

AA-T-112

JULY 25, 1955

SUPERSEDING

Int. Fed. Spec. AA-T-00101b (GSA-FSS)
Revision 1, 17 May 1954, and
Fed. Spec. AA-T-101 IN PART
February 2, 1932

FEDERAL SPECIFICATION**TABLES, WOOD, GENERAL OFFICE**

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. SCOPE AND CLASSIFICATION

1.1 Scope.—The wood tables covered by this specification are of the Federal Standard general office type intended for use as work tables and as conference tables. The size 4 tables are intended for use in conference rooms and have a total potential seating capacity of 10 persons.

1.2 Classification.

1.2.1 Type and sizes.—The tables shall be of but one type and of the following sizes as specified in the invitations for bids:

Size 1.—36 inches wide by 24 inches deep by 30½ inches high (one drawer).

Size 2.—45 inches wide by 34 inches deep by 30½ inches high (one drawer).

Size 3.—60 inches wide by 34 inches deep by 30½ inches high (one drawer).

Size 4.—96 inches wide by 42 inches deep by 30½ inches high (no drawers).

1.2.2 Colors of finish.—The colors of finish shall be as specified in the invitations for bids and shall match the following standard colors adopted by the Federal Supply Service, General Services Administration:

Light Oak
Walnut

(Sample panels of the standard color of finish are obtainable without charge from the Business Service Center, Regional Office Building, Federal Supply Service,

General Services Administration, Washington 25, D. C., or from the Business Service Center of the nearest General Services Administration Regional Office.)

2. APPLICABLE SPECIFICATIONS, STANDARDS, AND OTHER PUBLICATIONS

2.1 Specifications and standards.—The following specifications and standards of the issues in effect on date of invitation for bids, form a part of this specification:

Federal Specifications:

TT-L-57—Lacquer, Rubbing, Clear (For Wood Furniture).

TT-L-58—Lacquer; Spraying, Clear and Pigmented (General Use).

UU-T-111—Tape; Paper, Gummed (Sealing and Securing).

LLL-F-291—Fiberboard; Corrugated, Single Face (Flexible).

MMM-A-100—Adhesives, Animal Gelatin.

MMM-A-125—Adhesives, Casein-type.

MMM-A-188—Adhesives; Urea-resin-type (Liquid and Powder).

PPP-B-601—Boxes, Wood, Cleated-Ply-wood.

Military Specifications:

MIL-C-11456—Crates; Wood, Nailed, Unsheathed, Domestic Shipment, 1500 pounds maximum load.

MIL-L-10547—Liners, Case, Waterproof.

JAN-P-106—Packaging and Packing for Overseas Shipment—Boxes; Wood, Nailed (for Weight of Contents not in Excess of 1000 Pounds).

Military Standards:

MIL-STD-105—Sampling Procedures and Tables for Inspection by Attributes.

MIL-STD-129—Marking for Shipment and Storage.

MIL-STD-130—Identification Marking of U. S. Property.

(Activities outside the Federal Government may obtain copies of Federal Specifications and Standards 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 25, D. C.

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

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

(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 publication of the issue in effect on the date of invitation to bid, forms a part of this specification:

Commercial Standard:

CS-35-49—Hardwood Plywood.

(Copies of the Commercial Standard referenced above, may be obtained upon application, accompanied by money order, coupon, or cash, to the Superintendent of Documents, Government Printing Office, Washington 25, D. C. Prices may be obtained from the Superintendent of Documents.)

3. REQUIREMENTS

3.1 Material.—The materials used in the construction of the tables shall be not less than the kind and quality specified herein.

3.1.1 Adhesives.—Adhesives used in the construction of the tables and their permitted application shall be as shown in table I.

TABLE I.—Adhesives

Application	Kind of adhesive
All assembly joints, glue blocks, glued laminated stock, and edge joining of lumber core panels.	Any adhesive that will conform to or exceed the test requirements of the following: Animal, Fed. Spec. MMM-A-100 grade J-2 or Casein, Fed. Spec. MMM-A-125 or Urea-Resin, Fed. Spec. MMM-A-188
All plywood gluing, edge joining of veneers and edge banding.	Any adhesive that will conform to the test requirements of the type II bond or better, as described in Commercial Standard CS-35-49 for Hardwood Plywood.

