

A-A-1808B
 April 5, 1988
 SUPERSEDING
 A-A-1808A
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COMMERCIAL ITEM DESCRIPTION

FLATWARE, SILVERPLATED AND STAINLESS STEEL

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

This commercial item description (CID) covers both silverplated and stainless steel flatware equal in quality to a grade known within the industry as "high-quality hotel and restaurant" flatware. 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 types and items.

Type I - Silverplated

Type II - Stainless steel

Items:

- | | |
|--------------------------------------|--------------------------------|
| 1 - Fork, dessert (fig. 1) | 8 - Spoon, demitasse (fig. 8) |
| 2 - Fork, oyster (fig. 2) | 9 - Spoon, dessert (fig. 9) |
| 3 - Fork, salad (fig. 3) | 10 - Spoon, iced tea (fig. 10) |
| 4 - Fork, table (fig. 4) | 11 - Spoon, soup (fig. 11) |
| 5 - Knife, dessert (fig. 5) | 12 - Spoon, sugar (fig. 12) |
| 6 - Knife, table (fig. 6) | 13 - Spoon, table (fig. 13) |
| 7 - Spoon, bouillon (fig. 7) | 14 - Spoon, tea (fig. 14) |
| 15 - Ladle, gravy, table - (fig. 15) | |

Salient characteristics.

Materials. Materials not definitely specified shall be the type and quality supplied by the manufacturer for their normal commercial product 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 with the balance of copper and zinc in accordance with commercial practice.

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

Stainless steel. Stainless steel shall conform to a type 300 series in accordance with ASTM A 167.

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.

Base metal. For type I items the base metal shall be stainless steel, nickel brass or brass. Type II items shall be fabricated from stainless steel.

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	Stainless steel	brass/nickel brass
Forks:		
Dessert	15.0	16.0
Table	20.0	21.0
Oyster	7.0	8.0
Salad	10.0	11.0
Spoons:		
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 type I item shall represent an average thickness of at least 280 microinches or 0.23 troy ounce per square foot.

Weight of silver. The minimum weight of silver for type I items shall be as specified in Table II.

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TABLE II. Weight of silver, Type I items

Item	Minimum required weight of silver troy oz/gross
Forks:	
Dessert	2.9
Table	3.5
Oyster	1.0
Salad	1.84
Knives:	
Dessert, hollow handle (handle only)	2.0
Table, hollow handle (handle only)	2.0
Spoons:	
Bouillon	3.1
Demitasse	0.85
Dessert	2.8
Iced tea	1.65
Soup	2.8
Sugar	2.3
Table	3.5
Tea	2.1
Ladle, gravy	4.65

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

Knife blades. The blades of knives shall be fabricated from stainless steel. Blades shall have a hardness of between 40 and 58 on the Rockwell C scale or between 80 and 89 on the Rockwell 15-N scale when tested in accordance with ASTM E-18.

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. The finished items shall have a bright finish.

Marking. Each item, except for knives, 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.

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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. The silver plating of type I items shall be smooth, fine grained, adherent, and free from visible blisters, pits, porosity, and indications of burning or excessive edge buildup. The finished items shall not be fractured, dented, bent, punctured or malformed.

Quality assurance provisions.

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).

Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that 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 paragraph 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 be in accordance with MIL-STD-105, Sampling Procedures and Tables for Inspection by Attributes, except where otherwise indicated.

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.

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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 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	

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TABLE III (cont.)

Examine	Defects	Classification	
		Major	Minor
Construction and Workmanship	Silver plating not smooth, not fine grained and not free from blisters, porosity, indications of burning, or excessive edge build up (Type I items)	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.

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 the 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 the 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

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Weight of silver test. Samples of type I items 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 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 manufacturer's 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 176 degrees Fahrenheit. 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 stainless 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.

Alternate method. Randomly select and weigh any 100 pieces of the type of item to be tested before plating, record the weights, and calculate the average. Repeat the same procedure with any 100 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 as 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.

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The samples shall be measured in accordance with ASTM B 567, Measurement of Coating Thickness by the Beta Backscatter Method. The sample size shall not be less than 36 pieces. The average plate thicknesses of the samples when averaged shall not be less than 280 microinches.

Adhesion test. Samples shall be tested as follows for compliance: The samples shall be placed in an oven heated to between 275 degrees Fahrenheit and 350 degrees Fahrenheit 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.

Inspection for preparation and delivery. An inspection shall be made to determine whether the packaging, packing, and marking comply with the requirements of the contract or purchase order. Examination for defects shall be in accordance with Table II. For examination of interior packaging, the sample unit shall be one shipping container fully prepared for delivery. Sampling shall be in accordance with MIL-STD-105. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 with an AQL of 4.0 defects per hundred units.

Table II
Preparation for delivery defects.

<u>Examine</u>	<u>Defects</u>
Markings	Omitted; incorrect; illegible; improper size, location, sequence, or method of application.
Material	Any component missing, damaged, or not conforming to applicable requirements stated herein.
Workmanship	Inadequate application of components such as incomplete closure of container flaps, loose strapping, or distortion of container.
Contents	Quantity of container is more or less than required. Gross weight exceeds requirements of the box specification.

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Regulatory requirements. In accordance with 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 (Civil Agencies). The preservation, packaging, packing, labeling, and marking shall be as specified in the contract or order.

Packaging for Department of Defense Procurements.

Commercial packaging. Each flatware item shall be packaged in accordance with commercial practice.

Commercial packing. Flatware items shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall comply with Uniform Freight Classification, as applicable.

Export packaging. Each flatware item shall be preserved in a polyethylene bag. Fork tines and knife blades shall be covered to avoid punctures. Twelve identical items shall be packaged in a paperboard box conforming to PPP-B-566. Closure shall be in accordance with PPP-B-566.

Export packing. Only one type of flatware item shall be packed in a fiberboard box conforming to style RSC, type SF, class weather-resistant grade V2s of PPP-B-636. Each box shall be closed, waterproofed, and reinforced in accordance with PPP-B-636.

Unit loads (commercial and export). When applicable, flatware items shall be palletized in accordance with MIL-STD-147.

Marking of interior boxes and shipping containers (commercial and export). Commercial marking is acceptable provided the following information is included:

National Stock Number	Date of Packaging (Month/Year)
Item Description	Contract Number
Quantity, Unit of Issue	Name, Address and Zip Code of
Gross weight and Cube <u>1/</u>	Contractor <u>1/</u>

1/ Interior boxes do not require this information.

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

All dimensions on figures 1 through 15 are in inches.

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.

