

INCH-POUND

A-A-51195B  
13 April 2011  
SUPERSEDING  
A-A-51195A  
2 June 1998

## COMMERCIAL ITEM DESCRIPTION

### PRESS, ARBOR, "C" FRAME HYDRAULIC, HAND OPERATED

The General Services Administration has authorized the use of this commercial item description for all federal agencies.

1. **SCOPE.** This commercial item description (CID) covers both "C" (gap) and "4" post frame type hydraulic bench- or pedestal-mounted, hand-operated, arbor presses of the standard commercial type, which are used to force arbors into and out of holes or to assemble and disassemble press fit parts.

2. **CLASSIFICATION.** The arbor presses shall be classified by the following types and sizes:

2.1 **Type.** The arbor press shall be one of the following types, as specified (see (7.3(c)):

Type I - "C" (gap) frame

Type II - "4" post frame

2.2 **Size.** The arbor press shall be one of the following sizes, as specified (see (7.3(d)):

Size 10 - 10 ton

Size 25 - 25 ton

Beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data that may improve this document should be sent to: [STDZNMGT@dla.mil](mailto:STDZNMGT@dla.mil) or Defense Logistics Agency Aviation VEB, 8000 Jefferson Davis Highway, Richmond, VA 23297-5616. Since contact information can change, you may want to verify the currency of this address information using the ASSIST database at <https://assist.daps.dla.mil/>.

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## 3. SALIENT CHARACTERISTICS

3.1 Frame. The frame shall be of the "C" (gap) or "4" post frame type. When only one style of frame is acceptable, the particular style required shall be specified in the acquisition order (see 7.3(c)). The frame shall support the hydraulic system and ram assembly. The frame shall provide a means for securing the press to a bench or pedestal. The ram shall be perpendicular to the table surface to an accuracy of 0.025 inch total indicator reading per 6 inches of ram travel. The table shall have an opening aligned with the ram axis that will allow passage of the arbor.

3.2 Hydraulic system. The hydraulic system shall consist of a hand-operated pump, a fluid reservoir, a cylinder with ram, and the necessary fittings and hoses to ensure a complete hydraulic system. Unless otherwise specified in the acquisition order (see 7.3(e)), the system shall be equipped with a single acting cylinder. The system shall have overload protection and a means of preventing extension of the ram beyond its normal end-of-stroke position. Unless otherwise specified in the acquisition order (see 7.3(f)), the stroke length of the ram shall be 10.125 inches. A pressure gauge calibrated to read tons of ram force shall be provided.

3.3 Bolster plate. The "C" (gap) frame presses shall be provided with a circular bolster plate having not less than four equally spaced slots of varying widths for the passage of an arbor. The bolster plate shall be removable and shall allow the desired plate slot to be positioned below the ram.

3.4 Radius of work. The radius of work is defined as the distance from the center of the ram to the frame. Unless otherwise specified in the acquisition order (see 7.3(g)), the radius of work for the press to be furnished shall be selected from table I. The tolerance of the radius of work shall be  $\pm 0.5$  inch.

TABLE I. Radius of work.

Radius of work designation	Radius of work (in)
A	6.500
B	8.000
C	9.000
D	9.500

NOTE: Largest diameter of work is two times the radius. The radius of work designation is for use in developing the CID-based part or identification number only (see 7.1).

3.5 Vertical capacity. The vertical capacity is defined as the distance when measured from top of table surface to ram (ram up). Unless otherwise specified in the acquisition order (see 7.3(h)), the vertical capacity for the press to be furnished shall be as specified and selected from table II. The tolerance of the vertical capacity shall be  $\pm 1.0$  inch.

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TABLE II. Vertical capacity.

Vertical capacity designation	Distance ram to table (in)
1	9.500
2	15.000
3	15.375
4	16.500
5	20.250

NOTE: The vertical capacity designation is for use in developing the CID-based part or identification number only (see 7.1).

3.6 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 specified tolerances using conversion tables contained in the latest revision of FED-STD-376, "Preferred Metric Units for General use by the Federal Government", and all other requirements of this CID are met.

#### 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).

4.2 Environmental protection. During the manufacture of the press, materials hazardous to the ecological systems as prohibited by the Federal, State, or local statutes in effect on the date of the contract shall not be used or emitted.

