

A-A-1808A
 December 5, 1985
 SUPERSEDING
 A-A-1808
 February 27, 1981

COMMERCIAL ITEM DESCRIPTION

FLATWARE - SILVERPLATE

The General Services Administration has authorized the use of this commercial item description in preference to type II of Federal Specification RR-T-51.

This commercial item description (CID) covers silverplated flatware equal in quality to a grade known within the industry as "high-quality hotel and restaurant" silverplate. The design of the flatware is commercially known as the "Kings" pattern, and shall be the manufacturer's current, standard commercial product, except for changes necessary to comply with this CID. The items covered by this CID are intended for use in officers' and executives' messes and dining rooms.

The flatware shall be of the following items; see notes for ordering data.

Items: 1 - Fork, dessert	(figure 18)	8 - Spoon, demitasse	(figure 25)
2 - Fork, oyster	(figure 19)	9 - Spoon, dessert	(figure 26)
3 - Fork, salad	(figure 20)	10 - Spoon, iced tea	(figure 27)
4 - Fork, table	(figure 21)	11 - Spoon, soup	(figure 28)
5 - Knife, dessert	(figure 22)	12 - Spoon, sugar	(figure 29)
6 - Knife, table	(figure 23)	13 - Spoon, table	(figure 30)
7 - Spoon, bouillon	(figure 24)	14 - Spoon, tea	(figure 31)
	15 - Ladle, gravy, table		(figure 32)

Salient characteristics.

First article. When specified, see notes, the supplier shall furnish samples of the items to be procured under this commercial item description (CID) for the first article inspection, testing, and approval (see quality assurance provisions).

Materials. Materials not definitely specified shall be the type and quality supplied by the manufacturer as his "high-quality hotel and restaurant" silverplated flatware provided the completed items comply with all the provisions of this CID. Commercial tolerances are applicable to all material thicknesses and diameters.

Nickel brass sheet. Nickel brass sheet specified herein shall have a minimum of 8 percent by composition of nickel brass (also known as nickel silver) with the balance of copper and zinc in accordance with commercial practice.

Brass. Brass specified herein shall have a minimum of 65 percent copper with the balance of zinc.

A-A-1808A

Corrosion-resistant steel. Corrosion-resistant steel shall conform to either type 410, 429, 430, or the 440 series of ASTM A 176, latest revision. Type 302 or 304 steel shall be used for all hollow handles.

Design and construction. The design shall be the "Kings" pattern and shall be sharp and clearly defined. Figures 1 through 15 are to be used as a guide only. The scale on the figure is provided as a convenient means for approximating each item's size and proportions.

Base metal. Unless corrosion-resistant steel is specified (see notes), flatware, except knife blades, shall be fabricated from nickel brass or brass.

Weights of spoons and forks blanks. Minimum weights of blanks for the spoons and forks shall be as specified in table I.

TABLE I. Weight of blanks (minimum)
(Avdp. lbs. per gross)

Item	corrosion- resistant steel	brass / nickel brass
<u>Forks:</u>		
Dessert	16.0	17.0
Table	20.0	21.0
Oyster	7.0	8.0
Salad	10.0	11.0
<u>Spoons:</u>		
Bouillon	11.0	12.0
Demitasse	5.0	6.0
Dessert	19.0	20.0
Iced tea	10.0	11.0
Soup	19.0	20.0
Sugar	13.0	14.0
Table	29.0	30.0
Tea	11.0	12.0
Ladle, gravy	24.0	25.0

Silver plating. Silver plating weight and thickness values specified herein shall be determined in accordance with the Weight of silver test and the Thickness of silver test respectively.

Thickness of silver. The thickness of silver applied to each item shall represent an average thickness of at least 400 microns or 0.33 troy ounce per square foot

Weight of silver. The minimum weight of silver shall be as specified in Table II.

A-A-1808A

TABLE II. Weight of silver

Item	Minimum Req'd. wt. of silver troy oz/gross
<u>Forks:</u>	
Dessert	3.9
Table	4.6
Oyster	1.35
Salad	2.45
<u>Knives:</u>	
Dessert, hollow handle (handle only)	5.13
Table, hollow handle (handle only)	5.13
<u>Spoons:</u>	
Bouillon	4.1
Demitasse	1.14
Dessert	3.8
Iced tea	2.2
Soup	3.8
Sugar	3.1
Table	4.75
Tea	2.8
Ladle, gravy	6.2

Adhesion. When tested, the silver plating shall show no evidence of blistering.

Knife blades. The blades of knives shall be fabricated from corrosion-resistant steel. Blades shall have a hardness of between 40 and 58 on the Rockwell C scale or 80.4 and 89.3 on the Rockwell 15-N scale when tested in accordance with ASTM E-18, Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials.

Blade and tines attachment. Shells of hollow handle cutlery shall be one piece construction when possible. Blade and tines may be soldered into the handles with soft solder, secured by a nontoxic cement, or argon welded so that attachment is not evident in accordance with commercial practice.

Finish. Finished items shall have a bright finish.

Marking. Each item shall be clearly and permanently marked with the manufacturer's name, trademark, or tradename of such known character to be easily identifiable with said manufacturer. The surface opposite the markings shall show no signs of penetration.

A-A-1808A

Workmanship. Finished items shall be clean, well made, and free from any defect which may affect appearance or serviceability. Except for specified cutting edges or fork tine tips, there shall be no sharp edges, burrs, rough die, tool, gouge, or grind marks. Silver plating shall be smooth, fine grained, adherent, and free from visible blisters, pits, porosity, and indications of burning or excessive edge build up. The finished items shall not be fractured, dented, bent, punctured, or malformed.

Quality assurance provisions.

Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. Inspection records of the examinations or tests shall be kept complete and available to the Government as specified in the contract or purchase order. The Government reserves the right to perform any of the inspections set forth in the CID where such inspections are deemed necessary to assure that the supplies and services conform to prescribed requirements.

First article inspection. When a first article inspection is required by the user, the visual examination and testing shall be in accordance with the following paragraphs as applicable. The failure of any of the tests or examinations shall be cause for rejection of the first article.

Inspection. Sampling for inspection shall in accordance with MIL-STD-105, Sampling Procedures and Tables for Inspection by Attributes, except where otherwise indicated herein.

Component and material inspection. In accordance with responsibility for inspection above, components and materials shall be inspected and tested in accordance with all referenced documents unless otherwise excluded, amended, or qualified in this CID or applicable procurement document.

Weight of blank. One gross of each item, randomly selected, from a production lot shall be weighed to determine conformance to table I. Any total weight that falls below the specified minimum shall be cause for rejection of the lot.

Process examination. Examination shall be made to establish that soldering, cementing, or argon welding are in conformance to the specified requirements.

End item inspection. The sample unit for this inspection shall be one completely finished item of flatware. The inspection lot shall be all items of one type and configuration offered for delivery at one time.

Visual examination. Examination shall be made of the plated items for defects in table III. The inspection level shall be level II with an acceptable quality level (AQL) of 1.5 defects per hundred units for major defects and 4.0 total defects per hundred units.