3.1.1.1 The adhesive manufacturers' directions for mixing and handling adhesives shall be accurately followed, and the adhesive when applied shall be of the proper consistency and quantity to assure the maximum bondage and serviceability of the joining members.

3.1.2 Hardware.

3.1.2.1 Footsockets.—The footsockets shall be made of .032-inch-thick stamped brass. They shall be 1 $\frac{3}{8}$ inches in height, and shall have a flat closed bottom with rounded bottom edges.

3.1.3 Lacquer.—Lacquer shall conform to Federal Specification TT-L-58. The prime coat shall conform to type I, and all other coats shall conform to type I, except that the nonvolatile matter shall be not less than 21 percent. The nonvolatile matter of flat lacquer shall be not less than 21 percent. Alternatively, lacquer in accordance with type I or type II of Federal Specification TT-L-57 will also be acceptable.

3.1.4 Wood parts.—Wood parts including solid wood, plywood, veneers, and cores shall be of the kinds of wood listed in table II, and of the quality hereinafter specified. All wood shall

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be uniformly kiln-dried to a moisture content of from 5 to 8 percent dependent upon the manufacturer's best commercial practice and, in addition, shall be held in properly controlled warm dry storage for a sufficient period of time to insure a uniform distribution of moisture among the individual pieces. After gluing, built-up legs and lumber cores shall either be returned to the kiln or be permitted to cure out for a sufficient period of time to insure a uniform distribution of glue joint moisture and the elimination of sunken joints (see 6.2), spring back and stresses before planing and sanding for crossbanding.

3.1.4.1 Solid exterior parts.—All such parts of any single item shall be of the same kind of wood. Parts shall be free of defects which affect appearance or which might affect serviceability, except as follows:

- a. Sound, tight knots of not over $\frac{1}{4}$ inch in average diameter provided they are not in clusters.
- b. Figured grain or discoloration provided the wood is such as to permit a uniform color when finished.

3.1.4.2 Solid interior parts.—Wood shall be free of defects which might affect serviceability except as follows:

- a. Sound, tight knots of not over $\frac{1}{2}$ inch in average diameter provided they are not in clusters, except drawer sides.
- b. Holes not over $\frac{1}{16}$ inch in diameter.
- c. Surface checks with barely perceptible opening not over 4 inches long.
- d. Bark, gum or pitch pockets not over $\frac{1}{8}$ inch wide and 2 inches long, except drawer parts exposed when open.
- e. Figured grain or discoloration provided the wood is such as to permit a uniform color of finish.

3.1.4.3 Plywood.—All plywood shall be constructed according to the requirements of Commercial Standard CS-35-49 and as specified herein. Bondage shall be not less than type II. Crossbanding shall be not less than grade 2, and not less than $\frac{1}{20}$ inch thick before sanding. Face and back veneers shall be not less than $\frac{1}{28}$

inch thick before sanding. All exposed faces shall have grade 1 veneers either plain sliced or flat cut and matched for color and grain to present a uniform appearance. Not less than grade 2 veneers shall be used on the face of unexposed panels and for the backs of all drawer bottom panels and table tops. Lumber core panels shall be regular grade, except that no end butt joints will be permitted. Veneer shall be in full length pieces and shall be applied in balanced construction form with no veneer joint less than 1 inch from the edge of the panels. All veneers shall be edge-glued.

3.1.4.4 Varieties.—The wood to be used in any one item for the color of finish specified, shall be as shown in table II. It is to be noted that the wide range of species listed is in no way to be construed as all species being acceptable but rather all species that will uniformly conform to the standard finish color and wood quality specified. Exposed parts include all parts and surfaces of each item of furniture which are exposed to view when the item is placed in the generally accepted positions of use.

3.2 Construction.

3.2.1 Design.—The design of the tables and construction details shall be in strict accordance with the details as shown in figure 1 and as specified herein. Drawers are not required for size 4 tables.

