

W-S-570B
June 30, 1989
~~SUPERSEDING~~
W-S-570A
April 21, 1961

FEDERAL SPECIFICATION

SOLDERING IRON ELECTRIC

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 electrically powered soldering irons designed for hand soldering.

1.2 Classification. This specification covers soldering irons of the following types, classes, and sizes as specified in tables I and II. The type, class, size, and quantity to be furnished shall be as specified (see 6.2.1).

Type IV - Non-temperature controlled.

Type V - Temperature controlled, fixed temperature.

Class 1 - Temperature Controlled to $\pm 10^0$ Fahrenheit.

Class 2 - Temperature Controlled to $\pm 30^0$ Fahrenheit.

TYPE VI - Variable Temperature Controlled (Soldering Station).

2. APPLICABLE DOCUMENTS

2.1 Government publications. 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 STANDARDS

FED-STD-H28 - Screw Thread Standards for Federal Services.

FED-STD-376 - Preferred Metric Units for General Use by the Federal Government.

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(Activities outside the Federal Government may obtain copies of Federal specifications, standards, and commercial item descriptions as outlined under general information in the Index of Federal Specifications, Standards and Commercial Item Descriptions. The Index, which includes cumulative bimonthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402-0001.)

(Single copies of this specification, and other Federal specifications and commercial item descriptions required by activities outside the Federal Government for bidding purposes are available without charge from General Services Administration Business Service Centers in Boston, MA; New York, NY; Philadelphia, PA; Washington, DC; Atlanta, GA; Chicago, IL; Kansas City, MO; Fort Worth, TX; Houston, TX; Denver, CO; San Francisco, CA; Los Angeles, CA; and Seattle, WA.)

(Federal Government activities may obtain copies of Federal standardization documents and the Index of Federal Specifications, Standards and Commercial Item Descriptions from established distribution points in their agencies.)

MILITARY SPECIFICATION

MIL-W-45562 - Welding and Soldering Equipment, Supplies and Accessories, Packaging of.

MILITARY STANDARDS

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

(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 a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951 - Commercial Packaging, Standard Practice For.

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race St., Philadelphia, PA 19103-1187.)

UNDERWRITERS LABORATORY (UL) STANDARDS FOR SAFETY

UL 499 - Electric Heating Appliances.

(Application for copies should be addressed to Testing and Materials, 1916 Race St., Underwriters Laboratories, Inc., 333 Pfingsten Rd. Northbrook, IL 60062-2096.)

3. REQUIREMENTS

3.1 Material. The material used in the construction of the soldering irons shall be as specified herein. When material is not specified it shall conform to a high quality commercial grade.

3.1.1 Recovered materials. The offeror/contractor is encouraged to use recovered materials to the maximum extent possible.

3.1.2 Fire and casualty hazards. Each bidder shall submit to the contracting agency proof that soldering irons they propose to supply under this specification conform to the applicable requirements of UL-499. The label or listing of the Underwriters Laboratories, Inc. may be accepted as evidence that the soldering irons conform to this requirement. Compliance with UL-499 does not absolve the supplier from complete compliance with the requirements of this specification in order to secure acceptance of their material.

3.2 First article. When specified (see 6.2.1), one sample of each item shall be submitted for first article inspection (see 4.3). The first article may be a preproduction model or an initial production model.

3.3 General Requirements.

3.3.1 Design. The soldering irons shall be new and one of the manufacturers current models that will meet the requirements of this specification. The irons shall be furnished complete and ready for use.

3.3.2 Workmanship. Workmanship of the soldering irons shall be of a quality equal to that of the comparable commercial products furnished to the commercial market.

3.3.3 Construction. The soldering iron shall be constructed of parts which are new, and free of defects. The soldering iron shall be so constructed that all parts which are subject to replacement during the normal life of the iron are easily removable (for replacement) without the necessity of special tools.

3.3.4 Threads. All fasteners used on the soldering iron shall conform to FED-STD-H28.

3.3.5 Finish. Unless constructed of corrosion-resistant material, all metal parts of the soldering irons, other than soldering tips, shall be suitably protected to prevent corrosion from soldering flux and fumes.

