

A-A-51153A
March 19, 1991
SUPERSEDING
A-A-51153
March 13, 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.

Abstract. This description covers oxygen and acetylene welding and cutting torch tip cleaners of the standard commercial type.

Classification. The tip cleaning sets shall be of the following sizes. The size to be furnished shall be as specified (see ordering data).

- Size 1 - Tip cleaner set for torch orifice sizes 0.018 through 0.073 (see table I).
- Size 2 - Tip cleaner set for torch orifice sizes 0.076 through 0.128 (see table II).
- Size 3 - Tip cleaner set for torch orifice sizes 0.018 through 0.128 (see tables I and II).

Salient characteristics.

1. Design. The cleaning portion of the tip cleaners shall consist of a series of uniformly spaced, annular ridges of smooth contour. The tip cleaners shall not 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.

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

3. Dimensions. Each tip cleaner shall be not less than 2-1/4 inches and not greater than 2-3/4 inches in length. The ridged cleaning portion shall be not less than 3/4 inch and not greater than 1 inch in length. The pilot end shall be not less than 1/4 inch and not greater than 1/2 inch in length. The tip of the pilot end shall be rounded and free of burrs and sharp edges.

Beneficial comments recommendations, additions, deletions, clarifications, etc., and any data which may improve this document should be sent to: Defense Industrial Plant Equipment Center, ATTN: DIPEC-SSG, 2163 Airways Blvd., Memphis TN 38114-5051.

AMSC N/A

FSC 3439

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TABLE I. Size 1 tip cleaner set.

Drill size number		Cleans torch orifice size (inches)		Ridge diameter (inches)
minimum	maximum	minimum	maximum	
77	76	0.0180	0.0200	0.0160
75	74	0.0210	0.0225	0.0195
73	71	0.0240	0.0260	0.0230
70	68	0.0280	0.0310	0.0265
67	65	0.0320	0.0350	0.0310
64	62	0.0360	0.0380	0.0345
61	60	0.0390	0.0400	0.0380
59	58	0.0410	0.0420	0.0400
57	57	0.0430	0.0460	0.0420
56	56	0.0465	0.0510	0.0440
55	54	0.0520	0.0550	0.0500
53	52	0.0595	0.0635	0.0570
51	49	0.0670	0.0730	0.0650

TABLE II. Size 2 tip cleaner set.

Drill size number		Cleans torch orifice size (inches)		Ridge diameter (inches)
minimum	maximum	minimum	maximum	
48	47	0.0760	0.0785	0.0750
46	45	0.0810	0.0825	0.0800
44	43	0.0860	0.0890	0.0850
42	41	0.0935	0.0960	0.0925
39	38	0.0995	0.1015	0.0965
37	36	0.1040	0.1065	0.1015
35	33	0.1100	0.1130	0.1085
32	31	0.1160	0.1200	0.1140
30	30	0.1285	0.1300	0.1265

4. Tolerances. The tolerance of the ridge diameter shall be not greater than +0.0005 inch and -0.0015 inch for drill sizes 77 thru 43 and +0.001 inch and -0.002 inch for drill sizes 42 thru 30.

5. Tip cleaner case. Material and construction of the cleaning case shall be of the manufacturer's standard commercial product.

Contractor certification. The contractor shall certify and maintain substantiating evidence that the product offered meets the salient characteristics of this commercial item description, and that the product

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conforms to the producer's own drawings, specifications, standards, and quality assurance practices. The Government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

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.

Environmental protection. During the manufacture of the cleaning sets, materials hazardous to the ecological system as prohibited by the Federal, state, or local statutes in effect on the date of the contract shall not be used or emitted.

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

NOTES.

Ordering data. Purchasers should select the preferred options permitted herein, and include the following information in procurement documents:

- a. Title, number, and date of this commercial item description.
- b. Size, and quantity required.

CID based part identification number. The following part identification numbering procedure is for Government purposes and does not constitute a requirement for the contractor.

A	51155	X	
			----- Size
			----- Prefix
			----- CID number

MILITARY INTEREST:

Custodians

Army - AL
Navy - SH
Air Force - 99

Review Activities

Air Force - 84
DLA - GS

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PREPARING ACTIVITY:

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Project 3439-0161

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1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
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I RECOMMEND A CHANGE:

1. DOCUMENT NUMBER
A-A-51153A

2. DOCUMENT DATE (YYMMDD)
91 03 19

3. DOCUMENT TITLE

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

4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)

5. REASON FOR RECOMMENDATION

6. SUBMITTER

a. NAME (Last, First, Middle Initial)

b. ORGANIZATION

c. ADDRESS (Include Zip Code)

d. TELEPHONE (Include Area Code)
(1) Commercial
(2) AUTOVON
(If applicable)

7. DATE SUBMITTED
(YYMMDD)

8. PREPARING ACTIVITY

a. NAME

Defense Industrial Plant Equipment Center
ATTN: DIPEC-SSG

b. TELEPHONE (Include Area Code)
(1) Commercial
(2) AUTOVON

(901)-775- 6247

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Memphis, TN 38114-5051

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