3.2.1.1 Tolerances.—The following tolerances will be permitted:

- Over-all width, depth, and height—plus or minus $\frac{1}{8}$ inch.
- Dimensions of any solid-wood part—plus or minus $\frac{1}{16}$ inch.
- Dimensions of any plywood part—plus $\frac{1}{16}$ inch, minus $\frac{1}{32}$ inch.

3.2.2 Gluing.—All joints shall be accurately milled and tight, and shall be thoroughly glued and held under proper pressure until the glue has set sufficiently to handle. Nails or brads to accomplish the holding of glue joints will not be permitted, except as shown on the figures. Starved or poorly glued joints will not be per-

TABLE II.—Varieties of wood permitted

Color of finish	Exposed parts		Drawer parts (except fronts)	Unexposed parts			
	Veneers (except legs)	Solid parts and veneered legs (one only for any one item)		Solid	Veneers	Corestock (1)	Crossbands
Light Oak	Oak	Oak	Ash ¹ Beech Birch	Ash ⁴ Beech ⁴ Birch ⁴	Alder (red) Ash Aspen	Alder Basswood Butternut	Alder Aspen Basswood
Walnut	Walnut	Beech Birch Cherry Hickory Mahogany ² Maple Pecan Walnut	Cherry Mahogany ³ Maple Oak ² Sycamore	Cherry Hackberry ⁴ Hickory ⁴ Magnolia Mahogany Maple ⁴ Oak ⁴ Pecan ⁴ Sweetgum Sycamore Tupelo Walnut ⁴	Basswood Beech Birch Butternut Cherry Cottonwood Douglas fir ⁵ Magnolia Mahogany Maple (soft) Ponderosa-Pine ⁵ Redwood ⁵ Sitka Spruce ⁵ White Pine ⁵ Yel. Poplar Sycamore Willow	Chestnut Cottonwood Cherry Magnolia Mahogany Maple (soft) Maple (soft) Oak Sweetgum Tupelo Walnut Yel. Poplar Sycamore Willow	Beech Birch Butternut Cherry Chestnut Cottonwood Magnolia Mahogany Maple (soft) Oak Sweetgum Tupelo Walnut Yel. Poplar Sycamore Willow

¹ Only one of the species listed shall be used in any one panel.

² American and African Mahogany only.

³ Must be same wood in any one table.

⁴ Drawer bearers and built-up leg core must be of one of the species.

⁵ Vertical grain only.

mitted. Excess glue shall be neatly cleaned from exposed surfaces and shall be evident on unexposed surfaces.

3.2.3 Tops.—The tops shall be of 5-ply lumber-core plywood $1\frac{1}{4}$ inches thick. The bondage, lumber core, crossbanding, back and face veneers shall be of the grades and types specified in 3.1.4.3 and of the woods specified in table II. After five-ply gluing, the tops shall be banded all around with a solid-wood molding which shall be not less than $\frac{5}{16}$ inch thick and may be tongued into the core of the top. The molding shall be full-length, straight-grained strips, lap or butt joined at the corners and rounded on the top edge and on the corners on a uniform radius of not less than $\frac{1}{8}$ inch. The tops shall be secured to the base by screws inserted through holes bored and counterbored in the aprons and drawer stretchers. The screws used to attach the top

shall be not more than 16 inches apart, not less in size than number 10, penetrating not less than three-fourths the thickness of the top. The top shall extend 2 inches equally beyond the aprons at the front, back and ends.