3.3.6 Measurement system. In this specification all dimensions are given in US units. These measurements may be converted to SI units through the use of the conversion factors and methods specified in FED-STD-376.

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3.3.7 Identification marking. Each soldering iron shall be marked in a permanent manner with the following:

a. The manufacturer's name or with a trademark of such known character that source of manufacture may be readily determined.

b. Manufacturer's model or part number.

3.3.8 Reliability. The soldering iron shall be capable of operating under continuous cycles of 60 minutes on and 30 minutes off for a period of 120 hours without failure.

3.3.9 Electrical power requirements. Unless otherwise specified (see 6.2.1), the soldering irons shall be designed to operate on 120 volts, \pm 10 percent, AC, 60 Hertz (Hz), single phase power input.

3.3.10 Power cord. Unless otherwise specified (see 6.2.1), the type IV soldering irons shall be furnished with a three conductor power cord. The type V and VI soldering irons shall be furnished with a three conductor power cord. The resistance between the soldering iron tip and the power cord ground shall not exceed 2 ohms on all units furnished with a three conductor power cord.

3.3.11 Handle. The handle shall be manufactured of any suitable heat resistant material which meets the requirements of the Underwriters Laboratories (UL). The handle shall be fabricated so as to afford a comfortable grip to the hand and shall be flanged on the end nearest the heating unit. The external surface of the handle shall be smooth and free of any projections. When applicable the cord end of the handle shall be flared and smoothly finished or other means shall be provided to prevent chafing and breakage of the cord at its entrance to the handle.

3.3.12 Temperature rise of handle. The maximum temperature rise of any part of the handle with which the hand normally comes in contact, shall not exceed 70 degrees Fahrenheit above ambient temperature when operated continuously for a period of 4 hours.

3.3.13 Heater assembly. The heater assembly shall be manufactured from and electrically insulated with a material which meets the requirements of the Underwriters Laboratories. The assembly shall have a positive method for securing the soldering tip to the heater assembly such as threads, pins, set screws, or locking tapers.

3.4 Detailed requirements.

3.4.1 Type IV, Non-temperature controlled. The size of the type IV, Non-temperature controlled soldering irons shall refer to the heating capacity and shall be characterized as power in watts. Unless otherwise specified (see 6.2.1), the size of the type IV irons shall conform to table I. The idle wattage of the soldering iron furnished shall be \pm 10 percent of the manufacturer's stated value. The soldering tips furnished shall be in accordance with 3.4.4.

TABLE I. Size of type IV soldering irons.

Size	Wattage	Size	Wattage
1	10 to 19	8	150 to 199
2	20 to 29	9	200 to 399
3	30 to 39	10	400 to 499
4	40 to 49	11	500 to 599
5	50 to 74	12	600 to 699
6	75 to 99	13	700 to 799
7	100 to 149	14	800 to 1000

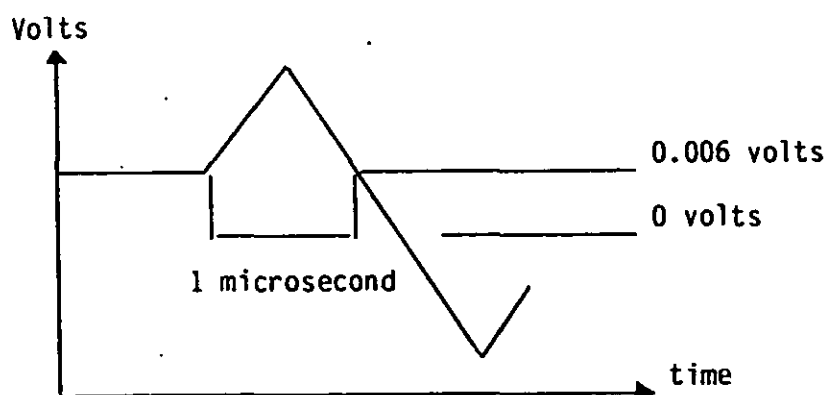
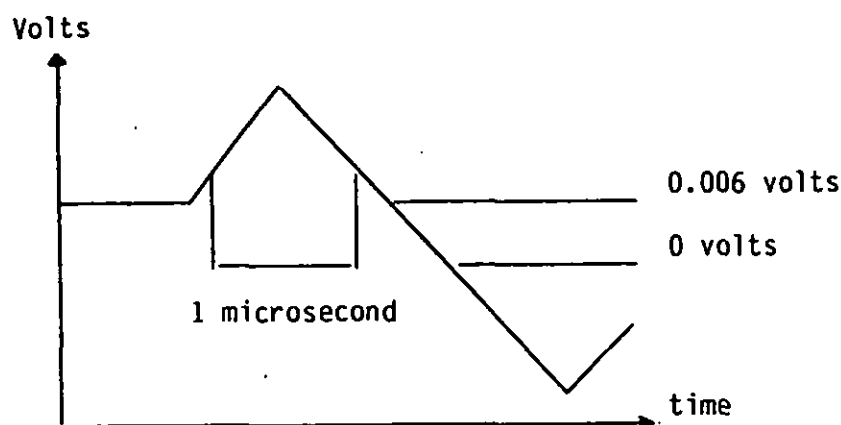
3.4.2 Type V, temperature controlled, fixed temperature. The size of the type V soldering irons shall refer to the controlled fixed tip temperature. Unless otherwise specified (see 6.2.1), the preselected temperature of the tip to be furnished shall be selected from table II. The soldering tips furnished shall be in accordance with 3.4.4.

