

MIL-P-12851D
9 June 1971

SUPERSEDING
MIL-P-12851C
1 November 1967

MILITARY SPECIFICATION

PAN, BAKING AND ROASTING, RECTANGULAR: WITH HANDLES

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

1. SCOPE

1.1 This specification covers an aluminum, rectangular, baking and roasting pan equipped with handles.

2. APPLICABLE DOCUMENTS

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

SPECIFICATIONS

FEDERAL

- QQ-A-225/5 - Aluminum Alloy Bar, Rod, and Wire (Rolled or Drawn), 2017
- QQ-A-250/8 - Aluminum Alloy, 5052, Plate and Sheet
- QQ-W-461 - Wire, Steel, Carbon, (Round, Bare and Coated)
- PPP-B-636 - Box, Fiberboard
- PPP-F-320 - Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes

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- MIL-T-10727 - Tin Plating; Electrodeposited or Hot Dipped, For Ferrous or Non Ferrous Metals

STANDARDS

FEDERAL

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

FSC 7330

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- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized and Containerized Unit Loads, 40" x 48" Pallets, Skids, Runners, or Pallet-Type Base

DRAWING

ARMY NATICK LABORATORIES

- 2-9-137 - Pan, Baking and Roasting, Rectangular; With Handles.

(A miniature copy of Drawing No. 2-9-137, identified as figure 1, is attached for information purposes only.)

(Copies of specifications, standards, and drawings, 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 otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply.

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT

National Motor Freight Classification

(Application for copies should be addressed to American Trucking Associations, ATTN: Tariff Order Section, 1616 P Street, N. W. Washington, D.C. 20036).

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 202 Union Station 516 W. Jackson Blvd. Chicago, Illinois 60606).

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

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3. REQUIREMENTS

* 3.1 First article.- When specified (see 6.2), the supplier shall furnish a sample for first article inspection and approval (see 4.2 and 6.4).

3.2 Materials.-

3.2.1 Aluminum.-

3.2.1.1 Sheet.- Aluminum alloy sheet shall be temper 0 conforming to QQ-A-250/8.

3.2.1.2 Wire and rod.- Aluminum alloy wire and rod shall conform to QQ-A-225/5.

3.2.2 Carbon steel.-

3.2.2.1 Sheet and strip.- Carbon steel sheet and strip shall conform to the chemical composition of any steel number from 1009 through 1020 of FED-STD-66.

3.2.2.2 Wire.- Carbon steel wire shall be finish 1, conforming to QQ-W-461.

3.2.3 Corrosion-resisting steel.-

3.2.3.1 Sheet, strip, and wire.- Corrosion-resisting steel sheet, strip, and wire shall conform to the chemical composition of any AISI steel number in the 300 series of FED-STD-66.

3.3 Design and construction.- The design and construction of the pan covered herein shall conform to the requirements of this specification and as shown on Drawing No. 2-9-137. When aluminum is used for the clips, the clips may be attached to the body by continuous fillet welding or a minimum of two spot welds. The pan body shall be of one-piece construction.

3.4 Finish.-

3.4.1 Body.- The pan body, including rivets or welds, as applicable, shall be finished in accordance with the manufacturer's standard commercial practice. All scratches deep enough to impede the progress of a fingernail when drawn across the scratch shall be removed.

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* 3.4.2 Handles and clips.— The carbon steel handle loops and clips shall be tin plated in accordance with type I (electrodeposited) or type II (hot-dipped) of MIL-T-10727. The minimum coating thickness shall be 0.0005 inch for type I plating and 0.00015 inch for type II plating. Corrosion-resisting steel and aluminum handles and clips shall be finished in accordance with the manufacturer's commercial practice.

3.5 Marking.— The letters "U.S." and the manufacturer's name, trade name, or trademark, of such known character as to be easily identifiable with the manufacturer, shall be indented on the pan as shown on Drawing No. 2-9-137.

* 3.6 Workmanship.— The finished pan shall be clean and shall not contain any rough or sharp edges, burrs, slivers, or scratches, rough die or grind marks, gouges, pits, rust or scale. Identification marking shall not cause unevenness, penetration, or distortion on the surface of the pan opposite the marking. The finished item shall not be fractured, buckled, bent, punctured, or damaged.

3.6.1 Riveting.— All rivet holes shall be accurately punched or drilled and all metal preventing proper setting of rivets shall be removed. Only low profile type (brazier head) rivets properly affixed and without open joints and seams shall be used to attach the clips to the pan body. Rivets shall be peened with heads in full contact with adjacent metal surfaces.

3.6.2 Welding.— Welding shall be complete, smooth, and uniform. Scale, excess flux, pits, and slag shall be removed. Welds shall not be cracked, fractured, or burned through.

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 this specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

* 4.2 First article.— When a preproduction sample is required, it shall be examined for the defects listed in table I and dimensions specified. The presence of any defects listed in table I or any dimension not within specified requirements shall be cause for rejection of the preproduction sample.

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4.3 Inspection.- Sampling for inspection shall be performed in accordance with MIL-STD-105, except where otherwise indicated hereinafter.

4.3.1 Component and material inspection.- In accordance with 4.1, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, standards, and drawings unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

4.3.2 End product inspection.- The inspection lot shall consist of all completely fabricated pans offered for inspection at one time. The sample unit shall be one pan.