Copies of military standards may be obtained from the Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

MILITARY INTERESTS:

PREPARING ACTIVITY:

Military Coordinating Activity:

GSA - FSS

Army - GL

Custodians

Army - GL

Navy - SA

Air Force - 99

Review Activities

Army - MD

Air Force - 84

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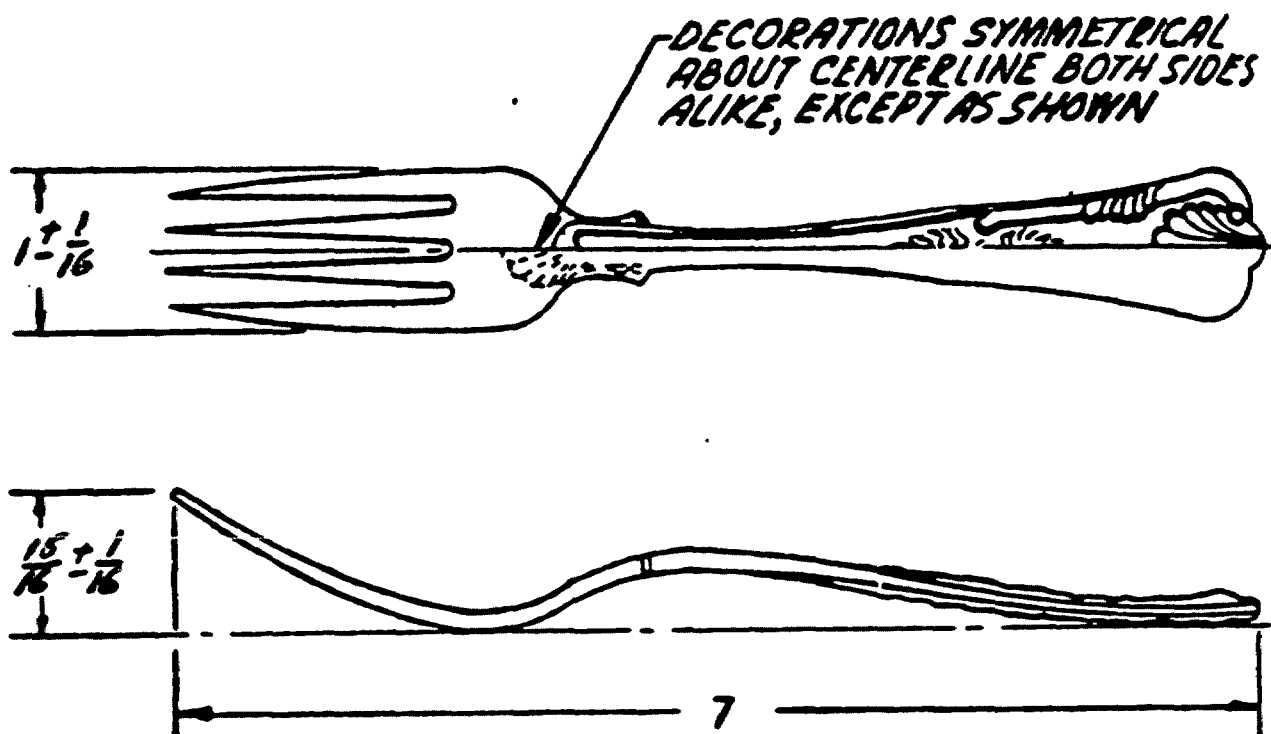


FIGURE 1 - FORK, DESSERT

All dimensions are in inches

Length dimension tolerance: $\pm \frac{1}{4}$ inch

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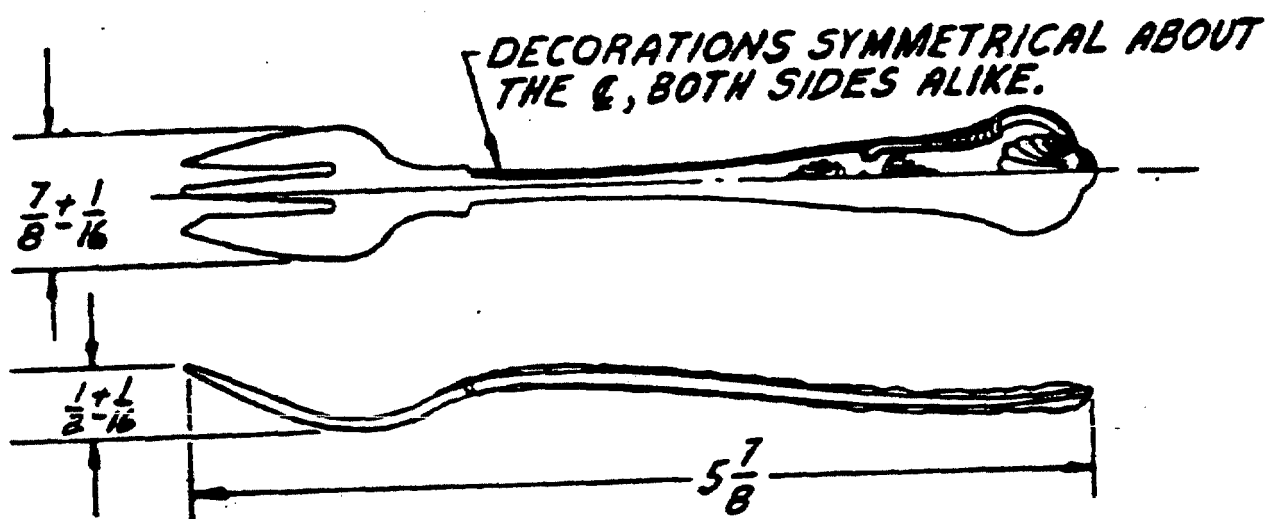


