

INCH-POUND

MIL-G-80152B
30 June 1988
SUPERSEDING
MIL-G-80152A
24 April 1978

MILITARY SPECIFICATION

GOUGING AND CUTTING MACHINE, MECHANIZED, DIRECT
CURRENT, ELECTRIC ARC, PORTABLE

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers one type and one size of metal gouging and cutting machine, with equipment and accessories specified herein. The direct current power supply is not included in this specification.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. The following specifications and standards form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation.

SPECIFICATIONS

MILITARY

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

STANDARDS

FEDERAL

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

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Defense Industrial Plant Equipment Center, ATTN: DIPEC-SSG, Memphis, TN 38114-5051, by using the self-addressed Standardization Document Improvement proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 3433

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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

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MIL-STD-461 - Electromagnetic Emission and Susceptibility Requirements for the Control of Electromagnetic Interference.

MIL-STD-462 - Electromagnetic Interference Characteristics, Measurement of.

2.1.2 Other Government documents. The following other Government document forms a part of this specification to the extent specified herein. Unless otherwise specified, the issue shall be that in effect on the date of the solicitation.

CODE OF FEDERAL REGULATIONS (CFR)

U. S. DEPARTMENT OF LABOR, OCCUPATION, SAFETY AND HEALTH ADMINISTRATION (OSHA)

29 CFR 1910 - Occupational Safety and Health Standards.

(Application for copies should be addressed to the Superintendent of documents, U.S. Government Printing Office, Washington, DC 20402-0001.)

(Copies of specifications, standards, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted shall be those listed in the issue of the DODISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS shall be the issue of the nongovernment document which is current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951- Standard Practice for Commercial Packaging.

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

NATIONAL FIRE PROTECTION ASSOCIATION (NFPA)

NFPA 79 - Electrical Standard for Industrial Machinery.

(Application for copies should be addressed to the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269-9101.)

(Nongovernment standards and other publications are normally available from the organizations which prepare or distribute the documents. These documents

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also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified in the contract or purchase order (see 6.2.1), a sample shall be subjected to first article inspection (see 4.4 and 6.3).

3.2 Design. The machine shall be new (not a prototype) and one of the manufacturer's current models. The machine shall be designed to remove a controlled amount of metal by simultaneous melting the base metal and blowing away the molten metal by a high velocity compressed air stream. Melting is attained with the heat of an arc struck between a copper coated carbon-graphite electrode and the metal to be removed. The machine with attachments shall be compact, lightweight, and portable, permitting movement from one location to another. The machine shall be designed to operate on flat or curved surfaces. The machine shall include all components, parts, and features necessary to meet the performance requirements specified herein. All parts subject to wear, breakage, or distortion shall be accessible for adjustment, replacement, and repair.

3.2.1 Design and construction dimensional system. Unless otherwise specified, (see 6.2.1), either the inch/pound or the International System of Units (SI) shall be used in the design and construction of the machine. In this specification, all dimensions, measurements, sizes, and capacities are given in US units. These dimensions may be converted to SI units through the use of the conversion factors and methods specified in FED-STD-376.

3.2.1.1 Measuring and indicating device calibrations. Unless otherwise specified, either the inch/pound or the International System of Units (SI) shall be used to graduate measuring and indicating devices. When only one system of graduation is acceptable, the particular graduation required shall be as specified (see 6.2.1). Regardless of the measurement system used, all measuring and indicating devices on the machine shall be graduated in the same system.

3.2.1.1.1 Dual calibrations. When specified (see 6.2.1), measuring and indicating devices shall be graduated in both the inch/pound and the SI System of Measurements. When a dual US and SI system is furnished, both dials shall have independent zero adjustments and both dials shall be calibrated in such a manner that the last dial graduation progresses into and is continuous with the first dial graduation as the dial is rotated through the zero position.

3.2.2 Reclaimed materials. The machine may contain reclaimed materials provided such materials will not jeopardize the intended use, performance, and

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design life of the machine. The reclaimed materials shall have been reprocessed, remanufactured, or recycled in a manner which will restore them to the same chemical composition and physical properties as the materials originally selected for use on the machine.

3.2.3 Energy efficiency. The machine and its components that directly consume energy in normal operation shall be designed and constructed for the highest degree of energy efficiency as governed by the latest developments available within the industry.