TABLE III - Classification of defects

Examine	Defects	Classification		
		Major	Minor	
Finish	Any component not finished as specified	X		
	Area of rust, pits, or scale	X		
	Any component surface containing embedded foreign materials	X		
	Any component surface containing cracks, burrs, or dents	X		
	Any component surface not clean or smooth	X		
Construction and workmanship	Any characteristic or detail of design or construction not in accordance with specified requirements	X		
	Component missing	X		
	Burrs, sharp corners, or projections which may cause injury	X		
	Any component bent, misshapen, deformed, distorted, or misaligned	X		
	Knife blade not uniformly ground and cutting edge not sharpened	X		
	Knife cutting edge broken in any place or containing nicks or burrs	X		
	Knife or fork blade loose in handle	X		
	Soldering or welding not smooth, fractured, cracked, or fused, or missing where required	X		
	Silver plating not smooth, not fine grained, and not free from blisters, porosity, indications of burning, or excessive edge build up	X		
	Identification	Missing, not legible, incomplete, incorrect, or not in proper location		X
Surface opposite markings show signs of penetration		X		

Testing of the end item. Sample units shall be tested in accordance with the applicable paragraphs under Testing. The sample size, except for the alternate method below, shall be a minimum of 72 items of flatware, randomly selected from each inspection lot. Failure of any sample to pass any applicable tests specified shall be cause for rejection of the lot.

A-A-1808A

Tests.

Hardness. Blade samples shall be tested for compliance with the knife blade paragraph as specified in ASTM E-18. Hardness readings shall be determined at a minimum of 3 locations; point, center, and 1 inch from the shoulder of the knife blade. Any hardness not within specified limits shall be considered a failure of this test.

Corrosion test. Steel samples shall be tested as follows for compliance. Three drops of copper sulfate solution shall be placed at intervals on the cleaned surface of the blade of each sample. After remaining on the blade for 6 minutes, the solution shall be washed off with clean water. Any visible indication of staining shall be considered failure of this test. The copper sulfate shall be mixed as follows:

Copper sulfate ($\text{CuSO}_4 \cdot 5\text{H}_2\text{O}$)	4 grams
Sulfuric acid (H_2SO_4) (sp.gr. 1.84)	10 ml
Water (H_2O)	90 ml

Weight of silver test. Samples shall be tested in accordance with the proper paragraphs below that specify the base metal, as applicable, or the alternate method for compliance with the minimum weight of silver requirement in table II. Any plating weight that falls below the specified limits shall be considered noncompliant. Each of the selected samples shall be tested as specified and the weight of the silver recorded. All the recorded weights for the same type of item shall be added together and the sum averaged to determine compliance with table II. The surface plated area specified under "Thickness of silver" shall be determined in accordance with the manufacturers' commercial practice for the determinations on the same or similar items.

On nickel brass. The 72 samples shall be thoroughly cleaned, rinsed, dried, and weighed. They shall then be introduced into a suitable vessel containing a mixture of 19 parts by volume of C.P. concentrated sulfuric acid (sp.gr. 1.84) and 1 part by volume of C.P. concentrated nitric acid (sp.gr. 1.42), the mixture having been heated (e.g., on a sand bath) to 80 degrees C (176 degrees F). The stripping bath shall be kept covered when not in use to prevent absorption of water. The samples shall be kept in the solution until all the silver has been dissolved, as indicated by the dark color over the entire surface. The samples shall then be thoroughly rinsed, dried, and reweighed. The loss in weight shall be considered silver.

On brass and corrosion-resisting steel. The 72 samples shall be thoroughly washed, rinsed, dried, and weighed; samples shall then be hung as anodes in a solution containing 30 g/L (4 oz/gal) of sodium cyanide, in which an iron or silver cathode is suspended. A potential of 3 to 4 volts shall be applied and the samples shaken or the solution agitated until all the silver is dissolved. The samples shall then be thoroughly rinsed, dried, and reweighed. The loss in weight shall be considered as silver.

A-A-1808A

Alternate method. Randomly select and weigh any 108 pieces of the type of item to be tested before plating, record the weights, and calculate the average. Repeat the same procedure with any 108 pieces of the same type of item randomly selected after plating. The difference between the averages shall be considered the weight of silver present. Calculate the weight of silver in troy ounces per gross for compliance with the minimum requirements in table II.

Thickness of silver test. Thickness of silver shall be determined as follows for compliance with the requirements of this CID. Any silver plating thickness, when averaged, that falls below the specified limit shall be considered noncompliant.

The samples shall be measured in accordance with American National Standard ANSI/ASTM B 504, Measurement of Thickness of Metallic Coatings by the Coulometric Method. The sample size shall not be less than 72 pieces. The average plate thicknesses of the samples when averaged shall not be less than 400 microns.

Adhesion test. Samples shall be tested as follows for compliance: The samples shall be placed in an oven heated to between 135 degrees C and 177 degrees C (between 275 F and 350 F) for the time required to bring the samples to the oven temperature plus 30 minutes. The samples shall then be removed cooled in air at room temperature, and examined at 4 diameters magnification. Any evidence of blistering shall be considered noncompliant.

Regulatory requirements. In accordance with the Section 23.403 of the Federal Acquisition Regulations, the Government's policy is to acquire items composed of the highest percentage of recovered materials practicable, consistent with maintaining a satisfactory level of competition without adversely affecting performance requirements or exposing suppliers' employees to undue hazards from the recovered materials.

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

A-A-1808A

Notes. When a first article is required it shall be so stated in the contract or purchase order.

Copies of military standards may be obtained from the procuring activity or as directed by the contracting officer.

Applications for copies of American Society for Testing and Materials (ASTM) Standards should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

WHEN THIS COMMERCIAL ITEM DESCRIPTION IS USED FOR PROCUREMENT, THE COMMERCIAL ITEM CERTIFICATION CLAUSE DOES NOT NEED TO APPEAR IN THE SOLICITATION.

MILITARY INTERESTS:

PREPARING ACTIVITY:

Military Coordinating Activity:

GSA - FSS

Army - GL

Custodians

Review Activities

Army - GL

Army - MD

Navy - SA

Navy - MS

Air Force - 99

Air Force - 84

A-A-1808A

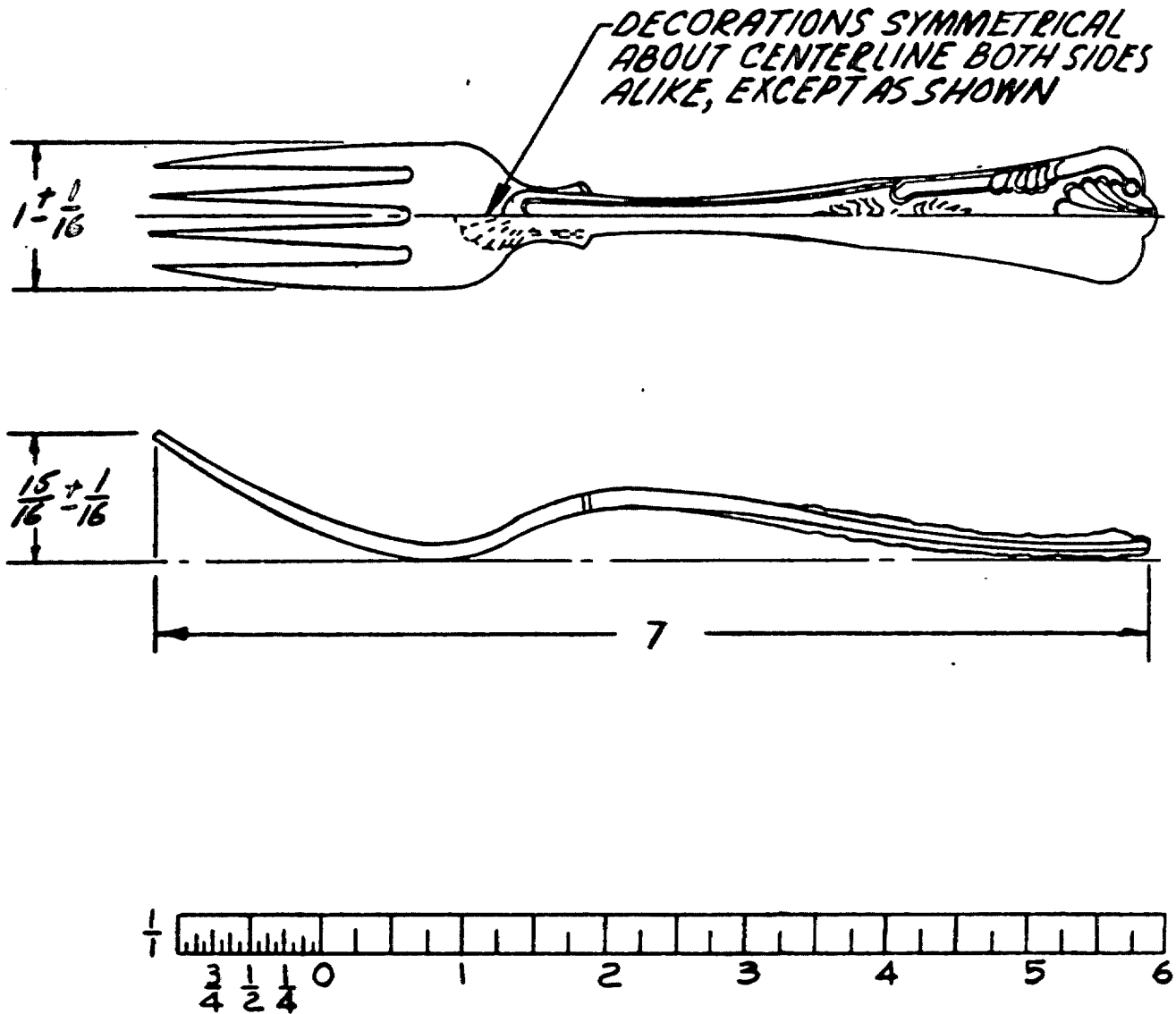


FIG.18-FORK, DESSERT

A-A-1808A

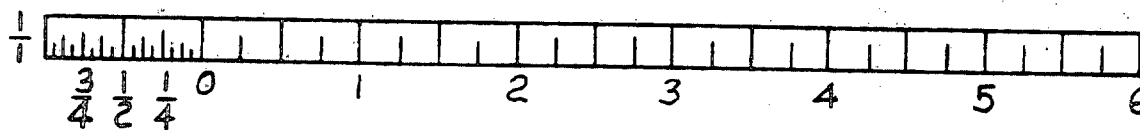
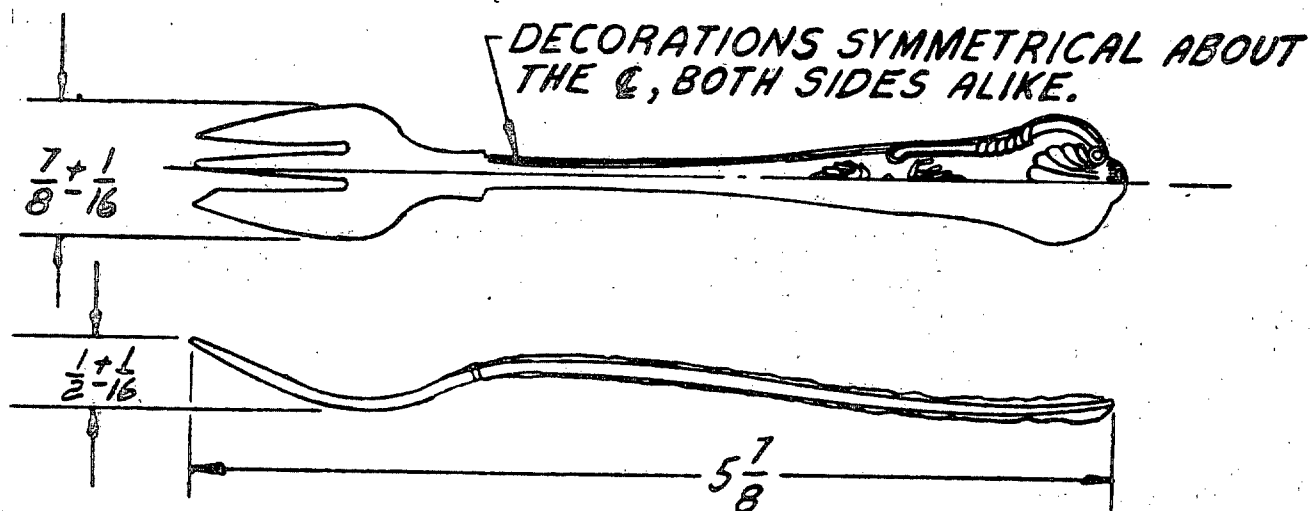


