

AA-T-00112A(GSA-FSS)

July 11, 1969

INTERIM REVISION OF

Fed. Spec. AA-T-112

July 25, 1955

INTERIM FEDERAL SPECIFICATION

TABLE, WOOD, GENERAL OFFICE

This Interim Federal Specification was developed by the Federal Supply Service, General Services Administration, Washington, D. C. 20406, based upon currently available technical information. It is recommended that Federal agencies use it in procurement and forward recommendations for changes to the preparing activity at the address shown above.

The General Services Administration has authorized the use of this Interim Federal Specification as a valid exception to Federal Specification AA-T-112, dated July 25, 1955.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers tables fabricated of wood for general office use.

1.2 Classification.

1.2.1 Type and sizes. The general office tables covered by this specification shall be of one type and two sizes as specified herein and as shown in Figure 1 (see 6.2).

Size 1 - 36 inches wide by 24 inches deep.

Size 2 - 60 inches wide by 30 inches deep.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of the specification to the extent specified herein.

Federal Specifications:

L-P-508 - Plastic Sheet, Laminated, Decorative and Nondecorative.
L-T-0041 - Table Top and Furniture Assemblies (Plastic Thermosetting Resin Laminate).
FF-S-107 - Screws, Tapping and Drive.
FF-S-111 - Screw, Wood.
MMM-A-130 - Adhesive, Contact.
PPP-B-636 - Box, Fiberboard.
PPP-P-291 - Paperboard, Wrapping and Cushioning.

Federal Standards:

Fed. Std. No. 123 - Marking for domestic shipment (Civilian Agencies).
Fed. Test Method Std. No. 141/GEN (General Provisions) Paint, Varnish, Lacquer, and Related Materials, Methods of Inspection, Sampling, and Testing.
Fed. Test Method Std. No. 141/6151 - Accelerated Weathering (Open Arc Apparatus).

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, D. C. 20402.)

(Single copies of this specification and other Federal Specifications required by activities outside the Federal Government for bidding purposes are available without charge from Business Service Centers at the General Services Administration Regional Offices in Boston, New York, Washington, D.C., Atlanta, Chicago, Kansas City, Mo., Fort Worth, Denver, San Francisco, Los Angeles, and Seattle, Washington.)

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(Federal Government activities may obtain copies of Federal Specifications, Standards, and Handbooks and the Index of Federal Specifications and Standards from established distribution points in their agencies.)

Military Standards:

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-129 - Marking for Shipment and Storage.

(Copies of Military Specifications and Standards required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply.

Commercial Standards:

CS35 - Hardwood Plywood.
CS236 - Mat-Formed Wood Particleboard.

(Copies of the Commercial Standards referenced above, which are Department of Commerce publications, may be obtained upon application, accompanied by money order, coupon, or cash, to the Superintendent of Documents, Government Printing Office, Washington, D. C. 20402. Prices may be obtained from the Superintendent of Documents.)

American Society for Testing and Materials (ASTM) Standard:

ASTM D905-49 - Standard Method of Test for Strength Properties of Adhesives in Shear by Compression Loading.

(Copies may be obtained upon application to American Society for Testing and Materials, 1916 Race Street, Philadelphia, Pennsylvania 19103.)

3. REQUIREMENTS

3.1 Preproduction sample. Unless otherwise specified (see 6.2), before production is commenced, a sample of the finished item and each component part conforming to the requirements of this specification shall be offered for approval of the contracting officer or his authorized representative. Approval of the preproduction sample authorizes the commencement of production, but does not relieve the contractor of responsibility from compliance with all other applicable provisions of this specification.

3.2 Materials. The materials used in construction of the tables shall be of the kind and quality specified herein.

3.2.1 Adhesives. The adhesives to be used and their permitted application shall be as shown in Table I.

TABLE I. Adhesives

Application	Kind of Adhesives
All glueblocks, assembly joints, glued laminated stock, and edge joining of lumber-core panels.	Any adhesive that will develop an average block shear strength of not less than 2800 pounds per square inch when tested as specified in 4.3.1.1.
All plywood gluing, edge-joining of veneer plies, cross-banding, and edge banding.	Any adhesive that will conform to or exceed the test requirements of the Type II bond, as described in the Commercial Standard CS35 for Hardwood Plywood.

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3.2.2 Stain. The stain shall be a homogenous liquid consisting of light-fast organic dyes dissolved in an organic solvent. The stain shall show no more than slight color change when tested as specified in 4.4.5.

3.2.3 Wood. The permissible woods for the component parts shall be as shown in table II.

3.2.3.1 Solid wood. The solid wood used for exposed parts shall be bright, well sanded and free from brashness, discolorations, worm holes, honeycomb, splits, and shakes. A few small burls, pin-knots averaging not more than two per square foot, mineral streaks a maximum of 1/16 inch by 4 inches, or 1/8 inch by 2 inches in area and averaging not more than one per square foot, will be permitted. The wood used for unexposed parts, including lumber-core, may contain small defects such as pin-knots, sapwood, or mineral streaks provided the strength of the part is not affected. All component wood parts shall be uniformly kiln dried to a moisture content of from 5 to 8 percent dependent on the manufacturer's best commercial practice.

