
 * INCH-POUND *

OO-D-2813
 June 25, 1993

SUPERSEDING
 MIL-D-2467F
 24 July 1987

FEDERAL SPECIFICATION

DOUGH ROLLING MACHINES, PIE

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 specification covers a two pass pie dough rolling machine operated by an electric motor.

1.2 Classification. The pie dough rolling machines furnished under this specification shall be of the following styles, models, and classes as specified (see 6.2):

Style A - Machine without a conveyor
 Style B - Machine with a conveyor

Model 1 - 30-inch (76.2 centimeters (cm)) long conveyor
 Model 2 - 36-inch (91.4 cm) long conveyor
 Model 3 - 42-inch (106.7 cm) long conveyor
 Model 4 - 48-inch (121.9 cm) long conveyor

Class 01 - Machine without stand
 Class 02 - Machine with stand mounted on casters

 * 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, 621 Pleasant Valley Road, Port Hueneme, CA 93043-4300, by using *
 * the Standardization Document Improvement Proposal (DD Form 1426) appearing*
 * at the end of this document or by letter. *

FSC 7320

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2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specification and standard. The following specification and standard form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

Military Specification

MIL-B-2316 - Bakery Equipment, Including Unit Assemblies, Repair Parts and Tools, Preparation for Delivery of

Military Standard

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

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.1.2 Other Government documents. The following other Government documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be that in effect on the date of the solicitation.

Department of Labor (DoL):

Occupational Safety and Health Administration (OSHA):

Occupational Safety and Health Standards

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

2.2 Other publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

National Sanitation Foundation (NSF International):

NSF No. 8 - Commercial Powered Food Preparation Equipment

NSF Listing of Food Service Equipment and Related Products, Components and Materials

(Application for copies should be addressed to NSF International, P.O. Box 130140, Ann Arbor, MI 48113-0140.)

Society of Automotive Engineers, Inc. (SAE):

SAE J534 - Lubrication Fittings

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(Application for copies should be addressed to the Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.)

Underwriters Laboratories Inc. (UL):

UL 763 - Standard for Safety, Motor-Operated Commercial Food Preparing Machines

(Application for copies should be addressed to the Underwriters Laboratories Inc., 333 Pfingsten Road, Northbrook, IL 60062-2096.)

(Non-Government standards and other publications are normally available from the organizations which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Description. The pie dough rolling machine, herein referred to as machine, shall be electrically operated. The machine shall consist essentially of a frame, dough guide and chute, flour tray, pressure plates, electric motor and controls, rollers, and scrapers. Also, the machine shall come with or without a stand mounted on casters and a conveyor, as specified.

3.2 Standard commercial product. The machine shall, as a minimum, be in accordance with the requirements of this specification and shall be the manufacturer's standard commercial product. Additional or better features 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 machine 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 one complete machine of the classification specified for first article inspection and approval (see 4.2.1 and 6.4).

3.4 Interchangeability. All units of the same classification furnished with similar options under a specific contract shall be identical to the extent necessary to insure interchangeability of component parts, assemblies, accessories, and spare parts.

3.5 Codes and standards. The machine shall conform to the requirements of UL 763 and NSF No. 8 as applicable.

3.5.1 Compliance. Prior to approval of the first shipment, the contractor shall submit for the approval of the contracting officer, or his authorized

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representative, satisfactory evidence that the pie dough rolling machine he proposes to furnish under this specification meets the requirements of UL 763 and NSF No. 8 as applicable.

3.6 Materials. Materials used shall be free from defects which would adversely affect the performance or maintainability of individual components or of the overall assembly. Materials not specified herein shall be of the same quality used for the intended purpose in commercial practice. Unless otherwise specified herein, all equipment, material, and articles incorporated in the work covered by this specification are to be new and fabricated using materials produced from recovered materials to the maximum extent possible without jeopardizing the intended use. The term "recovered materials" means materials which have been collected or recovered from solid waste and reprocessed to become a source of raw materials, as opposed to virgin raw materials. None of the above shall be interpreted to mean that the use of used or rebuilt products is allowed under this specification unless otherwise specified.