TABLE II. Preselected idle temperature of type V soldering irons.

Temperature designation	Tip temperature (degrees F)
1	600
2	700
3	800

3.4.2.1 Type V, class 1. The type V, class 1 soldering irons shall control temperature so the average tip temperature is within ± 10 degrees Fahrenheit (F) of the preselected idle temperature and the tip temperature stability is within ± 5 degrees F. The maximum tip leakage voltage when measured from the soldering iron tip to ground shall not exceed 0.002 volt RMS over a frequency range of 20 Hz to 20 kilo Hz for soldering irons having a 50 or 60 Hz voltage applied to the heating element. For soldering irons which have a radio frequency voltage applied to the heating element the maximum tip voltage leakage voltage shall not exceed 0.002 volt RMS over a frequency range of 20 Hz to 100 kilo Hz above the frequency of the voltage applied to the heating element. Switching transients shall be defined as a single pulse of voltage and shall not exceed a value of 0.006 volt peak for more than 1 microsecond (see figures 1 and 2).

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FIGURE 1. Acceptable switching transient waveform.FIGURE 2. Unacceptable switching transient waveform.

3.4.2.2 Type V, Class 2. The type V, class 2 soldering irons shall control tip temperature so the average tip temperature is within ± 30 degrees F. Of the preselected idle temperature and the tip temperature stability is within ± 15 degrees F.

3.4.3 Type VI, variable temperature controlled (soldering station). Unless otherwise specified (see 6.2.1), the type VI temperature controlled soldering iron (soldering station) shall have a minimum controlled temperature range from 400 degrees to 800 degrees F. The temperature shall be adjustable with a calibrated dial or readout device in increments of not more than 20 degrees F. The average tip temperature shall be controlled within ± 10 degrees F. Of the selected idle temperature. The maximum tip leakage voltage and switching transient voltage levels shall meet the requirements of 3.4.2.1. The soldering tips furnished shall be in accordance with 3.4.4. When specified (see 6.2.1), the voltage applied to the heating element shall be isolated from the input primary voltage by a step down or an isolation transformer.

3.4.4 Soldering tips. Unless otherwise specified (see 6.2.1), the soldering tips shall be made of commercially pure copper, tellurium copper, or leaded copper and shall be coated with another material which prevents oxidation and allows the tip to be readily tinned. The tip size and shape to be furnished with each soldering iron furnished shall be as specified by the procuring activity. Unless otherwise specified (see 6.2.1), the size of the tip to be furnished shall be selected from table III. Unless otherwise specified (see 6.2.1), the shape of the tip to be furnished shall be selected from table IV and shall be similar to figures 1 thru 6. Unless otherwise specified the length shall conform to the manufacturer's standard drawing.

TABLE III. Size of soldering iron tips.