3.2.3.2 Plywood. All hardwood plywood shall be constructed according to the requirements of Commercial Standard CS35 and as specified herein. The construction shall be either lumber core or veneer core. Bondage shall be not less than type II. Cross banding plies shall be not less than Grade 2 quality and not less than 1/20 inch thick. Face and back veneer plies shall be not less than 1/28 inch thick, except for walnut which shall be not less than 1/32 inch thick, before sanding. All exposed faces, including aprons shall have Grade 1 veneer plies, matched for color and grain to present a uniform appearance. Grade 2 veneer plies may be used on the face of unexposed surfaces. Lumber core panels shall be Regular Grade except that no end-butt joints will be permitted and the wood for laying up the cores shall be of full length strips not more than 4 inches wide. Veneer plies shall be full lengths and shall be applied in balanced construction form with no ply joints less than 1 inch from the edge of any panel. (Full length veneer strips shall be a minimum of 3-1/2 inches wide. Trim-off allowance of 3/16 inch shall be permissible on panel sides.)

TABLE II. Varieties of wood

Exposed parts			Unexposed parts		
Veneers (except legs)	Solid parts and veneered legs (one only for any one item)	Solid	Veneers	Corestock ^{1/}	Crossbands
Birch	Beech	Ash ^{4/}	Alder (red)	Alder	Alder
Cherry	Birch	Beech ^{4/}	Ash	Basswood	Aspen
Mahogany ^{2/}	Cherry	Birch ^{4/}	Aspen	Butternut	Basswood
Pecan	Hickory	Cherry	Basswood	Cherry	Beech
Walnut	Mahogany ^{2/}	Hackberry ^{4/}	Beech	Chestnut	Birch
Philippine ^{3/}	Maple	Hickory ^{4/}	Birch	Cottonwood	Butternut
hardwoods ^{3/}	Pecan	Magnolia	Butternut	Douglas Fir ^{5/}	Cherry
	Walnut	Mahogany	Cherry	Magnolia	Chestnut
	Philippine ^{3/}	Maple ^{4/}	Cottonwood	Mahogany	Cottonwood
	hardwoods ^{3/}	Oak ^{4/}	Magnolia	Maple (soft)	Magnolia
		Pecan ^{4/}	Mahogany	Ponderosa-	Mahogany
		Sweetgum	Maple	pine ^{2/}	Maple (soft)
		Sycamore	Oak	Redwood ^{5/}	Oak
		Tupelo	Sweetgum	Sitka Spruce ^{5/}	Sweetgum
		Walnut ^{4/}	Sycamore	White Pine ^{2/}	Tupelo
		Philippine ^{3/}	Tupelo	Yel. Poplar	Walnut
		hardwoods ^{3/}	Walnut	Sycamore	Yel. Poplar
			Yel. Poplar	Willow	Sycamore
			Philippine ^{3/}	Philippine ^{3/}	Willow
			hardwoods ^{3/}	hardwoods ^{3/}	Philippine ^{3/}
					hardwoods ^{3/}

^{1/} Only one of the species listed shall be used in any one panel.

^{2/} American and African Mahogany only.

^{3/} Red luan group only.

^{4/} Built-up leg core must be of one of the species.

^{5/} Vertical grain only.

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3.2.4 Particleboard. Particleboard shall conform to the requirements of Commercial Standard CS236 for type 1, grade B, (medium density), class 2, except that screw holding value shall be 285 pounds for face and 235 pounds for edge; type 1, grade A, (high density), class 1 or type 2, grade A, (high density), class 2.

3.2.5 Hardware.

3.2.5.1 Footsockets. The footsockets shall be made of 0.032 inch thick stamped brass or brass finished, anodized aluminum. They shall be 1-3/8 inches high and shall have a flat closed bottom with rounded bottom edges.

3.2.5.2 Screws. The screws used in assembly shall be in accordance with FF-S-111 in the size and type specified or Type A of FF-S-107.

3.2.6 Plastic laminate.

3.2.6.1 Decorative face sheets. The decorative face sheets shall conform to style D, type 1, grade HP, class 1, finish D (other), of L-P-508 and the nominal thickness shall be 1/16 inch. The color of the plastic laminate shall be as specified in 3.3.8.2.

3.2.6.2 Nondecorative backing sheets. The nondecorative backing sheets shall conform to style ND, type V, grade HP of L-P-508 and the nominal thickness shall be 1/16 inch.

3.3 Construction.

3.3.1 Design. The design of the tables shall be as shown in figure 1. The tables shall be fitted with four legs of knockdown construction. The height shall be 29-1/2 inches and the top shall overhang the aprons 13/16 inch on all four sides. The rectangular top surface shall be 36 inches wide by 24 inches deep for size 1 and 60 inches wide by 30 inches deep for size 2.

3.3.2 Tolerances. The following tolerances will be permitted, except where otherwise specified herein:

3.3.2.1 Overall tolerances for tables:

- (a) Height - plus 1/4 inch minus 1/8 inch.
- (b) Depth - plus 1/4 inch minus 1/8 inch.
- (c) Width - plus 1/4 inch minus 1/8 inch.

3.3.2.2 Component part tolerances:

- (a) Dimension of any solid wood part (width and thickness) plus 1/16 inch minus 1/32 inch.
- (b) Dimension of any plywood part (thickness only) - plus or minus 1/32 inch.
- (c) Dimension of any particleboard part (thickness only) - plus or minus 1/64 inch.
- (d) Any dimension, not otherwise specified - plus or minus 1/16 inch.

