

A-A-2594
March 16, 1989

COMMERCIAL ITEM DESCRIPTION

TRAY, SERVICE

The General Services Administration has authorized the use of this commercial item description in preference of Federal Specifications L-T-775 and L-T-776.

This commercial item description covers rectangular and trapezoidal service trays made from aluminum, fiberglass and plastic. They are not intended for direct contact with food for human consumption.

Salient characteristics.

Trays shall be of the following types, sizes, compositions, and colors as specified. The size and tolerances shall be as shown in Table I.

Type I - Rectangular (Figure 1)
 Size 1 - 20 1/2 by 15 1/4 inches
 Size 2 - 18 by 14 inches

Type II - Trapezoidal (Figure 2)
 Size 2 - 18 by 14 inches

Composition A - Aluminum alloy 3003 or 3004

Composition FG - Fiberglass

Composition P - Plastic, including phenolic molding materials, polycarbonate, and polypropylene

Color - Natural, Tan, Green, Brown, or other color as specified.

Table I - Dimensions

Size	Length inches +/- 3/32	Width inches +/- 3/32	Depth inch +/- 3/32	Corner radius inches +/- 3/16	Thickness inch minimum 1/
1	20 1/2	15 1/4	7/8	2 5/8	0.080
2	18	14	7/8	2 5/8	0.080

1/ Composition A, Aluminum trays shall have a minimum thickness of 0.050 inch.

Beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data which may improve this document should be sent to: General Services Administration, General Engineering Group (7FXEG), 819 Taylor St., Fort Worth, TX 76102

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 public release; distribution is unlimited.

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All materials used in the construction of the trays shall conform in every respect to the provisions of the Federal Food, Drug, and Cosmetic Act and General Regulations Promulgated Thereunder.

Type I trays shall be made in accordance with figure 1 and table I. Type II trays shall be made in accordance with figure 2 and table I. Composition A trays shall have the edge rolled over a tinned steel wire to form a tightly closed bead. At the manufacturer's option, Composition FG and P trays may have a wire-reinforced rim. Composition FG and P trays shall have a minimum of six stacking lugs molded on the side wall beneath the rim in order to permit an airspace between the trays when stacked.

Composition A trays shall be constructed from aluminum alloy 3003 or 3004. Composition FG trays shall have a minimum of 30 percent glass fiber content. Composition P trays shall be constructed from phenolic molding compounds, polycarbonate or polypropylene.

The trays shall be capable of passing the warpage test without exceeding 0.0625 inch measured warp. Composition FG and P trays shall show no cracks, change of color, or blooming of fibers and shall not warp more than 0.100 inch when tested for resistance to boiling water. Composition FG and P trays shall show no cracking or changes in finish when tested for resistance to acids and alkalis.

The surface of the tray shall have a uniform luster throughout produced by molding techniques and not by the application of a finish or protective coating of lacquer, varnish or other adulterant.

Workmanship. The finished trays shall be clean and free of flash, imperfections, sharp edges or irregularities, blisters, areas of delaminations, dimples, and other defects which may affect their appearance and serviceability. All surfaces shall be smooth, free from rough or sharp edges, and uniform in texture.

Quality Assurance:

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 Commercial Item Description where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

Inspection of the end item. Sampling shall be in accordance with MIL-STD-105, Sampling Procedures and Tables for Inspection by Attributes. The inspection lot shall consist of all trays of the same type, size, composition and color offered for inspection at one time. The sample unit shall be one tray.

Visual inspection. The visual examination of the trays for construction and workmanship defects shall be in accordance with Table II. The inspection level shall be S-3 and the acceptable quality levels (AQL's) shall be 2.5 percent defective for major defects and 6.5 percent defective for total defects.

TABLE II. Classification of defects

Examine	Defect	Classification	
		Major	Minor
Construction and Workmanship	Not specified type, size, composition or color	X	
	Deep cuts, nicks, sharp edges Waves, ripples or other surface irregularities, affecting serviceability	X	
	Slight dents, dimples, nicks, cuts, or scratches, affecting appearance		X
	Surfaces and curves not blended smoothly	X	
	Like units do not stack and nest firmly and evenly	X	
	Presence of oil, grease, dirt, wood shavings, metal chips, or other foreign material		X
	Any sign of delamination	X	

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Table II (Cont.)