FIG.19-FORK, OYSTER

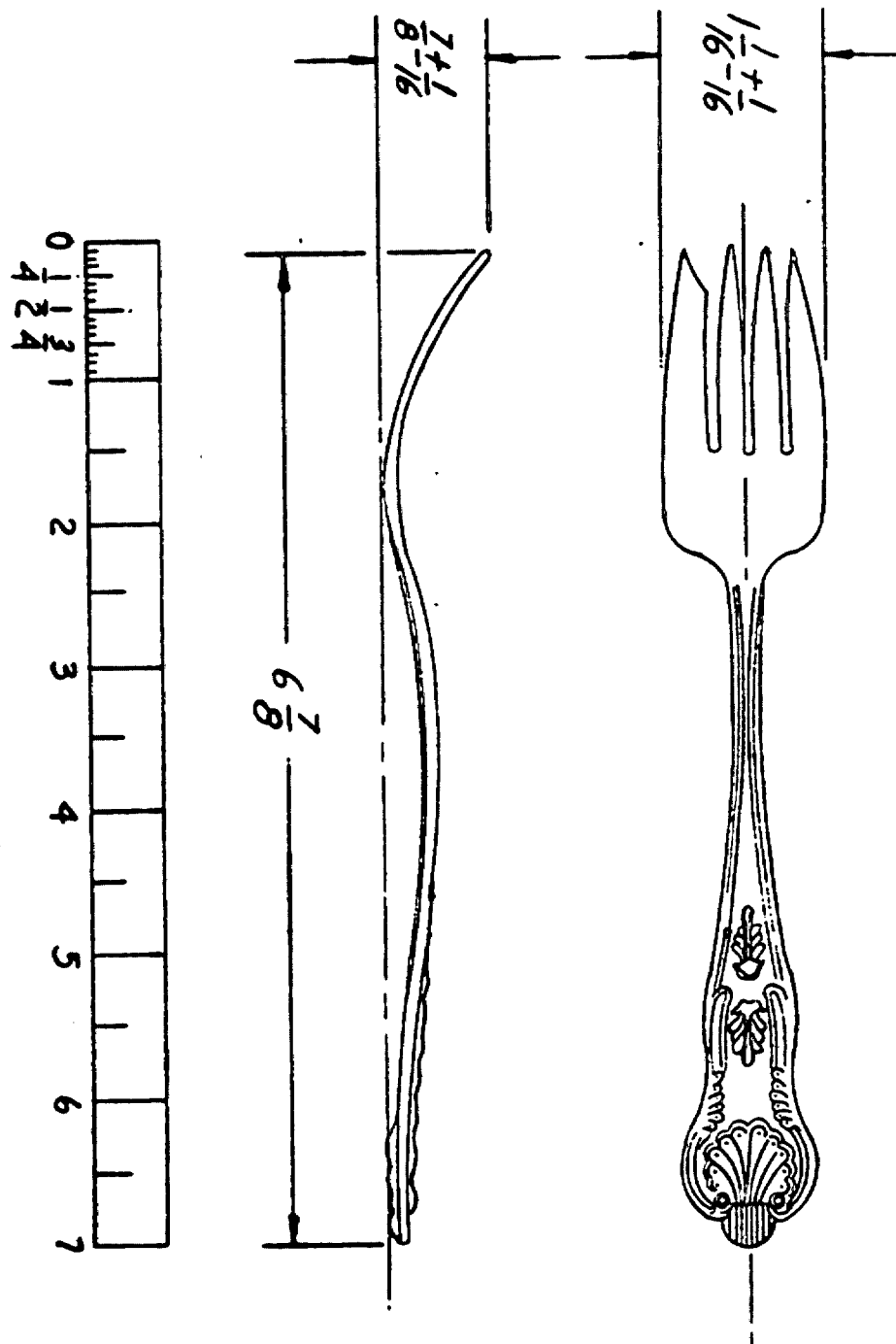


FIG. 20 - FORK, SALAD

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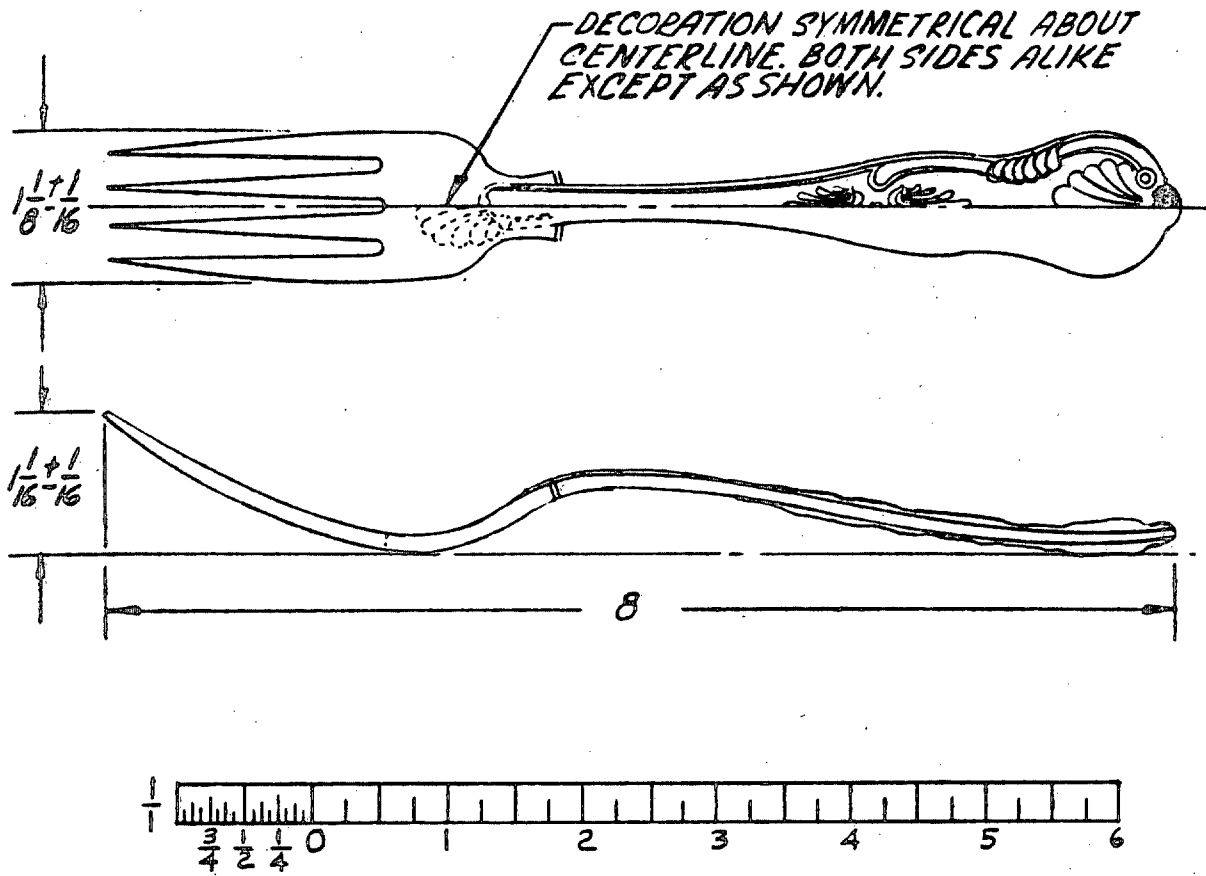


FIG. 21-FORK, TABLE

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DECORATIONS SYMMETRICAL ABOUT
CENTERLINE. BOTH SIDES TO BE ALIKE.

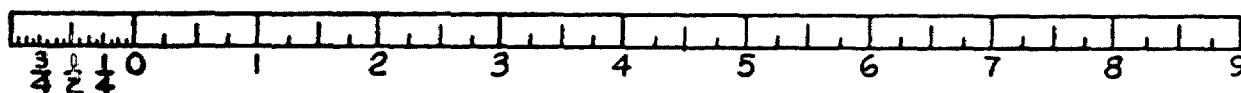
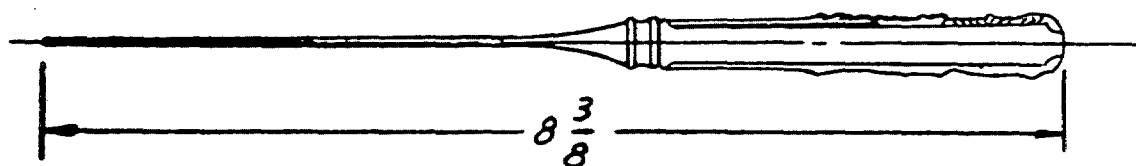


FIG 22-KNIFE, DESSERT

A-A-1308A

DECORATIONS SYMMETRICAL ABOUT CENTER-LINE. BOTH SIDES TO BE ALIKE.

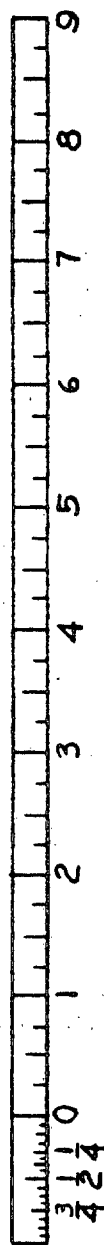
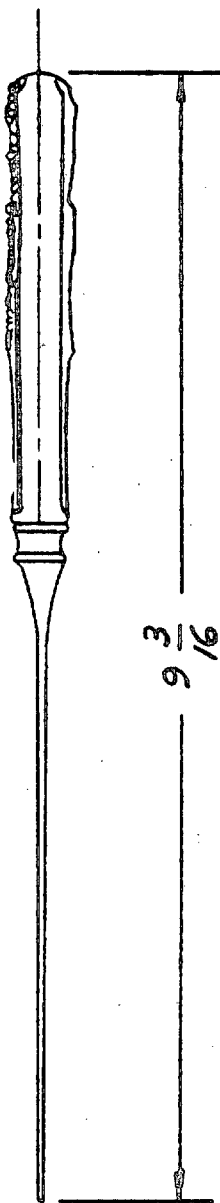