Size	Diameter	Size	Diameter
1	1/32	8	1/2
2	1/16	9	5/8
3	3/32	10	7/8
4	1/8	11	1
5	3/16	12	1 1/8
6	1/6	13	1 3/8
7	3/8	14	1 5/8
		15	1 3/4

NOTE: The tolerance of size 1 thru size 4 shall be +0.005 inches. The tolerance of size 5 thru size 15 shall be + 5%.

TABLE IV. Shape of soldering iron tips.

Shape designation	Shape of tip
A	Pencil
B	Pyramid
C	Chisel, short
D	Chisel, long
E	Conical
F	Conical bevel

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Figure 3- Pencil

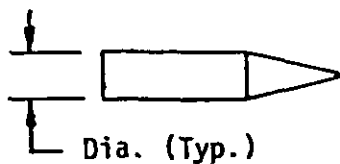


Figure 4 - Pyramid

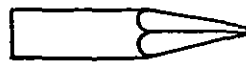


Figure 5-Chisel, short



Figure 6 - Screwdriver

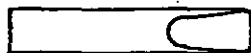


Figure 7 - Conical



Figure 8 - Conical bevel



3.4.5 Replacement soldering Iron tips. Replacement soldering iron tips shall be a replacement for the brand name and model number of soldering iron as specified by the procuring activity (see 6.2.1). Unless otherwise specified (see 6.2.1) the soldering iron tips furnished shall be in accordance with 3.4.4.

3.4.6 Soldering iron holders. When specified (see 6.2.1), a soldering iron holder shall be provided with each soldering iron. The holder shall be capable of supporting the operating iron for a minimum of 12 hours without damage to the stand or iron. When specified (see 6.2.1) the holder shall be furnished with a sponge for wiping the tip.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspections. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, 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 that supplies and services conform to prescribed requirements.

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (see 4.4).

4.3 First article inspection. When first article inspection is required, it shall be applied to the first article submitted in accordance with 3.2. Unless otherwise specified (see 6.2.1), first article inspection shall consist

of the examination in 4.5 and all tests in 4.6, and the inspection in 4.7. The soldering iron shall pass the examination, tests, and inspection to be accepted.

4.4 Quality conformance inspection. A quality conformance sampling inspection shall be applied to each item offered for acceptance under the contract. Unless otherwise specified (see 6.2.1), the quality conformance inspection shall consist of the examination in 4.5, and the inspection in 4.7. Failure of an item to pass the examination, and the inspection shall be cause for rejection.

4.4.1 Quality conformance sample. Sampling for quality conformance inspection shall be performed in accordance with MIL-STD-105. Sampling shall be at level S-1 with an AQL of 4.0.

4.5 Examination. The first article and each soldering iron in the sample selected for quality conformance inspection shall be visually examined to determine compliance with 3.3.1, 3.3.2, 3.3.3, 3.3.7, and 3.3.11.

4.6 Tests.

4.6.1 Test conditions. All tests shall be conducted in an ambient temperature within the range of 70 to 80 degrees F. With the soldering irons operating at their designed voltage, ± 1 volt.

4.6.2 Reliability test. The soldering iron shall be tested for conformance with 3.3.8. The test shall consist of energizing and deenergizing the soldering iron for 60 minutes on and 30 minutes off for a period of 120 hours without failure. The iron shall be operated in a holder designed for the specific iron. No auxiliary means shall be provided for dissipating the heat during the test.

4.6.3 Tip resistance to ground test. The soldering iron shall be tested for conformance with 3.3.10. Caution must be taken when making this measurement to eliminate the thermocouple effect of hot dissimilar metals.

4.6.3.1 Equipment required for tip resistance to ground test. The following equipment is required to perform the tip resistance to ground test. An ohmmeter capable of measuring 2 ohms ± 5 percent, cables, and a test plate manufactured from a piece of brass or copper shim stock approximately 1.5 inches long by 0.75 inch wide and from 0.008 to 0.020 inch thick.

4.6.3.2 Tip resistance to ground test procedure. The tip resistance to ground test shall be accomplished as follows:

- a. Remove any oxidation and corrosion from the shim stock.
- b. Bond a small pool of solder to the shim stock using sufficient heat to ensure a well wetted bond between the shim stock and solder.
- c. Connect leads of the ohmmeter between the test plate and the ground pin of the soldering iron under test.