FIGURE 2 - FORK, OYSTER

All dimensions are in inches

Length dimension: $\pm \frac{1}{4}$ inch

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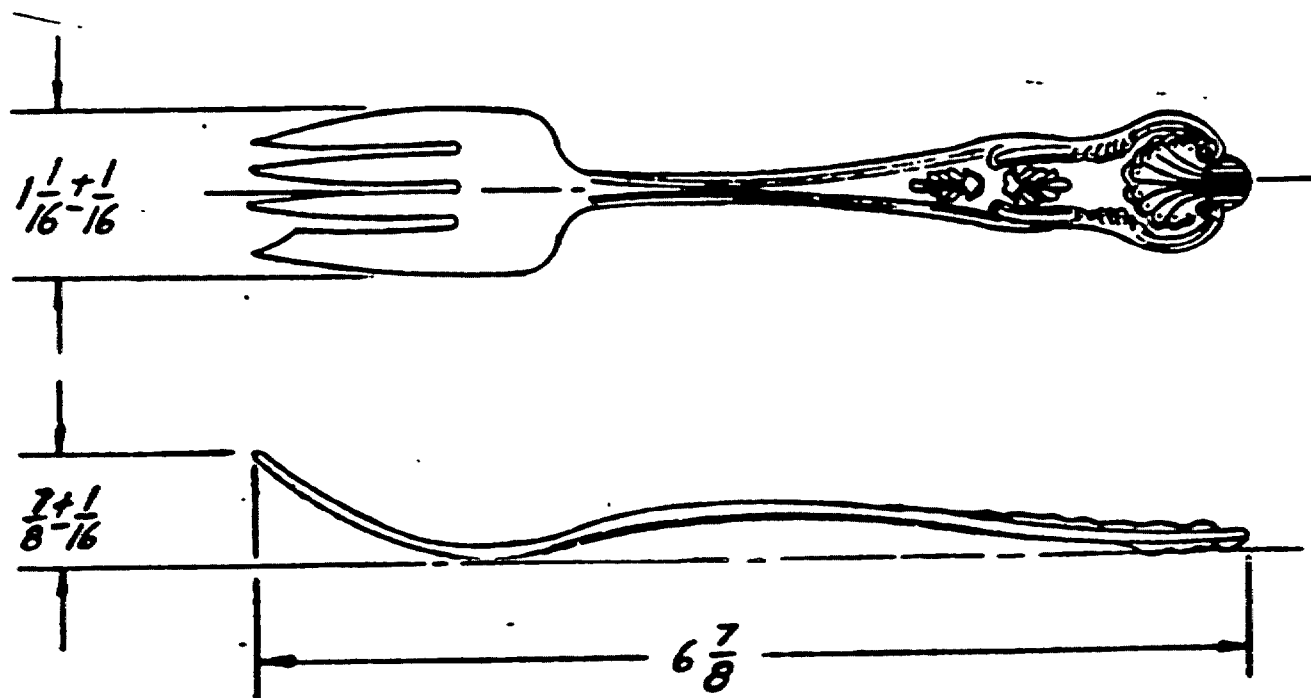


FIGURE 3 - FORK, SALAD

All dimensions are in inches

Length dimension: + 1/4, - 5/8 inch

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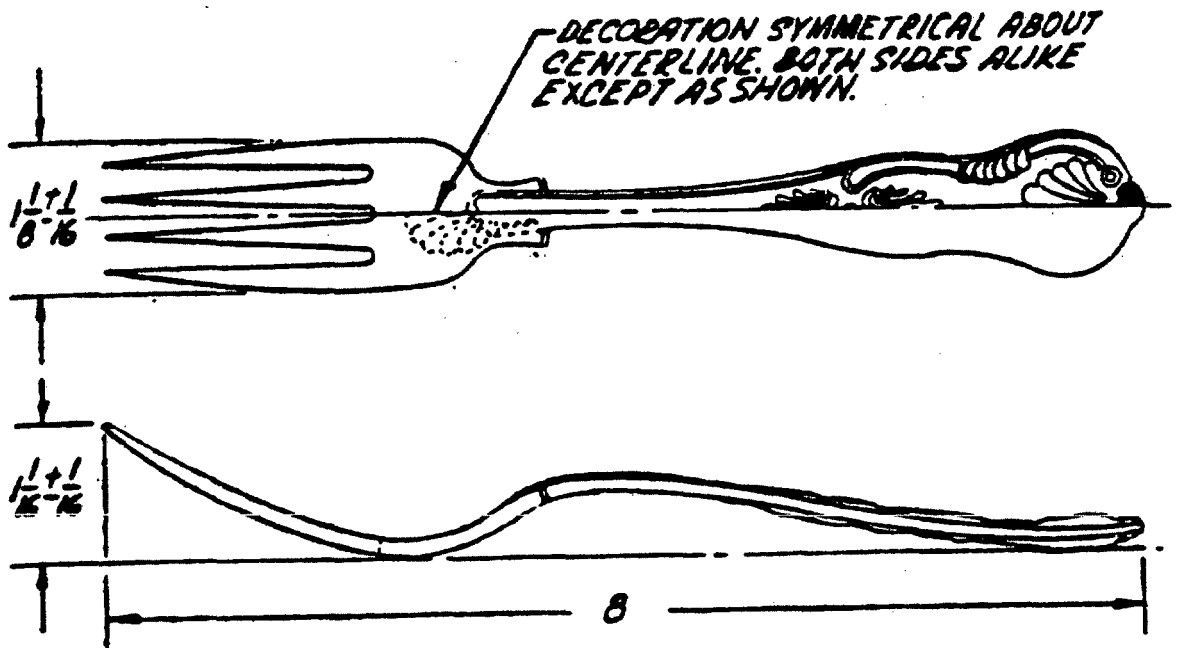


FIGURE 4 - FORK, TABLE

All dimensions are in inches

Length dimension tolerance: $\pm \frac{1}{4}$ inch

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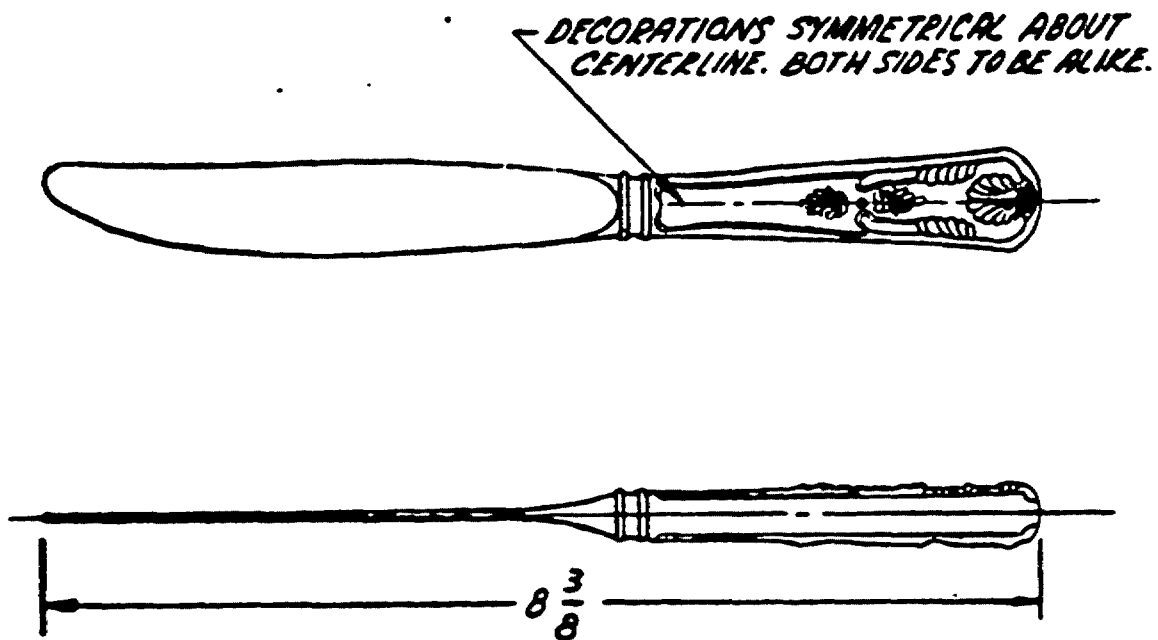


