

AA-T-2753
30 April 1991

TABLE, FOLDING, STEEL TUBE (ADVANCE BASE)

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

1. SCOPE AND CLASSIFICATION

1.1 Scope. This document covers requirements for component materials and their assembly into sturdily constructed folding tables 30 inches high with laminated plastic top surfacing, steel frame, and steel legs.

* 1.2 Classification. The folding tables covered by this specification shall be of the sizes as specified.

	PIN Code No
Grade I - 30" high, steel frame and legs, laminated plastic top	1
Size 1 - 30 inches by 48 inches (top).	A
Size 2 - 30 inches by 72 inches (top).	B

2. APPLICABLE DOCUMENTS

* 2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation, form a part of this specification to the extent specified herein.

Beneficial comments (recommendations, additions, deletions) and any pertinent
*data which may be of use in improving this document should be addressed to: *
*Commanding Officer (Code 156), Naval Construction Battalion Center, Port *
*Hueneme, CA 93043-5000, by using the self-addressed Standardization *
*Document Improvement Proposal (DD Form 1426) appearing at the end of this *
*document or by letter. *

AMSC N/A

FSC 7105

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SPECIFICATIONS

FEDERAL

L-P-508 - Plastic Sheet, Laminated, Decorative and Non-decorative.
PPP-B-636 - Boxes, Shipping, Fiberboard.

MILITARY

MIL-P-116 - Preservation, Methods of

STANDARDS

FEDERAL

FED-STD-595 - Colors.

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by
Attributes.
MIL-STD-129 - Marking for Shipment and Storage.
MIL-STD-2073 - DOD Materiel Procedures For Development &
Application Of Packaging Requirements

(Copies of specifications, standards, handbooks, drawings, and publications required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.1.2 Other Government documents, drawings, and publications. The following other Government documents form a part of this specification to the extent specified herein.

U.S. DEPARTMENT OF COMMERCE (NIST)

CS236-66 - Mat Formed Wood Particleboard.
PS1-83 - Construction and Industrial plywood.

(Application for copies should be addressed to the Superintendent of Documents, Government Printing Office, Washington, DC 20402.)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D3951 - Commercial Packaging, Standard Practice For.

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Industry association specifications and standards are generally available

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for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

* 3.1 Description. The table shall be constructed of square or round tubular steel legs and steel angle chassis secured to a plywood or particleboard core surfaced with a decorative laminated plastic sheet. The legs shall fold up completely flat under table top. The table shall be in accordance with the dimensions specified herein. The table shall contain a positive locking device effective in the open and rigid closed positions. The table shall sustain a static load of 1,000 pounds when tested in accordance with 4.5.

3.2 Standard commercial product. The table shall, as a minimum, be in accordance with the requirements of this specification and shall be the manufacturer's standard commercial product. Alternate features which equal or improve the quality or performance which are not specifically prohibited by this specification but which are a part of the manufacturer's standard commercial product, shall be included in the table being furnished. A standard commercial product is a product which has been sold or is being currently offered for sale on the commercial market through advertisements or manufacturer's catalogs, or brochures, and represents the latest production model.

3.3 First article. When specified (see 6.2), the contractor shall furnish a table for first article inspection and approval (see 4.2.1 and 6.3).

3.4 Materials. Materials shall be as specified herein and in applicable specifications and standards, and other referenced documents. Materials not specified shall be selected by the contractor and shall be subject to all provisions of this specification. Materials shall be free of defects which adversely affect performance or serviceability of the finished product.

3.4.1 Table top core. Plywood, 5/8-inch thick shall be in accordance with voluntary Product Standard PS1 grade A-C, exterior type or particleboard, 5/8-inch thick shall be in accordance with CS236, type 1, grade B, class 2.

3.4.2 Laminated plastic sheet. Laminated plastic sheet shall be in accordance with L-P-508, style D, type 1, class 1, 0.050-inch thick. Pattern, color, and finish shall be as specified (see 3.6.1 and 6.2).