FIG. 23-KNIFE, TALBE

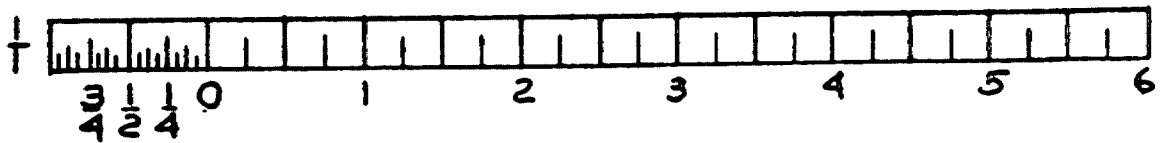
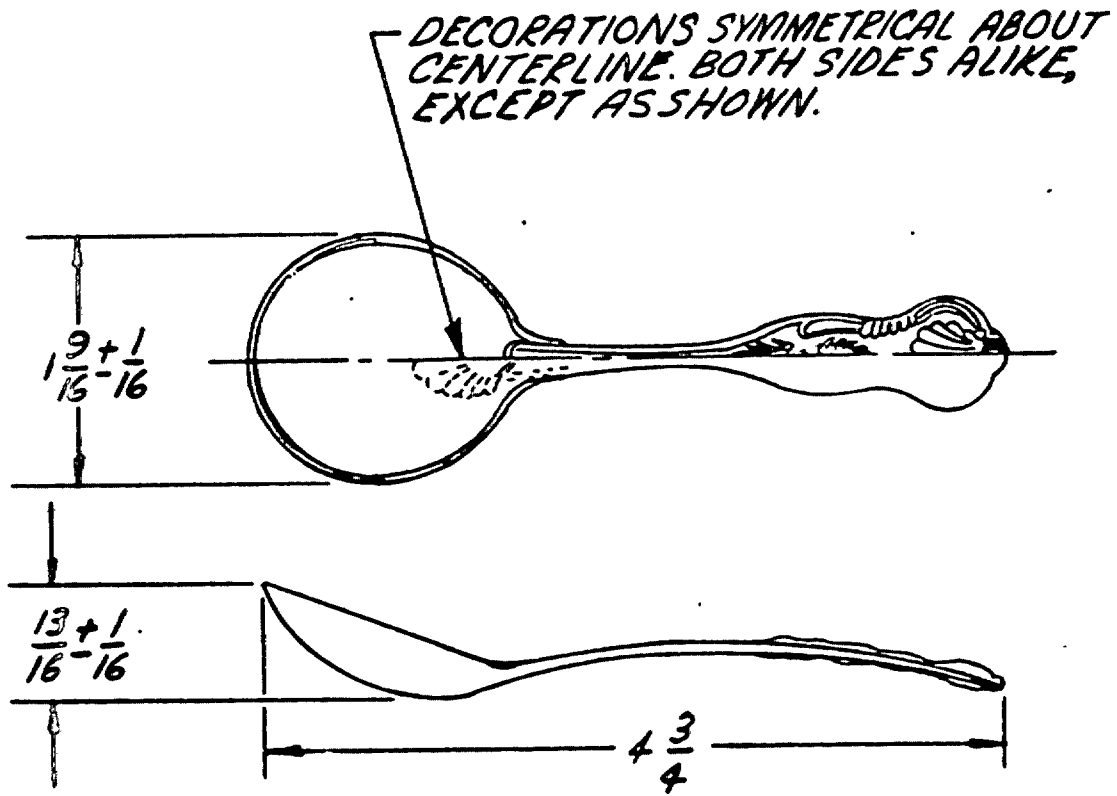


FIG. 24-SPOON, BOUILLON

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DECORATION SYMMETRICAL
ABOUT CENTERLINE. BOTH
SIDES ALIKE, EXCEPT AS
SHOWN.

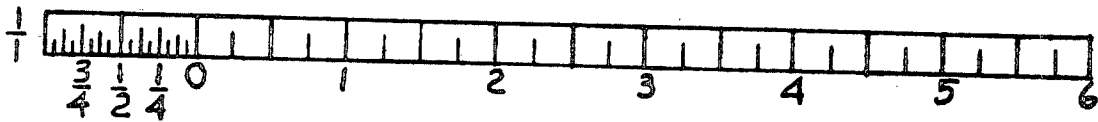
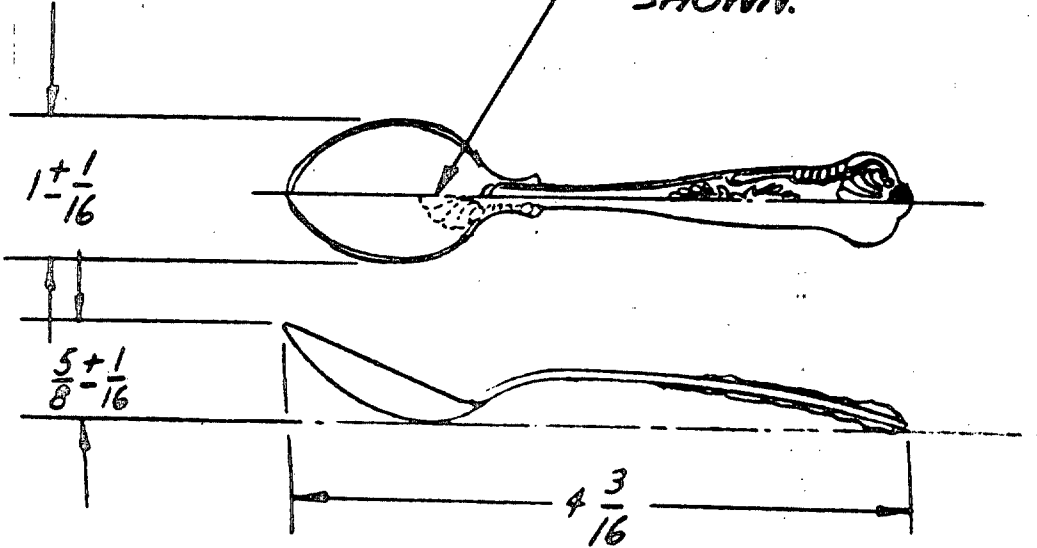


FIG. 25-SPOON, DEMITASSE

A-A-1808A

DECORATIONS SAME AS FIGURE NO.18
EXCEPT AS SHOWN.

