METRIC

A-A-59115
21 January 1998

COMMERCIAL ITEM DESCRIPTION

PAPER, MAP AND CHART, LITHOGRAPHIC-FINISH, ROLLED

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 two types of lithographic finish paper for use in printing charts and maps and reflects requirements parallel to those of the United States Government Printing Office as expressed in the Paper Schedules compiled by the Joint Committee on Printing (JCP). The paper is shipped in bulk rolls in accordance with the schedules herein.

2. CLASSIFICATION

2.1. Type 1. Offset Map, Lithographic-finish (JCP E30), rolled.

2.2. Type 2. 50% Chart, Lithographic-finish (JCP E50), rolled.

3. SALIENT CHARACTERISTICS

3.1. Type 1. Type 1 paper shall conform to Paper Schedule JCP E30, dated July 25,1996 in all respects except as follows:

a. Delivery shall be in rolls. The end of rolls shall be protected. Labels shall not be pasted on the ends of rolls. Labels shall be pasted on opposite sides of rolls.

b. Roll width and diameter shall be selected from the following schedule and shall be cited in the contract or purchase order:

Width (± 2mm)(1/16 inch)	Maximum roll dia.(nom)		Basis weight (±5%)
1105mm (43 ½ inches)	1016mm	(40 inches)	$90g/m^2$(60 lbs)$_{1 \text{ - see note}}$
781mm (30 ¾ inches)	1016mm	(40 inches)	$90g/m^2$(60 lbs)$_{1 \text{ - see note}}$
1187mm (46 ¾ inches)	1016mm	(40 inches)	$90g/m^2$(60 lbs)$_{1 \text{ - see note}}$
1238mm (48 ¾ inches)	1016mm	(40 inches)	$90g/m^2$(60 lbs)$_{1 \text{ - see note}}$

(Note 1. Basis weight in pounds is derived from equivalent basis weight of 500 sheets, size 25 X 38 inches in accordance with method T-410 of The Technical Association of the Pulp and Paper Industry (TAPPI)).

3.2. Type 2. Type 2 paper shall conform to Paper Schedule JCP E50, dated Jan 20, 1994 in all respects except as follows:

a. Delivery shall be in rolls. The end of rolls shall be protected. Labels shall not be pasted on the ends of rolls. Labels shall be pasted on opposite sides of rolls.

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

AMSC N/A FSC 9310

b. Roll width and weight shall be selected from the following schedule and shall be cited in the contract or purchase order:

Width (± 2mm)(1/16 inch)	Maximum roll dia.(nom)		Basis weight (±5%)
1086mm (42 ¾ inches)	1016mm	(40 inches)	$135g/m^2$(36 lbs)$_{2}$ - see note
934mm (36 ¾ inches)	1016mm	(40 inches)	$135g/m^2$(36 lbs)$_{2}$ - see note

(Note 2. Basis weight in pounds is derived from equivalent basis weight of 500 sheets, size 17 X 22 inches in accordance with method T-410 of The Technical Association of the Pulp and Paper Industry (TAPPI)).

3.3. Roll winding. The paper shall be tightly wound at even tension and shall not contain more than three splices per roll. Paper shall be free of cuts and wrinkles. The direction for unwinding the roll shall be indicated on the outer wrapper by an arrow symbol stamped near the ends of the roll. The unwind direction shall also be indicated on each roll end.

3.3.1. Splices. Splices shall be neatly and securely overlap-pasted and shall be made with repulpable adhesive which will not permit the splice to separate. The adhesive may be applied from a tape form backing, provided the backing is removed, leaving only the adhesive component on the splice. The adhesive shall not cause the splice to adhere to adjacent laps. The repulpable adhesive shall not allow the splice to separate while passing through a drying oven maintained at 200°C. The tails of the splices shall be neatly and evenly removed without damage to adjacent laps. Splices shall be flagged at both ends with projecting colored markers, which shall not be pasted to the splice.