3.4.3 Edging. Edging shall be anodized aluminum molding.

3.4.4 Fasteners. For frame to top, internally threaded hex head or pronged flange when specified (see 6.2) shank tapped to receive not less than an 8-32 machine screw. Lockwashers or a liquid compound which solidifies into a permanent set shall hold screws securely in place. The internally threaded fasteners shall be flush with the core top and shall not protrude beyond bottom. For frame to legs, cold-rolled steel, 1/4-inch thick rivets, or 1/4-inch screw type fastener or equal when specified (see 6.2). All fasteners shall be treated for corrosion resistance.

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3.5 Construction.

3.5.1 Table top. The top core shall be surfaced with a one-piece laminated plastic sheet (see 3.4.2), with the pattern and color as specified. The plastic sheet shall be bonded to the core with adhesive. The corners shall be rounded. The top perimeter shall be edged with an aluminum channel (see 3.4.3), with the edge projecting slightly above the top surface. The edging shall be secured under pressure and without voids or crevices at all contact areas. Nails or screws may be used on the bottom surface of the table to provide more screw attachment of the edging.

3.5.2 Chassis frame.

3.5.2.1 Size 1. The chassis frame shall be of standard commercial rolled steel angles. Each of the two longitudinal members shall be 45 inches long with metal stacking plates at the end of each rail or legs when folded shall be flush with bottom edge of chassis frame to provide a flat stacking surface or forms. The frame members shall be secured to the top with internally threaded shank fasteners and screws (see 3.4.4). Five fasteners shall secure each longitudinal member and three fasteners shall secure each cross member. The longitudinal member shall be approximately 2-1/2 inches from the edge. Location of the cross member is to be determined by leg placement. Frame shall be in true alignment, and the leg of each angle adjacent to the underside of the top shall lie flat at all points and without buckle.

3.5.2.2 Size 2. Same as size 1 (see 3.5.2.1), except longitudinal members shall be 69-1/2 inches long and secured with eight fasteners each side.

* 3.5.3 Legs assembly. The legs shall be constructed of 1-1/2 inch square or round, 20 gage, welded steel tube. The legs shall be secured to the chassis frame. Each leg shall be fastened to the chassis frame by a riveted folding arm or by a leg brace. Each pair of legs shall travel in unison when extended or folded. When folded, the table thickness shall not exceed 3 inches. The locking device shall automatically lock when the legs are open and remain rigid when closed. The lock design shall prevent accidental tripping. The bottom of each leg shall be capped with a smooth, round, non-marring steel glide or a black ABS plastic platform base glide. Glides shall not be capable of being removed without the use of tools.

3.6 Finish.

3.6.1 Color. Color shall be as specified (see Table I and 6.2). The leg assembly and chassis frame color shall be of the FED-STD-595 Color Number in table I and the laminated plastic sheet for the table top shall be of one pattern and color as specified in table I.

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TABLE I. Color

Color	FED-STD-595 Color No.	Laminated Plastic Sheet pattern and Color
Gray	26134	Westinghouse Micarta 81M67 Avocado Leather, Lo-Glare. Formica 772-64 Green Leather Design. Nevamar LH5-4 Avocado Leather Tex- tured Finish or equal.
Olive drab	24087	Same as above.
Green	24052	Same as above.
Green	24064	Same as above.

3.6.2 Table top bottom. The bottom or underside of the table top shall be treated with a water and insect repellent penetrating sealer.

3.6.3 Identification marking. Identification shall be permanently and legibly marked directly on the underside of each table or on a corrosion-resisting metal plate securely attached to the underside of the table at the source of manufacturer. Identification shall include the manufacturer's model and serial number, name and trademark to be readily identifiable to the manufacturer.

3.7 Workmanship.

3.7.1 Steel fabrication. The steel used in fabrication shall be free from kinks, sharp bends, and other conditions which would be deleterious to the finished product. Manufacturing processes shall not reduce the strength of the steel to a value less than intended by the design. Manufacturing processes shall be done neatly and accurately. All bends shall be made by controlled means to insure uniformity of size and shape.

3.7.2 Riveted connections. Rivet holes shall be accurately punched or drilled and shall have the burrs removed. Rivets shall be driven with pressure tools and shall completely fill the holes. Rivet heads, when not countersunk or flattened, shall be of approved shape and of uniform size for the same diameter of rivet. Rivet heads shall be full, neatly made, concentric with the rivet holes, and in full contact with the surface of the member.