3.7 Design. The machine shall be designed so that normal adjustments and repairs can be readily accomplished by means of general purpose tools with minimum disturbance of other components of the machine. Mechanical parts shall be located away from roller area and protected from flour and dough. The machine shall roll pie dough with two passes between rollers and shall have either two sets of rollers or three rollers. The machine shall be capable of being mounted on a stand. The style B machine shall be equipped with a conveyor.

3.7.1 Machine with two sets of rollers. The machine with two sets of rollers shall be designed so dough will first pass between one set of rollers and then pass between a second set of rollers. Each roller shall be not less than 3-1/2 inches (8.9 cm) in diameter. The first set of rollers shall be not less than 7 inches (17.8 cm) long and adjustable for dough thickness up to 5/8 of an inch (1.6 cm). Each roller shall be supported by two sealed ball bearings. The second set of rollers on the style A machine shall be not less than 14 inches (35.6 cm) long and the second set of rollers on the style B machine shall be not less than 17 inches (43.2 cm) long. The second set of rollers shall be adjustable for dough thickness up to 3/8 of an inch (1 cm). Levers shall adjust the space between rollers and means shall be provided to secure the levers in position. There shall be a numbered scale to indicate the dough thickness.

3.7.2 Machine with three rollers. The machine shall have an upper, middle, and lower roller. Each roller shall be not less than 3-1/2 inches (8.9 cm) in diameter. The upper roller shall be not less than 7 inches (17.8 cm) in length, and the middle and lower rollers shall be not less than 18 inches (45.7 cm) in length. The machine shall be furnished with levers to adjust the rollers and shall roll dough up to 1 inch (2.5 cm) thick. An indicator shall be provided to indicate the thickness of the dough being rolled. The machine shall be designed so dough shall first pass between the upper and middle roller, and then pass between the middle and lower roller.

3.7.3 System of measurement. The dimensions used in this specification are not intended to preclude the use of the metric system of measurement in the fabrication and production of the material, individual parts, and the finished product, provided form, fit, and function requirements are satisfied.

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3.8 Performance. Each style of machine when tested as specified in 4.5.2 shall be capable of rolling a minimum of five hundred 9-inch (22.9 cm) pie crusts per hour with a crust thickness of 1/8 inch (0.3 cm) (+1/32 of an inch (0.08 cm)). The machine shall roll the dough in one smooth operation from one position.

3.9 Construction. Unless otherwise specified (see 6.2), construction of the components of the machine shall be as specified herein.

3.9.1 Frame. The machine's frame shall be constructed of steel, stainless material or of aluminum alloy. Bearings and other moving parts shall be protected against accumulation of flour, dough, and other foreign materials and all exposed moving parts shall be enclosed or equipped with safety guards.

3.9.2 Flour tray. The flour tray shall be constructed of stainless material. The tray shall allow flour dusting of the dough between the first and second pass through the rollers.

3.9.3 Scrapers. The machine shall be furnished with scrapers to remove dough particles that might adhere to the rollers when tested as specified in 4.5.2. The scrapers shall be constructed of clock spring steel, stainless material or plastic. The scrapers shall be easily removable for cleaning.

3.9.4 Drive. The drive between the motor and rollers and motor and conveyor (style B) shall be belts and pulleys or roller chain and sprockets. The drive shall be fully enclosed.

3.9.5 Rollers. The dough rollers shall be fabricated as specified (see 6.2), from UHMW polyolefins or steel that has been precision ground, hard-chromed or gray-iron precision ground. The bearings on the rollers shall be sealed bearings.

3.9.6 Stand. Unless otherwise specified (see 6.2), the stand shall be constructed in accordance with the manufacturer's standard practice and as specified herein. The stand shall be constructed of steel or aluminum alloy. The bottom of the stand shall be constructed to provide for four casters, one on each corner. The top of the stand shall be sufficient in size for the placing and securing of the machine. The height of the stand shall permit the rolled dough to be discharged to a 34-inch (86.4 cm) high (+1/2-inch (1.3 cm)) table.

