

A-A-51153
13 March 1986

COMMERCIAL ITEM DESCRIPTION

CLEANING SETS, OXYGEN AND ACETYLENE, WELDING AND CUTTING TORCH TIPS

The General Services Administration has authorized the use of this commercial item description in preference to Military specification MIL-C-14223A.

1. SCOPE

1.1 Scope. This description covers oxygen and acetylene welding and cutting torch tip cleaners of the standard commercial type which are intended for industrial usage.

1.2 Classification. Tip cleaner sets shall be of the following types. The type of tip cleaning set to be furnished shall be as specified (see 6.1).

Type I - Tip cleaner set for torch orifice sizes 0.018 through 0.073 (see table I).

Type II - Tip cleaner set for torch orifice sizes 0.076 through 0.128 (see table II).

Type III - Tip cleaner set for torch orifice sizes 0.018 through 0.128 (see table I and II).

2. APPLICABLE DOCUMENTS

2.1 Documents. The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this description to the extent specified herein. The documents should be obtained from the contracting activity or as directed by the contracting officer.

Federal Specification PPP-T-1150 - Tools and Tool Accessories for Power Driven, Metal and Woodworking Machinery, Packaging and Packing of.

Federal Standard FED-STD-376 - Preferred Metric Units for General Use by the Federal Government.

A-A-51153

TABLE I. Type I tip cleaner set.

Drill size number		Cleans torch orifice size (inches)		Ridge diameter (inches)
minimum	maximum	minimum	maximum	
77	76	.0180	.0200	.0160
75	74	.0210	.0225	.0195
73	71	.0240	.0260	.0230
70	68	.0280	.0310	.0265
67	65	.0320	.0350	.0310
64	62	.0360	.0380	.0345
61	60	.0390	.0400	.0380
59	58	.0410	.0420	.0400
57	57	.0430	.0460	.0420
56	56	.0465	.0510	.0440
55	54	.0520	.0550	.0500
53	52	.0590	.0635	.0570
51	49	.0670	.0730	.0650

TABLE II. Type II tip cleaner set.

Drill size number		Cleans torch orifice size (inches)		Ridge diameter (inches)
minimum	maximum	minimum	maximum	
48	47	.0760	.0785	.0750
46	45	.0810	.0820	.0800
44	43	.0860	.0890	.0850
42	41	.0935	.0960	.0920
39	38	.0995	.1015	.0965
37	36	.1040	.1065	.1015
35	33	.1100	.1130	.1085
32	31	.1160	.1200	.1140
30	30	.1285	.1300	.1265

A-A-51153

American Society for Testing and - Standard Practice for Commercial
Materials ASTM D 3951 Packaging.

3. SALIENT CHARACTERISTICS

3.1 Design. The tip cleaners shall be new and of the manufacturer's standard design on the date of the solicitation. The cleaning portion shall consist of a series of uniformly spaced, annular ridges of smooth contour. The tip cleaners shall not cut or scratch the orifice walls of the oxygen-fuel cutting and welding tips. Means shall be provided for mounting the tip cleaners in a case, in such a manner that any individual cleaner can be swung out of the case for use without interference from the case or the remaining cleaners. The sets shall be assembled in consecutive order as specified in tables I and II. The type I set shall include all tip cleaners shown in table I. The type II set shall include all tip cleaners shown in table II. The type III set shall include all tip cleaners shown in tables I and II.

3.2 Material. Tip cleaners shall be made of 302 or 304 stainless steel wire.

3.3 Measurement system. All dimensions in this description are given in US units. The measurements may be converted to SI units through the use of the conversion factors and methods specified in FED-STD-376.

3.4 Dimensions and tolerances. Each tip cleaner shall be not less than $2 \frac{1}{4}$ inches or not greater than $2 \frac{3}{4}$ inches in length. The ridged cleaning portion shall be not less than $\frac{3}{4}$ inch and not greater than 1 inch in length. The pilot end shall be not less than $\frac{1}{4}$ inch and not greater than $\frac{1}{2}$ inch in length. The tip of the pilot end shall be rounded and free of burrs and sharp edges. The ridged diameter and the torch orifice size shall be as specified in tables I and II. The allowable ridged cleaning portion diameter of the tip cleaners shall be +0.0005 inches -0.0015 inches or drill sizes 77 thru 43 and +0.001 inches -0.002 inches for drill sizes 42 thru 30.

3.5 Tip cleaning case. The tip cleaning case material and construction shall be of the manufacturer's standard commercial product.

3.6 Regulatory requirements. The offeror/contractor is encouraged to use recovered materials to the maximum extent practical.

3.7 Workmanship. Workmanship of the tip cleaners shall be of a quality equal to that of comparable products furnished to the commercial market.

A-A-51153

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection and examination requirements specified herein. Except as otherwise specified in the contract or purchase 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 inspections set forth in this description where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.2 Sampling inspection. The supplier shall randomly select the number of samples in table III that is applicable to the quantity of items being purchased. Each sample item shall be inspected to determine conformance with the examination in 4.3 and the dimensional and tolerance inspection in 4.4. Any sample failing to meet all requirements specified herein shall be considered a defective item. If the number of defective items is equal to or less than the quantity specified under the "Acceptance, number defective" column of table III, the supplier shall replace the defective samples with items that meet all the requirements specified herein and the entire lot shall be considered acceptable for shipment. If the number of defective samples is equal to or greater than the quantity specified in the "Rejection, number defective" column of table III, the entire lot shall be considered defective and unsuitable for acceptance. A lot is defined as all tip cleaner sets of the same type presented at one time for acceptance.

TABLE III. Sampling plan.

Quantity of items being purchased			Sample size	Acceptance, number defective	Rejection, number defective
2	to	8	2	0	1
9	to	15	3	0	1
16	to	25	5	0	1
26	to	50	8	1	2
51	to	90	13	1	2
91	to	150	20	2	3
151	to	280	32	3	4
281	to	500	50	5	6
501	to	1200	80	8	9
1201	to	3200	125	12	13
3201	to	9999	200	18	19

A-A-51153

4.3 Examination. Each tip cleaning set submitted for sample inspection shall be visually examined to determine conformance with all requirements in this description.

4.4 Dimensions and tolerances. Each sample tip cleaning set shall be inspected to assure conformance with all dimensions and tolerances specified in 3.4.

4.5 Packaging inspection. Packaging shall be inspected for conformance with section 5.

5. PACKAGING

5.1 Preservation, packing, and marking. Unless otherwise specified in the contract or purchase order, preservation, packing, and marking shall be in accordance with ASTM D 3951. When specified (see 6.1), preservation, packing, and marking shall be in accordance with Federal Specification PPP-T-1150, level as required.

6. NOTES

6.1 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this commercial item description.
- b. Type and quantity required (see 1.2).
- c. Packaging in accordance with PPP-T-1150, if required (see 5.1).

6.2 Cross reference data. Cross reference of classification changes between this commercial item description and MIL-C-17223A are as follows:

MIL-C-17223A

Standard tip cleaner set

A-A-New

Type I (New type)
Type II (New type)
Type III (New type)

A-A-51153

MILITARY INTEREST:

Custodians

Army - AR
Navy - SH
Air Force - 99

Review Activities

DLA - GS
Air Force - 84

CIVIL AGENCY COORDINATING ACTIVITY:

GSA - FSS

PREPARING ACTIVITY:

DLA - IP

Project 3439-0549