3.7.3 Welding. Welding procedures shall be in accordance with a nationally recognized welding code. The surface of parts to be welded shall be free from rust, scale, paint, grease, or other foreign matter. Welds shall be of sufficient size and shape to develop the full strength of the parts connected by the welds. Welds shall transmit stress without permanent deformation or failure when the parts connected by the weld are subjected to proof and service loadings.

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3.7.4 Cleaning, treatment, and painting. Surfaces normally painted in good commercial practice shall be cleaned, treated, and painted as specified herein. The color of the finish coat shall be as specified (see 6.2). Surfaces to be painted shall be cleaned and dried to insure that they are free from contaminants such as oil, grease, welding slag and spatter, loose mill scale, water, dirt, corrosion product, or any other contaminating substances. As soon as practicable after cleaning, and before and corrosion product or other contamination can result, the surfaces shall be prepared or treated to insure the adhesion of the coating system. The painting shall consist of at least one coat of primer and one finish coat. The primer shall be applied to a clean, dry surface as soon as practicable after cleaning and treating. Painting shall be with manufacturer's current materials according to manufacturer's current processes and the total dry film thickness shall be not less than 2.5 mils over the entire surface. The paint shall be free from runs, sags, orange peel, or other defects.

4. QUALITY ASSURANCE PROVISION

* 4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by 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 supplies and services conform to prescribed requirements.

4.1.1 Component and material inspection. Components and materials shall be inspected in accordance with all the requirements specified herein and in applicable referenced documents.

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.2.1).
- b. Quality conformance inspection (see 4.2.2).

4.2.1 First article inspection. The first article inspection shall be performed on one table when a first article is required (see 3.3 and 6.2). This inspection shall include the examination of 4.4 and the tests of 4.5. The first article may be either a first production item or a standard production item from the supplier's current inventory provided the item meets the requirements of the specification and is representative of the design, construction, and manufacturing technique applicable to the remaining items to be furnished under the contract.

4.2.2 Quality conformance inspection. The quality conformance inspection shall include the examination of 4.4, the tests of 4.5 when a first article is not required, and the packaging inspection of 4.6. This inspection shall be performed on the samples selected in accordance with 4.3.

4.3 Sampling. Sampling and inspection procedures shall be in accordance with MIL-STD-105. The unit of product shall be one table. All tables of the same size offered for delivery at one time shall be considered a lot for the

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purpose of inspection. The inspection level shall be level II and the Acceptable Quality Level shall be 2.5 percent for major defects and 4.0 percent for minor defects. If an inspection lot is rejected, the contractor may rework it to correct the defects, or screen out the defective units, and resubmit for a complete reinspection. Resubmitted lots shall be reinspected using tightened inspection. If the rejected lot was screened, reinspection shall be limited to the defect causing rejection. If the lot was reprocessed, reinspection shall be performed for all defects. Rejected lots shall be separate from new lots, and shall be clearly identified as reinspected lots.

4.4 Examination. Each table shall be examined for defects listed in table II. Each table shall be examined for compliance with the requirements specified in section 3 of this specification. Any redesign or modification of the contractor's standard product to comply with specified requirements, or any necessary redesign or modification following failure to meet specified requirements shall receive particular attention for adequacy and suitability. This element of inspection shall encompass all visual examinations and dimensional measurements. Noncompliance with any specified requirements or presence of one or more defects preventing or lessening maximum efficiency shall constitute cause for rejection.

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TABLE II. Classification of Defects.

Classification	Defects	Requirement Paragraph
Critical	None Defined	
Major:		
101	Overall dimensions not as specified.	1.1 & 1.2
102	Table top core not as specified.	3.4.1
103	Laminated plastic sheets not as specified.	3.4.2
104	Edging not as specified.	3.4.3
105	Fasteners not as specified.	3.4.4
106	Aluminum edging not firmly secured in place.	3.5.1
107	Joints between laminated plastic and aluminum edging not tight and smooth.	3.5.1
108	Chassis frame dimension not as specified.	3.5.2.1
109	Chassis frame not in true alignment.	3.5.2.1
110	Leg of each angle of each chassis frame adjacent to underside of top does not lie flat without buckles at all points.	3.5.2.1
111	Leg assembly materials and dimensions not as specified.	3.5.3
112	Locking device not as specified.	3.5.3
113	Legs travel not in unison when extended or folded.	3.5.3
114	Legs cannot be fully extended or folded.	3.5.3
115	Folding arms or leg brace on each side of paired legs travel not in unison when legs are not extended or folded.	3.5.3