FIGURE 5 - KNIFE, DESSERT

All dimensions are in inches

Length dimension tolerance: $\pm 1/4$ inch

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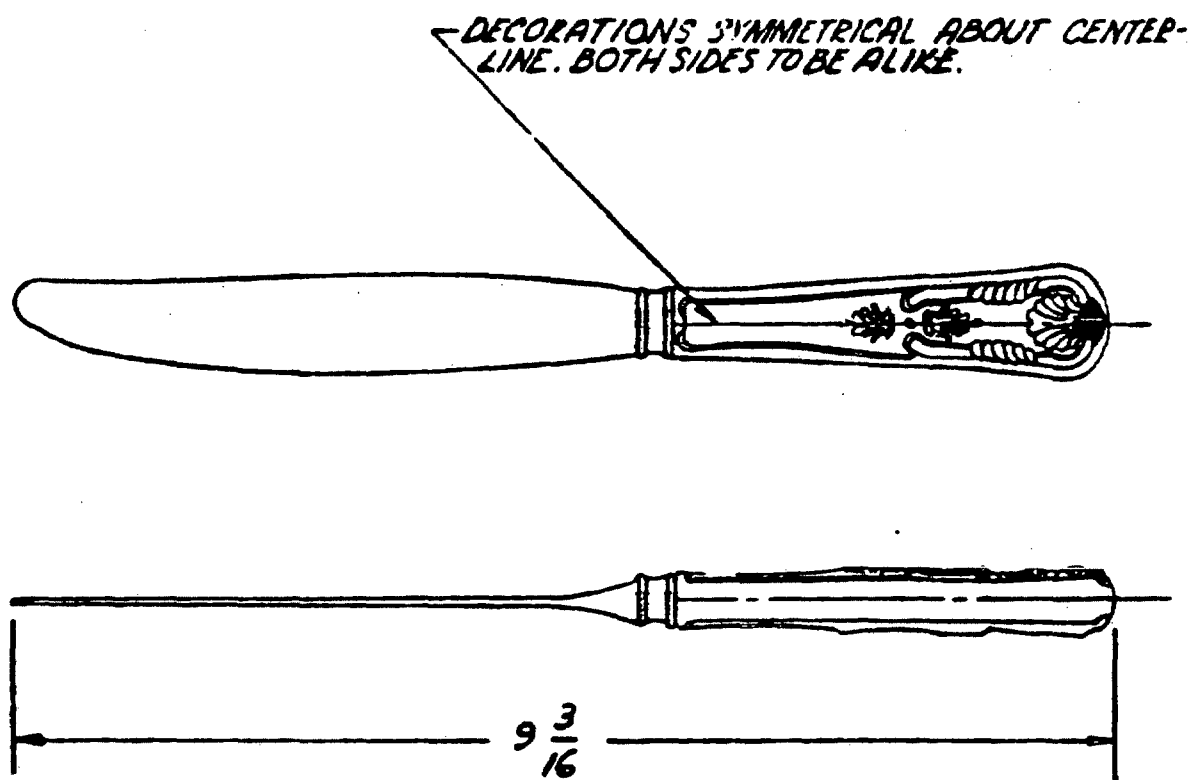


FIGURE 6 - KNIFE, TABLE

All dimensions are in inches

Length dimension tolerance: $\pm 1/4$ inch

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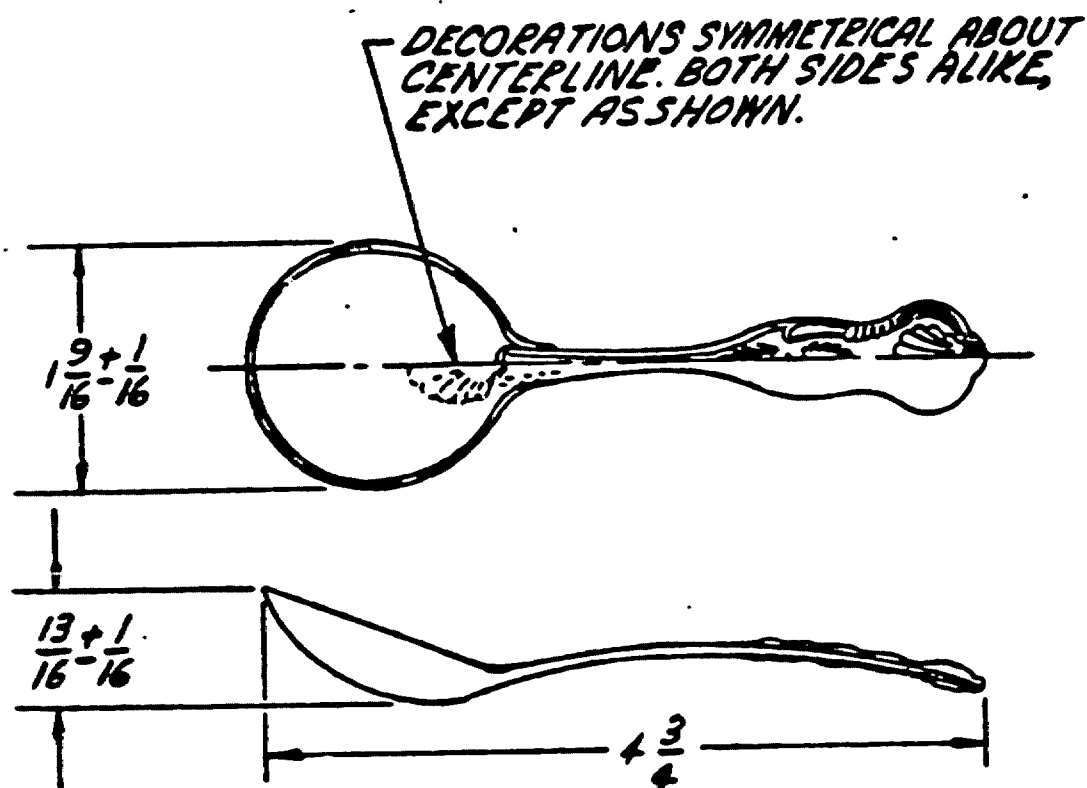


