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 SUPERSEDING  
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## FEDERAL SPECIFICATION

### BOWLS, FOOD MIXING; BOWL SET (CORROSION-RESISTING STEEL)

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 individual food mixing bowls and food mixing bowls assembled in a 3-piece set.

#### 1.2 Classification.

1.2.1 Classes and sizes. Mixing bowls furnished under this specification shall be of the following classes and sizes, as specified (see 6.2).

Class 1 - Individual bowl.

Size A - 3/4 quart capacity.  
 Size B - 1-1/2 quart capacity.  
 Size C - 3-quart capacity.  
 Size D - 4-quart capacity.  
 Size E - 5-quart capacity.

Class 2 - Bowl set.

#### 2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue 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:

QQ-S-766 - Steel Plates, Sheets, and Strip-Corrosion Resisting.  
 UU-P-553 - Paper, Wrapping, Tissue.  
 PPP-B-585 - Boxes, Wood, Wirebound.  
 PPP-B-591 - Boxes, Shipping, Fiberboard, Wood-Cleated.  
 PPP-B-601 - Boxes, Wood, Cleated-Plywood.  
 PPP-B-636 - Boxes, Shipping, Fiberboard.  
 PPP-B-640 - Boxes, Fiberboard, Corrugated, Triplewall.

##### Federal Standard:

Fed. Std. No. 123 - Marking for Domestic Shipment (Civil Agencies).

(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.

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(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.

(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 documents form a part of this specification to the extent specified herein. Unless otherwise indicated, 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 shall 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 shall be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

### 3. REQUIREMENTS

3.1 Preproduction sample. When specified (see 6.2), before production is commenced, a sample bowl or bowl set, as applicable, shall be submitted or made available to the contracting officer or his authorized representative for approval in accordance with 4.2. The approval of the preproduction sample authorizes the commencement of production, but does not relieve the supplier of responsibility for compliance with all applicable provisions of this specification. The preproduction sample shall be manufactured in the same facilities to be used for the manufacture of the production items.

3.2 Standard product. Except for modifications which are required to meet specific requirements of this specification, the bowls shall be the manufacturer's current standard product.

3.3 Material. Corrosion-resisting steel shall conform to class 302 or 304 of QQ-S-766.

3.4 Construction. The bowls covered by this specification shall be fabricated of the material specified in 3.3 and shall conform to the capacities and dimensions shown in table I when measured in accordance with 4.4.2 and 4.6. The bowl shall be formed from a single sheet of corrosion-resisting steel and shall be seamless and without welds. The side of the bowl shall be curved and the bottom resting surface of the bowl shall be flat or with shallow, inward crown. The bowl top shall have a flat circumferential lip to facilitate handling and lifting. The top edge shall be formed with a rolled closed bead.

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TABLE I. Food mixing bowl capacities and dimensions

| Minimum capacity <sup>1/</sup><br>quarts | Minimum diameter<br>over beads<br>inches | Total outside depth<br>(minimum)<br>inches | Minimum thickness<br>after fabrication<br>inches |
|--|--|--|--|
| 3/4                                      | 6-1/8                                    | 2-3/8                                      | 0.015  |
| 1-1/2                                    | 7-3/4                                    | 2-7/8                                      | 0.012  |
| 3  | 9-1/4                                    | 3-7/8                                      | 0.012  |
| 4  | 10-1/8                                   | 4-1/8                                      | 0.012  |
| 5  | 11-5/8                                   | 4-3/8                                      | 0.012  |

<sup>1/</sup> A maximum increase of 10 percent is allowable.

3.5 **Bowl set.** A bowl set shall include one each of the class 1, size A, B, and D bowls (see 1.2.1). The bowl set shown in figure 1 is for illustrative purposes only and is not intended to preclude bowls that otherwise conform to this specification.



FIGURE 1. Bowl set

3.6 **Marking for identification.** Marking of bowl capacity and manufacturer's identification shall be in accordance with the manufacturer's standard commercial practice.

3.7 **Finish.** Bowls shall have commercial general purpose, stain, or high luster polished surfaces. Bowls furnished on any one contract shall have an identical finish.

3.8 **Workmanship.** The finished bowls shall be clean, well made, and free from defects affecting appearance, durability, and serviceability.

#### 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, 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 **Preproduction sample.** Inspection and testing of the preproduction sample shall be made on a completely fabricated item for all applicable provisions of this specification.

4.3 **Sampling.** Sampling for inspection and acceptance shall be made in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

4.3.1 **Lot.** Unless otherwise specified (see 6.2), a lot shall consist of all bowls offered for acceptance at the same time.

#### 4.4 **End item inspection.**

4.4.1 **Visual examination.** Examination of the end item shall be in accordance with the classification of defects in table II. The inspection level shall be II with an acceptable quality level (AQL) of 2.5 of major defects and 6.5 for total defects, expressed in terms of defects per hundred units.