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- d. Apply power to the soldering iron under test and allow at least a 15 minute warmup period.
- e. Place the tip of the soldering iron under test in the solder on the test plate and allow solder to melt. Wait at least 30 seconds for the temperature to stabilize. Measure the resistance and record as R-1.
- f. Reverse ohmmeter leads and measure resistance and record as R-2.
- g. The true resistance is equal to R-1 plus R-2 divided by two.

4.6.4 Temperature rise of handle. The soldering iron shall be tested for conformance with 3.3.12 by placing the iron in a horizontal position and operating for a period of 2 hours. The temperature rise of the handle shall be measured by a surface pyrometer or other suitable means. The temperature rise of the handle which normally comes in contact with the hand shall not exceed 70 degrees F. above ambient temperature. The type VI soldering iron (soldering station) shall be tested at 800 degrees F.

4.6.5 Input wattage. The type IV soldering iron shall be tested for conformance with 3.4.1. The soldering iron shall be placed in a holder esigned for the specific iron and operated for a period of 2 hours. Wattage measurements shall be made after 1 hour and after 2 hours of operation. The wattage shall be ± 10 percent of the manufacturer's stated value.

4.6.6 Temperature control test. The type V, class 1 soldering iron shall be tested for conformance with 3.4.2.1, the type V, class 2 shall be tested for compliance with 3.4.2.2, and the type VI soldering (soldering station) shall be tested for conformance with 3.4.3.

4.6.6.1 Equipment required for temperature control test. The following equipment is required to perform the temperature control test using an embedded thermocouple. A thermocouple and a device capable of measuring the thermocouple voltage with a measurement accuracy of ± 0.5 degree.

4.6.6.2 Temperature control test procedure. The temperature of the soldering iron under test shall be accomplished as follows:

- a. Drill a hole approximately 0.052 inch in diameter and 1/8 inch deep in the tip of the soldering iron under test. Ensure no molten solder enters the hole.
- b. Insert the twisted thermocouple so the last twist is exactly at the edge of the hole. Wedge a small piece of copper into the hole to hold the thermocouple in tight contact with the tip. Trim off any excess length of the wedge.
- c. Attach the thermocouple wires to the voltage measuring device and apply voltage to the iron under test. Allow the iron to stabilize at idle temperature. Take a series of at least 5 temperature readings at intervals of approximately 1 minute apart. Calculate the average temperature.

- d. The average temperature shall meet the requirements of 3.4.2.1. for the type V, class 1, 3.4.2.2 for type V, class 2, and 3.4.3 for the type VI.