3.3.3 Top. The top shall be a plastic laminate assembly consisting of particleboard, specified in 3.2.4, or 5-ply lumbercore or multi-ply veneer-core construction (exclusive of the plastic face and back), specified in 3.2.3.2, surfaced with plastic laminate face sheets, specified in 3.2.6.1, and backing sheets, specified in 3.2.6.2. The nominal thickness of the top shall be 1-1/4 inches. The assembly shall be constructed in accordance with types I, II, III, or IV of L-T-0041, except that when type III is used the core material shall be high density particleboard, specified in 3.2.4, and when type IV is used the core material shall be medium density particleboard, specified in 3.2.4. Before application of the plastic laminate, the top shall be banded with full length, straight grained 5/16-inch thick, solid wood strips, specified in 3.2.3.1, tongued into the butt-end and lap or butt-joined at the corners. The grain pattern shall be horizontal. When particleboard core is used, banding shall be of "Tee" mold shape. The adhesives, specified in 3.2.1, shall be used for the banding and plastic laminate assembly. Alternatively, adhesive conforming to the requirements of MMM-A-130 may be used for the plastic laminate assembly. All corners shall be rounded to a 3/16 inch radius and all edges to a radius of between 1/16 and 1/8-inch.

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3.3.4 Aprons. The aprons shall be of solid wood, specified in 3.2.3.1, or of 5 or 7-ply hardwood plywood, faced one side, specified in 3.2.3.2. They shall be a minimum of 7/8 inch thick by 3 inches deep and all bottom edges shall be eased. The grain pattern shall be horizontal. The ends of the aprons shall be beveled to fit the taper of the legs so that the center line of the legs, or the two outside faces will be vertical when attached. The face of the leg shall extend not more than 3/16 inch beyond the apron. The aprons shall be secured to the top by screws inserted through bored and counterbored holes spaced 7 inches maximum apart starting approximately 3 inches from end of aprons. The screws shall be not less than No. 10 size and shall penetrate the top one inch minimum. When particleboard is used for the top, sheet metal type screws shall be used for attachment.

3.3.5 Corner braces. Each corner of the table shall have an accurately fitted corner brace set back from the ends of the aprons a minimum of 1-1/4 inches. The corner braces shall be of solid hardwood, specified in 3.2.3.1, and shall be 1-1/16 inches thick, minimum, by 2-3/4 inches wide. Each end of the brace shall be tenoned and glued into the aprons and secured by a minimum of two screws (No. 10 minimum) set at right angle to the aprons. The screws shall be countersunk and shall penetrate the apron 1/2-inch minimum.

3.3.6 Legs. The legs shall be solid or built-up stock. Built-up stock shall consist of not less than five full-length pieces, two of which shall cover the built-up edges, and the center portion of the leg shall be of wood shown in table II for leg cores. Alternatively, the leg may have a core built-up of not less than three full-length pieces and, after tapering, shall be veneered on all four sides. The veneers shall be as shown in table II and shall be not less than 1/8-inch thick when applied. The grain pattern shall be vertical. The legs shall be 1-3/4 inches square at the top and taper to 1-1/2 inches square at the bottom for size 1 tables and 2 inches square at the top tapering to 1-3/4 inches square at the bottom for size 2 tables. Each leg shall be uniformly tapered on all four sides. All corners shall be uniformly rounded to a 1/8-inch radius, minimum. Each leg shall be secured by two 5/16-inch, minimum, rail bolts through the corner brace as shown in figure 1. The bolts shall be spaced a minimum of 1-5/8 inches apart and shall penetrate the leg 1-1/2 inches, minimum. A steel washer, not less than 1/16-inch thick by 3/4-inch in diameter, and a nut shall be furnished with each rail bolt. Each leg shall be furnished with a footsocket specified in 3.2.5.1. The footsocket shall be tightly fitted, flush with the outside faces of the leg and secured with one 5/8-inch brass escutcheon pin (minimum) on the inside of the leg.

3.3.7 Method of finishing. The wood surfaces of the tables shall be finished as specified herein and finished surfaces shall comply with the requirements of 3.3.8. All wood surfaces normally exposed to view including bottom edge of aprons, shall be finish sanded smooth and all corners and edges eased, thoroughly cleaned, and finished as specified.

3.3.7.1 Exposed wood surfaces. Finish shall consist of an organic coating system with a dry film thickness of not less than 1.75 mils for vertical surfaces and 2.50 mils for horizontal surfaces which shall match the standard panel for color, texture, and gloss and shall conform to the requirements in Table III when tested as indicated therein.

TABLE III. Finish requirements

Property	Requirement	Test Reference
Abrasion resistance		
Loss in weight, grams maximum	0.125	4.4.1.1
Break through, 300 cycles	pass	4.4.1.2
Solvent resistance	No more than slight discoloration, softening, or checking.	4.4.2
Cleaning compound resistance	No more than slight discoloration or softening.	4.4.3
Toughness and adhesion	No whitening or cracking.	4.4.4

The natural grain of the wood shall not be clouded by the finishing materials. Bleaching agents or materials shall not be used. The application of materials, the drying time, sanding, cleaning and rubbing shall be controlled to produce items of smooth, uniform exposed surfaces without blisters, pits, wrinkles, runs, tackiness or more than a trace of orange peel.