3.2.4 Legs.—The legs for sizes 1 and 2 tables shall be $2\frac{1}{4}$ inches square at the top and shall have a uniform taper on all sides or on the two inside faces to $1\frac{1}{2}$ inches square at the bottom. The legs of all size 3 and 4 tables shall taper in the same manner from 3 to $2\frac{1}{4}$ inches. All sides shall be of exposed vertical-grain or quarter-sawn wood not less than $\frac{1}{8}$ inch thick before sanding and all corners shall be uniformly rounded on at least a $\frac{1}{8}$ -inch radius. The legs shall be built up 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 the wood shown in table II for leg cores, or

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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 with the same exposed wood as described above. The veneer shall be not less than $\frac{1}{8}$ inch thick when applied. Footsockets as specified in 3.1.2.1 shall be tightly fitted flush with the outside faces of the leg and secured by an escutcheon nail. Each leg shall be secured to the corner brace as shown in figure 1 by a $\frac{3}{8}$ -inch rail bolt, which shall be screwed into the leg not less than $1\frac{1}{2}$ inches and shall pass through the corner brace and have ample protrusion beyond the brace for securing the unit. A steel washer not less than 1 inch in diameter or less than $\frac{1}{16}$ inch thick and a nut shall be supplied with each rail bolt.

3.2.5 Aprons.—The aprons shall be of solid wood $\frac{3}{4}$ inch thick by 4 inches wide and the bottom edges shall be full-rounded. The face of the legs shall protrude not more than $\frac{5}{16}$ inch beyond the aprons. 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.

3.2.5.1 Corner braces. — The tables shall have four accurately fitted corner braces of hardwood, $\frac{3}{4}$ inch thick by 4 inches wide. The corner braces shall be set back from the ends of the aprons not less than $1\frac{1}{2}$ inches and shall be dadoed or dovetailed into the aprons. The corner braces shall then be secured to the aprons by glue and not less than two No. 10 screws at each end of the brace. The screws shall be set at right angles to the aprons, and shall penetrate not less than two-thirds of the thickness of the aprons.

3.2.6 Drawer stretchers.—The drawer stretchers shall be of solid wood $\frac{3}{4}$ inch thick. The ends of the drawer stretchers shall be dadoed into the front and back aprons, to a depth of $\frac{1}{4}$ inch and shall be glued full width and glue blocked thereto. The drawer stretcher shall be secured to the underside of the table top by not less than three equally spaced screws, except size 1 table shall have not less than two screws, inserted through holes bored and counterbored in the stretcher. The screws used shall be not less than size No. 10 and of such length that not less than three-fourths the thickness of the top will be pene-

trated. Only one center stretcher side to side, full apron height, will be required on size 4 tables.

3.2.7 Drawer bearers and stops.—The drawer bearers for sizes 1, 2, and 3 tables shall be solid wood $\frac{3}{4}$ inch thick and $1\frac{3}{4}$ inches wide. Each drawer bearer shall be glued to the bottom edge of the stretchers and be secured by not less than four $1\frac{1}{2}$ -inch No. 8 screws or six 6-penny nails cement coated. Drawer bearers shall not be joined to the aprons but shall be of such length to butt join the drawer front rail, which shall be placed beneath the drawer and behind the drawer front. The rail shall be $\frac{3}{4}$ inch thick by 2 inches wide, having $\frac{5}{8}$ -inch recess milled along the front to within 1 inch of each drawer side. The rail shall be secured to the bottom of each stretcher by means of glue and not less than two No. 8, $1\frac{1}{2}$ -inch screws with the heads countersunk flush. All drawers shall have suitable wood drawer stops secured by glue and screws so that drawer front will not stop on the drawer rail. Drawer guides as shown in figure 1 shall be securely glued to the drawer bearer and shall continue along the drawer side not less than two-thirds the depth of the drawer.

3.2.8 Drawers. — Drawer openings for sizes 2 and 3 tables shall be 24 inches wide and 22 inches deep, drawers for size 1 tables shall be not less than 18 inches wide and 18 inches deep. The drawer sides and backs shall be $\frac{7}{16}$ inch thick. The drawer sides shall be dovetailed flush and glued to the front and back and held under pressure until the glue has set. The top edges of the drawer sides and back shall be rounded full length or coved and the top of the drawer sides shall be flush with the top of the drawer front and back. To avoid sticking, total drawer front clearance (top and sides) shall be not less than $\frac{1}{16}$ inch or more than $\frac{1}{8}$ inch. The drawer fronts shall be apron type and shall be $\frac{3}{4}$ inch thick solid wood, and the bottom edge shall be full-rounded. The drawer front shall be the same height as the aprons minus top clearance, and shall conceal the drawer front rail. The drawer bottom shall be 3-ply plywood, $\frac{3}{16}$ inch thick, and as specified in 3.1.4.3. The front, back, and sides shall have a groove milled $\frac{3}{16}$ inch deep to receive the drawer bottom. After the drawer is