3.9.7 Casters. Each stand shall be mounted on four removable casters with a minimum wheel diameter of 3 inches (7.6 cm). Two casters shall be equipped with wheel brakes.

3.9.8 Conveyor. The type B machine shall have an infeed conveyor belt with a minimum of 17 inches (43.2 cm) in width. The conveyor belts shall be 3 ply neoprene impregnated belt or other materials as recommended by the manufacturer, and shall be operated by the same motor that operates the rollers. Each infeed conveyor shall be a minimum of 18 inches (45.7 cm) in width and shall be 30 inches (96.5 cm) in length for the model 1 machine, 36 inches (91.4 cm) for the model 2 machine, 42 inches (106.7 cm) for the model 3 machine, and 48 inches (121.9 cm) for the model 4 machine. The conveyor shall be fabricated from stainless materials or materials recommended by the manufacturer.

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3.10 Electrical components. Each machine shall have a manual switch conveniently located as recommended by the manufacturer. The machine shall be equipped with a 6 foot, 3-wire grounding type cord. The cord shall have a 3-prong grounding type plug. The cord and plug shall be as specified in UL 763.

3.10.1 Motor. The electric motor shall be not less than 1/4 horsepower (hp) for style A machine and shall be not less than 1/3 hp for style B machine. Unless otherwise specified (see 6.2), the motor shall operate on a nominal 120 volt, single phase 60 Hertz source. The motor shall have automatic thermal overload protection with automatic or manual reset and shall be fully enclosed. The motor shall conform to UL 763.

3.11 Safety and health requirements. The machine shall be equipped with safety devices for all parts that present a safety hazard. The devices shall include covers and guards for moving parts and shockproof controls for protection from mechanical and electrical hazards to personnel. All guards shall provide easy access to guarded parts and shall not interfere with operation of the machine (see 4.5.1). The machine shall comply with the applicable safety requirements of OSHA standards and UL 763.

3.12 Operation. Bearings shall not overheat. Moving components shall operate properly and shall not bind. Adjustable components shall be adjustable over the entire range without binding, and starting and stopping devices shall operate properly (see 4.5.1).

3.13 Treatment and painting. Unless otherwise specified (see 6.2), the machine shall be treated and painted in accordance with the manufacturer's standard practice. All surfaces of the machine other than corrosion-resisting steel shall be protected against corrosion and present a neat appearance.

3.14 Finish. Surface finish shall be as specified herein and in NSF No. 8. Surface of materials in the dough making zone shall be smooth, corrosion-resistant, nontoxic, stable and nonabsorbent under use conditions and shall not impart color, odor or taste to the dough (see 4.5.2). Exposed surfaces in the dough zone shall be finished so as to be easily cleanable after the tests in 4.5.2. Corrosion-resistant materials shall have a No. 3 or better finish.

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

3.16 Instruction plates. The machine shall be equipped with instruction plates suitably located, describing any special or important procedures to be followed in operating and servicing the equipment. Plates shall be of a material which will last and remain legible for the life of the equipment. Plates shall be securely affixed to the equipment with nonferrous screws or bolts of not less than 1/8-inch (0.3 cm) diameter.

3.17 Lubrication. Unless otherwise specified (see 6.2), means for lubrication shall be in accordance with the manufacturer's standard practice. The lubricating points shall be easily visible and accessible. Hydraulic

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lubrication fittings shall be in accordance with SAE J534. Where use of high-pressure lubricating equipment, 1,000 pound-force per square inch (psi) (6894 kPa) or higher, will damage grease seals or other parts, a suitable warning shall be affixed to the equipment in a conspicuous location. The unit shall be lubricated prior to delivery with type of lubricant specified in the operator's manual and grade of lubricant recommended for ambient temperature at the delivery point. The unit shall be conspicuously tagged to identify the lubricants and their temperature range.