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TABLE II. Classification of defects, end item

| Examine                      | Defect   | Classification |       |
|------------------------------|--|----------------|-------|
|                              |  | Major          | Minor |
| Finish                       | Not as specified.....                                  | X              |       |
|                              | Not uniformly applied.....                             |                | X     |
| Construction and Workmanship | Not one piece construction.....                        | X              |       |
|                              | Trimming or die marks.....                             |                | X     |
|                              | Dent, crack, hole, puncture, or fracture in metal..... | X              |       |
|                              | Bottom not flat, or not with shallow inward crown..... | X              |       |
|                              | Visibly out of shape.....                              | X              |       |
|                              | Edge not evenly rolled around top....                  |                | X     |
|                              | Sharp or burred edges or projections..                 | X              |       |
|                              | Wrinkles or waves in metal forming....                 | X              |       |
|                              | Scale or lamination in metal.....                      | X              |       |
|                              | Deep scratch or gouge on inside of bowl.....           | X              |       |
|                              | Light scratch, mar or dent.....                        |                | X     |

4.4.2 Dimensional examination. Measurement of the end item shall be made to determine compliance with the dimensional requirements in table I. Any noncompliance shall be classified a defect. The inspection level shall be S-3 with an AQL of 4.0 expressed in terms of defects per hundred units.

4.5 Inspection of preparation for delivery requirements. An inspection shall be made to determine that the preservation, packaging, packing, and marking comply with the requirements in section 5 of this specification. Defects shall be scored in accordance with table III. For examination of interior packaging, the sample unit shall be one shipping container fully prepared for delivery, selected at random just prior to the closing operations. Sampling shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 4.0 defects per hundred units.

TABLE III. Classification of preparation for delivery defects

| Examine                          | Defects  |
|----------------------------------|--|
| Markings (exterior and interior) | Omitted; incorrect; illegible; improper size, location, sequence, or method of application.  |
| Materials                        | Any component missing, or damaged.   |
| Workmanship                      | Inadequate application of components such as incomplete closure of container flaps, loose strapping, inadequate stapling. Distortion of container. |

#### 4.6 Test.

4.6.1 Capacity. Using standard laboratory volumetric measures, a sample bowl randomly selected for each representative size contained in each lot shall be filled with water to the minimum capacity allowed in table I. Any overflow observed shall constitute failure of the test and shall be cause for rejection of the lot.

### 5. PREPARATION FOR DELIVERY

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

#### 5.1.1 Level A.

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5.1.1.1 Bowls (individual). Each bowl shall be wrapped in two sheets of kraft paper, minimum basis weight 10 pounds (24 x 36-500). Six bowls shall be nested and packaged in a box conforming to PPP-B-636, class weather resistant. Closure shall be in accordance with the appendix to the box specification.

5.1.1.2 Bowls (set). One set of three bowls shall be nested with two or more sheets of tissue paper conforming to UU-P-553 between each bowl. The set of bowls shall be sealed in a commercial polyethylene plastic bag of minimum 1.5 mils and packaged in a close fitting box conforming to PPP-B-636, class weather resistant.

#### 5.1.2 Level B.

5.1.2.1 Bowls (individual). Each bowl shall be wrapped in two sheets of kraft paper, minimum basis weight 10 pounds (24 x 36-500). Six bowls shall be nested and packaged in a box conforming to PPP-B-636, class domestic. Closure shall be in accordance with the appendix to the box specification.

5.1.2.2 Bowls (set). One set of three bowls shall be nested. Each bowl shall be wrapped with tissue paper conforming to UU-P-553. The bowls shall be separated with paper-board or single-faced corrugated board. Each set shall be packaged in a snug-fitting box conforming to PPP-B-636, class domestic. Closure shall be in accordance with the appendix to the box specification.

5.1.3 Level C. The bowls in sets or individually, shall be packaged in accordance with the suppliers commercial practice.

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

5.2.1 Level A. Unit packages of individual bowls or bowls in sets, in quantities as specified (see 6.2), shall be packed in a snug-fitting box conforming to PPP-B-585, class 3; PPP-B-591, class 11; PPP-B-601, overseas type; PPP-B-636, class weather resistant or PPP-B-640, class 2. The box shall be closed and reinforced in accordance with the applicable specification or appendix thereto.

5.2.2 Level B. Eight unit packages (48 individual bowls) or six unit packages of bowl sets, as applicable, shall be packed in a box conforming to PPP-B-636, class domestic. Closure shall be in accordance with the appendix to the box specification.

5.2.3 Level C. The bowls shall be packed to insure carrier acceptance and safe delivery at destination in containers complying with Uniform Freight Classification rules or National Motor Freight Classification rules, as applicable.

#### 5.3 Marking.

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

5.3.2 Military activities. In addition to markings required by the contract or order, the packages and shipping containers shall be marked in accordance with MIL-STD-129.

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6. NOTES

6.1 Intended use. Bowls are intended primarily for hand mixing ingredients in the preparation of foods such as salads and desserts.

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) Class and size, as applicable, required (see 1.2.1).
- (c) When a preproduction sample is required (see 3.1).
- (d) Size of lot, if different from 4.3.1.
- (e) Levels of packaging and packing required (see 5.1 and 5.2).
- (f) Quantities of unit packages in shipping container (see 5.2.1).

Preparing activity:

GSA-FSS

Civil Agency Coordinating Activities:

GSA-FSS  
VA-DMS

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Orders for this publication are to be placed with the 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 10 cents each.