assembled a triangular brace of $\frac{1}{4}$ -inch thick 3-ply plywood not less than $1\frac{1}{2}$ inches by $1\frac{1}{2}$ inches along the right-angle sides shall be glued to and below the drawer bottom at each corner, and shall fit accurately. Not less than one additional $\frac{3}{8}$ -inch by $\frac{3}{8}$ -inch triangular glue block not less than 3 inches long shall be rubbed in place to each front, back, and side.

3.3 Method of finishing.

3.3.1 Exposed parts and surfaces.—All exterior surfaces normally exposed to view shall be finish sanded smooth and all corners and edges eased, thoroughly cleaned and finished as herein specified. The finishing materials, coating system and tests as specified in Federal Specification TT-L-57 will also be acceptable.

3.3.1.1 Stain.—All exposed surfaces requiring stain to produce the color of finish specified shall be stained with a light fast, nongrain-raising, solvent type stain. Top and side surfaces of drawer fronts shall also be stained.

3.3.1.2 Wash coat.—A wash coat of either shellac or lacquer sealer shall be applied to all surfaces to be finished.

3.3.1.3 Filler.—All pores of exposed open-grain wood shall be thoroughly filled with a wood filler. As the filler dries it shall be worked into all pores completely filling them, and the excess filler wiped away from all surfaces and corners. All close-grain wood not requiring filler shall have a second coat of lacquer sanding sealer.

3.3.1.4 Retouching.—All exposed filled or sealed surfaces shall be inspected and carefully corrected with lacquer shading-stain to the required standard color specified. The color of all exposed parts and surfaces shall be uniform.

3.3.1.5 Final coats.—After the above requirements are completed, the body or base and legs of the tables shall receive one coat of lacquer sealer and two coats of flat lacquer. The tops shall have three coats of clear lacquer and shall be rubbed to an egg-shell finish. The lacquer when applied shall be as specified in 3.1.3, and each coat shall be heavy enough to assure ample body for sanding and rubbing. Application, drying time, sanding, and cleaning shall be

controlled to produce a clean, smooth, heavy, even film of finish without blisters, pits, wrinkles, runs, or more than a trace of orange peel. The finish shall not cloud the natural grain of the wood.

3.3.2 Interior parts and underside of top.

3.3.2.1 Interior parts.—After the drawer fronts have been finished as specified in 3.3.1, and subparagraphs thereunder, the drawer interior and exterior surfaces, except the fronts, shall be finish sanded smooth and completely cleaned. The entire surfaces of the drawer, and the drawer rails and bearers shall be given a moisture retarding and lubricating treatment. The liquid used shall be an odorless (after 48 hours), nongrain-raising solution which shall contain not less than 30 percent nonvolatile, non-toxic matter of which not less than 7 percent shall be wax and 40 percent inert resins. The natural color of the wood shall not be materially changed. The entire surfaces of the unexposed parts of the drawers shall be submerged in the moisture-retarding solution for not less than 3 minutes. The drawers shall be allowed to drain before insertion into the tables and all surplus of the solution shall be thoroughly wiped from finished surfaces to insure a smooth finish and free-sliding drawer operation.

3.3.2.2 Under side of top.—The under side of the top shall receive a coat of the same moisture-retarding treatment as the drawers, or alternatively one coat of shellac or lacquer sealer and one coat of lacquer will be acceptable.