3.3.2. Caps, cores, and keyways. No keyways, no metal inserts or caps shall be used with the cores. Cores shall conform to U.S. Government Printing Office drawing number G.A. 4540F, dated 04/93. Core diameter shall be 78mm $^{+0}/_{-0.40}$mm (3 $^{1}/_{16}$ in. $^{+0}/_{-\ 1/64}$ in.). Unless otherwise specified in the contract or purchase order, cores of type "A", "B", or "C" construction will be acceptable. When specified in the contract or purchase order, non-returnable fiber cores conforming to drawing G.A. 4540F may be used.

3.4. Slime holes. The number of slime holes per roll shall not exceed four. Slime holes larger than 100mm by 100mm (4 in. by 4 in.) shall be cut out and replaced by a splice.

4. REGULATORY REQUIREMENTS

4.1. Recovered materials. The specifications and paper schedules included in this CID shall conform to the Minimum Content Standards cited in the Paper Recovered Materials Advisory Notice (61 FR 26985) for purchasing paper and paper products in compliance with section 6002 of the Resources Conservation and Recovery Act (RCRA) of 1976 (42 U.S.C. 6962). The government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be required under the provisions of the contract.

4.2. Recycled content labeling. The recycled content shall be marked on the product labels.

5. QUALITY ASSURANCE PROVISIONS

5.1 Product conformance. The product provided shall meet the salient characteristics of this Commercial Item Description, conform to the manufacturer's own drawings, process sheets, specifications, standards, and quality assurance practices and shall be the same product offered for sale in the commercial market. When specific quality assurance provisions are specified for any commercial characteristic the manufacturer shall maintain records resulting from his inspection(s) conducted in accordance with the specific quality assurance provisions. The government reserves the right to require proof of such conformance. The government reserves the right to audit the manufacturer's quality assurance records.

5.2. Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection requirements as specified herein or by referenced documents specified herein. The manufacturer shall provide and maintain a quality assurance process (inspection system) that is acceptable to the Government covering the paper to be delivered in accordance with this CID. The quality assurance system shall be utilized to perform all inspections and tests of materials and components prior to incorporation into end product and for such in process controls as necessary to verify conformance of the product to the requirements stated herein and for such end articles prior to offering them for delivery. The manufacturer is responsible for controlling product quality and for offering to the Government for acceptance only paper that conforms to contract requirements and for maintaining objective evidence of this performance. The manufacturer may utilize his own inspection and testing facilities or any commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specifications and paper schedules where such inspections are deemed necessary to assure that product conforms to prescribed requirements.

5.3. Responsibility for compliance. Paper shall meet all requirements described herein. The inspections set forth in this document shall become a part of the manufacturer's overall in process inspection system or quality assurance program. The absence of any inspection requirements in this CID shall not relieve the manufacturer of the responsibility of ensuring that all products submitted to the Government for acceptance comply with all requirements herein whether stated directly or by reference. Sampling inspections, as a part of manufacturing operations, shall be an acceptable practice to confirm conformance to requirements, however, this does not authorize submission (to the Government for acceptance) of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

5.4. Quality conformance inspection. Unless otherwise specified in the contract or purchase order, sampling shall be conducted in accordance with the current edition of the Technical Association of the Pulp and Paper Industry (TAPPI) Method T-400, "Sampling and accepting a single lot of paper, paperboard, containerboard, or related product." The quality conformance inspection shall consist of the inspections and tests listed in paragraphs 5.4.1 through 5.4.1.2 and Table 1.

5.4.1. Component and material inspection.

5.4.1.1. Caps, cores and keyways. Caps, cores and keyways shall be inspected for conformance to U.S. Government Printing Office drawing number G.A. 4540F, dated 04/93.

5.4.1.2. Material. Test methods in Table 1 shall be used to verify material conformance of the paper types covered by this CID. The manufacturer's test plan shall, as a minimum, include each of the tests included in Table 1 below. The alphanumeric citations refer to the methods of the Technical Association of the Pulp and Paper Industry (TAPPI) unless otherwise indicated. The characteristic is listed in the first column, followed by the test method in the second column. Tests shall be conducted in accordance with the modifications explained in "Test Method" of Table 1. Paper so tested and found not in conformance to the "Precision requirements" specified in the applicable JCP Paper Schedule, shall be rejected.