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3.3.7.2 Unexposed wood surfaces. All unexposed wood surfaces shall be machined smooth and cleaned, and given a coat of adhesive sealer.

3.3.8 Color and appearance of finish.

3.3.8.1 Exposed wood. Color and appearance of the finish of exposed wood surfaces shall be walnut and shall conform to the standard reference panel adopted by Federal Supply Service, General Services Administration for color, texture, and gloss (see 6.3).

3.3.8.2 Plastic laminate. Finish of plastic laminate surfaces shall be walnut, plate textured, and shall conform to the standard reference panel adopted by Federal Supply Service, General Services Administration for color, appearance, and gloss (see 6.3).

3.3.9 Identification marking. Each table shall be permanently and legibly marked in a inconspicuous place with the specification number, Federal Stock Number, contract number, date of manufacture and the manufacturer's name or trade-mark, so that the source of supply may be readily determined.

3.3.10 Workmanship. The methods of construction, veneering, finishing and assembly and the finished appearance of the tables shall be in strict accordance with the requirements of this specification. Where specific requirements are not given, good commercial practice of the contract furniture industry shall be used. Tables shall conform to the level of quality established herein.

4. QUALITY ASSURANCE PROVISIONS

4.1 General quality assurance provisions.

4.1.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirement.

4.1.2 Government verification. All quality assurance operations performed by the contractor shall be subject to Government verification at unscheduled intervals. Verification shall consist of surveillance of the operations to determine whether the practices, methods, and procedures of the written inspection plan are being properly applied, and Government product inspection, to measure quality of product offered for acceptance. Deviation from the prescribed or agreed-upon procedures, or instances of poor practices that might have an effect on the quality of the product will be immediately called to the attention of the contractor. Failure of the contractor to promptly correct the deficiencies discovered shall be cause for suspension of acceptance until the correction has been made or until conformance of product to prescribed criteria has been demonstrated. To avoid interference with operations, the contractor shall designate a responsible official, or officials, to whom the Government inspector will report such instances.

4.2 Preproduction sample inspection. Examination and testing shall be made on the completely fabricated item for all provisions of this specification.

4.3 Sampling for inspection and acceptance. Sampling and inspection shall be performed in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated herein after.

4.3.1 Inspection of materials and components. In accordance with 4.1, the supplier is responsible for insuring that materials and components used were manufactured, tested, and inspected in accordance with the requirements of referenced subsidiary specifications and standards to the extend specified, or if none, in accordance with this specification.

4.3.1.1 Testing of components. In addition to the quality assurance testing provision of the subsidiary specification, testing of the components shall be performed in accordance with table IV for the characteristics shown therein. The values specified in section 3 of this specification apply to the average determinations made on a sample unit for test purposes as specified in the applicable test method. When the sample size for components covered by the subsidiary specifications is not specified, the sample size for each characteristic shall be in accordance with inspection level S-2 of MIL-STD-105 except that for lot sizes of 501 (units of products) and over the sample size shall be 5. The lot shall be unacceptable if one or more sample units fail to meet any of the requirements specified.

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TABLE IV. Instructions for testing components and materials

Component	Characteristic	Requirement Reference	Test Method	Sample Unit
Adhesive	Block shear test	3.2.1	ASTM D 905-49 1/ 2/ 3/	1/2 pint
Finish system 4/ on wood surface	Abrasion resistance			
	Loss in weight	3.3.7.1	4.4.1.1 herein	Sufficient panel area to perform all tests once.
	Break through	3.3.7.1	4.4.1.2 herein	
	Solvent resistance	3.3.7.1	4.4.2 herein	
	Cleaning compound resistance	3.3.7.1	4.4.3 herein	
	Toughness and adhesion	3.3.7.1	4.4.4 herein	
Stain	Resistance to fading	3.2.2	4.4.5 herein	1/4 pint

- 1/ The following modifications apply when testing casein-type adhesive. The test blocks shall be placed under pressure between 10 and 20 minutes after spreading the adhesive, the adhering pressure shall be 175 ± 25 pounds per square inch, and the test blocks shall be held under pressure for at least four hours.
- 2/ The following modifications apply when testing animal adhesive. The moisture content of the wood shall be from 6 to 9 percent. The joints shall be conditioned at a relative humidity of 40 ± 4 percent.
- 3/ Whenever a specimen fails at a load of less than 2,800 pounds per square inch and the failure occurs 50 percent or more in the wood, the specimen shall be disregarded in computing the average. In case the shearing strength of one or more specimens is 2,800 pounds per square inch or higher, the variation among individual specimens is 10 percent or more (based on the strongest joint) the test shall be run again, provided the average is less than the required 2,800 pounds per square inch.
- 4/ The test shall be made on completely finished wood panels of the same wood used in production. The finish shall be in accordance with procedures used in producing furniture.

4.3.2 End item inspection.

4.3.2.1 Visual examination of the end item. The lot size shall be expressed in units of completed end item. The inspection level for purposes of determining the sample size shall be level I of MIL-STD-105. The unit product shall be one completed end item. The defects found during the examinations shall be classified in accordance with table V. The acceptable quality level (AQL) shall be 4.0 for major defects and 6.5 for total defects (major and minor combined) per hundred units.