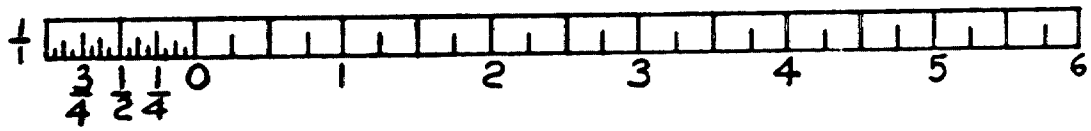
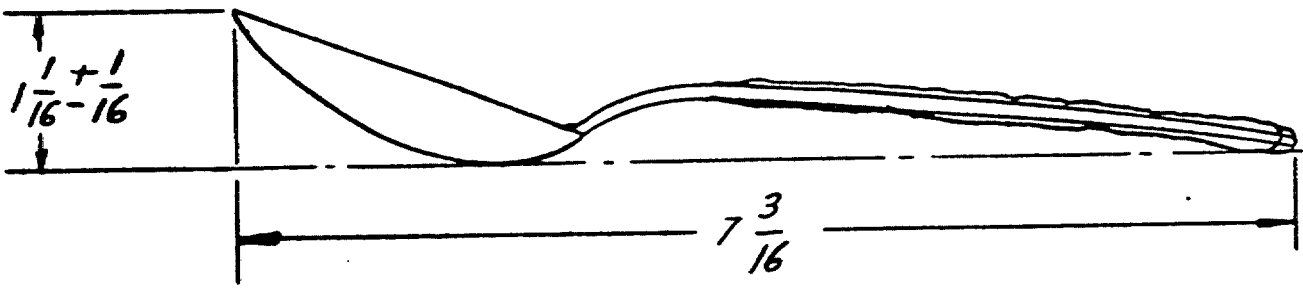
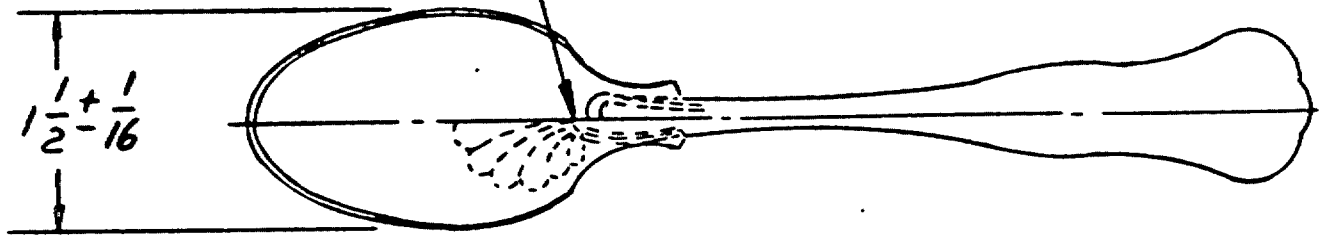


FIG. 26-SPOON, DESSERT

A-A-1808A

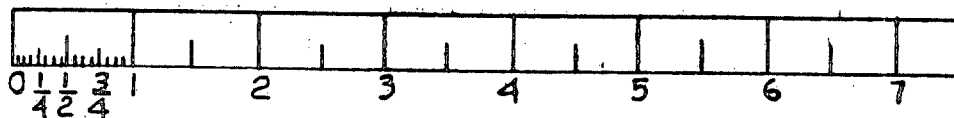
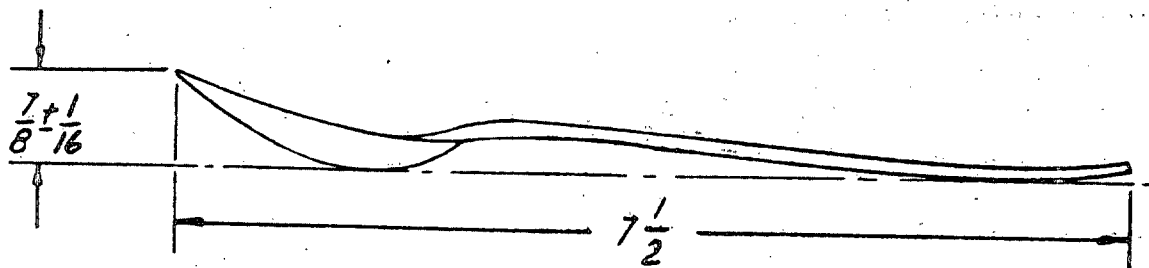
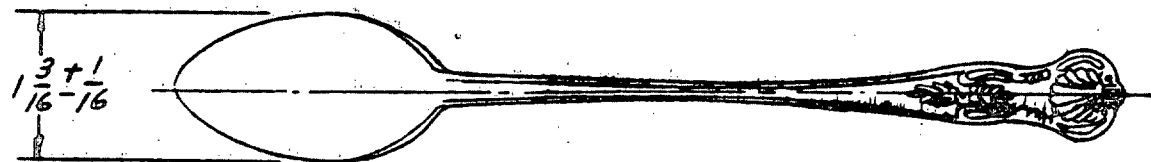


FIG. 27-SPOON, ICED TEA

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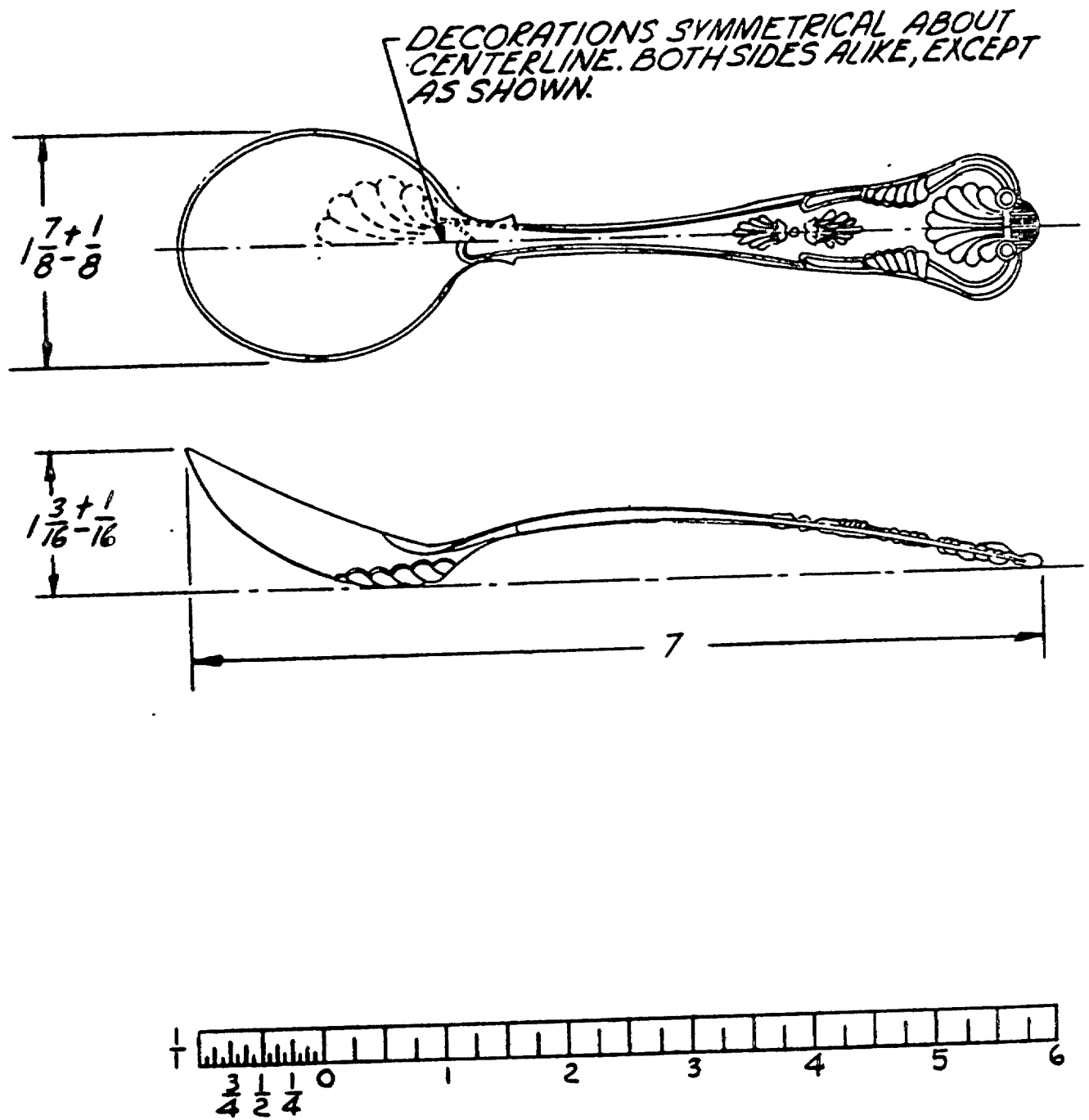