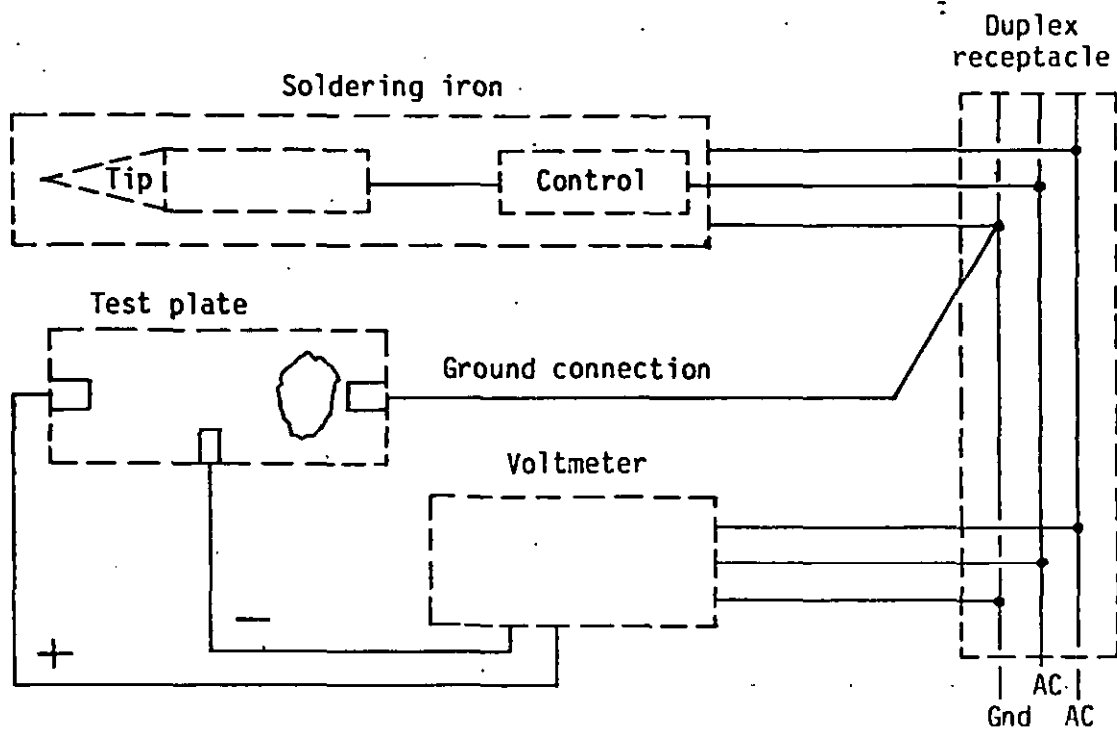
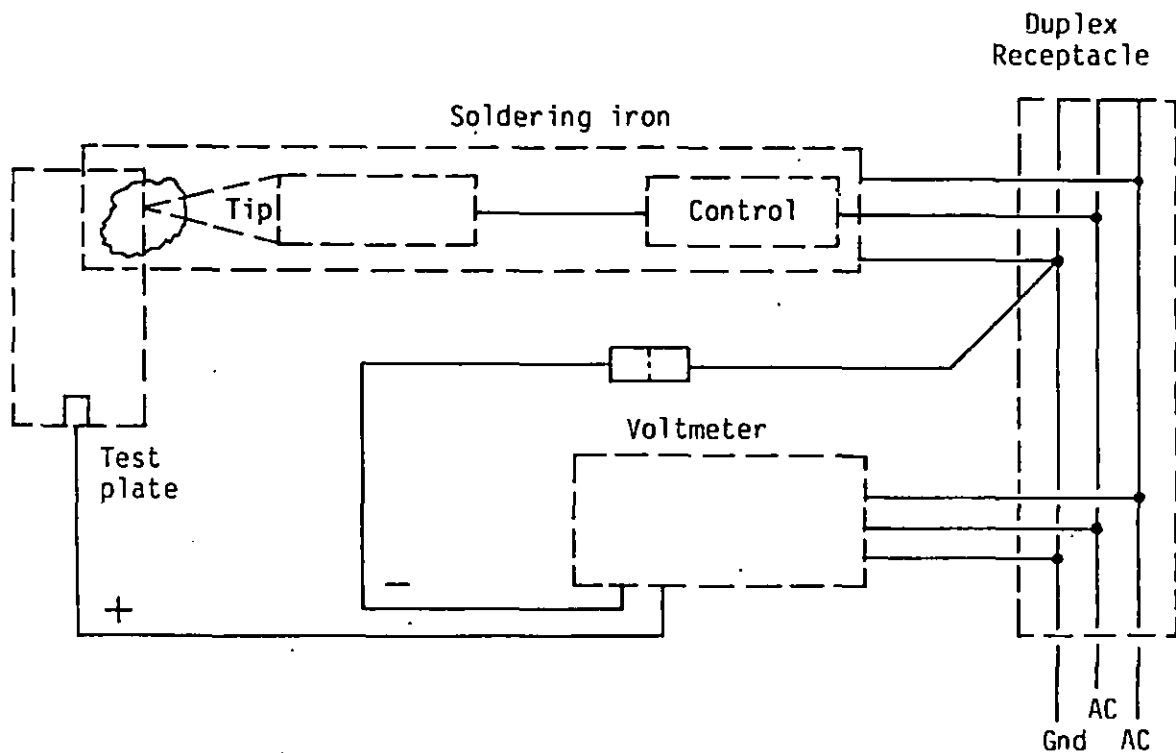
4.6.7 Leakage voltage test. The type V, class 1 soldering iron shall be tested for conformance with 3.4.2 and the type VI soldering iron (soldering station) shall be tested for conformance with 3.4.3.