TABLE V. Classification of End Item Defects

Examine	Defect	Classification	
		Major	Minor
Finish and appearance of exposed wood parts visible in normal use position.	Does not match standard reference panel with respect to color.	X	
	Discoloration (Bleeding) over 1 square inch.		X
	Spotted, affecting appearance.		X
	Light or dark colored areas, affecting appearance.	X	
	Area of no lacquer film over 1 square inch in area.	X	
	Glue stain or glue line clearly showing, affecting appearance.		X
	Excess glue not removed.		X
	Finish peeling, flaking, blistered, cracked, checked or wrinkled.	X	

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TABLE V. Classification of End Item Defects (Con't)

Examine	Defect	Classification	
		Major	Minor
Finish and appearance of exposed wood parts visible in normal use position, (Cont'd)	Finish cut or rubbed through to wood.		X
	Open grain. Finishing material not filling pores.		X
	Orange peel, affecting appearance.		X
	Damage or scratch, less than 1 inch long, or 1 inch square.		X
	Damage or scratch over 1 inch square or 1 inch long.	X	
	Finish tacky, i.e., not completely dry.		X
	Rough or gritty surface or foreign matter imbedded in finish.		X
	Light colored edge not touched up.		X
	Burn-in or repairs not neatly accomplished.		X
	Unstained (white) wood visible when item is in normal use position.		X
Quality of plywood and laminated wood on exposed surfaces.	Not harmonious grain match between panels on any one item.		X
	Species of wood not as specified.	X	
	Number of plies not as specified.	X	
	Open joint in face veneer.	X	
	Face veneer butt-matched.		X
	Uneven core surface telegraphing.		X
	Any cross break in veneer.	X	
	Sanded through face ply.	X	
	Waves of uneven sanding, affecting appearance.		X
	Machine mark, affecting appearance.		X
	Veneer blister.		X
	Veneer chipped or splintered.		X
	Any loose or unsound knot.		X
	Conspicuous patch.		X
	Decay, affecting appearance.		X
	Veneer joint less than 1 inch from edge of panel.		X
	Unfilled void at exposed edge.		X
	Lumber-core not "clear edge" where required.		X
	Species of wood not as specified.	X	
	Components not fabricated on one piece solid wood where required.		X
Quality of solid wood on exposed and unexposed surfaces.	More than 1 species of wood used for exposed wood components of any one item.		X
	Direction of grain not as specified.		X
	Check or split over 1 inch in length.	X	
	Wood warped, affecting appearance or serviceability.		X
	Loosened grain or shake on exposed surface.		X
	Loosened grain or shake on unexposed surface.		X
	Honeycomb.		X
	Loose or unsound knot.		X
	Hole on exterior surface, affecting appearance.	X	

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TABLE V. Classification of End Item Defects (Con't)

Examine	Defect	Classification	
		Major	Minor
Quality of solid wood on exposed and unexposed surfaces. (Con't)	Glue line in built-up stock open over 1 inch in length.		X
	Glued up pieces uneven in built-up stock.		X
	Wave of uneven sanding.		X
	Machine mark on exposed surface, affecting appearance.		X
	Any mineral streak on exposed surface over 1/16 inch by 4 inches or 1/8 inch by 2 inches.		X
	Any manufacturing defect or defect native to the wood filled in with plastic wood or other filler material.		X
Quality of Particleboard.	Not material specified.		X
Quality of laminated plastic.	Not material specified.	X	
	Color or grain character of face sheet not as specified.	X	
	Face or backing sheet missing.	X	
	Top surface not proper finish.		X
	Sheet containing area of no adhesion.		X
	Face sheet damaged, dented, cracked, marred, or discolored.	X	
	Scratch or nick in face sheet, affecting appearance.		X
	Evidence of telegraphing.		X
	Component missing.	X	
Construction, assembly and attachment of unexposed and exposed parts.	Component in wrong location, except attaching implements.		X
	Component loose or insecurely fastened where rigidity is required.		X
	Component out of alignment or out of square affecting serviceability.		X
	Poor fit of component part on mating part.		X
	Wood component not glued as specified.		X
	Solid wood used in place of veneer or vice versa.		X
	Wood component damaged or not properly machined.		X
	Routing not uniform or uneven.		X
	Component not chamfered where required.		X

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TABLE V. Classification of End Item Defects (Con't)

Examine	Defect	Classification	
		Major	Minor
Construction, assembly and attachment of unexposed and exposed parts (Con't).	Edges not "eased off" where required.		X
	Any loose or unsound glued joint.		X
	Wood joint not as specified.		X
	Glue joint open - exposed part:		
	1/16 inch or less.		X
	Over 1/16 inch.	X	
	Glue joint open - unexposed part:		
	1/8 inch or less.		X
	Over 1/8 inch.	X	
	Top panels warped 1/4 inch or more width or length.	X	
	Overhang of top panel uneven or not as specified.		X
	Any leg split.	X	
	Footsocket not as specified.		X
	Footsocket missing.		X
	Footsocket improperly placed.		X
	Footsocket not secured properly.		X
	Legs uneven.		X
	Not as specified or not as shown on drawings or figures.	X	
	Component not size or shape specified.		X
	Component not type or design specified.		X
Workmanship and attachment of screws, bolts, nuts and washers.	Component not assembled as specified.		X
	Any attachment device not type or size as specified.		X
	Material not as specified.		X
	Spacing of screws not as specified.		X
	Screw point visibly bulging wood.		X
	Wood at insertion point not countersunk when specified.		X
	Screws or bolts broken off.		X
	Screw or bolt in wrong location.		X
	More than 1 screw, bolt, nut, or washer missing.		X
	More than 1 bolt, screw or nut not drawn up tightly.		X
	Threads on nuts or bolts stripped.		X

