

TT-I-600C

April 25, 1975

SUPERSEDING

Int. Fed. Spec. TT-I-00600B (GSA-FSS)

January 19, 1970 and

Fed. Spec. TT-I-600A

December 3, 1959

FEDERAL SPECIFICATION

INKING PAD, RUBBER STAMP

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 three sizes of fabric, wooden, and foam latex rubber or foam plastic inking pads enclosed in covered containers, for use with hand rubber stamps in general office use.

1.2 Classification.

1.2.1 Types and classes. The rubber stamp inking pads shall be of the following types and classes, as specified (see 6.2).

Type I - Fabric pads, nainsook-covered.

Class 1 - With ink.

Class 2 - Without ink.

Type II - Wooden pad, with ink.

Type III - Foam latex rubber or foam plastic pads.

Class 1 - With ink.

Class 2 - Without ink.

1.2.2 Pad dimensions. The pads shall be furnished in the following sizes, as specified (see 3.2.1.1 and 6.2). A plus tolerance of 1/4 inch, and a minus tolerance of 1/8 inch will be permitted on each of the dimensions.

Size 1 - 2-3/4 by 4-1/4 inches.

Size 2 - 3-1/4 by 6-1/4 inches.

Size 3 - 4-1/2 by 7-1/2 inches.

1.2.3 Colors (ink). When applicable, inked pads shall be inked with black, blue, or red ink, as specified (see 6.2).

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:

TT-I-556 - Ink, Stamp, Pad.

UU-P-121 - Paper, Bond and Writing, White and Colored.

PPP-B-566 - Boxes, Folding, Paperboard.

PPP-B-636 - Boxes, Shipping, Fiberboard.

PPP-B-665 - Boxes, Paperboard, Metal Edged and Components.

PPP-B-676 - Boxes, Setup.

TT-I-600C

Federal Standards:

- Fed. Std. No. 123 - Marking for Domestic Shipment (Civil Agencies).
- Fed. Test Method Std. No. 191 - Textile Test Methods.
- Fed. Test Method Std. No. 601 - Rubber: Sampling and Testing.

(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, 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 Specifications:

- MIL-B-117 - Bags, Interior Packaging.
- MIL-L-10547 - Liner, Case, and Sheet, Overwrap, Water Vaporproof or Waterproof, Flexible.

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.)

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 Material.

3.1.1 Type I, fabric pads. Type I pads shall have a base made of wood or other suitable material impregnated to prevent absorption of ink. The base shall be covered with felt. The felt shall contain not less than 60 percent wool. The remainder of the felt may be cotton or other cellulose fibers. The felt, or the base and felt, shall be covered with nainsook. The nainsook shall have not less than 76 yarns per inch in the warp direction and not less than 73 yarns per inch in the filling direction. The weight shall be not less than 2.7 ounces per square yard. The nainsook shall be bleached and finished without sizing or dressing.

TT-I-600C

3.1.2 Type II, wooden pads. Type II pads shall be made of nonresinous wood having fine pores, with the surface of the pad cut across the grain of the wood. The wood shall be not less than 3/8 inch thick. The surface of the pad shall be smooth and level to permit even distribution of ink.

3.1.3 Type III, foam latex rubber or foam plastic pads. Type III pads shall be made of extra firm, foam latex rubber consisting of natural rubber latex, synthetic rubber latex, or a mixture of the two, or foam plastics. The pad shall be split from very small and uniform pore-size foam latex rubber or foam plastic stock. The split side shall form the surface of the pad and shall be smooth, even, and mat-like. Large pores on the surface of the pad that may cause uneven or improper inking of the stamp shall be cause for rejection. The thickness of the pad shall be not less than 0.22-inch nor more than 0.32-inch.

3.1.3.1 The compression-deflection of the foam latex rubber or foam plastics in the pad shall be 1.50-pounds \pm 0.25-pound per square inch.

3.1.3.2 The compression set of the foam latex rubber or foam plastics in the pad shall not exceed 20 percent.

3.1.3.3 The compression-deflection of the foam latex rubber or foam plastics after accelerated aging shall not change more than plus or minus 20 percent from the compression-deflection before aging.

3.1.4 Containers for inking pad. Pad containers can be constructed of metal or other functional materials. Metal shall be not less than 0.01-inch thick and shall be uniformly coated with a protective coating. The container shall meet the corrosion-resistance test described in 4.4.2.

