

MIL-C-0020534A (BuMed)
 29 June 1962

 USED IN LIEU OF
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MILITARY SPECIFICATION
 COMMODE

This limited coordination military specification has been prepared by the Defense Medical Supply Center based upon currently available technical information, but it has not been approved for promulgation as a revision of Military Specification MIL-C-20534. It is subject to modification. However, pending its promulgation as a coordinated military specification, it may be used in procurement.

1. SCOPE

1.1 This specification covers one type of commode, suitable for use in the field.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids form a part of this specification to the extent specified herein:

SPECIFICATIONS

Federal

TT-E-527	Enamel, Alkyd, Lusterless.
TT-R-191	Red Lead, Dry and Paste in Oil.
PPP-B-585	Boxes, Wood, Wirebound.
PPP-B-601	Boxes, Wood, Cleated-Plywood.
PPP-B-621	Boxes, Wood, Nailed and Lock-Corner.
PPP-B-636	Box, Fiberboard.

Military

MIL-L-10547 Liners, Case, Waterproof.

STANDARDS

Federal

Fed. Std. No. 595 Colors.

Military

MIL-STD-105 Sampling Procedures and Tables for Inspection by
 Attributes.
 MIL-STD-129 Marking for Shipment and Storage.

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(Copies of 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.)

3. REQUIREMENTS

3.1 Material.

3.1.1 Metal. All metal parts shall be steel, zinc-coated (galvanized), with not less than 2 ounces per square foot on both sides.

3.1.2 Gasket. The gasket shall be made of a durable waterproof fabric.

3.2 Construction. The commode shall consist of a bucket with a bail, a removable seat section, and a gasketed cover with a handhold. Design shall be as shown on figure 1.

3.2.1 Body. The body shall be of steel of a minimum thickness of 0.024 inch (No. 24, United States Standard gage) before galvanizing. The sides of the bucket shall be properly formed from one piece with the ends joined together in a locked seam, or in two pieces joined together by two lock seams diametrically opposite. The top edge shall be rolled over a bright steel wire not less than 1/8 inch in diameter. The body shall have the following dimensions:

	Inches
Height overall, exclusive of bail	12-3/4 ± 1/2
Diameter at top, inside	11-1/2 ± 1/4
Diameter at bottom, inside of flange	9-1/2 ± 1/4

3.2.2 Bottom. The bottom shall be lock seamed to the sides. The bottom flange of the bucket shall extend below the bottom not less than 5/8 inch nor more than 1 inch.

3.2.3 Bail. The bail shall be a 3/8-inch-diameter, medium-carbon-steel rod, bent into a semicircle of such size that when the bail is placed in the down position, it shall clear the top rim and rest against the side. The ends of the bail shall be formed into loops to engage the ears, the loops being of such size and shape as to permit the bail to move freely without binding or catching. Bail shall have a wooden handhold in its center, firmly attached.

3.2.4 Ears. Two forged split ears (or stamped split ears provided the loops of the ears permit the ball to move freely) shall be riveted to the outside of the bucket at points diametrically opposite, so that the center lines of the ears shall be directly over

the side seams of the bucket. In the case of a one-seam bucket, the center line of one ear shall be directly over the side seam. The ears shall be located vertically so that the axis about which the bail swings shall be not less than 1 inch nor more than 1-3/4 inches below the top of the bucket. Each ear shall be held securely in place by two rivets.

3.2.5 Seat section. The seat section shall be made of steel and shall be removable. The seat shall consist of a tapered section, circular in cross section, 3-1/4 ± 1/8 inches high, with the diameter at the top 10 ± 1/4 inches and at the bottom 11-1/4 ± 1/4 inches. The top shall be provided with a circular opening 8 ± 1/4 inches in diameter and a rim 1 inch wide which shall completely encircle the opening. The side wall, 1 inch from the bottom edge, shall be provided with a continuous shoulder, 3/8 inch wide. This shoulder shall act as a stop and support when the seat section is inserted into the top of the bucket. The walls from the top edge to the shoulder support shall be well tapered to accept the gasketed cover.

3.2.6 Cover. The cover shall be provided with a handhold in the center of the top. The cover shall consist of an outer shell and an inner shell symmetrically shaped and riveted together. Along the exposed edge and held tightly by the two shells there shall be a gasket, bent over a continuous strip of 1/16-inch-thick galvanized iron, which shall act as a core. The gasket thus formed shall project 3/8 inch from the two shells which hold it. The gasket shall have an overall thickness of 5/64 inch. The cover shall have a tight friction fit. A suitably shaped hook shall be provided inside the wall of the cover for hanging the cover to the side of the bucket.

3.3 Finish. All external surfaces of the bucket and cover shall be coated with enamel conforming to Specification TT-E-527, and to color X34087 (see 6.2) of Federal Standard No. 595. The inside of the cover shall be finished in red lead conforming to Specification TT-R-191.