Examine	Defect	Classification	
		Major	Minor
Finish	Stains, discoloration, wrinkles, or die marks	X	
	Orange peel, not uniform luster, or evidence of lacquer, varnish, or other coating material	X	
	Not uniform in texture, where applicable		X

Dimensional examination. Trays shall be measured for dimensional compliance with table I and figures 1 or 2, as applicable. Any nonconformance with specified requirements shall be classified a defect. The inspection level shall be II with an AQL of 6.5, expressed in defects per hundred units.

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 III. For examination of interior packaging, the sample unit shall be one shipping container fully prepared for delivery. The inspection level shall be S-2 with an AQL of 4.0 defects per hundred units. The sample unit shall be one unit, intermediate or shipping container as applicable.

Table III - Preparation for delivery defects

Examine	Defects
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.

Certificate of conformance. Unless otherwise specified, a certificate of conformance to the test requirements shall be acceptable in lieu of testing each lot. The contractor shall have available for review evidence that those tests specified herein have been performed on similar items in the past twelve months, that the product tested conformed with the requirements of this CID, and that the product being offered has been manufactured using the same materials, processes, and manufacturing techniques, and is otherwise identical to the product tested.

Testing of the end item. The end item shall be tested for the applicable characteristics. A sample unit shall consist of one complete tray. No more than one sample unit randomly selected shall be drawn from any one shipping container. The inspection level shall be S-1 and the AQL shall be 6.5 percent defective.

Warpage test. Warpage shall be determined by placing the tray upside down on a flat surface and holding it firmly in place by a 10 pound weight with a diameter not exceeding 5 inches positioned at the center of the tray. In this position, the tray shall be sufficiently plane so that the clearance between the tray and flat surface at any point measured is less than the thickness of a 0.0625 inch feeler gauge.

Resistance to boiling water test. Composition FG and P trays shall be immersed by suspension for 1 hour in boiling water in a manner to avoid tray contact with the sides of the vessel containing the boiling water. After immersion, the tray shall be removed from the water, wiped dry, and allowed to cool without assistance to normal room temperature before examination. The tray shall be examined for cracks, changes of color and blooming of fibers. The tray shall be examined for warpage in accordance with the warpage test except that the maximum allowed warp shall be 0.100 inch.

Resistance to acids. One pool of 5 percent (by weight) acetic acid, one of 5 percent (by weight) citric acid, one of 5 percent (by weight) tannic acid and one of 5 percent (by weight) hydrochloric acid shall be made on the top surface of the tray. Each pool shall consist of approximately 15 drops of solution and shall be spaced sufficiently far apart to prevent mixing of the solutions. The solution shall be carefully deposited with a pipette or other instrument equally effective in preventing splashing and mixing of the pools. Four hours after the acid solutions have been placed on the surface, they shall be absorbed by means of blotting paper and the surface shall be wiped dry and examined for cracking or changes in finish.

Resistance to alkalis. The tray shall be immersed in a boiling 2 percent sodium carbonate solution for 30 minutes. The tray shall be rinsed in cold water, wiped dry and examined for cracking and changes in finish.

Metric products. Products manufactured to metric dimensions will be considered on an equal basis with those manufactured using inch-pound units, provided they fall within the tolerances specified using conversion tables contained in the latest revision of Federal Standard No. 376, and all other requirements of this CID are met.

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If a product is manufactured to metric dimensions and those dimensions exceed the tolerances specified in the inch/pound units, a request should be made to the contracting officer to determine if the product is acceptable.

The contracting officer has the option of accepting or rejecting the product.

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 and marking (Civil Agencies). Preservation, packaging, packing, and marking shall be as specified in the contract or purchase order.

Packaging (DoD). Packaging shall be in accordance with ASTM Standard D 3951.

Notes. Purchaser should specify type, size, composition and color required.

National Stock Numbers (NSNs):

7350-00-879-9128	Type I, Size 1, Composition A
7350-00-926-6181	Type I, Size 1, Composition FG, Color - Natural
7350-00-926-6180	Type I, Size 2, Composition FG, Color - Natural
7350-00-789-0095	Type II, Size 2, Composition FG, Color - Green

Part Numbering System for Commercial Item Description A-A-2594

Example: AA2594 - I 1 A T (AA2594-11AT)

				----- Color, T - Tan
				----- Composition, A - Aluminum
				----- Size, 1 - 20 1/2 by 15 1/4 inches
				----- Type, I - Rectangular

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

Application for copies of ASTM Standards should be addressed to ASTM, 1916 Race Street, Philadelphia, PA 19103.