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TABLE V. Classification of End Item Defects (Con't)

Examine	Defect	Classification	
		Major	Minor
Identification marking	Text incomplete.		I
	Missing, incorrect or illegible.		I
	Marking in wrong location.		I

4.3.2.2 Assembly examination. An examination of the assembly of the legs to the table aprons shall be made for defects in ease of assembly and fit of components. The lot size shall be expressed in units of tables. The inspection level shall be S-2 of MIL-STD-105. The unit of product shall be one table. Defects shall be scored in accordance with table VI. The acceptable quality level (AQL) shall be 4.0 defects per hundred units.

(Note. Unassembled tables and legs, selected by the Government inspector, shall be fully assembled by the contractor. The inspector shall witness the assembly of the legs to the table aprons and shall observe the ease of assembly and fit of components).

TABLE VI. Assembly defects

Examine	Defect
Assembly of legs to table aprons.	Not easily assembled, i.e., assembling required realignment of parts, drilling or enlargement of holes, use of hammer, drift pin or other mechanical means.
	Legs uneven, i.e., table rocks more than 1/16 inch when on flat surface.

4.3.2.3 Dimensional examination. The lot size shall be expressed in units of completed tables. The inspection level shall be S-2 of MIL-STD-105. The unit of product shall be one completed table. Any external overall dimensions that are not within the specified tolerance shall be classified as a defect. The acceptable quality level (AQL) shall be 4.0 defects per hundred units.

4.3.3 Inspection of preparation for delivery requirements. An examination shall be made to determine that packaging, packing, and marking requirements of section 5 of this specification are complied with. Defects shall be scored in accordance with table VII. The sample unit shall be one shipping container, fully packed, selected just prior to the closing operation. Closed shipping containers shall be examined for closure defects. The lot size shall be expressed in number of shipping containers. The inspection level shall be S-2 of MIL-STD-105 and the acceptable quality level (AQL) shall be 4.0 defects per hundred units.

TABLE VII. Preparation for delivery defects

Examine	Defect
Markings (exterior and interior).	Incorrect; incomplete; illegible; omitted; of improper size, location, sequence, or method of application.
Materials.	Any nonconforming component; component missing, damaged, or otherwise defective.
Workmanship.	Inadequate application of components: such as incomplete closure of container, loose or inadequate sealing, strapping or stapling; bulged or distorted containers.

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4.4 Test Methods.

4.4.1 Abrasion resistance. Abrasion resistance shall be measured using a Taber Abraser equipped with Taber Abraser Wheel No. S-33 and Behr-Manning 5/0-180A finishing paper with a load of 500 grams on each wheel.

4.4.1.1 Loss in weight. Three weighted finish panels shall be subjected to a minimum of 100 revolutions of the abraser. Panels shall be weighed after the test period and the average loss in weight calculated.

4.4.1.2 Break through. Three finish panels shall be subjected to a minimum of 300 revolutions of the abraser. Panels shall be examined for evidence of "break-through" of the film. Failure of 2 panels shall constitute failure of the test.

4.4.2 Solvent resistance. Pools containing 3 cubic centimeters each of the following solvents shall be placed on fully cured finish panels. Each pool shall be covered with a 2-1/2 inch diameter watch glass and allowed to remain for the time indicated:

Ethyl alcohol, 100 proof	6 hours
Acetone	1 hour
Distilled water	6 hours

The finish shall then be examined for evidence of discoloration or checking. After removal of the solvent and a period of 30 minutes the finish shall be examined for evidence of softening by finger-nail test.

4.4.3 Cleaning compound resistance. A pool containing 3 cubic centimeters of a 5 percent solution of trisodium phosphate shall be placed on a fully cured finish panel and covered with a 2-1/2 inch diameter watch glass. After 12 hours the finish shall be examined for evidence of permanent discoloration or softening.

4.4.4 Toughness and adhesion test. The toughness and adhesion test shall be made by using Bell Laboratories Adhesion Tester, U. S. Testing Company, Model Number 1001, in accordance with instructions for using, as provided for by the manufacturer of the tester (see 6.4). The panel shall be marred both parallel and perpendicular to the grain. The resulting indentation shall be examined for whitening or cracking.

4.4.5 Resistance to fading. Ten milliliters of the stain shall be mixed with 15 milliliters of a freshly prepared 5 percent cellulose acetate butyrate solution. A flow-out shall be made on a pane of milk glass. One-half of the thoroughly dried film shall be masked with a shield to prevent transmission of light. The stained film shall be tested in accordance with method number 6151 of Federal Test Method Standard No. 141 for 4 hours without use of water sprays. Compare the exposed with the unexposed surface for evidence of color change. The 5 percent test solution shall consist of the following:

	Grams
Cellulose acetate butyrate (see 4.4.5.1).....	50
Butyl acetate.....	145
Methyl ethyl ketone.....	178
Ethyl acetate.....	540
Acetone.....	87
	<hr/> 1000

4.4.5.1 Cellulose acetate butyrate. The cellulose acetate butyrate shall conform to Eastman Chemical Products, Inc. No. EAB-381-20, or equal.