FIG. 28-SPOON, SOUP

A-A-1808A

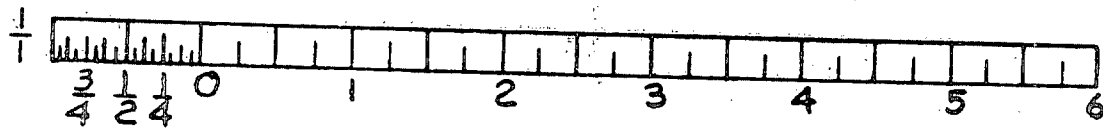
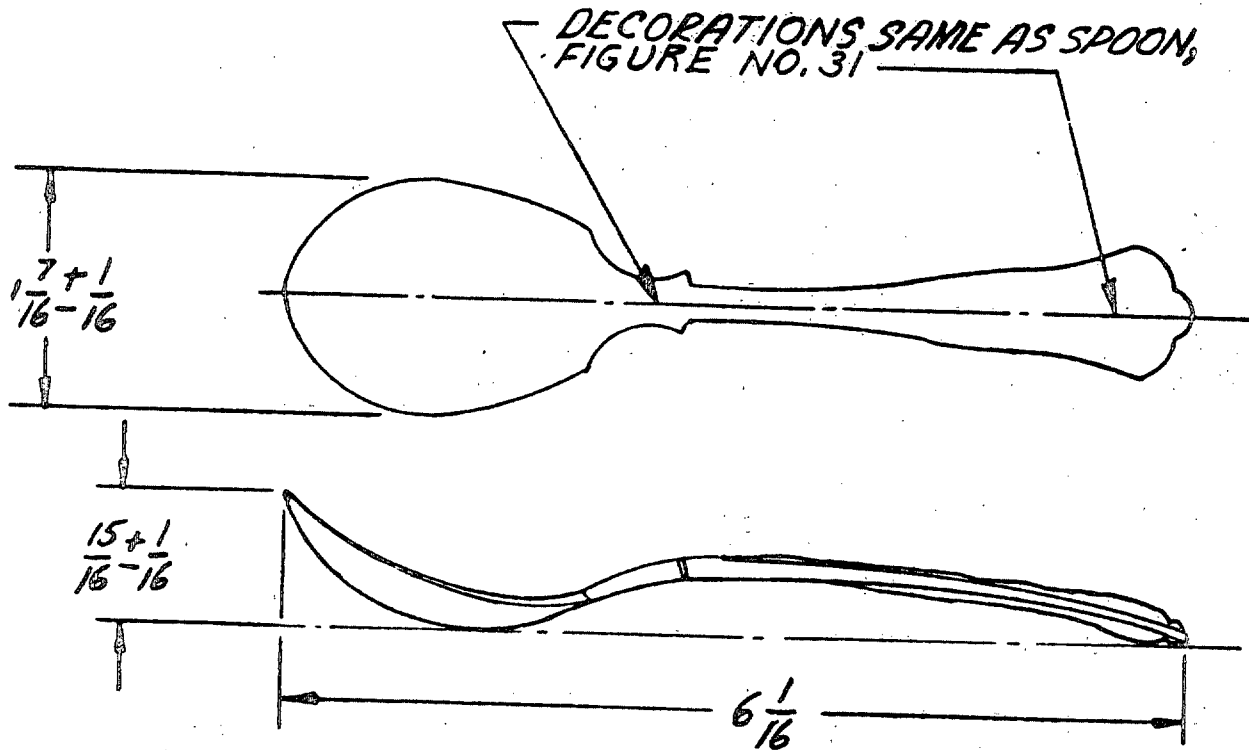


FIG. 29 - SPOON, SUGAR

A-A-1808A

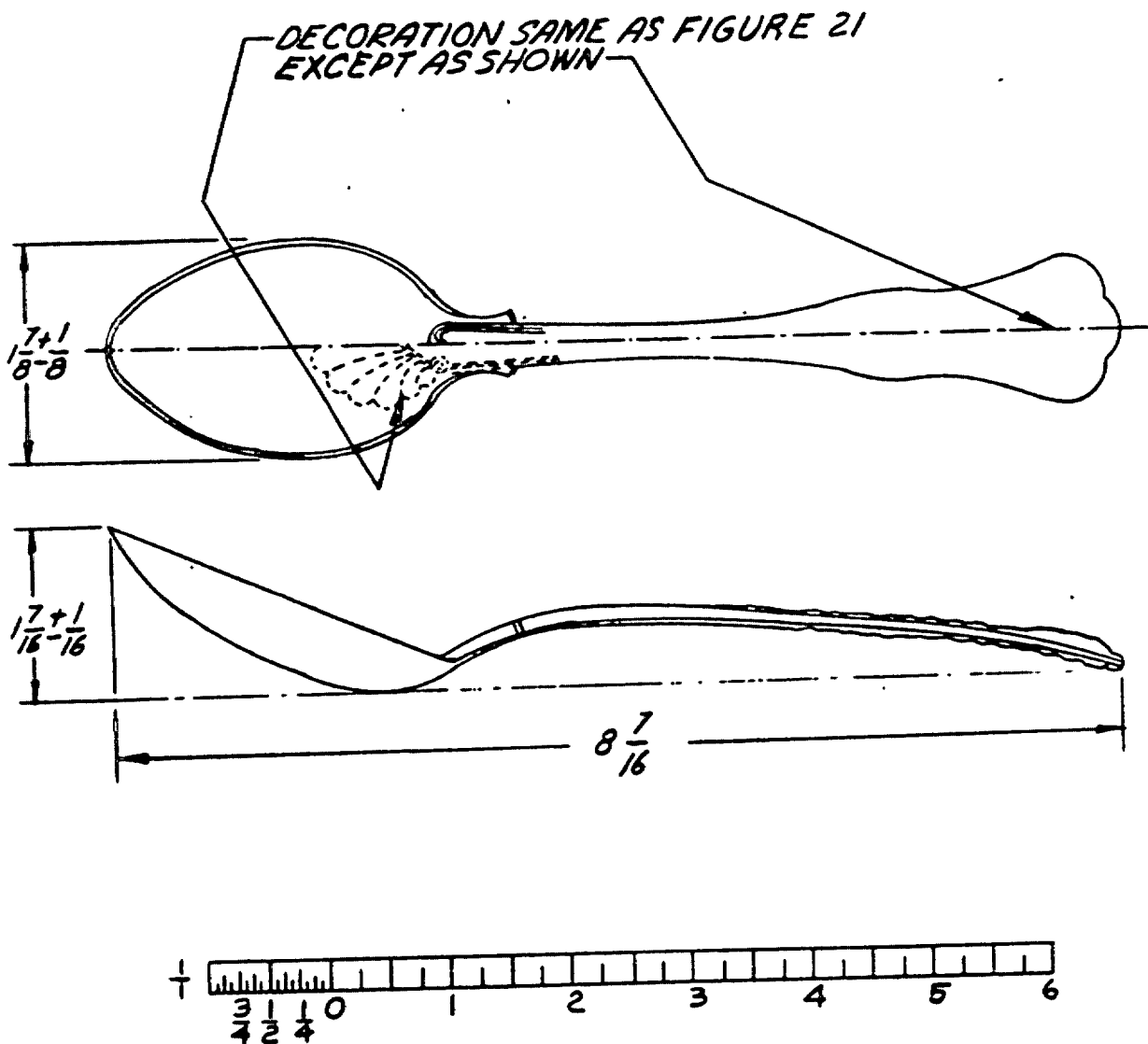


FIG. 30-SPOON, TABLE

A-A-1808A

DECORATIONS SYMMETRICAL ABOUT
CENTERLINE. BOTH SIDES ALIKE,
EXCEPT AS SHOWN.