3.18 Workmanship.

3.18.1 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.

3.18.2 Bolted connections. Boltholes shall be accurately punched or drilled and shall have the burrs removed. Washers or lockwashers shall be provided in accordance with good commercial practice, and all bolts, nuts, and screws shall be tight.

3.18.3 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.

3.18.4 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.

3.18.5 Castings. All castings shall be sound and free from patching, misplaced coring, warping, or any other defect which reduces the casting's ability to perform its intended function.

3.19 Metric products. Products manufactured to metric dimensions will be considered on an equal basis with those manufactured using inch-pound units, providing they fall within the tolerances specified and all other requirements of this document are met. If a product is manufactured to metric dimensions and those dimensions exceed the tolerances specified in the inch-pound units, a request should be made to the specification preparing activity for changes to this document.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of

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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 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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

4.1.3 Standards compliance. The contractor shall make available to the contracting officer or his authorized representative evidence of compliance with the applicable standard(s) cited in 3.5. The Government reserves the right to examine and test all machines to determine the validity of the certification.

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 a machine 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, and when specified, the preproduction pack inspection of 4.6 (see 6.2). 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, 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 machine. All machines offered for delivery at one time shall be considered a lot for the purpose of inspection.

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4.3.1 Sampling for examination. Guidance for inspection level and the Acceptable Quality Level (AQL) is provided in 6.6.1.

4.4 Examination. Each machine shall be examined for defects listed in table I. Each attribute within each classification of multiple defects shall constitute one defect.

TABLE I. Classification of defects.

-----				*-----*
*Classification	Defects		Requirement	*-----*
			paragraph	
*Critical				*
* 001	The machine is unsafe to operate because	3.11		*
*	of failure to comply with appliance safety			*
*	requirements of OSHA standards and UL 763.			*
*Major:				*
*				*
* 101	Materials not as specified and	3.6		*
*	obviously damaged, defective, or			*
*	not suited for the purpose intended.			*
*				*
* 102	Design not as specified. Normal	3.7 thru*		*
*	adjustments and repairs not readily	3.7.2		*
*	accomplished as specified. Size of			*
*	rollers not as specified. Bearing			*
*	not sealed. Levers not as specified			*
*	or means not provided to secure levers			*
*	in position. Scale to indicate dough			*
*	thickness missing or not as specified.			*
*	Number of rollers not as specified.			*
*				*
* 103	Frame not constructed of materials as	3.9.1		*
*	specified. Moving parts not protected			*
*	or enclosed as specified.			*
*				*
* 104	Flour tray not as specified.	3.9.2		*
*				*
* 105	Scraper not as specified or not easily	3.9.3		*
*	removed for cleaning.			*
*				*
* 106	Drive not as specified or fully	3.9.4		*
*	enclosed.			*
*				*
* 107	Rollers not fabricated of material	3.9.5		*
*	specified. Bearings not sealed.			*
*				*
* 108	Stand not as constructed of material	3.9.6		*
*	specified. Not provided with casters.			*
*	Top of stand not of proper size. Height			*
*	of stand not as specified.			*
*				*
* 109	Casters missing or not of size	3.9.7		*
*	specified. Two of four casters not			*
*	equipped with wheel brakes.			*

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TABLE I. Classification of defects - Continued.