5. PREPARATION FOR DELIVERY

5.1 Packaging.

5.1.1 Level B. The legs shall be removed from the table and the nuts and washers shall be replaced and tightened on bolts. Exposed threads of leg screws shall be protected by wrapping with cushioning

material secured in place with tape. The legs shall be individually wrapped in a sheet of machine-glazed Kraft paper. Two legs shall be nested head-to-foot and overwrapped in at least two thicknesses of single-face corrugated fiberboard (flexible) conforming to Type I of PPP-P-291, and taped. The wrapped legs shall be placed in a fiberboard box conforming to PPP-B-636, Type CF, class domestic, style optional, minimum 175 p.s.i. bursting strength. The box containing wrapped legs shall be secured to prevent opening during shipment. All finished surfaces of the tables shall be completely covered with a sheet of machine-glazed Kraft paper having a minimum basic weight of 30 pounds per ream (24 by 36 - 500). The paper shall be taped to the underside of the apron. The top of the table shall be cushioned with a pad fabricated from one of the following materials or a combination of these materials to provide built-up cushioning of not less than 3/4 inch in thickness:

1. Macerated paper.
2. Shredded paper.
3. Wood-wool.
4. Laminated creped cellulose wadding backed with corrugated fiberboard.
5. Wood-fiber felt.
6. Creped cellulose wadding.
7. Excelsior (sealed ends).
8. Cotton wadding.
9. Molded pulpboard.

The legs shall be positioned inside of apron. All legs shall be secured to prevent movement in transit.

5.2 Packing.

5.2.1 Level B. Each table, packaged in accordance with 5.1, shall be packed in a new fiberboard shipping container constructed to conform to Type CF or SF, class domestic, Style FTC (full-telescope), of PPP-B-636. Burst test of fiberboard used in construction of the container shall be not less than 350 p.s.i., and the container shall be closed and strapped in accordance with the appendix of the box specification. Prior to closure, folded or built-up pads of corrugated fiberboard of not less than 2-1/4 inches thickness by 4 inches in width by not less than 18 inches in length shall be placed and secured by tape, between the outside surface of table aprons and inside surface of container, on both sides and both ends of the table. Pads shall be centered to aprons, approximately equidistant from ends of aprons. Box containing legs shall be placed and secured as specified in 5.1 prior to closure and strapping. Alternatively, in lieu of metal strapping, plastic-laminated-fiber strapping may be used, substituted for metal strapping size-for-size in accordance with the fiber strip manufacturer's table of recommended replacement for metal strap.

5.3 Marking.

5.3.1 Civil agencies. In addition to any special marking required by the contract or purchase order, marking of shipping containers shall be in accordance with Fed. Std. No. 123.

5.3.2 Military activities. In addition to any special marking required by the contract or purchase order, marking of shipping containers shall be in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. The tables covered by this specification are intended for general office use.

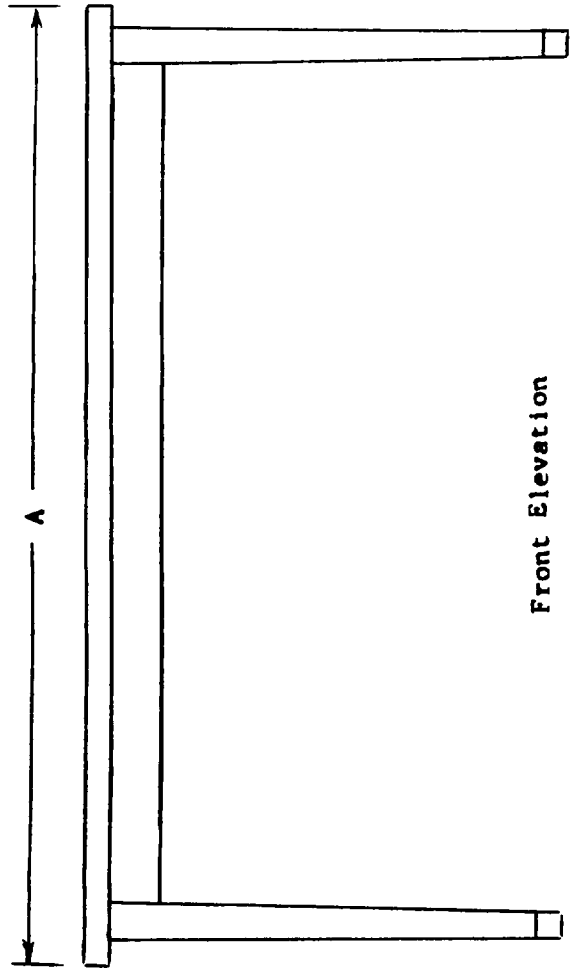
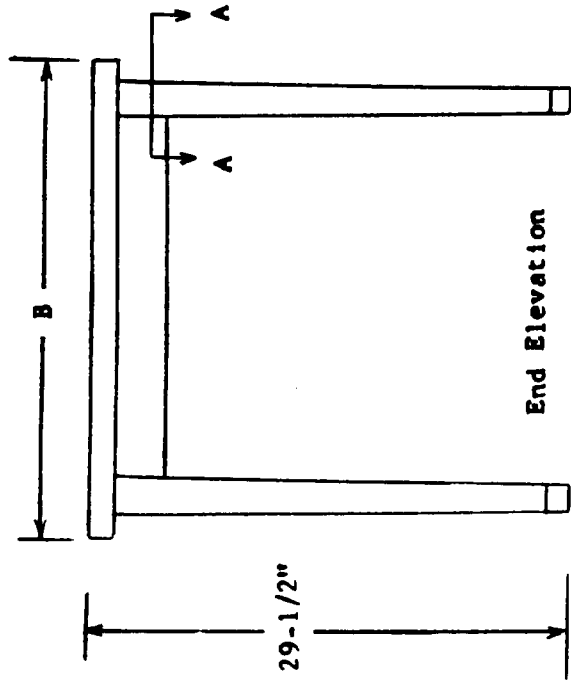
6.2 Ordering data. Purchasers should select the preferred options permitted herein and include the following information in procurement documents:

