

7. **Manufacturing/ Stitching Guidelines**

a. **Shirt Men's Multicam Pixilate.**

- (1) The shirt Multicam Pixilate shall be made from the material given at **Anx 'A'** and other details as shown in separate drawing at **Anx 'B'**.
- (2) The measurement of shirt shall be as per **Appendix-I & Appendix -III** to this tech data.
- (3) One piece back without yoke, with Round Collar without lapel cut.
- (4) Shoulder of the CCD Shirt are designed as plain/ without shoulder straps.
- (5) **Name Plate.** 02 x Velcro Dark Khaki Male/Female having dimension (14 cm x 2.5 cm). Each Velcro shall be stitched 1 cm above the chest pocket on each side, straight/ without tilt as per approved sample/ drawing.
- (6) **Command Badge and Insignia.** Position of command badge and insignia as per approved sample/ drawing.
- (7) **Chest Pockets.** 02 x diagonal chest pockets (01 x left side and 01 x right side) without flaps. Side puttee of self-material concealing the zipper (Zipper of Chest pocket without braided cord). Zip shall be closed to upward direction. Pockets and side puttee shall be stitched with single stitching as per approved sample and drawing.
- (8) **Rank Tab**
 - (a) **For Male.** 1 x Velcro will be stitched on front facing puttee as its **upper** edge almost touching of **1st** Button of chest opening as per approved sample.

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- (b) **For Female.** 1 x Velcro will be stitched on front facing puttee as its upper edge almost touching the fold of collar opening and closer to the neck as per approved sample.

(9) **Buttons**

- (a) The shirt shall be made with an open front facing with 4 x concealed button/ buttons hole equidistantly placed at **110mm.**
- (b) Front puttee shall have concealed button/ buttons hole. Button hole shall be provided at left side, underneath the shirt separately stitched facing of self-material as shown in the drawing.
- (c) Button shall be provided corresponding the button holes on right side facing at the place indicated in the separate drawing. All raw edges will be secured with overlocking. Separately stitched facing shall be tacked at four places.
- (d) One extra Buttons should be stitched on bottom at button take puttee at the place indicated in separate drawing.
- (e) The Buttons when stitched with sewing machine there shall be not less than total 18 stitches, 9 each way when sewn by hand there shall be not less a total 6 stitches i.e. 3 each way of double thread.
- (f) Button hole shall be made by machine only. The number of stitches per 2.5 cm shall not be less than 25.

(10) **Arm Sleeves**

- (a) **On Left Arm Sleeve.** 01 x Arm Pocket stitched diagonally fastened with plastic zipper as per approved sample. Zip closed towards shoulder direction. 02 x Female Velcro shall be stitched on arm pocket, 01 x female Velcro for attachment of Pakistan Flag 4 cm and 01 x female Velcro for attachment of formation sign as shown in separate drawing. Pen slots (for 02 x pen) and elbow patch shall be stitched as per approved sample/ drawing.

- (b) **On Right Arm Sleeve.** 01 x Arm Pocket stitched diagonally fastened with plastic zip as per approved sample. Zip closed towards shoulder direction. Elbow patch shall be stitched as per approved sample/ drawing. Both left/ right arm sleeves having cuff with pointed strap at end with self-material.
- (c) **Cuff.** Velcro tape (male/female) stitched for cuff adjustment instead of button. The cuff/ strap shall be made of self-material without fuse buckram as per approved sample / drg.

(11) Seam/ Stitching

- (a) The shirt shall be assembled with machine using sewing thread polyester Dark Khaki 2/31.5 Tex regulated not less than 9 stitches not more than 11 stitches per 2.5 cm. All the stitching shall be of even tension throughout and loose ends shall be securely fastened off.
- (b) The shirt shall be finished with lap seam at arm hole, sleeve and side of the body by double rows of machine stitching 0.6cm apart. The dimension of arm hole should be corresponding to respective chest measurement and 1.5 cm loose.
- (c) All seems and loose ends should be secured by over locking by using Sewing Thread Polyester 3/12.59 Tex Dark Khaki.
- (d) Bottom of shirt shall be open (without hem) for adjustment of length

- (12) Vents.** 2 x under each arm hole and 2 x vents inside the left and right pleats stitched at back. The internal dia of ventilators should be 5mm finished and should be machine made by using Sewing Thread Polyester 2/ 31.5 Tex Dark Khaki.

- (13) Each Shirt shall be properly presses by ironing after final inspection.

b. **Trouser Men's Multicam Pixilate**

(1) The Trouser Multicam Pixilate shall be made from material given in **Anx 'A'** and shape, design and other details as shown in separate drawing as **Anx 'C'**.

(2) The measurement of Trouser shall be as per **Appendix-II & Appendix -IV** attached to this tech data.

(3) **Waist Band**

(a) Waist band of body material shall be provided as per approved sample.

(b) Double loops (07 x inner loops – 6.5 cm long for smart belt and 03 x outer loops, same as that of existing uniform for Belt Waist Ribbed Pattern) has been provided as shown in the drawing.

(c) An in lay margin of 38 mm at waist tapered down to 13 mm at the crutch is to be provided at seat seams for possible alteration. Side seam shall be of double stitching.

(4) **Front Fly.** Front fly with four button of 19 mm and button holes corresponding to button holes at waist should be provided as per drawing. Top button at waistband shall be open. Fly shall have lining of body materials.

(5) **Pockets**

(a) **Upper Pockets.** The trouser shall have two straight semi-circular opening as shown in approved sample / drawing.

(b) **Back Pockets.** The trouser shall have two back pockets as shown in approved sample / drawing.

(c) **Cargo Pockets.** The trouser shall have two semi diagonal (angular) type pockets (one at each thigh) having two reserve pleats. Each Cargo pocket have also rectangular flap and fabric puttee for button holes. 02 x Plastic buttons shall be stitched on each cargo pocket as shown in approved sample / drawing.

(d) **Patch at knee and Seat Patch.** Patch at knee and seat patch at hip as per dimensions and design as shown in approved sample / drawing.

(e) **Seam/ Stitching**

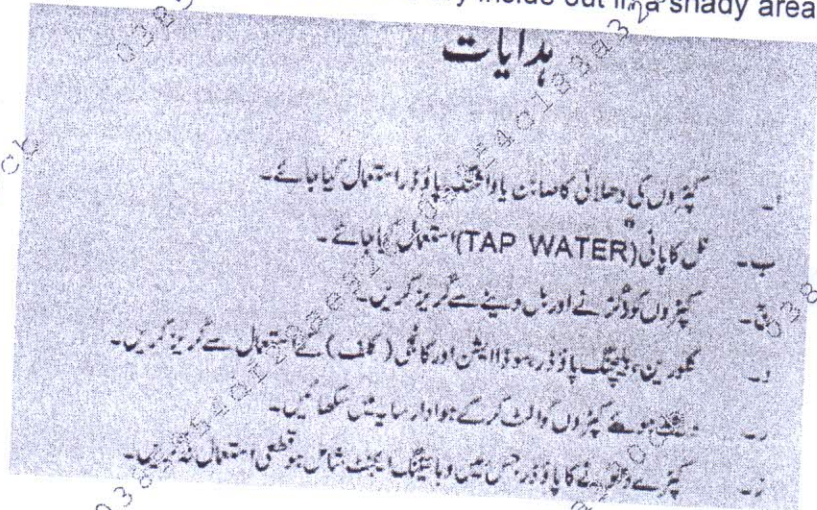
- i. The Trouser shall be assembled with machines stitching using sewing thread polyester Dark Khaki 2/31.5 Tex regulated at not less than 9 and more than 11 stitches per 25 mm. All stitches shall be of even tension through-out and loose/free ends and shall be securely fastened off.
- ii. Leg seam should be pressed open of double closet rows of seam having over-locked at end to secure raw edges. Back seam shall have double closet row of stitching and pressed open on ends should be over-locked.
- iii. Bottom of trouser shall be open (without hem) for adjustment of length. However, tying cord with every trouser shall be provided with each pair.

(6) Each Trouser shall be properly pressed by ironing after final inspection.

c. **Washing/ Care Instruction**. Washing instr label shall be stitched as well as additional leaflet with care/ washing instruction shall be provided with each uniform. Detail of washing instructions are as under:-

- (1) Washing powder or soap should be used. Avoid use of detergent containing whitening agent and OBA (optical brightening agent).
- (2) Avoid use of Chlorine, Bleaching Powder and Soda Ash.
- (3) Tap water should be used.
- (4) Do not wrench and rub the cloth during washing.
- (5) Machine-wash with gentle cycle at 60°C.
- (6) Dry at low heat (not over 75°C), if dryer is used.

(7) Avoid long exposure to sun It and dry inside out in a shady area.



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Workmanship and Finish

- a. Workmanship and finish shall be equivalent to the approved sample. It shall be the best of its class and to the entire satisfaction of Inspector.
- b. CCD Uniform shall conform to approved sample in respect of all properties and qualities not defined in this technical data.

9. **Tests.** Stores / materials during manufacturing and after delivery shall be tested and examined, as and when Inspector considers it necessary in order to determine whether, they conform to this technical data or otherwise.

Inspection and Rejection

- a. All stores supplied shall comply with the terms of this tech data and shall in all respects be to the satisfaction of Inspector.
- b. The dyed cloth shall be examined to ensure correctness of materials, evenness of dye, shade, width, length and other qualitative and quantitative parameters given in tech data.
- c. The supplier shall carryout 100% check of the cloth to be tendered for inspection and shall ensure that all defective cloth is eliminated from the tendered cloth and that cloth offered for inspection are strictly in accordance with tech data. The tendered cloth shall be liable to rejection if failing to comply with requirements of this tech data.
- d. Sampling shall be carried out by the Inspection Authority / Inspecting Officer in such a manner that samples taken are true representative of the manufacturing / processing stage and quality of cloth under inspection.
- e. Each sample shall be taken from a different piece and shall be cut at least three meters away from either end. It shall be large enough to provide material for all the tests required by this tech data and shall be identified with piece or lot from which it is taken.
- f. Each piece shall be inspected for:-
 - (1) Shade which should conforms to respective standard shade.
 - (2) Dyeing defects.
 - (3) All loose threads, snarls and prominent slubs.
 - (4) Gen appearance with particular reference to nippiness, kitty and missing ends / picks.

- (5) Length, width, ends and picks.
- g. On examination, if any sample from any portion of a consignment and packing found NOT fully in accordance with this tech data, the whole supply may be rejected.
- h. On examination of 20% of any delivery, if 20% of examined store including packing material are found NOT conforming to this tech data in respect of pattern, dimensions, workmanship and finish, the whole consignment may be rejected.
- i. All stores and packing NOT fully in accordance with this tech data shall be rejected.

11. **Marking**

- a. **Marking of Store.** Each item shall be clearly and indelibly marked with nomenclature, Cat / Part no, Firm's name, recognized trade mark, Contract no and date, year of manufacturing, Challan no and date, actual length of piece in meters, number of flags, free cutting allowance per piece claimed in meters and Inspector Acceptance Mark.

Marking of Carton. Marking on cartons will be stenciled with quick drying black indelible ink paint in clearly defined characters as under:-

(1) **On Front and Top**

- (a) Cat part no and designation of the store packed.
- (b) Quantity of the item packed.

(2) **On Back**

- (a) Consignee address.
- (b) Destination i.e. railway station.
- (c) Weight of the package.
- (d) No of individual packages and total no of packages in the consignment joined by the word 'of' e.g 1 of 100.

(3) **On End**

- (a) Consignor's name.
- (b) Voucher no or Inspection Note no.
- (c) Date, month and year of packing.

121 **Packing.** Quality of packing shall be examined / tested, as the Inspector considers necessary in order to determine whether they conform to this tech data or otherwise.