FIGURE 7 - SPOON, BOUILLON

All dimensions are in inches

Length dimension tolerance: $+ \frac{1}{2}$, $- \frac{3}{4}$ inch

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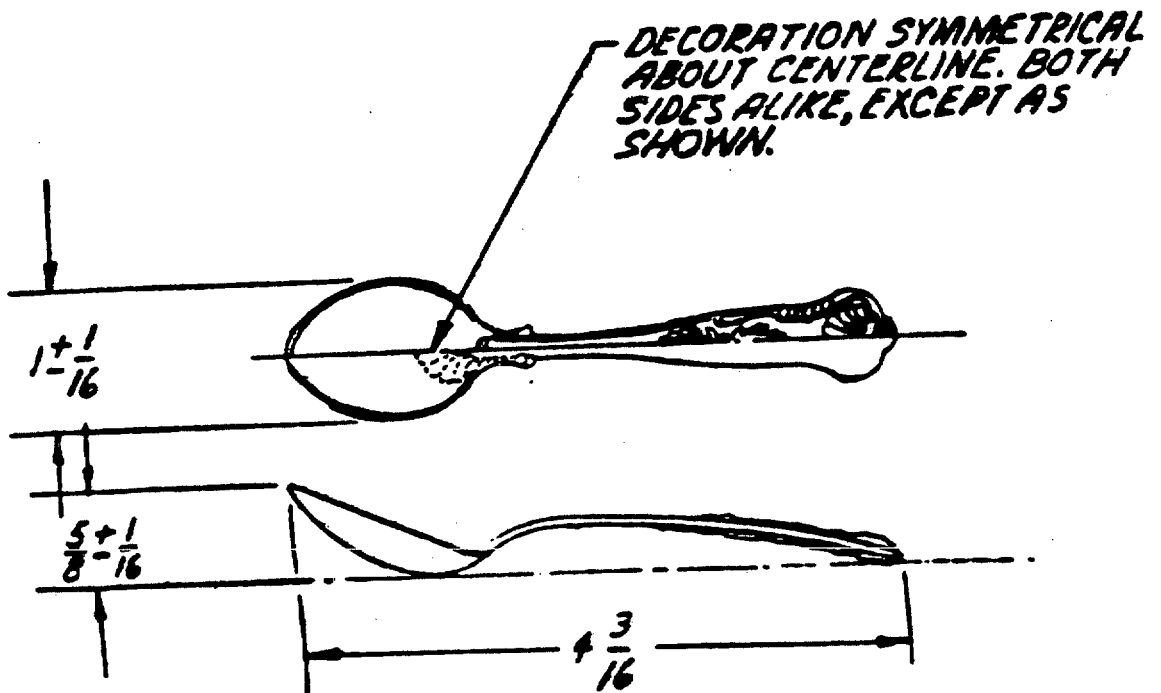


FIGURE 8 - SPOON, DEMITASSE

All dimensions are in inches

Length dimension tolerance: $\pm 1/4$ inch

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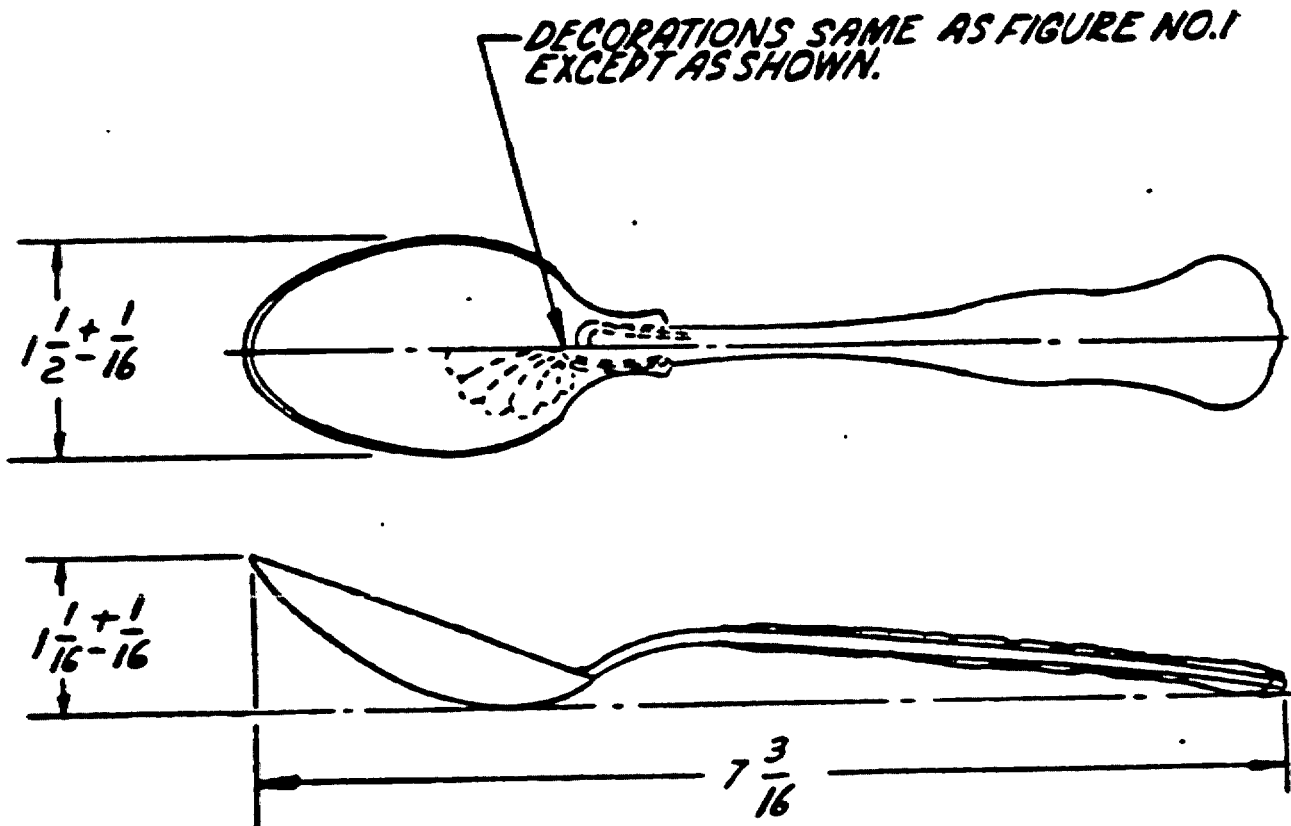


