

FF-T-311E  
October 9, 1974  

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SUPERSEDING  
Int. Fed. Spec. FF-T-00311D(GSA-FSS)  
November 9, 1971 and,  
Fed. Spec. FF-T-311C  
July 15, 1963

FEDERAL SPECIFICATION

THUMBTACK

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. This specification covers general purpose thumbtacks of various sizes.

1.2 Classification.

1.2.1 Type and class. The thumbtacks shall be of the following type and class, as specified (see 6.2).

Type I - Deleted (see 6.3).  
Type II - General Purpose.  
Class 1 - Solid head.

1.2.2 Sizes. See 3.5 and table I.

2. APPLICABLE DOCUMENTS

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

Federal Specifications:

PPP-B-566 - Boxes, Folding, Paperboard.  
PPP-B-636 - Boxes, Shipping, Fiberboard.  
PPP-B-676 - Boxes, Setup.

Federal Standards:

Fed. Std. No. 123 - Marking for Domestic Shipment (Civil agencies).  
Fed. Test Method Std. No. 304 - Metals, Chemical Test Method (For Identification).

(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, DC 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, DC, Atlanta, Chicago, Kansas City, MO, Fort Worth, Denver, San Francisco, Los Angeles, and Seattle, WA.

(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.

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(Copies of Military Specifications and Standards required by suppliers 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.

National Motor Freight Traffic Association, Inc., Agent:

National Motor Freight Classification.

(Application for copies should be addressed to the American Trucking Associations, Inc., Tariff Order Section, 1616 P Street, N.W., Washington, DC 20036.)

Uniform Classification Committee, Agent:

Uniform Freight Classification.

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza., Chicago, IL 60606.)

3. REQUIREMENTS

3.1 Standard product. The thumbtacks furnished under this specification shall be the manufacturer's standard commercial product, except for changes necessary to comply with the requirements of this specification.

3.2 Material. Type II thumbtacks shall be made of cold-rolled steel, or copper zinc alloy (brass), or a combination thereof, at the option of the manufacturer. The base material, including nickel coating, shall conform to the dimensional requirements established by this specification, and shall be of such quality to assure that the end item will pass the tests specified in 4.4.

3.3 Design and construction.

3.3.1 Type II, class 1. The thumbtacks shall be made of material as specified in 3.2, and the dimensions of the heads and pins shall be as specified in 3.5. The head and pin shall be swaged together without the pin extending through the head. The pin shall be in the center of the head and perpendicular thereto. The free end of the pin shall have a sharp point. The pin shall not become loose, detached, or break off the head, when tested as specified in 4.4.1.1.

3.4 Finish. The exposed surfaces of the thumbtacks shall be coated with nickel of a thickness used in standard commercial practice (see 3.4.1 and 4.4.1.3).

3.4.1 Resistance to corrosion. When tested for resistance to corrosion as specified in 4.4.1.2 the total surface of any thumbtack showing corrosion shall not exceed 5 percent.

3.5 Dimensions. The diameter and thickness of the head, and the diameter and length of the pin shall conform to the dimensions specified in table I (see 1.2.1, and 6.2):

| TABLE I. Dimension (inch)       |                   |                 |                 |
|---------------------------------|-------------------|-----------------|-----------------|
| Diameter of head                | Thickness of head | Diameter of pin | Length of pin   |
| 0.375, 0.50, 0.5625<br>± 0.0312 | 0.025 minimum     | 0.041 ± 0.005   | 0.3125 ± 0.0312 |

3.6 Identification marking. Each box of thumbtacks shall be legibly marked with the name or trademark of the manufacturer.

3.7 Workmanship. All surfaces of the thumbtacks shall have a smooth finish and shall be free of rough or sharp edges with the exception of the sharp point of the pin. The thumbtacks shall be clean and uniform, and shall be free from defects or imperfections which adversely affect appearance, or might impair serviceability.

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## 4. QUALITY ASSURANCE PROVISIONS

4.1 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 in the contract or order, the supplier 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 that supplies and services conform to prescribed requirements.

4.2 Sampling.

4.2.1 Size of lot. Thumbtacks of the same type, class and size presented for inspection at one time shall be considered a lot for purposes of examination and test.

4.2.2 Sampling and inspection for acceptance. Sampling and inspection for acceptance shall be performed in accordance with MIL-STD-105, except where otherwise specified.

4.2.3 Sampling for visual and dimensional examination. Boxes of thumbtacks shall be taken at random from each lot in accordance with MIL-STD-105. The sample unit shall be one box, except that five (5) thumbtacks, taken at random from each box, shall be examined as specified in 4.3.1. The Inspection Level shall be S-3, with an Acceptable Quality Level (AQL) of 2.5 percent defective.

4.2.4 Sampling for tests. For each test, boxes of thumbtacks shall be selected at random from each lot in accordance with MIL-STD-105. The sample unit shall be one box, except that five (5) thumbtacks, taken at random from each box, shall be tested as specified in 4.4. The Inspection Level shall be S-2, with an AQL of 4.0 percent defective.

4.2.5 Sampling for preparation for delivery requirements. Sampling shall be in accordance with MIL-STD-105. The sample unit shall be one container fully prepared for delivery. The lot shall be the number of containers offered for inspection at one time. The Inspection Level shall be S-2, with an AQL of 4.0 defects per hundred units.

4.3 Examination.

4.3.1 Visual and dimensional examination. Samples taken in accordance with 4.2.3 shall be examined for defects listed in table II. Any thumbtack having one or more defects shall be rejected. If the number of defective units in the sample exceeds the acceptable number for that sample, the entire lot represented by the sample shall be rejected.

