screw post and nut. Navy visor. The entire shako is Nautical Navy Grained Vinyl. Clear plastic chinstrap with gold buckle. Front strap of Xtreme Dri Nightscape Navy – grommet at each end of strap. Separating 45L Gilt Dome prong back buttons in gold at each lower side. There is a metal hook in the back of the shako for the chinstrap to rest on. There will be a clear pocket for the size and identification of each shako. The cord inside the shako for adjustability does not tie but has a special cord lock for ease of use and added security.

MIRROR: Custom multi-color layered shield design with school logo and Velcro.

PLUME: 14-inch White French Upright. Gilt cup.

GARMENT BAG: 200 Denier nylon garment bag with heavy-duty vertical zipper with reinforced zipper stop. Heavy-duty zippered utility/accessory pocket in back. Clear viewing window for identification purposes. Top opening for hanger. Double needle stitching throughout. Metal

grommet reinforced air vent. Handles at top and bottom of bag to carry as a fold over bag. One-color screen imprint included.

RAINCOAT: Navy Blue 400 Denier Nylon. Navy Blue 400 Denier Nylon Hood. Black Hood Zipper. Gold left chest imprint, Gold hood imprint. Thinsulate lining in coat. Pockets have thinsulate lining. Snaps are navy blue. Sleeve hem is top stitched. Shoulder seams are sealed.

SHAKO BOX: Shako-Mate style in black high impact polystyrene.

HANGER: Black plastic wishbone style to be included with each uniform.

UNIFORM MANGEMENT SYSTEM: A UMS system that is “cloud” or “web” based and is accessible with any desktop or laptop computer or any handheld device wherever an internet connection is available. It easily assigns uniforms based on just a few measurements or pieces of information. It is easily accessible with login and password that can be adjusted and changed by the user. The UMS system is free of any yearly charges or fees.

DIGITAL PARADE BANNER: 3' X 8' custom printed parade banner with tunnel loop at top and bottom for banner carrier frame. Banner will have custom artwork prepared for approval and a mini-banner sent for approval of colors prior to printing full size banner.

Each bidder will submit exact samples of all items requested for immediate evaluation

CERTIFICATION OF FABRIC

This is to confirm that bidder is to use first quality goods. The material supplied, depending upon specifications, is to be 14 - 14 1/2 oz., 55% Dacron/45% Wool and/or 15 1/2 - 16 oz., 100% Wool.

All materials are to be supplied directly from the manufacturer, and are not to be, in any way, seconds or rejected goods. A certified Kaumagraph label is to be on the inside of all garments.

Bidder _____

Signature _____

Corporate Officer

CERTIFICATION OF PROOF OF
FABRIC STABILIZATION

This is to confirm that bidder is to have any and all Dacron/Wool blend fabric stabilized, pre-shrunk, and decated. This treatment is necessary to prevent excess shrinkage and to improve the lustre, hand, and finish of the fabric. Upon completing such a process, shrinkage is to be well within industry tolerance.

All firms used for fabric stabilization of Dacron/Wool or all wool fabrics shall be named below and identified by name, address, phone number, and contact person.

Bidder_____

Signature_____

Corporate Officer

DEVIATION FORM

In the event that the undersigned Bidder intends to deviate from the specifications by utilizing any materials, items, treatments, finishes, inner construction, tailoring details, etc., contrary to those listed as standards in the specifications, the bidder is to fully document and list each deviation in complete detail including reasons for the deviation. General statements are not acceptable. Furthermore, these deviations are to be approved in writing.

If no deviations are submitted, the bidder assures the buyer of full compliance with the specifications and conditions, and assures the buyer that samples accompanying bid meet all construction specifications.

If deviations are found on said sample, and not listed, the bidder is to be disqualified!

Company _____
Signed _____
Title _____
Date _____

BID FORM

The bidder certifies he has familiarized himself with your specifications, has carefully read them and understands their contents. Any uniforms furnished by us will be in the style and quality requested.

<u>Quantity</u>	<u>Item</u>	<u>Unit Price</u>	<u>Total Price</u>
160	Band Coats		
160	Band Bibbers		
160	Shako/Shako Wrap		
160	Garment Bags		
160	Hat Boxes		
160	Gauntlet Pairs		
160	Plumes		
170	Raincoats		

TERMS:

If awarded the contract, the undersigned agrees to ship the entire order within _____ calendar days after approval of the sample and receipt of necessary details and all measurements.

Date: