

A-A-1203B
March 21, 1986
SUPERSEDING
A-A-1203A
October 25, 1985

COMMERCIAL ITEM DESCRIPTION

LAPPING AND GRINDING COMPOUND (VALVE)

The General Services Administration has authorized the use of this commercial item description.

This commercial item description covers water- and grease-mixed valve grinding compound containing silicon carbide abrasive grain.

Salient characteristics:

The compound shall be of the following types and grit sizes, as specified.

Type I - Grease-mixed
Type II - Water-mixed

Grit 100 - Coarse, for chromium-cobalt valve seats
Grit 120 - Coarse, for fast valve grinding
Grit 150 - Special medium coarse
Grit 180 - Medium coarse
Grit 220 - Medium
Grit 240 - Fine for chrome-cobalt valve seats
Grit 280 - Fine for finish valve grinding, lapping cylinders and lapping rings into cylinders
Grit 400 - Extra fine, special purpose for fine lapping, polishing, and fitting of parts
Grit 500 - Extra fine
Grit 600 - Extra fine
Grit 800 - Extra fine
Grit 1000 - Extra fine
Grit 1200 - Extra fine

The compound shall be composed essentially of silicon carbide, boron carbide, or aluminum oxide abrasive grain and shall be graded in accordance with the requirements of ANSI B74.12 through grit size 240. For grit sizes over 240, the grading shall be in accordance with ANSI B74.10.

The vehicle of the Type I compound shall be cup grease or mineral oil with a lard oil.

The vehicle of the water-mixed Type II compound shall be starch or other material which in combination with the preservative and water will produce a soft cohesive paste, free from "stringiness".

The compound shall comply with the fineness requirements specified in ANSI Standards B74.12 for grit sizes through 240 and B74.10 for grit sizes over 240.

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Workmanship. The lapping and grinding compound shall have no defects which will affect its use and serviceability.

The issues of ANSI Standards B74.10 and B74.12 in effect on the date of the solicitation shall be used to determine compliance with these requirements.

Preservation, packaging, packing, labeling, and marking. The preservation, packaging, packing, labeling, and marking shall be as specified in the contract or order.

Notes.

Purchaser should specify type and grit size.

ANSI Standards are available from the American National Standards Institute Inc., 1430 Broadway, New York, NY 10018.

When this commercial item description is used for procurement, the commercial item certification clause must appear in the solicitation.

NSN's are as follows:

Type I		Type II	
NSN	Grit size	NSN	Grit size
120	5350-00-193-7227 (1 lb)	100	5350-00-576-1689
120	5350-00-271-5966 (4 oz)	120	5350-00-224-6693
150	5350-00-193-1340	240	5350-00-576-1687
220	5350-00-193-1341	280	5350-00-224-6692
240	5350-00-579-2513	800	5350-00-927-3867
400	5350-00-193-1348		
500	5350-00-193-1349		

Custodian

GSA - FSS

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