*Classification	Defects	Requirement	paragraph	*

* 110	Conveyor belt not of proper width or	3.9.8	*	*
*	material. Belt not operated by motor.		*	*
*	Conveyor not of proper size or length.		*	*
*	Conveyor not fabricated of proper material.		*	*
*			*	*
* 111	Electrical components not as specified.	3.10	*	*
*	Manual switch missing. Cord and plug not		*	*
*	as specified.		*	*
*			*	*
* 112	Motor not as specified or not fully	3.10.1	*	*
*	enclosed.		*	*
*			*	*
* 113	Machine not equipped with necessary	3.11	*	*
*	safety devices. Shockproof controls are		*	*
*	not provided for protection from electrical		*	*
*	hazards to personnel. Moving parts not		*	*
*	protected by covers or guards where required		*	*
*	for safety purposes. Guards do not provide		*	*
*	easy access to components.		*	*
*			*	*
* 114	Paint chipped, peeled or blistered, or	3.13	*	*
*	does not present a neat appearance.		*	*
*			*	*
* 115	Surface of materials in dough making	3.14	*	*
*	zone not smooth and easily cleaned.		*	*
*	Finish of materials not No. 3 or better.		*	*
*			*	*
* 116	If furnished, instruction plates missing	3.16	*	*
*	or instructions incomplete.		*	*
*			*	*
* 117	Steel has sharp edges and corners, burrs,	3.18.1	*	*
*	dents, or deformities.		*	*
*			*	*
* 118	Missing screws, bolts, and nuts. Boltholes	3.18.2	*	*
*	not as specified.		*	*
*			*	*
* 119	Rivet holes with burrs. Rivet heads		*	*
*	not countersunk or flattened.	3.18.3	*	*
*			*	*
* 120	Welding incomplete, burn holes, cracked	3.18.4	*	*
*	or fractured.		*	*
*			*	*
* 121	Castings not free from patching, misplaced	3.18.5	*	*
*	coring or warping.		*	*
*			*	*

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TABLE I. Classification of defects - Continued.

*Classification	Defects		Requirement	* paragraph *

*Minor:				*
*				*
* 201	Marking missing, incomplete or illegible.	3.15		*
*				*
* 202	Machine not lubricated.	3.17		*
*				*
* 203	Threads of bolts and screws stripped or cross threaded. Loose nuts and screws.	3.18.2		*
*				*
*				*
* 204	Rivet heads and peened ends not in contact with metal.	3.18.3		*
*				*

4.5 Tests. The first article shall receive the tests of 4.5.2. Each production unit shall receive the test of 4.5.1. Failure to pass any test shall constitute cause for rejection.

4.5.1 Operation. Connect the machine to a compatible electric power source and allow the machine to run for a minimum of 30 minutes. Stop and start the machine at least 5 times and observe: bearings for overheating; starting and stopping devices for proper operation; moving components for binding or improper operation; adjustable components for binding and improper operation requirements of 3.12. During operation observe the safety requirements to insure compliance with 3.11. Any nonconformance to specified requirements shall constitute failure of the test.

4.5.2 Functional. Connect the machine to a compatible electric power source and set the roller adjustment to produce rolled pie dough of 1/8 inch (0.3 cm) thickness. Roll pie dough pieces to produce at least 9-inch (22.9 cm) diameter crusts continually for 5 minutes. The rollers shall be examined to determine that scrapers conform to 3.9.3. Count the number of dough pieces rolled and measure every fifth piece for average thickness, on at least four places, to determine that the machine will roll not less than 500 pieces of pie dough per hour with a thickness of 1/8 inch (0.3 cm) plus or minus 1/32 inch (0.08 cm) as required by 3.8. After the functional test, inspect the dough to insure that the machine did not impart color, odor or taste to the dough and that the exposed surfaces of the dough zone are easily cleanable as required by 3.14. Any nonconformance to specified requirements shall constitute failure of this test.

4.6 Packaging inspection. The inspection of the preservation, packing, and marking shall be in accordance with the requirements of section 4 of MIL-B-2316. The inspection shall consist of the quality conformance inspection; and, when specified (see 6.2), a preproduction pack shall be furnished for examination and test within the time frame required (see 6.2).

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5. PREPARATION FOR DELIVERY

5.1 Preservation, packing, and marking. Preservation, packing, and marking shall be in accordance with the requirements of MIL-B-2316 with the level of preservation and the level of packing as specified (see 6.2). When fiberboard shipping containers are permitted for level B packing, the fiberboard shall be weather-resistant grade as specified in MIL-B-2316.

