

RR-P-90B
August 20, 1974
SUPERSEDING
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August 24, 1966

FEDERAL SPECIFICATION

PAN, PIE (ALUMINUM FOIL)

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 disposable piepans made from aluminum foil.

1.2 Classification.

1.2.1 Sizes. Piepans shall be of the following sizes:

Size A - 5 inch (nominal top inside diameter).

Size B - 8-1/4 inch (nominal top inside diameter).

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 Specification:

PPP-B-636 - Box Shipping Fiberboard.

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.

(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 Specification:

MIL-A-148 - Aluminum Foil.

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 suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

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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.

Federal, Food, Drug and Cosmetic Act and General Regulations Promulgated Thereunder.

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

3. REQUIREMENTS

3.1 Material.

3.1.1 Aluminum foil. The aluminum foil shall withstand the baking process with minimum distortion to original shape and dimensions. Aluminum foil used in the manufacture of the piepan covered by this specification shall meet the requirements for chemical composition, temper, and finish of MIL-A-148.

3.1.1.1 Toxicity. Aluminum foil and method of preparation of the aluminum foil piepans shall conform in every respect to the provisions of the Federal Food, Drug, and Cosmetic Act, Food Additive Amendment and Regulations Promulgated Thereunder.

3.2 Construction.

3.2.1 Bottom. Embossed designs or beads are permissible to reinforce the bottom of the pans.

3.2.2 Sidewalls and rims. Symmetrically spaced wrinkles in the sidewalls and rim, which offer considerable resistance to deforming, shall conform to good commercial practice.

3.2.2.1 Rim shall be reinforced by either 180° crimped edge or by a round bead.

3.3 Dimensions. The piepans shall conform to the dimensions shown in table I.

TABLE I. Dimensions (inches)		
	Size A	Size B
Thickness of foil	0.0035 ± 0.0005	0.0045 ± 0.0005
Top outside diameter	$5\frac{3}{4} \pm \frac{1}{8}$	$9 \pm \frac{1}{8}$
Top inside diameter	$5 \pm \frac{1}{8}$	$8\frac{1}{4} \pm \frac{1}{8}$
Bottom diameter	$3\frac{3}{8} \pm \frac{1}{8}$	$6\frac{3}{4} \pm \frac{1}{8}$
Vertical height	$1\frac{5}{8} \pm \frac{1}{8}$	$7\frac{7}{8} \pm \frac{1}{8}$
Slant depth	$1\frac{3}{4} \pm \frac{1}{8}$	$1\frac{1}{8} \pm \frac{1}{8}$

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. The sample size levels of inspection shall be in accordance MIL-STD-105.

4.2.1 Lot. All piepans of the same size, presented at one time, shall be considered a lot for the purpose of sampling and inspection.

4.2.2 Sampling for dimensional and visual examination of and item. Sampling of piepans for these characteristics shall be in accordance with level S-1.

4.3 Inspection.

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4.3.1 End item. Pipepans selected in 4.2.2 shall be examined in accordance with table II. The acceptable quality levels (AQL's) for defects listed in table II shall be 6.5 percent defective for major defects and 10 percent for minor defects in accordance with MIL-STD-105.

TABLE II. Classification of defects, end item

Defects	Major	Minor
Diameter and depth, not as specified.....	X	
Material thickness less than specified.....	X	
Rim not formed as specified in 3.2.2.1.....	X	
Not symmetrically spaced wrinkles.....	X	
Nicks and creases in base.....		X
Splits or slivers in edges.....		X

4.4 Inspection of preparation for delivery. An inspection shall be made to determine that packaging, packing and marking requirements of section 5 of this specification are complied with. Defects shall be scored in accordance with Table II. For examination of contents the sample unit shall be one shipping container fully prepared for delivery selected just prior to the closing operations. Defects of closure listed 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 II and the AQL shall be 6.0 defects per hundred units.

TABLE III. Classification of preparation for delivery requirements

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 staplings.
	Bulging or distortion of container.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A. One thousands pans of like description shall be packed in a close-fitting to PPP-B-636, W5c. The box shall be waterproofed sealed and strapped in accordance with the appendix to the box specification.

5.1.2 Level B. One thousands pans of like description shall be packed in a close-fitting box conforming to PPP-B-636, class domestic. The box shall be closed in accordance with the appendix to the box specification.

5.1.3 Level C. The pans shall be packed to insure carrier acceptance and safe delivery at destination in containers complying with the rules and regulations applicable to the mode of transportation.

5.2 Marking.

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

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

6. NOTES

6.1 Intended use. Piepans furnished under this specification are intended for one time use in the baking of pies, casseroles, and similar type dishes.

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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) Size required (see 1.2).
- (c) Selection of applicable levels of packing and marking required (see 5.1 and 5.2).

Preparing activity:

GSA-FSS

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 25 cents each.