

MIL-H-10044B(GL)**10 SEPTEMBER 1964****SUPERSEDING****MIL-H-10044A****18 OCTOBER 1952****MILITARY SPECIFICATION****HINGES, CHEST, OFFSET****1. SCOPE**

1.1 Scope. This specification covers one type of steel offset chest hinges.

1.2 Classification. Offset chest hinges shall be of the following sizes as specified (see 6.2):

Sizes

1½ by ⅞-inch
2 by ⅞ inch

*** 2. APPLICABLE DOCUMENTS**

2.1 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.

SPECIFICATIONS**FEDERAL**

QQ-S-698 — Steel, Sheet and Strip, Low-Carbon.

QQ-W-461 — Wire, Steel, Carbon, (Round, Bare and Coated).

QQ-Z-325 — Zinc Coating. Electrodeposited, Requirements for.

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

PPP-B-636 — Box, Fiberboard.

PPP-B-676 — Boxes, Set-up, Paperboard.

MILITARY

MIL-F-116 — Preservation, Methods of.

STANDARDS**MILITARY**

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

MIL-STD-129 — Marking for Shipment and Storage.

MIL-STD-130 — Identification Marking of U.S. Military Property.

DRAWING**ARMY NATICK LABORATORIES**

4-1-85 — Hinges, Chest, Offset.

(Miniature copy of Drawing 4-1-85, identified as figure 1, is attached for information purposes only.)

(Copies of specifications, standards, and drawing required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

*** 3.1 Preproduction sample.** When spec-

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ified (see 6.2), before production is commenced, a sample offset chest hinge shall be submitted or made available to the contracting officer or his authorized representative for approval in accordance with 4.2. The approval of the preproduction sample authorizes the commencement of production, but does not relieve the supplier of the responsibility for compliance with all applicable provisions of this specification. The preproduction sample shall be manufactured in the same facilities to be used for the manufacture of the production item.

3.2 Materials. The materials specified shall conform to the referenced specifications and requirements specified hereinafter.

3.2.1 Steel.

* **3.2.1.1 Steel, carbon, sheet and strip.** Sheet steel shall conform to commercial quality cold rolled, and strip steel shall conform to cold rolled, tempers 4 or 5 of QQ-S-698, as applicable.

* **3.2.1.2 Wire, steel, carbon round.** Round carbon steel wire shall conform to steel numbers 1015 or 1020, practice A or B, finish 1 of QQ-W-461.

* **3.3 Construction.** The construction of the offset chest hinges shall conform to the requirements specified herein, and as shown on Drawing 4-1-85. The hinge leaves shall match to permit freedom of movement without excessive looseness, or any binding. The hinge pin shall be neatly peened and securely fasten the hinge leaves together. All burrs or sharp edges shall be removed.

* **3.4 Finish.** The completely fabricated hinges shall be either hot dipped galvanized or zinc-coated in accordance with type I, class 3 coating of QQ-Z-325. The weight of the coating shall be in accordance with industry practice. The coating shall be smooth, continuous, and free from such imperfections as lumps, blisters, gritty areas, uncoated spots, acid and black spots, dross and flux,

or other defects not consistent with best commercial practice.

* **3.5 Marking for identification.** The offset chest hinges shall be marked with the manufacturer's identification in accordance with MIL-STD-130. The markings shall be legibly stamped or indented, and located on the outer side of the hinges.

* **3.6 Workmanship.** The finished offset chest hinges shall conform to the quality and grade of product established by this specification.

* 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, the supplier may utilize his own facilities or any commercial laboratory acceptable to 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 supplies and services conform to prescribed requirements.

4.2 Preproduction sample inspection. When a preproduction sample is required, it shall be examined in accordance with the classification of defects in table I and dimensions specified.

4.3 Sampling for inspection and acceptance. Sampling for inspection and acceptance shall be performed in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated.

4.3.1 Inspection of materials and components. In accordance with 4.1 above, the supplier is responsible for insuring that materials and components used were manufactured, tested and inspected in accordance with the requirements of referenced sub-

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subsidiary specifications and standards to the extent specified, or if none, in accordance with this specification.

4.3.2 Inspection of the end item. The lot shall consist of all complete hinges of one size offered for inspection at one time. The sample unit for this inspection shall be one completely fabricated hinge.