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The pie dough rolling machine is intended primarily to be used in pastry kitchens and mess halls to roll pie crusts.

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

- a. Title, number, and date of this specification
- b. Style, model and class required (see 1.2)
- c. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1, 2.1.2, and 2.2)
- d. When a first article inspection is required (see 3.3, 4.2.1, and 6.4)
- e. When construction is other than as specified (see 3.9)
- f. Type material required for dough rollers (see 3.9.5)
- g. When stand is other than as specified (see 3.9.6)
- h. When electric requirements are other than as specified (see 3.10.1)
- i. When treatment and painting is other than as specified (see 3.13)
- j. When lubrication is other than as specified (see 3.17)
- k. When a preproduction pack inspection is required and the time frame required (see 4.6)
- l. Level of preservation and level of packing required (see 5.1)

6.3 Data requirements. When this specification is used in an acquisition and data are required to be delivered, such as a certified test report, the data requirements shall be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the approved Contract Data Requirements List (CDRL), incorporated into the contract. When the provisions of DOD FAR Supplement, Part 27, Sub-Part 27.410-6 (DD Form 1423) are invoked and the DD Form 1423 is not used, the data shall be delivered by the contractor in accordance with the contract or purchase order requirements.

6.4 First article. When a first article inspection is required, the item will be tested and should be a first production item 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 machine. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, test, and approval of the first article.

6.5 Classification cross reference. Classifications used in this specification (see 1.2) are identical to those found in the superseded military specification, MIL-D-2467F.

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6.6 Sampling procedures.

6.6.1 Sampling for examination. Recommended inspection level is S-2 and AQL is 2.5 percent defective (see 4.3.1).

6.7 UL certification. Recommended acceptable evidence of meeting the requirements of UL 763 shall be the UL certification symbol or label, listing in the UL Electrical Appliance and Utilization Equipment List, or a certified test report from a recognized independent testing laboratory indicating the machine has been tested and conforms to UL 763. Such evidence must be acceptable to the contracting officer.

6.8 NSF certification. Recommended acceptable evidence of meeting the requirements of NSF No. 8 shall be the NSF certification symbol or label, listing in the NSF Seal of Approval Listing of Food Service Equipment, or a certified test report from a recognized independent testing laboratory, acceptable to the Surgeon General, indicating the machine has been tested and conforms to NSF No. 8. Such evidence must be acceptable to the contracting officer.

6.9 Part or Identifying Number (PIN). The PIN to be used for items acquired to this specification is created as follows:

	OOD2813	-	X	-	X	-	XX
	*		*		*		*
	*		*		*		*
"M" prefix and basic specification number	----	*		*	*		*
Dash letter indicating style	-----	*		*	*		*
(A for style A; B for style B)				*	*		
Dash letter indicating model	-----	*		*	*		*
(1 for model 1; 2 for model 2;							*
3 for model 3; 4 for model 4)							*
Dash number indicating class	-----	*		*	*		*
(01 for class 1; 02 for class 2)							

6.9.1 Styles, models, and classes. The styles, models, and classes of pie dough rolling machine are identified by numeric and alpha characters as identified in 1.2. The following is an example of the PIN for a pie dough rolling machine with a conveyor 42 inches (106.7 cm) long, with a stand:

OOD2813-B-3-02

6.9.2 Part numbers. The PIN procedure is for Government purposes and does not constitute a requirement for the contractor.

6.10 Supersession data. This specification replaces military specification MIL-D-2467F dated 24 July 1987.

6.11 Subject term (key word) listing.

Bakery equipment
Two pass

OO-D-2813

6.12 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

MILITARY INTERESTS:
ACTIVITIES:

CIVIL AGENCY COORDINATING

Military Coordinating Activity

GSA - FSS
VA - OSS

Navy - YD

PREPARING ACTIVITY:

Custodians

Navy - YD

Navy - YD

Air Force - 99

(Project 7320-0898)

Review Activities

Navy - MC

Air Force - 84, 50

DLA - GS

User Activity

Army - GL

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