TABLE 1

CHARACTERISTIC	TEST METHOD
Acidity (pH)	T-435 (Use method T-509 for cold extraction)

TABLE 1 (continued)

CHARACTERISTIC	TEST METHOD
Blocking	UM-565 Take rectangular specimens 45mm X 60mm. Use a top plate and weight such that the total mass is equivalent to 70 g/cm^2 on the specimens for uncoated paper, and 9 g/cm^2 for coated paper. Prepare the specimens by soaking in water at 25±5 °C for 15 minutes. Water shall have free access to both sides of each specimen. Remove specimens from the water and gently shake to remove excess water from the surface. Stack and allow assembly to dry at 25±5 °C. Proceed with UM-565.
Color deviation and variation	TIS 0804-04 Calculate using the CIELAB equations described in TAPPI TIS 0804-04. Measurements shall be made under the following conditions: Ill D65, 2 degree observer, specular component included. Measure at start and end of roll and in proximity of all splices.
Color by spectral reference	T-524
Cleanliness (dirt)	T-437
Curl	T-466
Equilibrium relative humidity	T-502
Erasing quality	T-478 Ink-Erasing Quality of Paper (Available upon request from TAPPI Technical Services Dept.)
Folding endurance	T-423 (Schopper) or T-511 (M.I.T.)
Grain (Machine direction)	T-409
Grammage (g/m^2)	T-410
Opacity (Type 1 only)	T-425
Roll size and weight	Measure roll diameter and width. Record in (mm). Weigh roll to closest 5kg and record.
Rosin	T-408
Smoothness	T-538 (Sheffield Method)
Stock (fiber analysis)	T-401

TABLE 1 (continued)

CHARACTERISTIC	TEST METHOD
Sizing	T-530
Surface	T-537 Surface shall be free of lint, fuzz, or any particles which will pick, lift, fluff, or pile on the blanket under normal press conditions.
Tearing strength (Type 1 only)	T-414 (Elmendorf-Type Method)
Thickness (Caliper)(mm)	T-411
Water resistance (Type 1 only)	T-433 (Dry Indicator Method)
Writing quality	Use any commercially available ball point or felt tip pen. Characters shall be clear cut and free from feathering.

6. PACKAGING

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

6.1.1. Commercial. In the absence of detailed instructions in the contract or purchase order, preservation and packing shall be in accordance with ASTM D 3951, Standard Practice for Commercial Packaging.

7. NOTES

7.1. Referenced documents. Copies of referenced documents are available from:

7.1.1. Government documents:

Standardization Documents Order Desk
700 Robbins Avenue
Building 4, Section D
Philadelphia, PA 19111-5094

Drawing Number G.A.4540 and Paper Schedules compiled by the Joint Committee on Printing (JCP) are available from:

Director, Materials Management Service
U.S. Government Printing Office
Room A344, Stop MMPP
Washington, D.C. 20401

7.1.2. Non-government documents:

ASTM D 3951 may be obtained from:

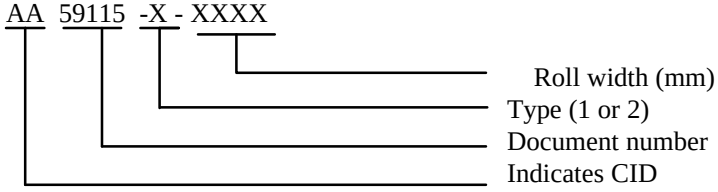
ASTM
100 Barr Harbor Drive

Conshohocken, PA 19428-2959

Technical Association of the Pulp and Paper Industry (TAPPI) documents are available from:
TAPPI PRESS
P.O. Box 105113
Atlanta, GA 30348

7.2. Part identification number (PIN). The following part identification numbering procedure is for government purposes and does not constitute a requirement for the contractor. The PIN shall be constructed as follows:

AA 59115 -X - XXXX



7.3. Subject term (key word) list.

map paper	chart paper
lithographic	offset map
lithographic-finish	

MILITARY INTERESTS:
Custodians
Air Force - 99
Army - GL
Navy - SA

Reviewer
NIMA - MP

CIVIL AGENCY COORDINATING ACTIVITY:
GSA-FSS/2FYE

PREPARING ACTIVITY:
DLA-GS

(Project 9310-0122)