FIGURE 9 - SPOON, DESSERT

All dimensions are in inches

Length dimension tolerance: $\pm \frac{1}{4}$ inch

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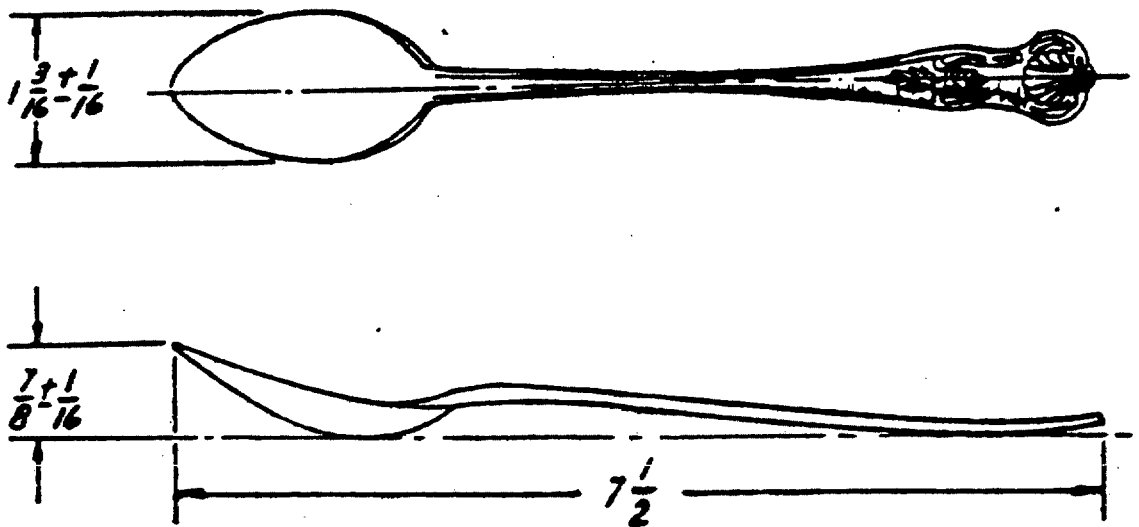


FIGURE 10 - SPOON, ICED TEA

All dimensions are in inches

Length dimension tolerance: $\pm \frac{1}{4}$ inch

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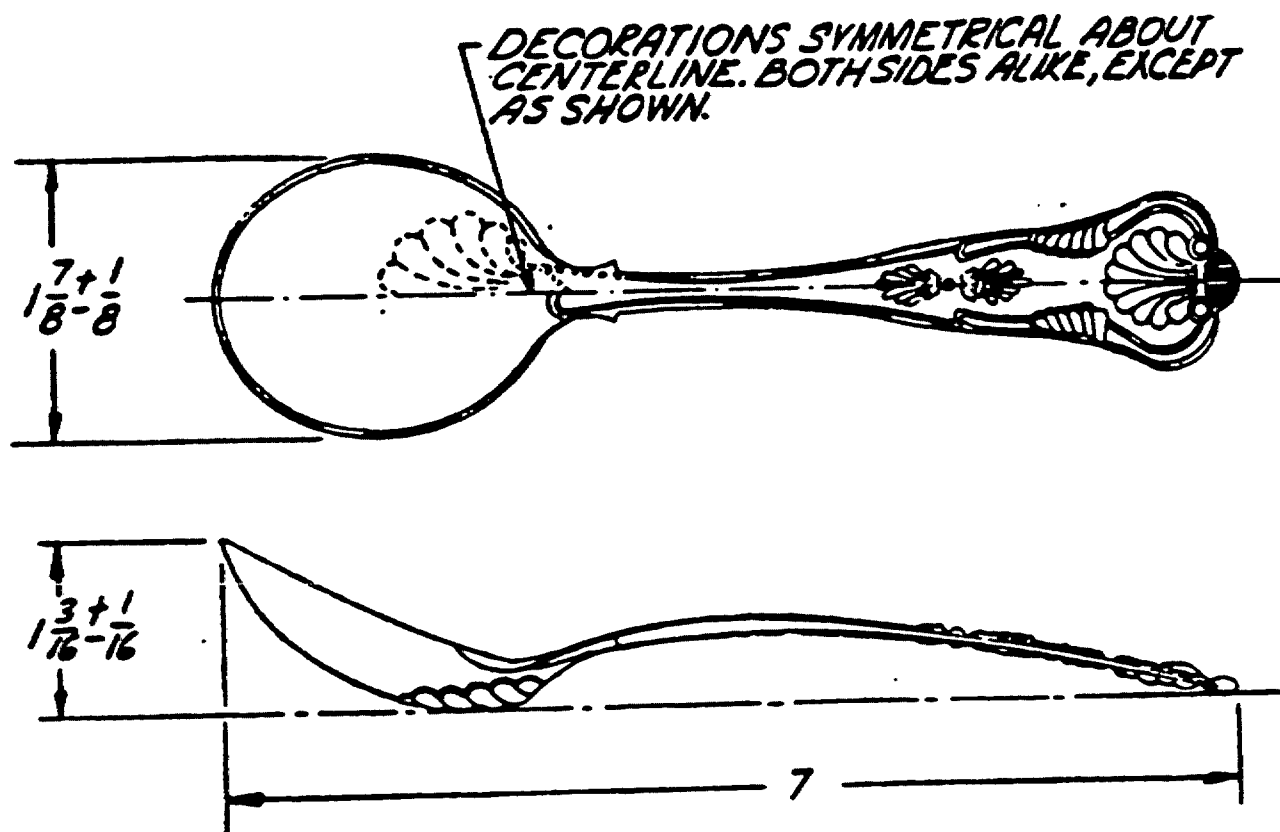