3.2.4 Controls All operating controls shall be located conveniently to the operator's normal work station.

3.2.5 Safety and health requirements. Covers, guards, or other safety devices shall be provided for all parts of the machine that present safety hazards. The safety devices shall not interfere with the operation of the machine. The safety devices shall prevent unintentional contact with the guarded part, and shall be removable to facilitate inspection, maintenance, and repair of the parts. All parts, components, mechanisms, and assemblies furnished, whether or not specifically required herein, shall comply with all of the requirements of 29 CFR 1910 that are applicable to the machine itself. The machine shall be equipped with all point-of-operation guarding normally furnished as standard on the manufacturer's commercial machine supplied to the commercial market. If specific point-of-operation guarding is required, the procuring activity should specify the exact configuration of the guard required because the guard configuration is dependent on the size and configuration of the workpieces. The above and any other additional safety and health requirements should be specified in detail (see 6.2.1).

3.2.6 Mercury restriction. The machine shall not contain mercury or mercury compounds nor be exposed to free mercury during manufacture.

3.2.7 Asbestos restriction. Asbestos and materials containing asbestos shall not be used on or in the machine

3.2.8 Environmental protection. The machine shall be so designed and constructed that, under the operation, service, transportation, and storage conditions described herein, the machine shall not emit materials hazardous to the ecological system as prohibited by Federal, state, or local statutes in effect at the point of installation.

3.2.9 Lubrication. Means shall be provided to ensure adequate lubrication for all moving parts. All oil holes, grease fittings, and filler caps shall be readily accessible.

3.2.10 Interchangeability. All parts shall be manufactured to definite dimensions and tolerances that will permit installation of replacement parts without modification of the part or machine.

3.3 Construction. The machine shall be constructed of parts which are new, without defects, and free of repairs. The structure shall withstand all forces encountered during operation of the machine to its maximum rating and capacity without permanent distortion.

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3.3.1 Castings and forgings. All castings and forgings shall be free from defects, scale, and mismatching. Processes such as welding, peening, plugging, or filling with solders or pastes shall not be used on castings or forgings to reclaim any defective components for use on the machine. Such processes may be used only for enhancing surface finish and appearance.

3.3.2 Welding, brazing, or soldering. Welding, brazing, or soldering shall be employed only where specified in the original design. None of these processes shall be employed as a repair measure for any defective part.

3.3.3 Fastening devices. All fasteners shall be installed in a manner to prevent change of tightness. Fastening devices subject to removal or adjustment shall not be permanently installed.

3.3.4 Surfaces. All surfaces shall be clean and free of harmful or extraneous materials. All edges shall be either rounded or beveled unless sharpness is required to perform a necessary function. Except as otherwise specified herein, the condition and finish of all surfaces shall be in accordance with the manufacturer's commercial practice.

3.3.5 Painting. Unless otherwise specified (see 6.2.1), the machine shall be painted in accordance with the manufacturer's standard commercial practice and color.

3.3.6 Threads. All threaded parts used on the machine and its related attachments and accessories shall conform to FED-STD-H28 and the applicable "Detailed Standard" section referenced therein.

3.3.7 Gears. All gears shall be constructed from a material suitable for the intended purpose. All drive gears shall have the hardness, surface finish, and toughness that will enable the gear train to transmit full rated torque of the drive motor without gear damage, failure, or premature deterioration and wear.

3.3.8 Electromagnetic interference control. When specified (see 6.2.1), equipment furnished under this specification shall comply with MIL-STD-461. The equipment and subsystems class and the emission and susceptibility requirement shall be as specified.

3.4 Components.

3.4.1 Control console. The control console shall contain all controls and related circuitry necessary for operation and monitoring of the system. Minimum controls and monitoring devices to be furnished are start-stop switch, carriage travel manual-automatic switch, electrode up-down switch, ammeter, voltmeter, and indicator light(S) to indicate when electric power and air are applied to the electrode. Any additional controls normally furnished by the manufacturer shall be included. The control system shall detect when air pressure becomes low, if gouging current or voltage becomes excessively low or high, and if the electrode runs off the work piece. If any of these conditions exist the control system shall immediately stop carriage movement, retract the electrode, and de-energize the air solenoid and contactor. The control console shall be housed in a cabinet of sufficient strength to provide necessary protection.

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3.4.2 Torch. The Torch shall be a mechanized torch designed for use with 5/16 through 3/4 inch diameter electrodes at currents up to 1500 amperes. The torch shall contain an electrode holder, electrode feed mechanism, electrode holder tube, a means to make cutting angle adjustments, and a means to mount the torch to a travel system or fixture.

3.4.2.1 Electrode feed mechanism. The electrode feed mechanism shall maintain control of the electrode under all operating conditions. The control shall be able to respond at sufficient speed to assure accuracy of the cutting depth. The feed mechanism shall allow the electrode to travel in both the up and down direction.