3.1.5 Ink. The ink furnished in inked pads shall meet the requirements of TT-I-556 as indicated in table I.

TABLE I. Ink requirements

Pads	TT-I-556
Type I, class 1	Class 1
Type II	Class 2
Type III, class 1	Class 1

3.2 Construction.

3.2.1 Inking pads. The pads shall be enclosed in containers and firmly held in the base of the containers without moving or sliding. (See 3.2.1.1.) The inking pads shall be manufactured of materials as specified in 3.1.1, 3.1.2, or 3.1.3. The pads shall absorb and hold a sufficient amount of ink to avoid frequent re-inking. When the pads are re-inked, they shall absorb the ink readily. When the stamp is applied to the inked pad with normal hand pressure the face of the type of the stamp shall be evenly inked and produce a sharp and uniformly intense impression. Surplus ink shall not adhere to the shoulder or sides of the type. (See 4.4.4.1.)

3.2.1.1 Metal container. Metal containers shall be manufactured of material as specified in 3.1.4. The design shall allow 180° total cover opening. When open, the entire cover shall be on the same plane as the base. The container shall consist of a base and hinged lid and shall be of drawn construction. The edges shall be rolled or so designed and constructed to prevent injury to the user. The inside dimensions of the base shall be not less than the dimensions given in 1.2.2 for the respective sizes. Pad inserts shall not make contact with the cover, when closed.

3.3 Identification marking. Each metal container shall be permanently and legibly marked with the name or trademark of the manufacturer.

3.4 Workmanship. The rubber stamp inking pads shall be free from defects or imperfection which may affect appearance or impair serviceability. The metal container shall be devoid of sharp corners, edges, or other imperfections that may be hazardous to the user.

3.5 Shelf life. The inked pads shall, under normal storage conditions, retain their serviceability as defined by this specification not less than 12 months from the time of manufacture.

TT-I-600C

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.

4.1.1 Inspection and testing of components and material. In accordance with 4.1, the supplier is responsible for insuring that components and material are manufactured, examined, and tested in accordance with this specification or referenced subsidiary specifications, standards, and other documents.

4.2 Sampling.

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

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

4.2.3 Sampling visual and dimensional examination. Random samples of inking pads shall be taken from each lot in accordance with MIL-STD-105. The sample unit shall be one inking pad. The inspection level shall be S-4, and the Acceptable Quality Level (AQL) shall be 4.0 percent defective.

4.2.4 Sampling for preparation for delivery requirements. Sampling shall be in accordance with MIL-STD-105. The sample unit shall be one shipping container fully prepared for delivery at one time. The lot shall be all of the containers offered for delivery at one time. The inspection level shall be S-2, and the AQL shall be 4.0 defects per hundred units.

4.2.5 Sampling for material tests. Unless otherwise specified, the contractor shall furnish for test purposes samples of materials taken from the materials used in the manufacture of inking pads delivered, as shown in table II. If class 2, type I and III inking pads are being tested, two sample inking pads may be randomly selected for each lot, in lieu of the sample material indicated in table II.

TABLE II. Material samples

Pads	Materials	Size of samples
Type I	Felt	1 square foot
Type I	Nainsook	1 square foot
Type II	Wood	16 square inches
Type III	Foam latex rubber or foam plastic	1 square foot
Type I and III, class 1, and Type II	Ink	2 fluid ounces
Type I, II, and III	Metal container	2 containers

4.2.6 Sampling for performance test (ink transfer). Two inking pads shall be selected at random from each lot and tested as specified in 4.4.4.1.

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 III. Any inking pad 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 III. Visual and dimensional examination

Examine	Defect
Type and classes	Not as specified (see 1.2.1).
Dimension	Not as specified (see 1.2.2).
Color	Color of ink not as specified (see 1.2.3).
Material	Not as specified (see 3.1.1, 3.1.2, 2.1.3, 3.1.4, and 3.1.5).
Construction	Not as specified (see 3.2.1 and 3.2.1.1).
Identification marking	Metal container not marked as specified (see 3.3).
Workmanship	Not in accordance with 3.4.

4.3.2 Examination of preparation for delivery. Samples selected in accordance with 4.2.4 shall be examined for defects listed in table IV to determine that packaging, packing, and marking comply with the requirements of section 5. Defects of closure listed shall be examined on shipping containers fully prepared for delivery.

TABLE IV. Classification of preparation for delivery defects

Examine	Defect
Marking (exterior and interior)	Omitted; incorrect; illegible; or improper size, location, sequence or method of application.
Materials	Any component missing, or not as specified. Any component damaged, affecting serviceability.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate stapling.
Content	Bulging or distortion of containers. Number per container is more, or less than required. Gross weight exceeds the requirements of the box specification.

4.4 Tests.

4.4.1 Test for materials. Samples obtained in accordance with 4.2.5 and table II shall be subjected to the following tests. Failure to pass the tests shall be considered cause for rejection of the lot, as not meeting the material requirements of this specification.

4.4.1.1 Nainsook and felt. The physical properties of the nainsook and felt shall be tested in accordance with the following test methods described in Fed. Test Method Std. No. 191, to assure compliance with the requirements stated in 3.1.1.

