

MIL-I-3578B

24 September 1974

SUPERSEDING

MIL-P-3578A

21 August 1963

MILITARY SPECIFICATION**INKING PAD, RUBBER STAMP (FOOD INSPECTION, VETERINARY)**

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

1. SCOPE

1.1 This specification covers a hand stamp inking pad for food inspection service.

2. APPLICABLE DOCUMENTS

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

SPECIFICATIONS**FEDERAL**

- | | | | |
|---|-----------|---|--|
| * | TT-I-600 | - | Inking Pad, Rubber Stamp |
| | PPP-B-566 | - | Boxes, Folding, Paperboard |
| * | PPP-B-636 | - | Boxes, Shipping, Fiberboard |
| * | PPP-T-45 | - | Tape, Gummed, Paper, Reinforced and Plain, for
Sealing and Securing |
| * | PPP-T-76 | - | Tape, Pressure-Sensitive, Adhesive, Paper,
(for Carton Sealing) |

STANDARDS**FEDERAL**

- | | | |
|------------|---|---|
| FED-STD-66 | - | Steel: Chemical Composition and Hardenability |
|------------|---|---|

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, standards, drawings and publications 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:

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.)

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.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

3. REQUIREMENTS

- * 3.1 First article. When specified, the supplier shall furnish a sample of the item to be procured under this specification for first article inspection and approval (see 4.3, 6.2, and 6.9).
- * 3.2 Standard product. The inking pad delivered under this specification shall be the manufacturer's commercial product, except for any changes necessary to comply with specification requirements. All like items furnished on any one contract, including parts and subassemblies thereof shall be new and interchangeable.
- * 3.3 Materials. The materials shall be as specified herein. Materials not definitely specified shall be of the quality normally used by the manufacturer in his standard commercial inking hand stamp pad provided the completed item complies with all provisions of this specification.

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3.3.1 Corrosion-resisting steel. Corrosion-resisting steel shall conform to type 301, 302 or 304 of FED-STD-66 (see 4.5).

- * 3.4 Design and construction. Inking pad shall consist of an uninked pad enclosed in a corrosion-resisting steel container equipped with a sliding cover and a movable handle. The design and construction shall be in accordance with the requirements and dimensions specified herein and as shown on figure 1.
- * 3.4.1 Container. The container bottom, cover and handle shall each be fabricated from steel conforming to 3.3.1. The container bottom, cover, and cover handle shall each be formed from one piece of steel not less than 0.030-inch thick. Corner joints shall be soldered (see fig. 1). The container bottom shall not leak when tested as specified in 4.6.
 - 3.4.1.1 Handle for cover. The handle shall be attached to the cover by two loose rivets, one on each side, and shall be capable of enclosing the container in the cover (see fig. 1). The rivets shall be of the same material used to fabricate the container.
- * 3.4.2 Pad. The uninked pad shall conform to type III, class 2 of TT-I-600 except the pad shall be cut to size (see fig. 1), so that the pad shall remain in place in the container without movement and shall be readily replaceable.
- * 3.5 Finish. The entire inside and outside surfaces of the container, cover, and handle shall be finished in accordance with the manufacturer's commercial practice.
- * 3.6 Marking for identification. Each container shall have the manufacturer's identification indented on the outside bottom of the container. The surface opposite the marking shall show no signs of penetration or unevenness, nor shall the markings cause distortion of the adjacent surfaces.
- * 3.7 Workmanship. The container bottom, cover, and handle shall be clean and free from cracks, fractures, sharp edges and corners, slivers, burrs, dents, and surface discoloration. Soldered joints shall be smooth and free from pits and solder flux. The container bottom, cover, and handle shall be free from wrinkles, die marks and waves.

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 supplies and services conform to prescribed requirements.

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- * 4.2 Classification of inspection. The inspection requirements specified herein are classified as follows:
1. First article inspection (see 4.3).
 2. Quality conformance inspection (see 4.4).
- * 4.3 First article. When a first article is required, the inking pad shall be examined as specified in 4.4.2.1 and 4.4.2.2 and tested as specified in 4.6. Any nonconformance shall be cause for rejection of the first article.
- * 4.4 Quality conformance inspection. Except as otherwise specified herein, sampling for inspection shall be performed in accordance with the provisions set forth in MIL-STD-105.
- * 4.4.1 Component and material inspection. The supplier shall insure that all components and materials used are manufactured, examined, and tested in accordance with referenced specifications and standards unless excluded, amended, modified or qualified in this specification or applicable purchase document.
- * 4.4.2 End item inspection. The inspection lot shall be all inking pads offered for inspection at one time.
- * 4.4.2.1 Visual inspection. The inking pad shall be examined for the defects in table I. The inspection level shall be II with an acceptable quality level (AQL) of 2.5 for major defects and 6.5 for total defects, expressed in terms of defects per hundred units.