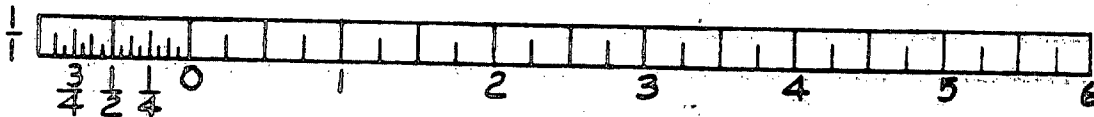
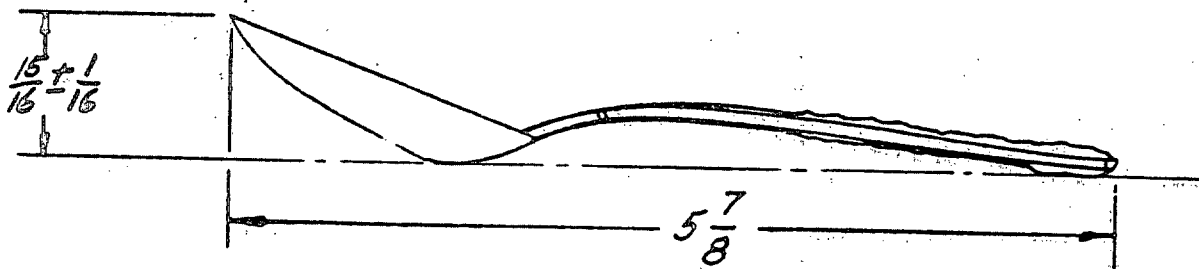
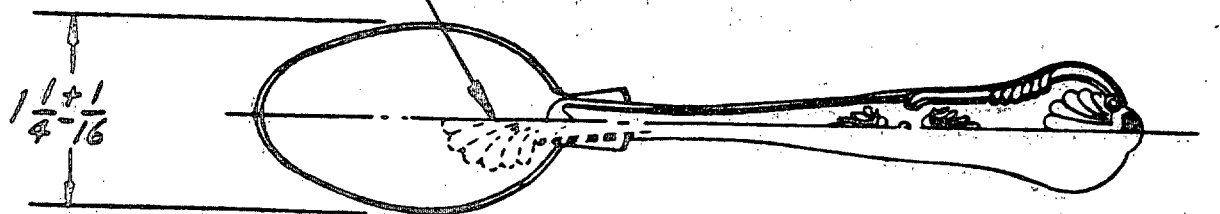


FIG. 31-SPOON, TEA

A-A-1808A

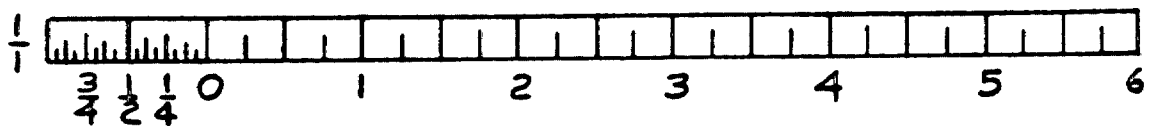
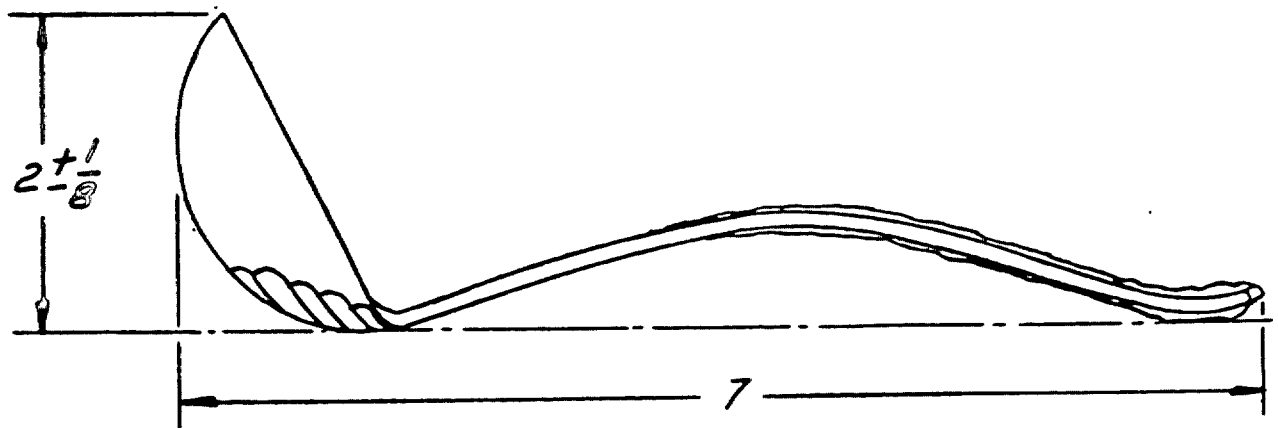
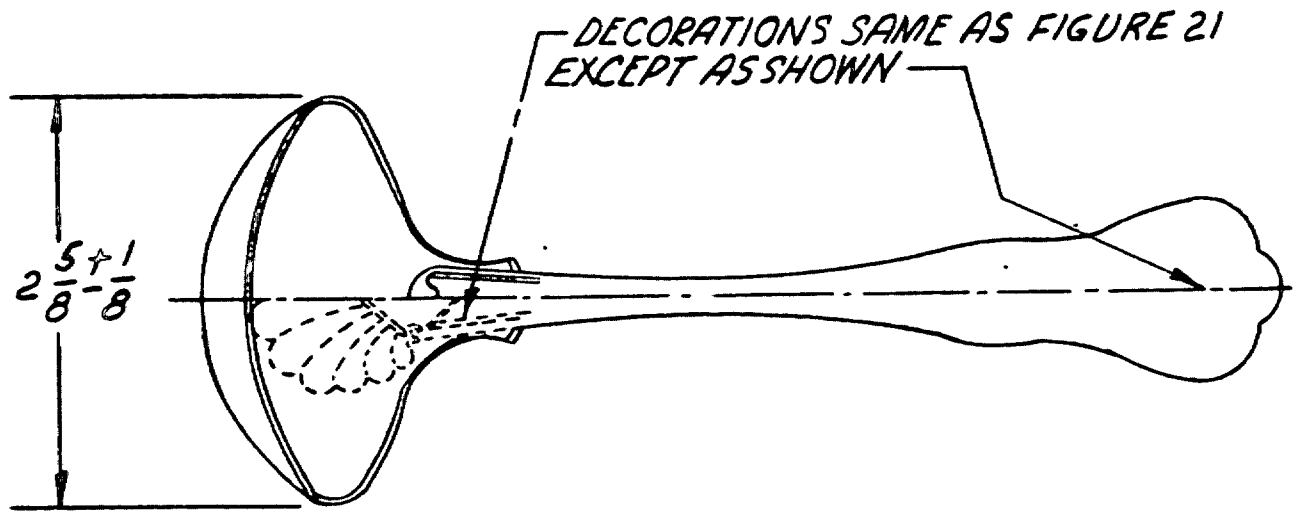


FIG. 32 LADLE, GRAVY, TABLE