FIGURE 11 - SPOON, SOUP

All dimensions are in inches

Length dimension tolerance: $\pm \frac{1}{4}$ inch

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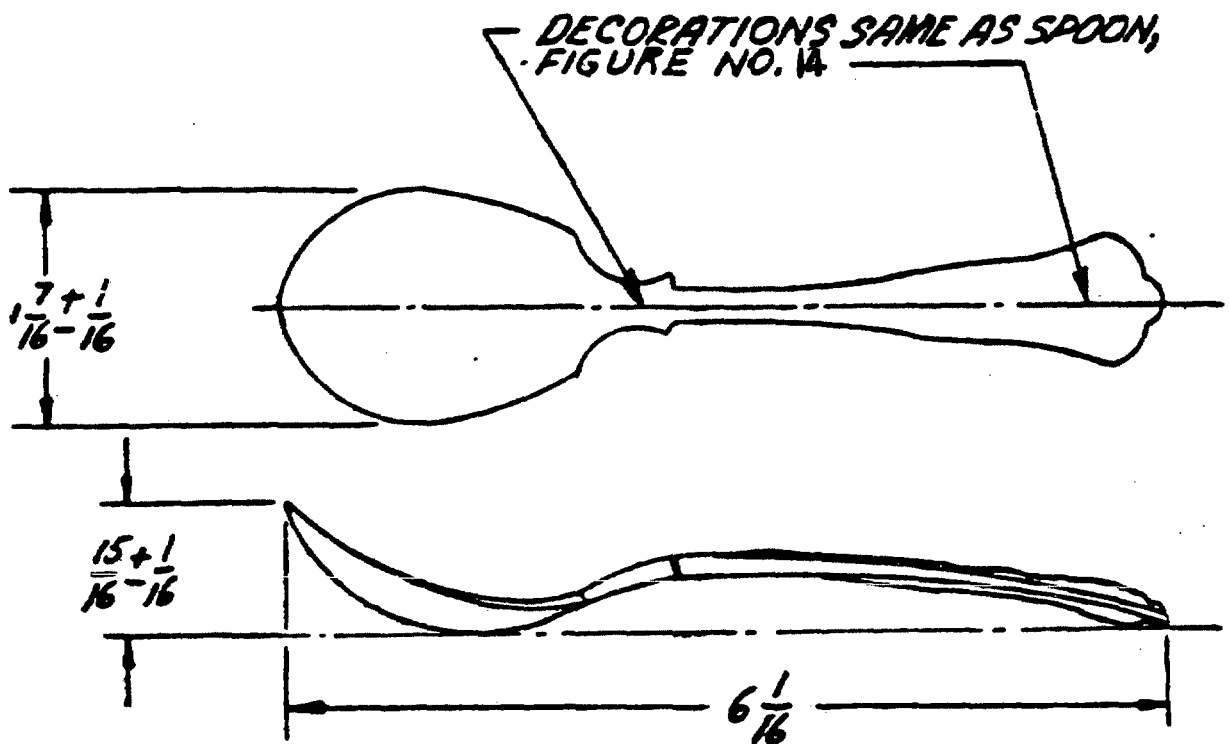


FIGURE 12 - SPOON, SUGAR

All dimensions are in inches

Length dimension tolerance: $\pm 1/4$ inch

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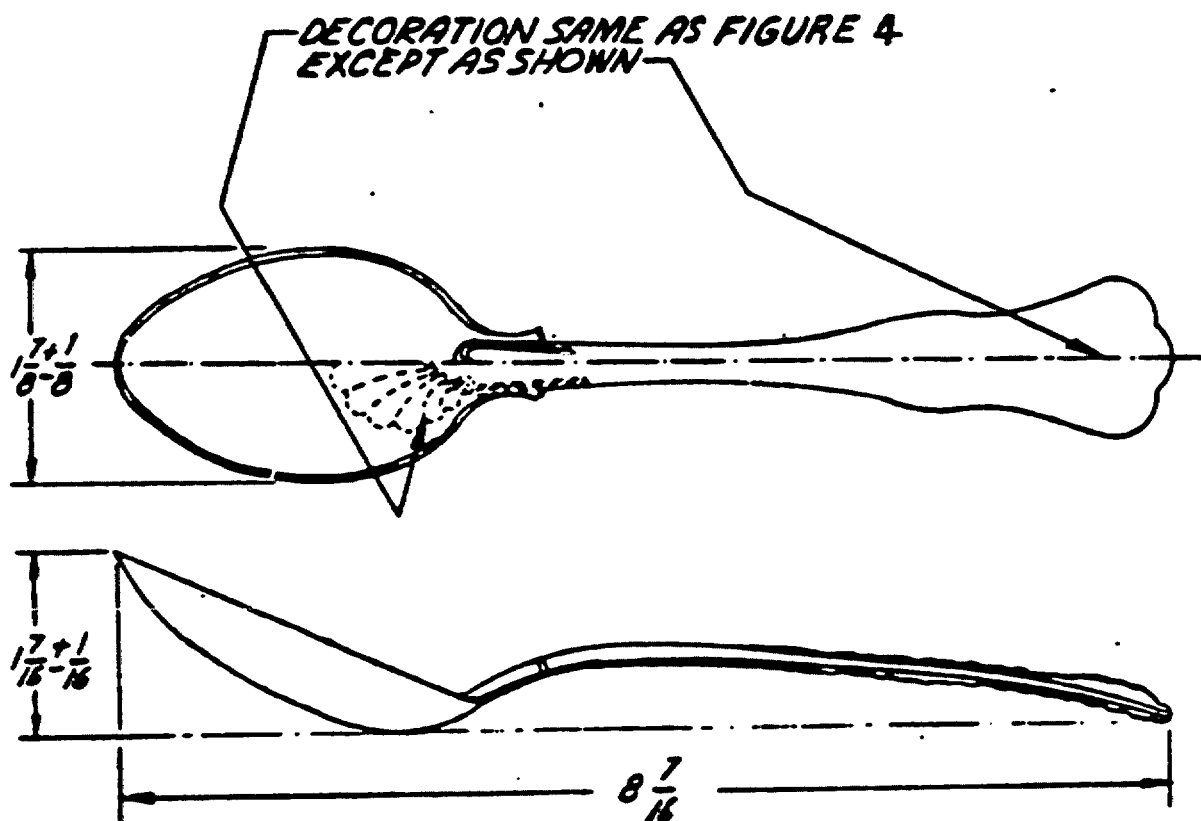