3.4.2.2 Electrode holder tube. The electrode holder tube shall be manufactured of a translucent, non-conductive material and designed to shield the trailing end of the electrode against accidental grounding.

3.4.2.3 Cutting angle adjustment. The angle of the electrode with relation to the workpiece shall be adjustable both vertically and horizontally. The limits of adjustment shall permit positioning of the electrode for optimum gouging and cutting efficiency. The torch shall be equipped with a calibrated inclinometer or other means to assist the operator in adjusting the electrode to the specific angle required for optimum operation.

3.4.3 Carriage. Unless otherwise specified (see 6.2.1), a carriage designed to carry the gouging torch and associated equipment shall be furnished. The type carriage to be furnished shall be selected from 3.4.3.1 and 3.4.3.2. The carriage assembly shall consist of a housing, drive motor, variable speed drive train, controls, track, and any other features necessary to meet the requirements of this specification.

3.4.3.1 Carriage, straight line operation. When specified (see 6.2.1), a carriage designed for straight line operation on a metal track shall be furnished.

3.4.3.2 Carriage, multiposition operation. When specified (see 6.2.1), a carriage designed for multiposition operation on a metal track shall be furnished. The carriage shall be capable of operation in a horizontal, vertical, and overhead position.

3.4.3.3 Carriage housing. The carriage housing shall completely enclose the drive components and shall provide for mounting of the torch. The housing shall be of sufficient strength to provide protection of all internal components and to assure accuracy of gouging and cutting operations.

3.4.3.4 Carriage Drive motor. The carriage drive motor shall be of sufficient size and horsepower to meet maximum operating conditions.

3.4.3.5 Carriage drive. The carriage shall have a variable speed drive system. The speed of the carriage shall be infinitely variable through out the operating range. Unless otherwise specified (see 6.2.1), the operating range shall be from not more than 6 through not less than 60 inches per minute (ipm) in both the forward and reverse direction. The drive mechanism shall be capable of being disengaged for free wheeling and manual positioning of the carriage on the track.

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3.4.3.6 Carriage controls. All controls required for operation and control of the carriage shall be furnished.

3.4.3.7 Carriage Track. The carriage track shall be of sufficient strength and rigidity to provide support for and control of the carriage under all operating conditions. Unless otherwise specified (see 6.2.1), the track shall be furnished in 10 foot sections. The number of sections furnished shall be as specified (see 6.2.1). Track sections shall be provided with positive interlocking ends to insure a tight, solid connection between sections.

3.4.3.7.1 Track holding system. Unless otherwise specified (see 6.2.1), the track sections shall be equipped with magnets of sufficient number and strength to attach and hold the track to the workpiece. When specified (see 6.2.1), a vacuum suction cup system for holding the track to a workpiece shall be furnished.

3.4.4 Electric power cables. Each machine shall be furnished with all electric power cables complete with necessary connectors required for operation at maximum rated power. Unless otherwise specified (see 6.2.1), the length of cables shall be the manufacturers standard length.

3.4.5 Contactor. Each torch shall be equipped with a contactor for applying electric power to the electrode. The contactor shall be designed for mounting on the DC power supply or on the control panel as an integral part of the control system. When designed for mounting on the power supply, the contactor shall be equipped with a remote switch that may be hand carried, permitting the operator to control power to the electrode for a minimum distance of 20 feet from the contactor. If mounted on the control panel, the switch shall be positioned for fingertip control.

3.4.6 Heat shield. When necessary the torch shall be equipped with a heat shield to protect the electrode drive motor and other components from radiated heat and metal spatter.

3.4.7 Air hose. The machine shall be furnished with all hoses and fittings required for operation. When air is not supplied to the torch through the power cables, all necessary hoses complete with fittings shall be furnished. Unless otherwise specified (see 6.2.1), the length of hose furnished shall be the manufacturer's standard length.

3.5 Electrical system. Unless otherwise specified (see 6.2.1), the electrical system shall conform to NFPA 79.

3.6 Electrical power requirements. The electrode drive mechanism and control system shall be designed to operate from a single phase, 60Hz 115 volts source.

3.7 Compressed air requirements. The torch shall meet all requirements specified herein when connected to an air source capable of delivering a maximum of 50 standard cubic feet per minute at a maximum pressure of 65 pounds per square inch.

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3.8 Performance. The machine shall conform to the requirements of this specification and be capable of gouging and cutting grooves in any electrically conductive material. The grooves shall be uniform in depth and width when the machine is working on a flat, irregular, or curved surface. The machine shall meet or exceed the requirements of table I when gouging steel with a carbon content of not less than SAE 1020 steel.

TABLE I. Gouging speed and tolerances.

