

[INCH-POUND]
A-A-51153B
19 May 2000
SUPERSEDING
A-A-51153A
19 March 1991

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 for all federal agencies.

1. **SCOPE.** This commercial item description covers tip cleaners for hand-held oxyacetylene welding and cutting torches.
2. **CLASSIFICATION.** The tip cleaning sets shall be of the following sizes listed in tables I and II. The sizes to be furnished shall be as specified (see 7.2(b)).

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 0.221 (see table II)

Size 3 - Tip cleaner set for torch orifice sizes 0.018 through 0.221 (see tables I and II)

3. SALIENT CHARACTERISTICS

3.1 **General requirements.** 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.

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

3.3 **Dimensions.** Each tip cleaner shall be not less than 2-1/4 inches and not greater than 2-3/4 inches in length. The ridge 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 round and free of burrs and sharp edges.

Beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data that may improve this document should be sent to: Defense Supply Center Richmond (DSCR), ATTN: DSCR-VBD, 8000 Jefferson Davis Highway, Richmond, VA 23297-5610.

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TABLE I. Size 1 tip cleaner set.

Torch tip orifice size, inches		Drill size		Ridge diameter, inch
Minimum	Maximum	Minimum	Maximum	
0.0180	0.0200	77	76	0.0160
0.0210	0.0225	75	74	0.0195
0.0240	0.0260	73	71	0.0225
0.0280	0.0310	70	68	0.0265
0.0320	0.0350	67	65	0.0305
0.0360	0.0380	64	62	0.0345
0.0390	0.0400	61	60	0.0375
0.0410	0.0420	59	58	0.0395
0.0430	0.0460	57	57	0.0415
0.0465	0.0510	56	56	0.0450
0.0520	0.0550	55	54	0.0505
0.0595	0.0635	53	52	0.0575
0.0670	0.0730	51	49	0.0655

Note: The tolerance of the ridge diameter shall not exceed ± 0.001 inch.

TABLE II. Size 2 tip cleaner set.

Torch tip orifice size, inches		Drill size		Ridge diameter, inch
Minimum	Maximum	Minimum	Maximum	
0.0760	0.0785	48	47	0.0745
0.0810	0.0825	46	45	0.0795
0.0860	0.0890	44	43	0.0845
0.0935	0.0960	42	41	0.0920
0.0995	0.1015	39	38	0.0980
0.1040	0.1065	37	36	0.1025
0.1100	0.1130	35	33	0.1085
0.1160	0.1200	32	31	0.1145
0.1285	0.1300	30	30	0.1265
0.1410	0.1435	28	28	0.1400
0.1620	0.1645	20	20	0.1610
0.1850	0.1875	13	13	0.1840
0.2210	0.2230	2	2	0.2200

Note: The tolerance of the ridge diameter shall not exceed ± 0.001 inch.

4. REGULATORY REQUIREMENTS

4.1 Recovered materials. The offeror/contractor is encouraged to use recovered materials to the maximum extent practicable, in accordance with paragraph 23.403 of the Federal Acquisition Regulation (FAR).

5. QUALITY ASSURANCE PROVISIONS

5.1 Product conformance. The products provided shall meet the salient characteristics of this commercial item description, conform to the producer's own drawings, specifications, standards, and quality assurance practices, and be the same product offered for sale in the commercial marketplace. The government reserves the right to require proof of such conformance.

6. PACKAGING

6.1 Preservation, packing, and marking. For acquisition purposes, the tip cleaner set shall be preserved, packed, and marked as specified in the acquisition order (see 7.2(c)).

7. NOTES

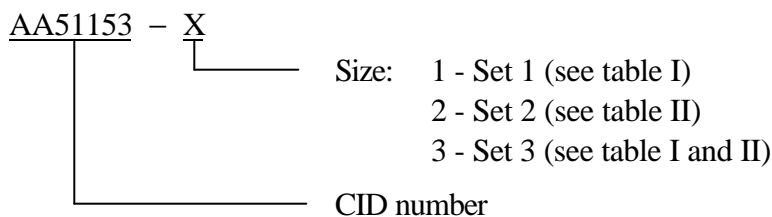
7.1 Source of documents.

7.1.1 FAR. The FAR may be obtained from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402-0001.

7.2 Ordering data. Acquisition documents must specify the following:

- a. Title, number, and date of this document
- b. Tip cleaner set (see 2)
- c. Packaging if different (see 6.1)

7.3 Part or identification number (PIN). The following part or identification numbering procedure is for government purposes and does not constitute a requirement for the contractor.



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MILITARY INTERESTS:

Custodians:

Army - AL

Navy - SH

Air Force - 99

Reviewer:

Air Force - 84

CIVIL AGENCY
COORDINATING ACTIVITY:

GSA - 6FET

Preparing activity:

DLA - GS

(Project 3439-0876)