4.6.7.1 Equipment required for leakage voltage test. The following equipment is required to perform the leakage voltage test. An AC voltmeter capable of indicating 0.002 volt over the frequency range specified in 3.4.3 to an accuracy of +3 percent with an input impedance of 10 mega ohms or greater, miscellaneous shielded cables and clips, and a test plate manufactured from a piece of brass or copper shim stock approximately 1.5 inches long by 0.75 inch wide and from 0.008 to 0.020 inch thick.

4.6.7 Leakage voltage test procedure. The leakage voltage test shall be accomplished as follows:

- a. Remove any oxidation and corrosion from the shim stock.
- b. Bond a small pool of solder to the shim stock using sufficient heat to ensure a well wetted bond between the shim stock and solder.
- c. If the voltmeter is not battery operated, it must be plugged into the same duplex wall receptacle as the unit under test.
- d. Attach a cable between the test plate and ground the ground pin of the soldering iron under test.
- e. Attach the positive and negative cables of the voltmeter to the test plate, (see fig 9). Ensure that a good electrical connection is made.
- f. Apply power to the voltmeter and soldering iron under test. Adjust type VI soldering irons to 800 degrees. Allow at least a 15 minute warmup. Select the proper range on the voltmeter and measure the measurement system voltage. Record as V1.
- g. Remove the cable connected between the test plate and and the ground of the soldering iron under test. Remove the voltmeter negative cable from the test plate and attach to the to the soldering iron under test ground (see fig 10).
- h. Place the tip of the soldering iron in the solder and allow solder to melt. Allow temperature to stabilize and then measure voltage. Record as V2.
- i. The leakage voltage of the unit under test is the difference of V2 and V1. This voltage shall be 0.002 volt or less.

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FIGURE 9. Measurement of test system Voltage level.FIGURE 10. Measurement of leakage voltage.

4.6.8 Transient voltage test. The type V, class 1 soldering iron shall be tested for conformance with 3.4.2 and type VI soldering iron (soldering station) shall be tested for conformance with 3.4.3. The test shall be accomplished with the iron at idle temperature and with the ground connected.

4.7 Packaging inspection. Packaging of the soldering gun shall be inspected to determine compliance with the requirements of section 5.

5. PREPARATION FOR DELIVERY

5.1 Preservation, packing, and marking. Unless otherwise specified, packaging, packing, and marking shall be in accordance with ASTM D 3951. When specified (see 6.2.1), level A or level B preservation, level A or level B packing and marking shall be accomplished in accordance with MIL-W-45562.

6. NOTES

6.1 Intended use. The soldering irons covered by this specification are intended to be used for manual soldering operations.

