

[METRIC]

A-A-59315

September 4, 1998

SUPERSEDING

MIL-P-85856

December 7, 1988

COMMERCIAL ITEM DESCRIPTION

POWDER MATERIALS FOR FLAME AND PLASMA SPRAYED COATINGS, GENERAL REQUIREMENTS FOR

The General Services Administration has authorized the use of this commercial item description as a replacement for MIL-P-85856 by all federal agencies.

1. **SCOPE.** This commercial item description (CID) covers the general requirements for metallic and non-metallic powders that are applied using either plasma arc or combustion gas (flame spray) techniques.

2. **CLASSIFICATION.** The flame and plasma sprayed coatings covered by this CID shall be in accordance with the following types (materials) and classes (particle size distributions).

2.1 Types.

Type I - Metallics

Type II - Non-metallics

Type III - Mixtures of either type I and type I materials, type I and type II, or type II and type II materials.

2.2 Classes.

Class 1 - Fine powders, predominantly less than 45 microns (-325 mesh)

Class 2 - Coarse powders, predominantly greater than 45 microns (+325 mesh)

2.3 Compositions. As defined in the individual CID sheets.

3. SALIENT CHARACTERISTICS.

Beneficial comments, recommendations, additions, deletions, clarifications, etc., and any data which may improve this document should be sent to: Commander, Naval Air Warfare Center Aircraft Division, Code 414100B120-3, Highway 547, Lakehurst, NJ 08733-5100.
--

FSC 3439

A-A-59315/GEN

3.1 Chemical composition. Chemical composition shall be as specified in the individual CID sheets, by weight, determined by wet chemical methods in accordance with ASTM-E354 or ASTM-E363 or by spectrographic or other analytical methods.

3.2 Particle size. The particle size distribution by weight, determined in accordance with ASTM-B214 or ASTM-C117, shall be as specified in the individual CID sheets.

3.3 Unit of issue containers. Unless otherwise specified in the contract or order, the powder shall be packaged in 2 kilogram, individual unit containers.

3.4 Quality. The powder covered by this CID shall be thoroughly blended, uniform in color and quality, dry, and free from foreign materials and imperfections detrimental to its spraying quality. The powder shall be capable of flowing freely through a powder feeder and spray gun so that the powder stream flows consistently and without excessive pulsation.

4. REGULATORY REQUIREMENTS.

4.1 Regulatory requirements. 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 market. The government reserves the right to require proof of such conformance.

5.2 Market acceptability. The item offered must have been sold to the government or commercial market.

6. PACKAGING.

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

7. NOTES.

7.1 This commercial item description covers the salient characteristics for procuring powders used in flame and plasma sprayed coatings. Acceptance standards for the sprayed coatings can be agreed upon between the contractor and the procuring activity.

A-A-59315/GEN

7.2 Copies of ASTM documents may be obtained from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

7.3 Copies of the FAR may be obtained from the Superintendent of Documents, Government Printing Office, Washington, DC 20402.

7.4 Ordering Data. Procurement documents should specify the following:

- a. Title, number, and date of the applicable CID sheet
- b. Quantity desired
- c. Levels of packaging and packing

MILITARY INTERESTS:

Custodians:

Army - MR
Navy - AS
Air Force - 11
DLA- GS

Review activities:

Navy - SH
Air Force - 71, 99

**CIVIL AGENCY COORDINATING
ACTIVITY:**

GSA/FSS-7FXE

Preparing activity:

Navy - AS
(Project 3439-0910)