

GGG-S-775a

AMENDMENT—2

January 11, 1965

SUPERSEDING

Interim Amendment—1 (DOD)

December 10, 1963

## FEDERAL SPECIFICATION

# STUD REMOVER AND SETTER

*This amendment, which forms a part of Federal Specification GGG-S-775a, dated June 8, 1960, was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.*

Page 2, paragraph 2.1 under Military Specifications. Delete "MIL-C-12968—Coatings Phosphate, Protective (For Iron and Steel) "and substitute "MIL-P-16232—Phosphate Coatings, Heavy, Manganese or Zinc Base (For Ferrous Metals)". Also delete "MIL-P-15424—Packaging of Hand Tools for Domestic and Overseas Shipment and Storage" and substitute "MIL-H-15424—Hand Tools; Packaging Of".

Page 2, paragraph 2.1. Under Federal Standards add: "Fed. Test Method Std. No. 151—Metals; Test Methods."

Page 3, paragraph 3.3.2.7.1. Delete and substitute:

3.3.2.7.1 For Army purchases, phosphate coating shall be in accordance with type M, class 1, of MIL-P-16232.

Page 11, table V. Change thread size designation of size 2 collet from "3/8—34" to "3 8—24."

Pages 14 and 15, paragraphs 4 through 4.4.1. Delete and substitute:

### 4. SAMPLING, INSPECTION, AND TEST PROCEDURES

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, 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 requirements.

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

4.2.1 *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 extent specified herein, or, if none, in accordance with this specification.

4.2.2 *Inspection of the end item.* A lot shall consist of all stud removers and setters of one type, design, style, and size, or all kits or sets as applicable. The sample unit for this examination shall be one complete stud remover or setter.

4.2.2.1 *Visual examination.* Each sample unit shall be examined for defects set forth below. The inspection level shall be level II with an AQL of 2.5 for major defects and 6.5 for total defects, expressed in terms of defects per hundred units.

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Examine	Defect	Classification	
		Major	Minor
Finish	Not as specified.		X
	Not adherent, smooth, continuous, and free from pits, blisters, and nodules (as applicable).		X
Design	Any characteristic not in accordance with the specified requirements.	X	
Construction and workmanship	Sharp burrs and edges.	X	
	Fractured, sprung, cracked, malformed, dented, bowed, or otherwise impaired.	X	
	Adjustable or functional parts that require abnormal force to operate.		X
	Threads stripped, broken, or otherwise impaired.	X	
	Metal case not provided with sufficient compartments to hold complete set, when applicable	X	
	Handles on metal case missing.	X	
	Necessary hinges not provided.	X	
	Set of instructions not permanently secured to inside of cover lid of metal case.		X
	Missing or not as specified.		X
	Incomplete, not legible, not permanent.		X
Marking identification			X

**4.2.2.2 Dimensional and coating thickness examination.** Each sample unit shall be examined to determine compliance with the dimensional and coating thickness requirements specified herein. Any nonconforming dimension or coating thickness shall be classified a defect. The inspection level shall be S-3 with an AQL of 4.0 defects, expressed in terms of defects per hundred units.

### 4.2.2.3 Testing of the end product.

**4.2.2.3.1 Torsion.** Each sample unit shall be tested as specified in 4.5.2 to determine compliance with the requirements as referenced below:

Type I, design A—Sizes 1, 2, and 3 shall conform to 3.8 and table I.

Type I, design B—Style a, sizes 1, 2, and 3 shall conform to 3.8 and table II.

Style b, shall conform to 3.8 and table III.

Type I, design C—Style c, shall conform to 3.8 and table IV.

Style d, sizes 1, 2, and 3 shall conform to 3.8 and table V.

Type II shall conform to 3.9.

Type III shall conform to 3.10.

Type IV, size 1, shall conform to 3.11.3.

Type IV, size 2, shall conform to 3.11.4.

The inspection level shall be S-4 with an AQL of 1.5 defects, expressed in terms of defects per hundred units.

**4.2.2.3.2 Flammability, impact, and heat distortion.** Each sample unit of type I, design B stud remover and setter with plastic hand grip shall be tested as specified in 4.5.3.1, 4.5.3.2, and 4.5.3.3. The inspection level shall be S-2 with an acceptance number of zero for all sample sizes. If any sample fails, the lot shall be rejected.

**4.2.2.3.3 Hardness.** Each sample unit shall be tested for hardness as specified in 4.5.1 to determine compliance with the applicable hardness requirements referenced below:

Type I, design A, shall conform to 3.8.2.1.

Type I, design B, shall conform to 3.8.3.1, 3.8.3.2.1, 3.8.2.2., 3.8.3.3, 3.8.3.5, 3.8.3.6.1, and 3.8.3.6.2.

Type I, design C, shall conform to 3.8.4.1 through 3.8.4.3.

Type II shall conform to 3.9.1.

Type III shall conform to 3.10.2 and 3.10.3.

Type IV, sizes 1 and 2 shall conform to 3.11.1 and 3.11.2.

The inspection level shall be S-2 with an AQL of 1.5 defects, expressed in terms of defects per hundred units.

**4.2.3 Examination of preparation for delivery.** An examination shall be made to determine compliance with preservation and packaging, packing, and marking requirements in accordance with MIL-H-15424."

Page 15, paragraph 4.5.1. Delete and substitute:

**4.5.1 Hardness test.** Stud removers and setters shall be subject to a hardness test in accordance with method 243.1 of Fed. Test Method Std. No. 151.

Pages 15 and 16, paragraph 4.5.2, Torsion test, second and third lines. Delete "selected in accordance with 4.2.3."

Page 16, paragraph 4.6. Delete in its entirety.

Pages 16 and 17, section 5. Delete and substitute:

## 5. PREPARATION FOR DELIVERY

Fed. Std. No. 102 shall be referred to for definitions and application of the various levels of preservation, packaging, and packing for civil agency procurements.

**5.1 Levels A, B, and C.** Preservation, packaging, and packing shall be in accordance with the applicable requirements of MIL-H-15424 (see 6.1).

### 5.2 Marking.

**5.2.1 Civil agencies.** In addition to any special marking required by the contract

or order, interior packages and shipping containers shall be marked in accordance with Fed. Std. No. 123.

**5.2.2 Military requirements.** In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

Page 17, paragraph 6.1 Delete (h) and substitute:

"(h) Selection of applicable levels of preservation, packaging, and packing (see 5.1)."

## MILITARY CUSTODIANS:

Army—GI

Navy—Ships

Air Force—MOA

Interested activities:

Review

Army—MO

Navy—Ships, Docks

Air Force—MOA

User

Army—WC

Review/user information is current as of the date of this document. For future coordination of changes to this document, draft circulation would be based on the information in the current DOD Standardization Documents.