6.2 Ordering data.

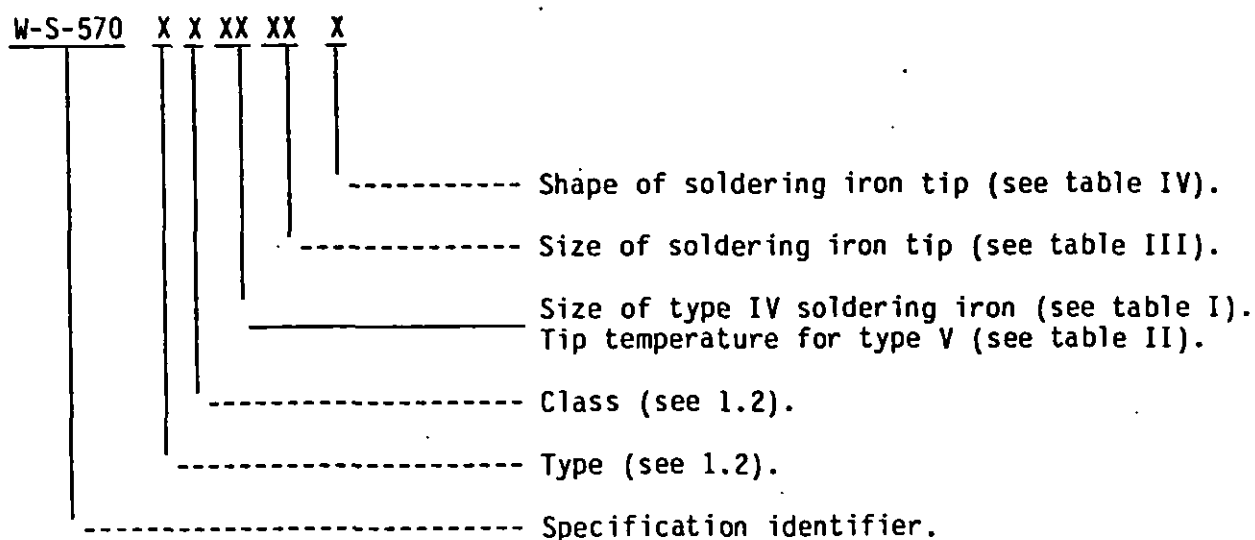
6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. Type, class, size, and quantity of soldering irons required (see 1.2).
- c. First article, if required (see 3.2 and 4.3).
- d. Electrical input requirements, if different (see 3.3.9).
- e. Power cord, if different (see 3.3.10).
- f. Size of type IV soldering to be furnished (see 3.4.1).
- g. Size of type IV soldering iron, if not selected from table I (see 3.4.1).
- h. Temperature designation of type V soldering iron to be furnished (see 3.4.2).
- i. Temperature of type V soldering iron to be furnished, if not selected from table II (see 3.4.2).
- j. Temperature range of type VI soldering iron to be furnished, if different (see 3.4.3).
- k. If voltage isolation is required, specify (see 3.4.3).
- l. Composition of soldering tips, if different (see 3.4.4).

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- m. Size of soldering tip to be furnished (see 3.4.4)
- n. Size of soldering tip, if not selected from table III (see 3.4.4).
- o. Shape of soldering tip to be furnished (see 3.4.4)
- p. Shape of soldering tip, if not selected from table IV (see 3.4.4)
- q. Length of soldering tip, if different (see 3.4.4).
- r. Brand name and model number of soldering iron which replacement tip will be used with (see 3.4.5).
- s. Describe replacement soldering tip (see 3.4.5).
- t. Soldering holder when required (see 3.4.6).
- u. Sponge, when required (see 3.4.6).
- v. First article inspection, if different (see 4.3).
- w. Quality conformance inspection, if different (see 4.4).
- x. Packaging in accordance with MIL-W-45562, if required specify level (see 5.1).

6.3 Identification number. The following part identification numbering procedure is for government purposes and does not constitute a requirement for the contractor.



NOTE: Where applicable, Arabic numbers shall be substituted for Roman numerals.

6.3 Cross-reference of classification changes. Cross reference of classification changes between this specification and the preceding issue are as follows:

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Type I		Deleted
Class 1	Deleted	
Class 2	Deleted	
Type II	Deleted	
Cord Assembly	Deleted	
Cord Assembly	Deleted	
Type III	Deleted	
Class 1	Deleted	
Style A	Deleted	
Class 2	Deleted	
Style A	Deleted	
Cord assembly 1	Deleted	
Cord assembly 2	Deleted	
Style B	Deleted	
Heating assembly 1	Deleted	
Heating assembly 2	Deleted	
Heating assembly 3	Deleted	
	Type IV(new type)	
	Type V (new type)	
	Class 1 (new type)	
	Class 2 (new type)	
	Type VI(new type)	

MILITARY INTERESTCIVIL AGENCY COORDINATING ACTIVITY:Custodians:

GSA-FSS

Army - AR
Navy - SH
Air Force - 99

PREPARING ACTIVITY:

DLA-IP:

Review activities:

Air Force - 84
DLA-GS

DOD project 3439-0650

User Activities

Navy - MC, YD

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NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER W-S-570B		2. DOCUMENT TITLE Soldering Iron Electric	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
b. ADDRESS (Street, City, State, ZIP Code)		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify): _____	
5. PROBLEM AREAS			
a. Paragraph Number and Wording:			
b. Recommended Wording:			
c. Reason/Rationale for Recommendation:			
6. REMARKS			
7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	