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116	Uneven leg lengths at floor contact points.	3.5.3
117	Legs catch or stick when being extended or folded.	3.5.3
118	Legs do not lock in place when extended in use position, or when folded, remain rigid	3.5.3
119	Color coordination not as specified.	3.6.1
120	Paint application not as specified.	3.6.2 & 3.7.4
121	Table underside not treated as specified.	3.6.3
122	Surface metal cracked, contains burrs, or rough edges.	3.7.1
123	Metal buckled, distorted, or bent out of shape, affecting serviceability or appearance when in use position.	3.7.1
124	Sharp edges or protrusions in wood or metal surfaces that could cause injury or tear clothing.	3.5.1 & 3.7.1
125	Welding not as specified.	3.7.3
126	Painting not as specified.	3.7.4

4.5 Tests. Each sample table selected shall be set-up in the use position and an evenly distributed static load of 1,000 pounds shall be placed on the table for a period of 5 minutes. Any table failing to sustain the load as specified shall be considered a defective unit.

4.6 Packaging inspection. The preservation, packing, and marking of the tables shall be inspected to determine compliance with the requirements of Section 5 of this specification.

5. PACKAGING

5.1 Preservation. Preservation shall be level A or commercial, as specified (see 6.2).

5.1.1 Level A. Each table shall be folded flat and preserved method III in accordance with MIL-P-116. The unit pack container shall be a box conforming to PPP-B-636, class weather-resistant. The box shall be closed method V in accordance with the appendix to PPP-B-636.

* 5.1.2 Commercial. Each table shall be folded flat and packaged in accordance with ASTM D3951. Requirements as a minimum shall conform to applicable carrier rules and regulations.

5.2 Packing. Packing shall be level A, B, or commercial as specified (see 6.2).

* 5.2.1 Levels A and B. Packing shall be in accordance with MIL-STD-2073-1A for the applicable level specified. Containers shall be selected from appendix C, Table VII for the appropriate level.

* 5.2.2 Commercial. Material shall be packed in accordance with ASTM D3951. Requirements as a minimum shall conform to applicable carrier rules and regulations.

5.3 Marking. Marking shall be in accordance with MIL-STD-129.

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6. NOTES

6.1 Intended use. This is intended to be a replacement for MIL-T-23153C. The folding legs table covered by this specification is intended for use in advance base functions as a general purpose utility worktable.

* 6.2 Ordering data. Purchasers shall select the preferred Options permitted herein and include the following information in procurement documents:

- a. Title, number, and date of this specification
- b. Quantity of tables required.
- c. Size required (see 1.2).
- d. When first article is required for inspection and approval (see 3.3, 4.2.1 and 6.3).
- e. Color required (see 3.4.2, 3.6.1, 3.7.4 and table I).
- f. Fasteners required (see 3.4.4).
- g. Level of preservation and level of packing required (see 5.1 and 5.2).
- h. Grade and class or PIN required (see 1.2).

6.3 First article. When a first article inspection is required, the item will be tested and should be a first article sample or it may be a standard production item from the contractor's current inventory as specified in 4.2.1. The first article should consist of one complete table unit. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, test, and approval of the first article.

* 6.4 Changes from previous issue. Asterisks are used in this revision to identify changes with respect to the previous issue.

* 6.5 Part or Identifying Number (PIN). PIN's were developed to identify items covered by this specification for cataloging purposes. The PIN consists of this specification identifier (M2753) and the SPN code number (see 1.2). The PIN shall be designated as follows:

PIN designation	M2753	1	B
	*	*	*
Specification number-----*		*	*
		*	*
Grade-----*			*
			*
Class/Type-----*			*

The above identifies a grade 1 steel (frame and legs) table with a top size of 30 x 48 ".

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MILITARY INTERESTS:

MCA:

Navy - YD

Custodians:

Navy - YD

Air Force - 99

Review Activity:

Army - GL

Air Force - 84

CIVIL AGENCY COORDINATING ACTIVITIES:

GSA - FSS/FCNE

Preparing activity:

Navy - YD

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