Electrode Diameter	Groove Depth	Groove Width	Travel Speed	Tolerance(+)	
				Depth	Width
5/16	5/16	3/8	30	0.020	0.063
3/8	3/8	1/2	20	0.025	0.063
1/2	1/2	11/16	24	0.025	0.063
5/8	7/8	7/8	30	0.025	0.063
3/4	3/4	1	22	0.025	0.063

NOTE: All measurements are in inches.

3.9 Additional performance requirements. Performance features required in addition to, or in lieu of, the requirements herein shall be as specified and fully described (see 6.2.1).

3.10 Standard equipment. Unless otherwise specified, all equipment normally furnished with the manufacturer's standard commercial machine shall be furnished. When specified (see 6.2.1), required additional equipment shall be furnished and fully described.

3.11 Optional equipment. Optional equipment shall be furnished as specified and shall be fully described (see 6.2.1).

3.12 Repair parts. Repair parts shall be furnished as specified (see 6.2.1).

3.13 Marking on plates and charts. All words on plates and charts shall be in the English language. Characters shall be engraved, etched, embossed, or stamped in boldface on a contrasting background.

3.14 Lubrication chart or plate. A lubrication chart or corrosion resistant plate shall be securely attached to each machine. If a chart is furnished, it shall be placed in a transparent plastic folder or permanently sealed between clear plastic sheets with suitable means of mounting. Unless otherwise specified (see 6.2.1), the chart or plate shall contain the following information:

Points of lubricant application
 Servicing interval
 Type of lubricant

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3.14.1 Nameplate. A corrosion resistant nameplate shall be securely attached to each machine. Unless otherwise specified (see 6.2.1), the nameplate shall contain the information listed below. If the machine is a special model, the model designation shall include the model of the basic standard machine and a suffix identified in the manufacturer's permanent records. The captions listed may be shortened or abbreviated, provided the entry for each caption is clear as to its identity.

Nomenclature
 Manufacturer's name
 Manufacturer's model designation
 Manufacturer's serial number
 Power input (volts, amps, phase, frequency)
 Date of manufacture
 Contract Number or Order Number
 National Stock Number or Plant Equipment Code (when applicable)

3.15 Hour meter. When specified (see 6.2.1), the machine shall be equipped with an hour meter. The hour meter shall be installed to display accumulated operating time of the machine. The meter shall be of the nonresetting type and shall have a range of 0 to 99,999 hours in increments of not greater than one hour. The meter shall be sealed to prevent the entrance of dust and moisture and shall be mounted to withstand shock and vibration generated by the machine. Upon reaching 99,999 hours, the meter readout shall automatically return to zero and continue to accumulate time.

3.16 Technical data. When technical data is required it shall be furnished in accordance with the requirements of the contract. All technical data furnished shall be written in the English language.

3.17 Workmanship. Workmanship of the machine and accessories shall be commensurate with all requirements specified herein. The machine shall be of a quality equal to that of the manufacturer's commercial equipment of the type specified herein.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspections. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements specified herein. Except as otherwise specified in the contract or purchase order, 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 inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all

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requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

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

- a. First article inspection (see 4.4).
- B. Quality conformance inspection (see 4.5).

4.3 Inspection conditions. Unless otherwise specified herein, all inspections, tests, and examinations shall be performed in the manufacturer's designated indoor test area under the ambient temperature, the relative humidity, and the air pressure existing inside the building at the time the inspections, tests, and examinations are performed.

4.4 First article inspection. When first article inspection is required, it shall be applied to the first article submitted in accordance with 3.1. Unless otherwise specified (see 6.2.1), first article inspection shall consist of the examination in 4.6 and the tests in 4.7.1 and 4.7.2 and when applicable 4.7.3. Failure of the item to pass the first article examination and all tests shall be cause for rejection.

4.5 Quality conformance inspection. A quality conformance inspection shall be applied to each item prior to being offered for acceptance under the contract. Unless otherwise specified (see 6.2.1), the quality conformance inspection shall consist of the examination in 4.6, the test in 4.7.1, and the inspection in 4.8. Failure of the item to pass the examination, the test, and the inspection shall be cause for rejection.

4.6 Examination. The machine shall be visually examined to determine compliance with all requirements of this specification.

4.7 Tests.

4.7.1 Operational test. The complete gouging and cutting machine shall be assembled and connected to the required electric power source and air supply. The carriage shall be operated for a period of not less than five minutes. When a multiposition carriage is furnished, it shall be operated in the horizontal, vertical, and overhead position. The carriage shall meet the requirements of this specification. The complete machine shall be operationally tested by gouging a groove in carbon steel plate as specified in 3.8. The duration of the gouging operation shall be at least one minute.