3.4 Identification marking.—Unless otherwise specified, each table shall be permanently marked on the under side of the top or drawer bottom in a plain and legible manner with the specification number, the Federal stock number, the date of manufacture, and the manufacturer's name or trade-mark of such known character that the sources of supply may be readily determined. When specified, tables shall be marked in accordance with Military Standard MIL-STD-130, *Identification Marking for U. S. Property.*

3.5 Workmanship.—The details of construction, including design, veneering, joining, assembling, finishing and marking shall be in strict ac-

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cordance with the requirements and tolerances of this specification and figure 1. Finished tables and all parts thereof shall be free from any defects that affect appearance or which might affect the safety of the user or the serviceability of the tables.

4. SAMPLING, INSPECTION, AND TEST PROCEDURES

4.1 Sampling for lot acceptance.

4.1.1 Inspection lot.—Normally, the inspection lot size shall consist of all units submitted for inspection at one time.

4.1.2 Sampling for inspection.—Representative random samples shall be selected from the lot in accordance with table III. Acceptance or rejection of the lot shall be based on the number of defective units found in the sample selected and inspected, as being equal to or less than the specified acceptance number; or equal to or greater than the specified rejection number of table III.

TABLE III.—*Sampling for visual and dimensional inspection based on—Acceptable Quality Level (AQL) of 2.5%*

Lot size	Sample size	Acceptance number	Rejection number
15 and under .	3	0	1
16 to 40	7	0	1
41 to 110	15	1	2
111 to 300	35	2	3
301 to 500	50	3	4
501 and over ...	75	4	5

NOTE 1—The Government Inspector may institute tightened or reduced inspection in accordance with Section 9 of MIL-STD-105.

NOTE 2—The above is a single sampling procedure, alternate double or multiple sampling procedures of alternate Acceptable Quality Levels for different classes of defects may be specified at the discretion of the procuring agency.

4.2 Inspection.—The tables shall be inspected to determine compliance with this specification as to workmanship, materials, design, details of construction, hardware, finish, marking and packing. Inspection shall be made at the

factory by a representative of the Government at any time during process of manufacture, or at point of delivery.

5. PREPARATION FOR DELIVERY

5.1 Application.—Tables, wood, shall be packaged and packed for domestic shipment (immediate use), domestic shipment (storage), or overseas shipment (commercial), overseas shipment (military) as specified. (See section 6.1.)

5.2 For domestic shipment (immediate use).—Unless otherwise specified, tables, wood, shall be packed in containers, which (together with packaging, wrapping and inner packing) are acceptable by common or other carriers for safe transportation to point of destination specified in shipping instruction at the lowest transportation rate for such supplies.

5.3 For domestic shipment (storage).—When specified.

5.3.1 Packaging (all sizes).—The legs shall be removed from the table and the nuts shall be replaced and tightened on bolts. 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 Federal Specification LLL-F-291, and taped. The drawer shall be immobilized by means of strips of commercial pressure-sensitive tape, minimum 2-inch width, applied over all applicable edges of the drawer front and adjacent surfaces of the table. Alternatively, metal drawer clips may be used. All finished surfaces of the tables shall be completely covered with a sheet of machine-glazed kraft paper having a minimum basis weight of 30 pounds per ream (24 by 36—500). The paper shall be taped to the underside of the apron and drawers. 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 $\frac{3}{4}$ 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.

Table sizes 1, 2, and 3 shall have the wrapped legs positioned lengthwise against the front and rear of the drawer, and table size 4 shall have the legs positioned inside of apron. All legs shall be cushioned to prevent movement in transit. A sheet of fiberboard having a minimum mullen test of 200 p.s.i., shall be positioned and taped to apron so as to completely enclose the under side of the table. Unless otherwise specified, all taping shall be effected with gummed paper tape, minimum 2 inches in width, conforming to Federal Specification UU-T-111, class 1.

5.3.2 Packing.—Each table packaged as specified in 5.3.1 shall be packed in a nailed wood crate, style C-1 conforming to Military Specification MIL-C-11456.

5.4 For overseas shipment (commercial export).—When specified, subject commodity shall be packed in containers which together with packaging, wrapping and inner packing, are acceptable by oceangoing vessels for safe transportation to the points of destination specified in the shipping instructions at the lowest transportation rate for such supplies.