- (a) Title, number and date of this specification.
- (b) Size (see 1.2.1 and 3.3.1).
- (c) When preproduction sample is NOT required (see 3.1).
- (d) Marking requirements (see 5.3).

6.3 Standard sample. Sample panels of the standard color for walnut finish are obtainable, without charge, from the Business Service Center, Regional Office Building, General Services Administration, Washington, D. C. 20407, or from the Business Service Center of the nearest GSA Regional Office.

6.4 Bell Laboratories Adhesion Tester. Information about the Bell Laboratories Adhesion Tester, Model No. 1001, may be obtained from U. S. Testing Company, Inc. 1415 Park Avenue, Hoboken, New Jersey.

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Dimensions in inches

	A	B
Size 1	36	24
Size 2	60	30

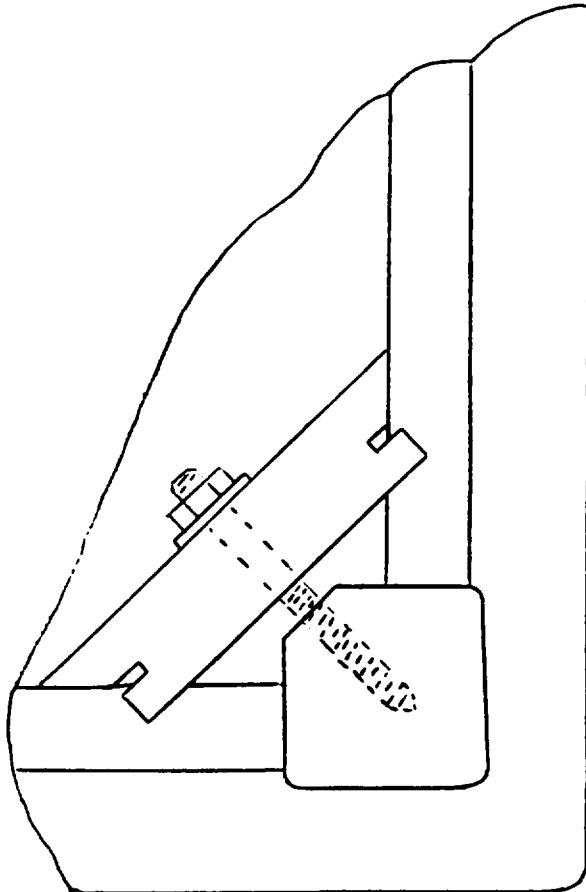


Figure 1. Tables

GENERAL SERVICES ADMINISTRATION - FEDERAL SUPPLY SERVICE

BUDGET BUREAU NO.

SPECIFICATION COMMENT SHEET

29-R0175

INSTRUCTIONS

This form provides a way for users of this specification to inform the originator of problems encountered in its use. It is not to be used to request changes to accommodate proprietary features. All comments will be considered and appreciated, but please do not expect a reply. To comment: detach, complete, fold, staple, and mail.

NOTE: Comments on this form do not constitute or imply authorization to waive any part of the document or serve to amend contractual requirements.

1. SPECIFICATION

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TABLE, WOOD, GENERAL OFFICE

2. CONTRACT NO. (If any)

3. QUANTITY ON CONTRACT (Optional)

4. DOLLAR VALUE (Optional)

5. GENERAL NATURE OF PROBLEM (e.g., inspection difficulties, manufacturers unable to meet tolerances, containers collapse under normal warehousing conditions, etc.)

6. SPECIFIC REQUIREMENTS AFFECTED (Include paragraph number and lines of wording)

7. SPECIFIC PROBLEMS (e.g. tests in 4.2.2 will not assure that the battery will last required time; temperature ranges in table 2 do not conform to commercially available items.)

8. RECOMMENDATIONS

9. NAME OF MANUFACTURER, ASSOCIATION, GOVT., AGENCY, ETC.

10. ADDRESS (Number, Street, City, State and Zip Code)

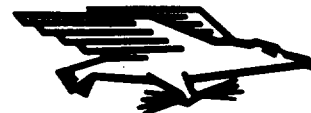
11. NAME AND TITLE OF SUBMITTER

12. DATE

FOLD

GENERAL SERVICES ADMINISTRATION

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