3.4 Labeling. The following legend shall be stenciled, using a waterproof paint, in black block letters 1/2 inch high on the external surface of the cover:

WHEN NOT IN USE HANG
COVER AT SIDE.

3.5 Identification marking. Each bucket shall have stenciled on its side wall, in a black waterproof paint, the letters U.S. 1 inch in height. In addition, the name or registered trademark of the manufacturer shall be stenciled on. Markings secured by adhesives shall not be used.

3.6 Workmanship. Workmanship shall be first class throughout. The commodes shall be free from defects which detract from their appearance or which may impair their serviceability.

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4. QUALITY ASSURANCE PROVISIONS

4.1 Supplier responsibilities for inspection. The supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own or any other inspection facilities and services acceptable to the Government. Inspection records of the examination and tests shall be kept complete and available to the Government as specified in the contract or order. 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 Inspection. Inspection, as used in this specification, is defined as both examination (such as visual, auditory, etc., investigation without the use of special laboratory appliances or procedures) and testing (determination by technical means of physical and chemical properties) of the item.

4.1.2 Certificates of quality. When available, certificates of quality, supplied by the manufacturer of the component or material, listing the specified test method and test results obtained, may be furnished in lieu of actual performance of such testing by the contractor.

4.2 Sampling.

4.2.1 For examination. Sampling for examination shall be conducted in accordance with Standard MIL-STD-105. Inspection level for dimensional examination shall be L5, with an AQL of 2.5 defects per hundred units.

4.2.2 For tests. Sampling for tests shall be conducted in accordance with Standard MIL-STD-105.

4.3 Examination. The commodes shall be examined to determine compliance with all requirements contained in this specification.

4.3.1 Dimensional examination. The commodes shall be examined for defects in dimensions. Any dimension not within the tolerances specified herein shall be classified as a defect.

4.4 Tests. Tests shall be conducted, as necessary, to determine compliance with specification requirements.

5. PREPARATION FOR DELIVERY

5.1 Packaging.

5.1.1 Unit of issue. One (1) commode, as specified, constitutes one unit of issue.

5.1.2 Packaging quantities. The number of units of issue indicated in table I shall be packaged in each unit and exterior container, as applicable for the required level of protection specified in the procurement document.

Table I - Packaging Quantities

Unit package	Intermediate package	Exterior container
1 unit	Not required	4 units

5.1.2.1 Packing variation permitted. If the required number of units to be shipped is less than the number of units specified to be overpacked in an exterior container, such units shall be packed in an exterior container of suitable size and design, acceptable to a common carrier, which will insure safe delivery to destination.

5.1.3 Level A.

5.1.3.1 Unit package. Each unit shall be packaged in a carton of appropriate size constructed in accordance with Specification PPP-B-636, type I, class 1. Closure of carton shall be adequate to prevent spillage of contents under normal handling.

5.1.4 Level C. Units shall be packaged in standard commercial containers of the size and kind commonly used, which will afford the degree of protection required for shipment and use of the product for its intended purpose within the continental limits of the United States of America.

5.2 Packing.

5.2.1 Level A.

5.2.1.1 Exterior container. Exterior container shall be designed for type 2 load, and constructed in accordance with Specification PPP-B-585, style 3, for class 3 use; PPP-B-601, table II, using type III, class 1 plywood; or PPP-B-621, table III.

5.2.1.2 Case liner. Each level A box shall be lined with a waterproof case liner conforming to Specification MIL-L-10547. Closure and sealing shall conform to applicable paragraphs of appendix thereto.

5.2.1.3 Strapping. Strapping, when required, shall be in accordance with applicable paragraphs of appendix thereto.

NOTE: Strapping will not be required for shipments forwarded to a receiving activity within the continental limits of the United States for storage and redistribution.

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5.2.2 Level B.

5.2.2.1 Exterior container. Exterior container shall conform to Specification PPP-B-601, table I, using type III, class 1 plywood, or shall be designed for type 2 load, and constructed in accordance with Specification PPP-B-585, style 3, for class 2 use; PPP-B-621, table I; or PPP-B-636, type I, class 1, fabricated from not less than 275-pound test fiberboard.

5.2.3 Level C. The subject commodity shall be packed in substantial commercial containers of the type, size, and kind commonly used for the purpose, so constructed as to insure acceptance and safe delivery by common or other carriers, at the lowest rate, to point of delivery called for in the contract or order.

5.3 Marking.

5.3.1 Unit package. Each unit package shall be marked in accordance with Standard MIL-STD-129. Contract number and name of contractor shall be shown. Waterproofing of labels shall be required only when carton utilized is fabricated of water-resistant material.

5.3.2 Exterior container. Exterior container shall be marked in accordance with Standard MIL-STD-129. In addition, the letter "L" shall precede the Federal stock number. One space shall be allowed between the letter "L" and the first digit of the stock number. The terms "Stock number" or "FSN" shall not be indicated. Service color and service symbol markings are required only on direct shipments from the contractor's plant to overseas activities.