TABLE I. Classification of visual defects

Examine	Defect	Classification	
		Major	Minor
Finish	Container bottom, cover, or handle not finished in accordance with manufacturer's commercial practice		X
Construction and workmanship	Any characteristic or detail of construction not in accordance with specific requirements	X	
	Container bottom, cover, and handle each not of one piece construction	X	
	Not free from cracks, fractures, sharp edges, and corners, slivers, burrs, dents and surface discoloration	X	
	Soldered joints and corners not smooth and free from pits and solder flux	X	

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TABLE I. Classification of visual defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Construction and workmanship (cont'd)	Wrinkles, die marks, or waves in metal, from forming operations affecting appearance		X
	Pad does not remain in place in container without movement	X	
	Pad not readily replaceable	X	
Identification markings	Omitted; illegible; incorrect; incomplete, not specified size, or not in proper location		X
	Penetration of marking indentation; unevenness or distortion		X

* 4.4.2.2 Dimensional examination. The inking pad shall be examined for compliance with dimensions specified. Any dimension not within the specified tolerance shall be a defect. The inspection level shall be S-1 with an AQL of 6.5 defects, expressed in terms of defects per hundred units.

* 4.4.2.3 End item testing. Sample inking pads shall be tested as specified in 4.6. Failure to pass the test shall be a defect. The inspection level shall be S-1 with an AQL of 6.5 defects, expressed as defects per hundred units.

* 4.4.3 Examination of preparation for delivery. An examination shall be made to determine that packaging, packing, and marking as required by section 5 are complied with. Defects will be as specified in table II. The sample unit shall be one shipping container fully prepared for delivery. ~~The lot shall be the number of shipping containers offered for inspection at one time. The~~ inspection level shall be S-2 and the AQL shall be 1.0 defects per hundred units

* TABLE II. Preparation for delivery defects

Examine	Defect
Markings (exterior and interior containers)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.
Materials	Component missing, damaged, or otherwise defective affecting serviceability.
Workmanship	Inadequate application of components; such as, incomplete closure of case liners or carton flaps, loose strapping, inadequate stapling, bulging or distortion of containers.

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* TABLE II. Preparation for delivery defects (cont'd)

<u>Examine</u>	<u>Defect</u>
Contents (exterior and interior containers)	Number per container is more or less than required.

- * 4.5 Code and standard examination. Certificate of compliance, certified test reports, approval labels or listing marks for codes and standards, as applicable, that are submitted as proof of compliance with specification requirements shall be examined and validated (see 3.3.1).
- * 4.6 Leak test. The container bottom shall be filled with water and after remaining at rest for 5 minutes shall be checked for leaks to determine compliance with the leak requirements of 3.4.1. Any nonconformance shall constitute failure to pass this test.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A.

5.1.1.1 Unit packaging. Each completely fabricated inking pad shall be individually packaged in a snug-fitting paperboard box conforming to style II, type A, class a of FPP-B-566.

- * 5.1.1.2 Intermediate packaging. Six completely fabricated inking pads packaged as specified in 5.1.1.1 shall be packaged in a snug-fitting fiberboard box conforming to type I or II, class 1, style RSC of FPP-B-636. Each box shall be closed by covering all seams full length with strips of tape, ~~minimum 2 inches wide, conforming to FPP-T-36, type I or II, or class 2 of FPP-T-45.~~ The center strip shall extend a minimum of 1-1/2 inches onto the end panels. Alternatively, the bottom flaps may be sealed with adhesive or by metal stitching.

- * 5.1.2 Level C. Completely fabricated inking pads shall be packaged to afford adequate protection against physical damage during shipment from the supplier to the first receiving activity. The package and quantity per package shall be the same as that normally used by the supplier for retail distribution.

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

5.2.1 Level A. Seventy-two inking pads, packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard container conforming to class 2,

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V3c or V3e, style RSC of FPP-B-636. Each shipping container shall be closed, waterproofed, and strapped or banded in accordance with the appendix to the container specification.

5.2.2 Level B. Seventy-two inking pads, packaged as specified in 5.1, shall be packed in a snug-fitting fiberboard container conforming to class 1, type I or II, style RSC of FPP-B-636. The minimum bursting strength of the fiberboard shall be 275 psi. Box closure shall be in accordance with the appendix to the container specification.

* 5.2.3 Level C. Inking pads, packaged as specified in 5.1, shall be packed in accordance with the manufacturer's commercial practice to assure acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The quantity per shipping container shall be the same as that normally used by the supplier for retail distribution. Shipping containers shall conform to Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

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 the requirements of MIL-STD-129.