4.7.2 Cutting test. The machine shall be tested by gouging at least two grooves in carbon steel plate as specified in 3.8. The plate thickness shall be as determined by the manufacturer. The duration of each cut shall be at least two minutes. The electrode diameter and depth of cut shall be in accordance with table II. The performance of the machine shall equal or exceed the requirements of table I.

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TABLE II. Cutting test requirements.

Cut number	Electrode diameter (inches)	Groove depth (inches)
1	3/8	3/8
1	5/8	7/8

4.7.3 Electromagnetic interference control tests. When specified (see 6.2.1), the machine shall be tested for conformance with 3.3.8. The test shall be accomplished in accordance with MIL-STD-462.

4.8 Packaging inspection. Packaging of each item shall be inspected to determine compliance with the requirements of section 5.

5. PACKAGING

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

6. NOTES

6.1 Intended use. Gouging and cutting machines are intended to be used primarily for welding preparation work.

6.2 Ordering data.

6.2.1 Acquisition requirement. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. First article, if required (see 3.1).
- c. If machine design and construction is required in a specific dimensional system (inch/pound or SI), state required system (see 3.2.1).
- d. If measuring and indicating devices are required to be graduated in a specific measurement system (inch/pound or SI), state required system (see 3.2.1.1).
- e. Dual calibrations (inch/pound or SI), if required (see 3.2.1.1.1).
- f. Additional safety and health requirements, if required (see 3.2.5).
- g. Painting, if different (see 3.3.5).

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- h. If electromagnetic interference control is required, specify the equipment and subsystem class and the emission and susceptibility required (see 3.3.8).
- i. If carriage not required, specify (see 3.4.3).
- j. When required, specify type of carriage required (see 3.4.3, 3.4.3.1 and 3.4.3.2)
- k. Carriage operating speed range, if different (see 3.4.3.5).
- l. Length of track sections, if different (see 3.4.3.7)
- m. Number of track sections required (see 3.4.3.7).
- n. Type of track holding system, if different (see 3.4.3.7.1).
- o. Vacuum suction cup track holding system, if required (see 3.4.3.7.1).
- p. Length of electric power cables, if different (see 3.4.4).
- q. Length of air hose, if different (see 3.4.7).
- r. Electrical system, if different (see 3.5).
- s. Additional performance features, if required (see 3.9).
- t. Standard equipment, if different (see 3.10).
- u. Specify and fully describe optional equipment, if required (see 3.11).
- v. Specify applicable repair parts, if required (see 3.12).
- w. Lubrication chart or plate, if different (see 3.14.1).
- x. Nameplate, if different (see 3.14.2).
- y. Hour meter, if required (see 3.15).
- z. First article inspection, if different (see 4.4).
- aa. Quality conformance inspection, if different (see 4.5).
- bb. Electromagnetic interference control test, if required (see 4.7.3).
- cc. If preservation, packing, and marking in accordance with MIL-W-45562 is required, specify level of preservation and packing required (see 5.1).

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6.2.2 Contract data requirements. Required technical data such as operator's manuals, parts lists, wiring diagrams, and acceptance test reports should be specified on a DD Form 1423, Contract Data Requirements List, incorporated into the contract.

6.3 First article. When first article inspection is required, the item to be tested should be the first item offered for acceptance under the contract. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, test, and approval of the first article.

6.4 Cross-reference of classification changes. The machine classification changes from the previous issue of this specification are as follows:

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Size 1 (deleted)	One type - One size
Size 2 (deleted)	

6.5 Subject term (key word) listing.

Arc cutting
Metal cutting

6.6 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodians:
Army - AR
Air Force - 99

Preparing activity:
DLA - IP

(Project 3433-0114)

Review activities:
Navy - AS
Air Force - 84

User activities:
Army - AR
Navy - AS, MC, OS, SH

INSTRUCTIONS: In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (*DO NOT STAPLE*), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

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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DEFENSE LOGISTICS AGENCY

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Defense Industrial Plant Equipment Center
ATTN: DIPEC-SSG
Memphis, TN 38114-5051



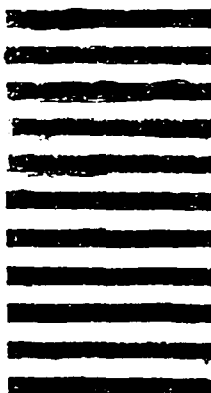
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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER MIL-G-80152B		2. DOCUMENT TITLE Gouging and Cutting Machine, Mechanized, Direct Current, Electric Arc, Portable	
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)	