4.3.2.1 Visual examination. Examination of the hinges shall be in accordance with the classification of defects specified in table I. The inspection level shall be II with an acceptable quality level (AQL) of 4.0 for major defects, and 10.0 for total defects, expressed in terms of defects per hundred units.

TABLE I. *Classification of defects*

Examine	Defect	Classification	
		Major	Minor
Finish	Not zinc-coated (galvanized)	X	
	Not smooth, continuous, and free of lumps, blisters, gritty areas, uncoated spots, acid and black spots, dross and flux		X
Construction and workmanship.	Hinge leaves not matching, or permitting free movement		X
	Hinge pin not peened	X	
Hinge pin	Sharp edge and burrs not removed		X
Marking	Missing, misspelled, illegible, not stamped or indented, incomplete or misplaced		X

4.3.3 Dimensional examination. Inspection shall be made of hinges for compliance with dimensions specified. Any dimension not within specified tolerances shall constitute a defect. The inspection level shall be S-2 with an AQL of 4.0, expressed in terms of defects per hundred units.

termine that packaging, packing, preservation and marking as required by section 5 of this specification are complied with. Defects shall be scored as specified in table II. The sample unit shall be one shipping container fully prepared for delivery. The lot shall be the number of containers offered for delivery at one time. The inspection level shall be S-2 with an AQL of 4.0, expressed in terms of defects per hundred units.

4.3.4 Examination of preparation for delivery. An examination shall be made to de-

TABLE II. *Examination of preparation for delivery*

Examine	Defect
Marking (interior and exterior).	Omitted, incomplete, incorrect, illegible or not in accordance with contract requirements.
Preservation	Preservative improperly applied or missing.
Materials	Component missing, damaged or otherwise defective.
Workmanship	Inadequate application of components such as incomplete closure of container flaps, loose strapping, or tape banding bulging or distortion of containers.
Contents	Number per container is more or less than required.

*** 5. PREPARATION FOR DELIVERY****5.1.1 Level A.**

5.1 Preservation and packaging. Preservation and packaging shall be level A or C as specified (see 6.2).

5.1.1.1 Preservation. Each hinge shall be preserved method I of MIL-F-116.

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5.1.1.2 Packaging. Twenty hinges of one size only, preserved as specified in 5.1.1.1, shall be packaged in a snug-fitting folding or set-up paperboard box conforming to style III or VIII, type B, class a of PPP-B-566; or type I, grade A, class A, style 3 or 4 of PPP-B-676, respectively. Closure shall be in accordance with the appendix of the box specification.

5.1.2 Level C. Hinges shall be preserved and packaged in accordance with the industry's practice.

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

5.2.1 Level A. Two hundred hinges of one size only, preserved and packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to class 2, V3c or V3s, style RSC of PPP-B-636. Closure, waterproofing by means of tape, and reinforcing with flat steel strapping or tape banding shall be in accordance with the appendix of the container specification.

5.2.2 Level B. Two hundred hinges of one size only, preserved and packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard shipping container conforming to type I or II, class 1, style RSC of PPP-B-636. Closure shall be in accordance with the appendix of the container specification.

5.2.3 Level C. Hinges, preserved and packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. Containers shall be in accordance with rules or regulations of carriers applicable to the mode of transportation.

5.3 Marking. In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. The offset chest hinges covered by this specification are intended for use on certain Military toolkit chests or similar items of wooden construction.

*** 6.2 Ordering data.** Procurement documents should specify the following:

- (a) Title, number and date of this specification.
- (b) Size of hinges required (see 1.2).
- (c) When preproduction sample is not required (see 3.1).
- (d) Selection of applicable levels of preservation and packaging and packing (see 5.1 and 5.2).

≠ 6.3 Transportation description. Transportation descriptions and minimum weights applicable to this commodity are —

Rail:

Hinges, Chest, Offset

Carload weight 14,000, 20,000, or 30,000 pounds, subject to Rule 34, Uniform Freight Classification.

Motor:

Hinges, Chest, Offset.

Truckload weight 14,000, 20,000 or 30,000 pounds, subject to Rule 115, National Motor Freight Classification.

6.4 The outside margins of this document have been marked to indicate where changes from the previous issue have been made. An asterisk (*) indicates a substantive change in the paragraph text. The sign (#) indicates the addition of a completely new paragraph. This has been done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content as written irrespective of the marginal notations and relationship to the last previous issue.

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