5.5 For overseas shipment (military).—When specified.

5.5.1 Packaging.—Tables shall be packaged as specified in 5.3.1 except fiberboard sheet specified for enclosing the underside of the table shall not be required.

5.5.2 Packing.—Each table packaged as specified in 5.3.1 shall be packed in a cleated plywood or nailed wood box constructed and strapped in accordance with Federal Specification PPP-B-601, overseas type; or JAN-P-106, styles 2, 2½, or 4. Each shipping container shall be provided with a type I or II, grade B or C, class 2, L-2 or M material, case liner in conformance with Military Specification MIL-L-10547.

5.6 Marking.—Unless otherwise specified, shipping containers shall be clearly marked with the name, size and color of the commodity, the item number, the name of the contractor, and the number of the contract or order and the full name and address of the consignee. When specified, container shall be marked in accordance with MIL-STD-129. In addition, each container shall have arrow indicators placed on the side of the container to indicate the position in which the container shall be handled in transit. The word "UP" shall be placed at the point of the arrows in letters at least two inches high:

UP FURNITURE UP
Fragile Handle With Care

Top panels shall be marked as follows:

FURNITURE
Fragile Handle With Care
THIS SIDE UP

6. NOTES

6.1 Ordering data.—Purchasers should specify the size and the color of finish required or whether a different AQL or special marking is required or whether packing for other than domestic shipment (immediate use) is required and should exercise any desired options offered herein (see 1.2.1, 1.2.2, 3.4, 4.1, 5.1, and 5.6).

a. Domestic shipment (immediate use).—Applies to that material required for immediate use without storage or reshipment by the initial domestic receiving activity. (See 5.2.)

b. Domestic shipment (storage).—Applies to that material for storage and reshipment to a domestic receiving activity not involving sea transportation. (See 5.3.)

c. Overseas shipment (commercial).—Applies to that material to be transported by oceangoing or coastwise vessel and is to be accorded normal covered storage at destination or where the end use of the item is to be at the initial receiving activity. (See 5.4.)

d. Overseas shipment (military).—Applies to that material to be transported by oceangoing or coastwise vessel and handled, issued, and stored in the military supply system. (See 5.5.)

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6.2 Sunken joints.—Tests have shown that sunken joints in edge-glued panels of solid stock can be largely eliminated by observing one of the following conditioning schedules after edge gluing and before surfacing:

- (a) 7 days at 80° F. and 30 percent relative humidity.
- (b) 4 days at 120° F. and 35 percent relative humidity.
- (c) 24 hours at 160° F. and 44 percent relative humidity.
- (d) 16 hours at 200° F. and 55 percent relative humidity.

6.3 Federal specifications do not include all the types, classes, grades, sizes, etc., of the commodities indicated by the titles of the specifications, or which are commercially available, but are intended to cover the types, etc., which are suitable for Federal Government requirements.

6.4 It is believed that this specification adequately describes the characteristics necessary to secure the desired material, and that normally no samples will be necessary prior to award to determine compliance with this specification. If, for any particular purpose, samples with bids are necessary they should be specifically asked for in the invitation for bids, and the particular purpose to be served by the bid sample should be definitely stated, the specification to apply in all other respects.

6.5 Transportation description.—Transportation description applicable to this item is:

Tables, not otherwise indexed by name, wooden, finished (indicate knocked-down or set-up).

Carload minimum weights:

In cars 40' 9" or less in length, inside measurements—10,000; 12,000; 15,000; 18,000; 22,000; 30,000.

In cars exceeding 40' 9" in length, inside measurements—16,000; 18,000; 21,000; 24,000; 30,000; 40,000.

Truckload minimum weights:

Set-up—12,000 pounds.

Knocked-down—20,000 pounds.

Minimum weights shown apply when material is transported at classification ratings. They will vary when material moves on commodity rates. When in doubt consult General Services Administration, Regional Traffic Manager.

Patent notice.—When Government drawings, specifications, or other data are used for any purposes other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data, is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

MILITARY INTEREST:

Army—M Q
Air Force.

Copies of this specification may be purchased for 15 cents.