6. NOTES

6.1 Ordering data. Procurement documents should specify the following:

- (a) Number and date of this specification.
- (b) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

6.2 Availability of color standards. The color standards of the color referenced in 3.3 are available from:

Commanding General
Aberdeen Proving Ground, Maryland
Attention: Coating and Chemical Laboratory

6.3 This specification does not include all types, classes, grades, sizes, etc., of the commodity indicated by the title of this specification, or which are commercially available, but is intended to cover the types, etc., which are normally procured to meet Military requirements.

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6.4 Transportation description. Transportation description applicable to this item is:

Sanitary commodes, steel, set-up, in boxes.

Carload minimum weight varies in accordance with the Uniform Freight Classification.

Truckload minimum weight varies in accordance with the National Motor Freight Classification.

Notice. When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

Custodians:

Army - Med
Navy - BuMed
Air Force - AFCSG

Preparing activity:
Defense Medical Supply Center

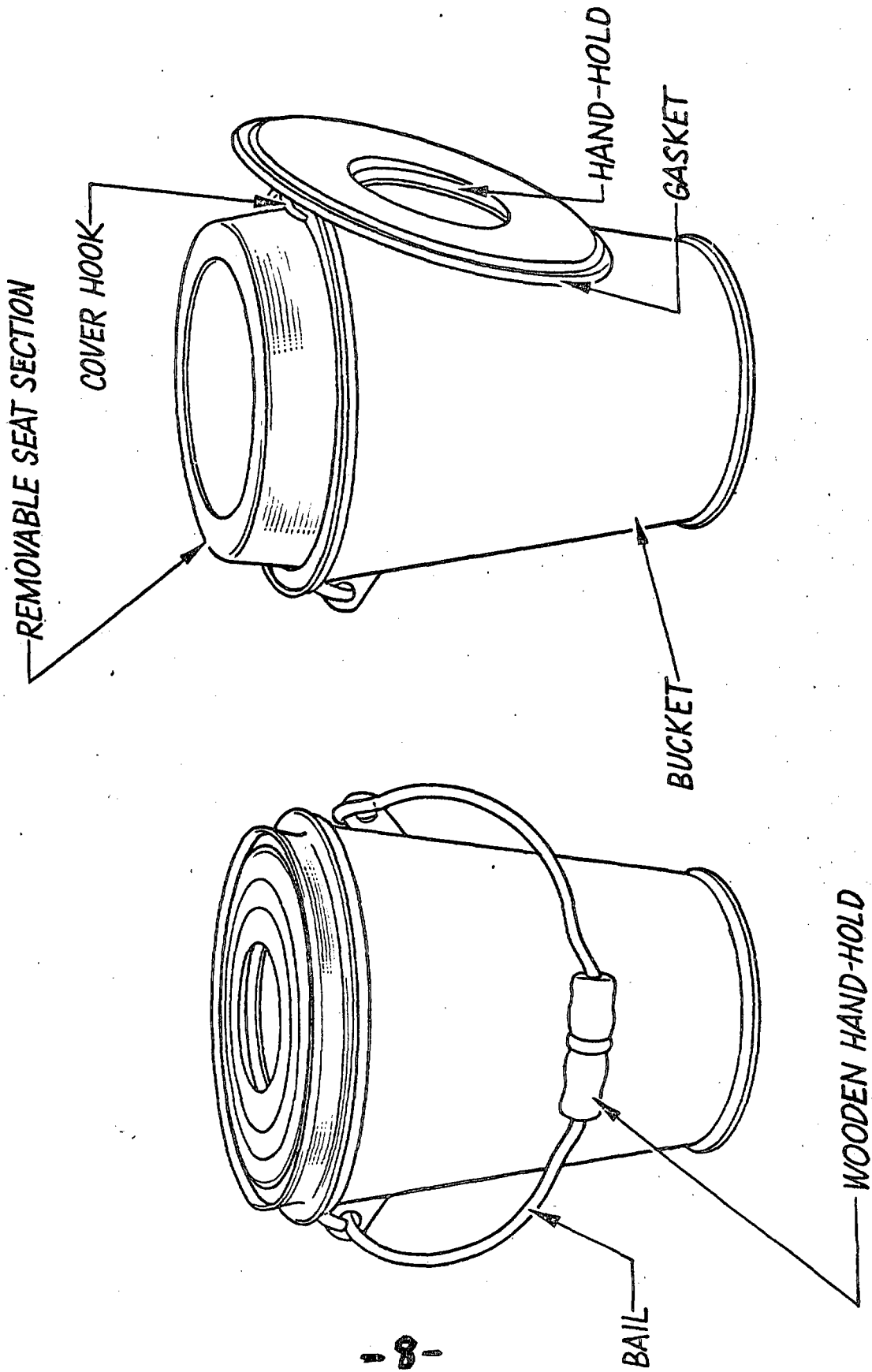


FIGURE 1