FIGURE 13 - SPOON, TABLE

All dimensions are in inches

Length dimension tolerance: $\pm 1/4$ inch

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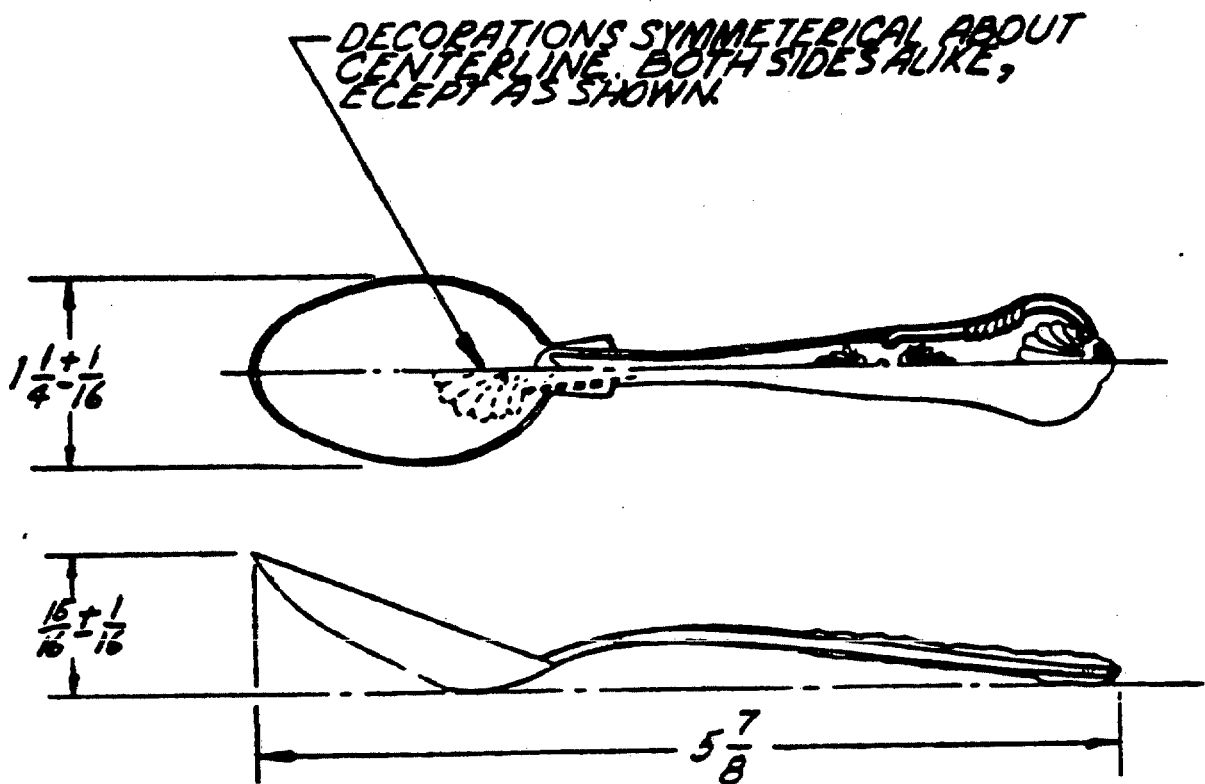


FIGURE 14 - SPOON, TEA

All dimensions are in inches

Length dimension tolerance: $\pm 1/4$ inch

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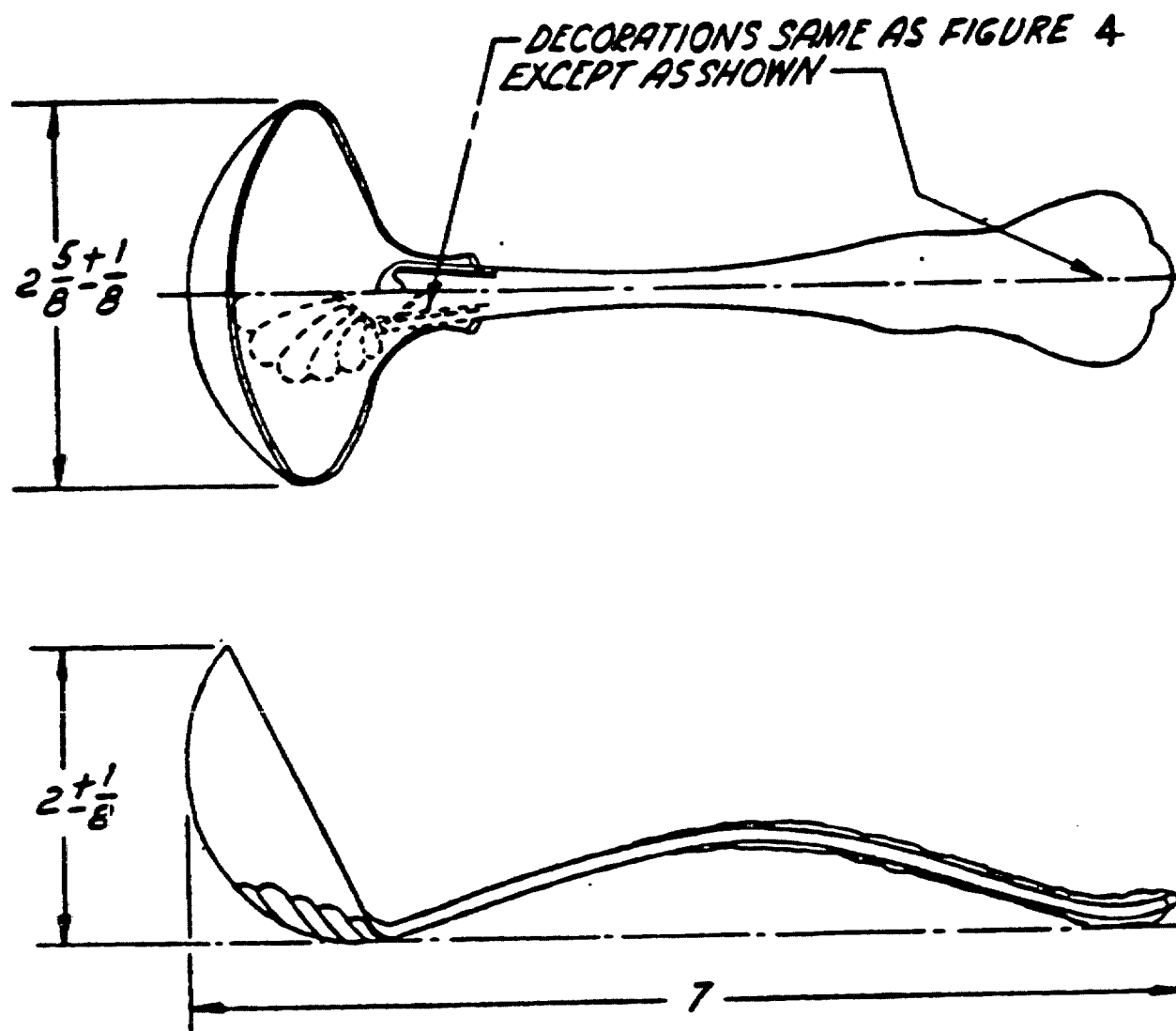


FIGURE 15 - LADLE, GRAVY, TABLE

All dimensions are in inches

Length dimension tolerance: $\pm \frac{1}{4}$ inch