#### 5. PRODUCT CONFORMANCE PROVISIONS

5.1 Product conformance. The products provided shall meet the salient characteristics of this CID, 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.

5.2 Market acceptability. The products offered must have been previously sold either to the government or on the commercial market.

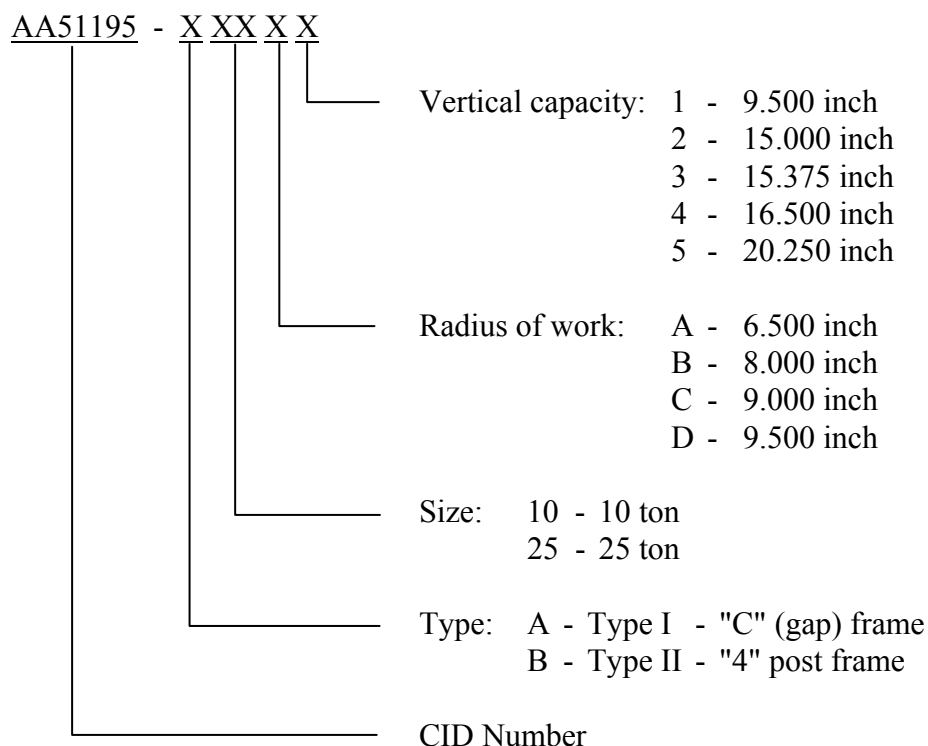
#### 6. PACKAGING

6.1 Preservation, packing, and marking. Preservation, packing, and marking shall be as specified in the acquisition order (see 7.3(i)).

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## 7. NOTES

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



Example of reference part number: AA51195 - A10D5

7.2 Sources of documents.

7.2.1 FAR. The FAR may be obtained from the Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954. Electronic copies may be obtained from <https://www.acquisition.gov/far/>.

7.2.2 Federal standards. Copies of federal standards may be obtained from General Services Administration, Federal Supply Service, Specification Section, 470 East L'Enfant Plaza SW, Suite 8100, Washington, DC 20407. Electronic copies may be obtained from <https://assist.daps.dla.mil/>.

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7.3 Ordering data. The acquisition order should specify the following information:

- a. CID document number, revision, and CID PIN.
- b. Quantity required.
- c. Type (see 2.1 and 3.1).
- d. Size (see 2.2).
- e. Dual acting cylinder, if required (see 3.2).
- f. Stroke length, if different (see 3.2).
- g. Radius of work, if different (see 3.4).
- h. Vertical capacity, if different (see 3.5).
- i. Preservation, packing, and marking (see 6.1).

7.4 Intended use. Arbor presses covered by this CID are for use in machine production, repair, and maintenance shops.

7.5 Subject term (key word) listing.

Bench  
Bolster  
Cylinder  
Pedestal  
Ram

MILITARY INTERESTS:

Custodians:

Army - AR  
Navy - SH  
Air Force - 99  
DLA - GS

Review Activities:

Navy - YD  
Air Force - 84

Preparing Activity:

DLA - GS6

(Project 3444-2011-001)

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