TABLE II. Classification of defects

| Examine                 | Defects                                                      |
|-------------------------|--------------------------------------------------------------|
| Type, class, and size   | Not as specified (see 1.2.1, 1.2.2, 3.3.1, 3.5, and table I) |
| Standard product        | Not standard product (see 3.1).                              |
| Material                | Not as specified (see 3.2).                                  |
| Design and construction | Not as specified (see 3.3).                                  |
| Identification          |                                                              |
| Marking                 | Boxes of thumbtacks not marked as specified (see 3.6).       |
| Workmanship             | Workmanship not in accordance with 3.7.                      |

4.3.2 Examination of preparation for delivery defects. Samples selected in accordance with 4.2.5 shall be examined for defects listed in table III to determine whether the packaging, packing, and marking comply with the requirements of Section 5 of this specification.

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TABLE III. Examination of preparation for delivery

| Examine     | Defects                                                                                    |
|-------------|--------------------------------------------------------------------------------------------|
| Contents    | Not as specified.                                                                          |
| Containers  | Not as specified.                                                                          |
| Markings    | Omitted; incorrect; illegible; improper size, location, sequence or method of application. |
| Materials   | Component missing or damaged.                                                              |
| Workmanship | Bulging or distortion of containers.<br>Cushioning inadequate, improper or missing.        |

4.3.2.1 Examination of closure and reinforcement for containers. When shipping containers are required to comply with PPP-B-636, examination for defects in closure and reinforcement shall be in accordance with the appendix of that specification.

#### 4.4 Tests.

4.4.1 End item tests. Samples selected in accordance with 4.2.4 shall be subjected to the following tests. Any thumbtack in the sample failing the test shall be considered defective. If the number of defective thumbtacks exceeds the acceptance number for the sample, the lot represented by the sample shall be rejected.

4.4.1.1 Bending test. The pins of the sample thumbtacks shall be bend 90° so that the pin rests flat on the underside of the head. The pin shall not become loose, detached, or break off the head. (See 3.3.1)

4.4.1.2 Resistance to corrosion. The sample thumbtacks shall be boiled in distilled water in a glass beaker for 30 minutes and allowed to remain submerged for 24 hours. The surface of the thumbtacks shall then be examined for compliance with 3.4.1.

4.4.1.3 Identification for presence of nickel. To determine presence of nickel coating, the thumbtacks shall be tested in accordance with method 108 of Fed. Test Method Std. No. 304 (see 3.4).

### 5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A, B, or C, as specified (see 6.2).

#### 5.1.1 Level A.

5.1.1.1 Unit packaging. One hundred (100) thumbtacks shall be packaged in a box conforming to PPP-B-566, variety 2, water resistant or PPP-B-676 variety 2, water resistant. The box shall be closed in accordance with the appendix to the appropriate box specification.

5.1.1.2 Intermediate packaging. Ten (10) packages of thumbtacks shall be intermediately packaged in a box and closed as specified in 5.1.1.1.

5.1.2 Level B. Thumbtacks shall be unit and intermediately packaged as specified in 5.1.1.1 and 5.1.1.2 except that variety 1 non-resistant paperboard shall be used for boxes conforming to PPP-B-566 and variety 1 - plain shall be used for boxes conforming to PPP-B-676.

5.1.3 Level C. Thumbtacks shall be packaged to afford adequate protection against damage during shipment from the supply source to the first receiving agency.

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

5.2.1 Level A. Thumbtacks, in quantities as specified in 6.2, packaged as specified in 5.1, shall be packed in a box conforming to PPP-B-636, class weather resistant. The box shall be closed in accordance with the appendix of the box specification.

5.2.2 Level B. Twenty-five (25) intermediate packages shall be packed in a box and closed as specified in 5.2.1 except that the fiberboard box shall be class domestic.

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5.2.3 Level C. Thumbtacks in quantities as specified (see 6.2), packaged as specified in 5.1, shall be packed in containers to assure carrier acceptance and safe arrival at destination. Containers shall be in compliance with Uniform Freight Classification and National Motor Freight Classification, as applicable.

5.3 Marking. Marking shall be in accordance with 5.3.1 and 5.3.2, as specified (see 6.2).

5.3.1 Civil agencies. In addition to any special markings required by the contract or order, all interior packages and shipping containers shall be marked in accordance with Fed. Std. No. 123.

5.3.2 Military agencies. In addition to any special markings required by the contract or order, all interior packages and shipping container shall be marked in accordance with MIL-STD-129.

## 6. NOTES

6.1 Intended use. The thumbtacks covered by this specification are primarily intended to attach various materials in sheet forms to drawing boards, bulletin boards and the like.

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) Type, class and size (see 1.2.1 and 1.2.2).
- (c) Level of packaging and packing required (see 5.1 and 5.2).
- (d) Quantities required (see 5.2.1 and 5.2.3).
- (e) Whether special marking is required (see 5.3).

6.3 Change in classification. This specification deletes type I, and type II, classes 2 and 3 thumbtacks cited in previous specifications. Type I thumbtack has become obsolete with the introduction of a draftsman's tape, and no users are recorded for type II, class 2 and 3 thumbtacks.

DOD HAS WAIVED COORDINATION INTEREST

### User activity:

Army - GL  
Navy - SA  
Air Force - 84

### Preparing activity:

GSA-FSS

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Orders for this publication are to be placed with General Services Administration, acting as an agent for the Superintendent of Documents. See Section 2 of this specification to obtain extra copies and other documents referenced herein. Price 30 cents each.