TABLE V. Physical properties testing (nainsook and felt)

Physical properties	Fed. Test Method Std. No. 191
Wool content, alkali method	Test Method No. 2101.
Determination of weight of textile material:	
Small specimen method	Test Method No. 5041.
Yarn per inch in woven fabric	Test Method No. 5050.

4.4.1.2 Foam latex rubber or foam plastics. The physical properties of these materials shall be tested in accordance with the following test methods described in Fed. Test Method Standard No. 601, to assure compliance with the requirements listed in 3.1.3, 3.1.3.1, 3.1.3.2, and 3.1.3.3.

TABLE V. Physical properties testing

Physical properties	Fed. Test Method Std. No. 601
Thickness, cellular rubber	Test Method No. 12031
Compression set, cellular rubber	Test Method No. 12131.1/

TT-I-600C

TABLE V. Physical properties testing (con.)

Physical properties	Fed. Test Method Std. No. 601
Compression deflection, cellular rubber.	Test Method No. 12151.1/
Air heat test, cellular rubber.	Test Method No. 12211.2/

1/ The inside diameter of the die for cutting the specimen may be 1.129 inches \pm 0.001 inch.

2/ The time of exposure shall be 22 hours \pm 1/4 hour. The amount of deterioration shall be measured by the change in compression-deflection.

4.4.2 Metal container corrosion resistance test. The containers shall be suspended above water in a desiccator, or similar enclosed vessel, for 48 hours at room temperature. At the conclusion of this exposure there shall be no indication of attack of the protective coating or corrosion of the metal. Noncompliance shall be cause for rejection of the entire lot.

4.4.3 Ink. The ink shall be tested in accordance with TT-I-556.

4.4.4 Performance test. Each sample obtained in accordance with 4.2.6 shall be subjected to the following test for ink transfer. Failure of either pad to pass the test shall be considered cause for rejection of the lot, as not meeting the material requirements of this specification.

4.4.4.1 Ink transfer. The type face of a clean, dry, rubber stamp shall be inked by pressing it firmly on the inked pad. An impression shall be made immediately upon a sheet of 32-pound (17 X 32 inch 1,000 sheets) bond paper conforming to the requirements for type III of UU-P-121. The impression shall be sharp and uniformly intense. There shall be no filling of closed portions of letters or other characters or designs and no impressions other than those determined by the type face shall be present. Inking the rubber stamp and making an impression shall be repeated until 10 successive impression have been made. The tenth impression shall be sharp and distinct and shall contain no excessive deposit of ink.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A. Each type I, class 1, type II; and type III, class 1 inking pad shall be individually sealed in a bag conforming to MIL-B-117 or wrapped in a manner to prevent leakage of ink during shipment. Unit packaging is not required for type I, class 2; and type III, class 2 pads.

5.1.1.1 Intermediate packaging. Twelve inking pads of one type, class and size only, packaged as specified in 5.1.1, shall be intermediate packaged in a box conforming to PPP-B-566, PPP-B-665, or PPP-B-676. The boxes shall be closed in accordance with the applicable specification or appendix thereto.

5.1.2 Level C. Inking pads of one type, class, and size only shall be packaged to insure protection during shipment and safe delivery at destination.

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

5.2.1 Level A. Inking pads, packaged as specified in 5.1 and in quantities as specified (see 6.2), shall be packed in a close-fitting box conforming to PPP-B-636, V3c or V3s. Close, waterproof seal and strap each box in accordance with the appendix to PPP-B-636. The net weight of the contents of each shipping container shall not exceed 65 pounds. Each shipping container shall be provided with a sealed case-liner conforming to MIL-L-10547, type I or II, grade B or C, class 2.

5.2.2 Level B. Twelve intermediate packages (144 inking pads) packaged as specified in 5.1 shall be packed in a close-fitting box conforming to PPP-B-636, class domestic. The box shall be in accordance with Method II of the appendix to PPP-B-636.

5.2.3 Level C. The inking pads packaged as specified in 5.1 shall be packed to comply with the National Motor Freight Classification Rules or Uniform Freight Classification Rules.

TT-I-600C

5.3 Marking. In addition to any special marking required by the contract or order (see 6.2), the unit, intermediate and shipping containers shall be marked in accordance with Fed. Std. No. 123 or MIL-STD-129, as applicable.

6. NOTES

6.1 Intended use. The inking pads are intended to facilitate inking of hand rubber stamps.

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 of inking pads required (see 1.2.1 and 1.2.2).
- (c) Color of ink (when applicable; see 1.2.3).
- (d) Level of packaging, packing, and marking required (see 5.1, 5.2, and 5.3).

DOD Coordination has been waived.

PREPARING ACTIVITY:

User Interest:

GSA - FSS

Army - GL

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.