6. NOTES

6.1 Intended use. The inking pad covered by this specification is intended for use as a component part of the Veterinary Rubber Stamp Kit covered by MIL-R-3842. The stamp pad, in conjunction with the other components of the kit, is used by Veterinary Inspectors to accomplish the stamping of foods of animal origin accepted for use by the Military Services.

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

- (a) Title, number, and date of this specification.
- (b) When a first article is required (see 3.1).
- (c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

* 6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of ASPR 7-104.55. The first article should be a preproduction sample, initial production item or other specific item described under the definition of a first article in the ASPR. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should include specific instructions in all procurement instruments regarding arrangements for inspection and approval of the first article.

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- * 6.4 The margins of this specification are marked with an asterisk (*) to indicate where changes (additions, modifications, corrections, deletions) from previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and suppliers are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

Army - GL
Air Force - 84

Preparing activity:

Army - GL
Project No. 7510-0272

User activities:

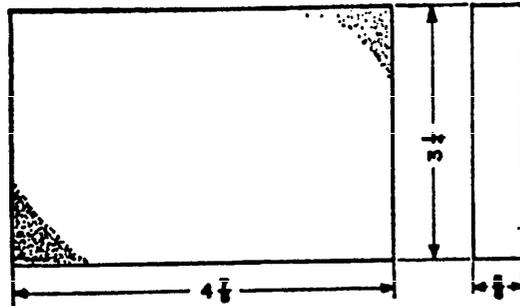
Army - MD
Navy - MS, SH, SA
Air Force - 03

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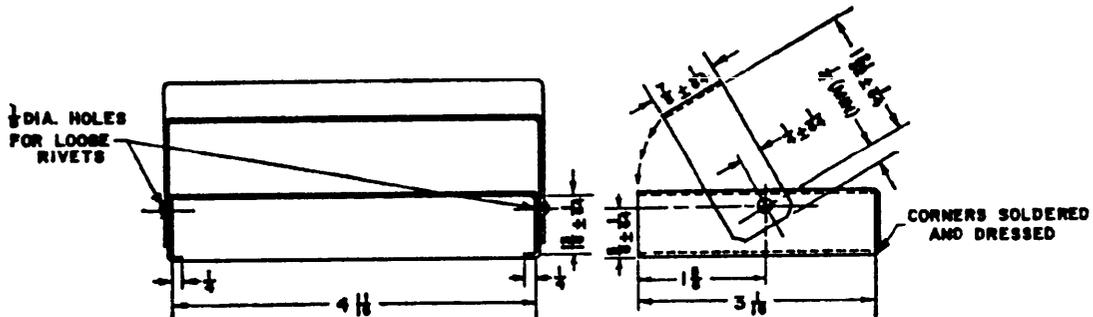
INKING PAD

PART NO.	PART NAME
1	REFILL, FOAM RUBBER
2	CONTAINER, BOTTOM
3	CONTAINER, COVER

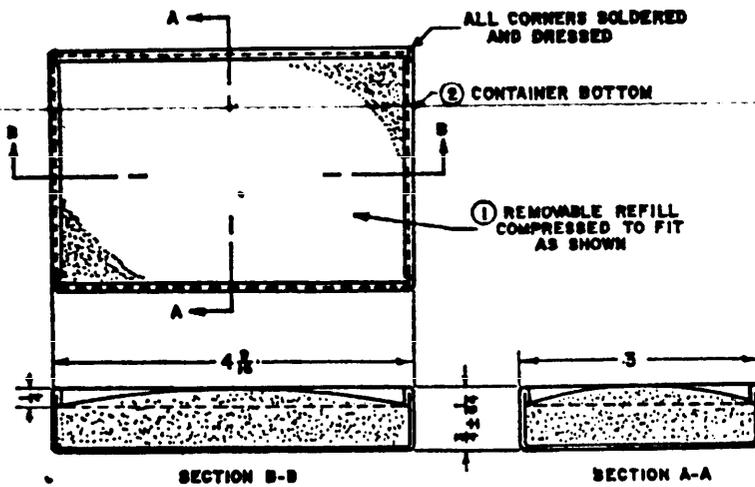
- NOTES: 1. ALL DIMENSIONS IN INCHES.
 2. TOLERANCE, $\pm \frac{1}{32}$ UNLESS OTHERWISE INDICATED.
 3. METAL THICKNESS, 0.030-INCH MINIMUM THROUGHOUT.



REFILL, FOAM RUBBER



③ CONTAINER COVER



INKING PAD (WITHOUT COVER)

FIGURES I.—Inking Pad, Rubber Stamp, Food Inspection, Veterinary

FOLD

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