The standards referenced in this document shall be the issues in effect on the date of the invitation for bids or request for quotation and shall be used to determine compliance with these requirements. In the event that there is a conflict between this document and a standard referenced herein, this document shall take precedence.

This commercial item description (cid) may involve hazardous materials, operations, and equipment. This cid does not purport to address all of the safety problems associated with its use. It is the responsibility of whoever uses this cid to consult and establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

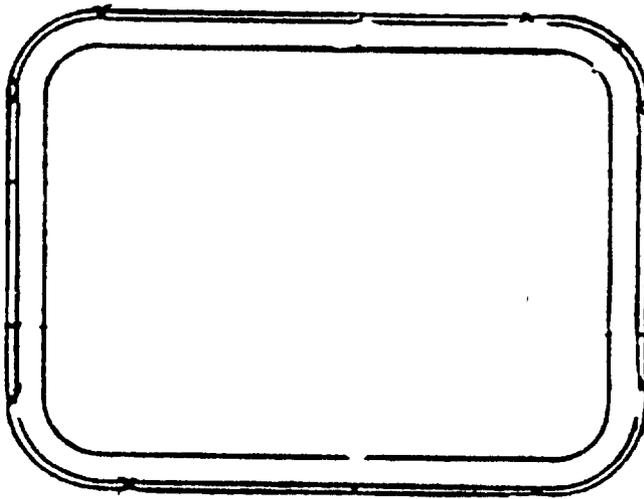


FIGURE 1

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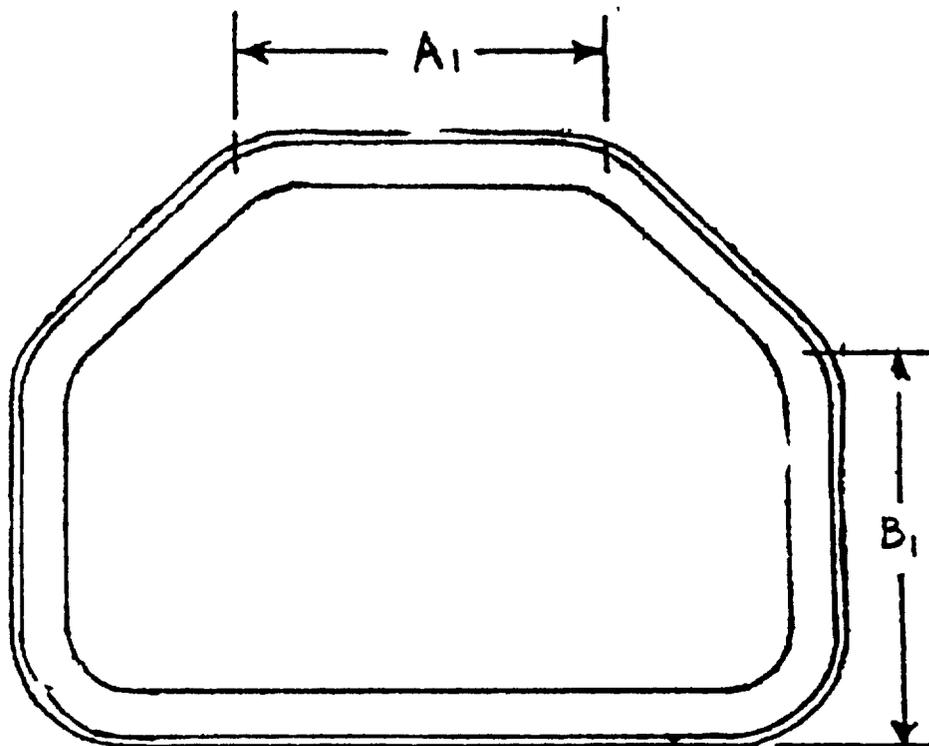


FIGURE 2

Dimension A_1 - 8 inches \pm 3/32 inch

Dimension B_1 - 9 inches \pm 3/32 inch

MILITARY INTERESTS:

NONE: DoD has determined that no military activity has an official interest in this CID.

CIVIL AGENCY COORDINATING ACTIVITY:

VA-OSS

PREPARING ACTIVITY:

GSA-FSS