- * 4.3.2.1 Visual examination.- Examination shall be made of the pans for the defects listed in table I. The inspection level shall be II with acceptable quality levels (AQL's) of 2.5 for major defects and 6.5 for total defects, expressed in terms of defects per hundred units.

* TABLE I.- Classification of Defects

Examine	Defect	Classification	
		Major	Minor
Finish	Not natural finish	X	
Body	Scratches on pan body which impede progress of fingernail when drawn across scratch	X	
Handles and Clips (carbon steel)	Dirt, oil, grease, or other foreign matter not removed Area of no coating	X	X
Construction and workmanship (applicable to all components and assemblies)	Any rough or sharp edges, burrs, slivers, or scratches, rough die or grind marks, gouges, pits, rust, or scale Any component missing, bent, buckled, fractured, punctured, or malformed	X	
Rivets (when applicable)	Rivet heads not in full contact with adjacent metal surfaces Not properly peened Not properly set	X X X	

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* TABLE I.- Classification of defects (cont'd)

Examine	Defect	Classification	
		Major	Minor
Welding (when applicable)	Not welded as specified	X	
	Missing, incomplete, burn holes, cracked, or fractured	X	
	Pitted, scale, excess flux or slag not removed	X	
Marking	Incomplete, missing, not located as specified, illegible, incorrect		X
	Surface opposite marking uneven or distorted		X

4.3.2.2 Dimensional examination.- Examination shall be made of the pan for defects in dimensions. Any dimension not within specified requirements shall be classified a defect. The inspection level shall be S-2 with an AQL of 4.0, expressed in terms of defects per hundred units.

4.3.3 Examination of preparation for delivery.- An examination shall be made to determine that packing and marking, as required by section 5 of this specification are complied with. Defects shall be as indicated in table II. The lot shall be the number of containers offered for inspection at one time. The sample unit shall be one shipping container fully prepared for delivery. The inspection level shall be S-2 with a AQL of 6.5, expressed in terms of defects per hundred units.

TABLE II.- Examination of preparation for delivery

Examine	Defect
Marking	Omitted; incorrect; illegible; of improper size, sequence, or method of application.
Materials	Component missing or damaged
Contents	Number per container is more or less than required

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4.3.3.1 Examination of shipping containers.- When shipping containers are required to be in accordance with PPP-B-636, examination for defects in closure, waterproofing, and strapping shall be in accordance with PPP-B-636.

4.3.4 Examination of palletization.- An examination shall be made to determine that palletization is in compliance with section 5 of this specification. Defects shall be as indicated in table III. The sample unit for this examination shall be one palletized unit load ready for shipment. The lot shall be the number of palletized unit loads submitted for inspection at one time. The inspection level shall be S-1 with an AQL of 6.5 expressed in terms of defects per hundred units.

TABLE III.- Examination of Palletization

<u>Examination</u>	<u>Defect</u>
Finished dimension	Length, width, or height exceeds specified maximum requirements.
Palletization	Not as specified. Pallet pattern not as specified. Interlocking of loads not as specified. Load not bonded with required straps specified.
Weight	Exceeds maximum load limits.
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.

5. PREPARATION FOR DELIVERY

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

* 5.1.1 Level A.- Twelve pans shall be packed in a snug-fitting fiber-board shipping container conforming to style RSC, V2s or PPP-B-636. Each shipping container shall be provided with built-up pads fabricated from V3c or V3s of PPP-F-320 to protect the handles. Closure, waterproofing by means of tape, and reinforcing with flat strapping or tape banding shall be in accordance with the appendix of PPP-B-636.

5.1.2 Level B.- Twelve pans shall be packed in a snug-fitting fiber-board shipping container conforming to style RSC, type CF, variety SW, or type SF, class domestic of PPP-B-636. Each shipping container shall

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be provided with built-up pads fabricated from the same material as the shipping container to protect the handles. Closure shall be in accordance with method II of the appendix of PPP-B-636.

- * 5.1.2.1 When specified (see 6.2), the shipping container shall be V3c, V3s, or V4s fabricated and closed in accordance with PPP-B-636.
- * 5.1.3 Level C.- Pans 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 Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.
- * 5.2 Palletization.- Unless otherwise specified (see 6.2) pans packed as specified shall be palletized in accordance with Load Type I of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.
- * 5.3 Marking.- In addition to any special marking required by the contract or purchase order, shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use.- The aluminum pan covered by this specification is intended for use as a baking and roasting pan and is a component of the range outfit covered by MIL-R-14601.

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, 4.2, and 6.4).
- (c) Selection of applicable level of packing (see 5.1).
- (d) When a weather-resistant grade fiberboard shipping container is required for level B shipment (see 5.1.2.1).
- (e) When palletization is not required (see 5.2).

- * 6.3 The margins of this specification have been marked with an asterisk (*) to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for

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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.

6.4 First article.- When a first article is required, it shall be inspected and approved under the appropriate provisions of paragraph 7-104.55 of the Armed Services Procurement Regulations. The first article should be a preproduction sample. The first article should consist of one unit. The contracting officer should include specific instructions in all procurement instruments, regarding arrangements for inspection and approval of the first article.

Custodians:

Army - GL
Navy - SA
Air Force - 84

Preparing activity:

Army - GL
Project No. 7330-0366

Review activities:

Army - MD
Navy - MC, MS

User activities:

Navy - YD, CG

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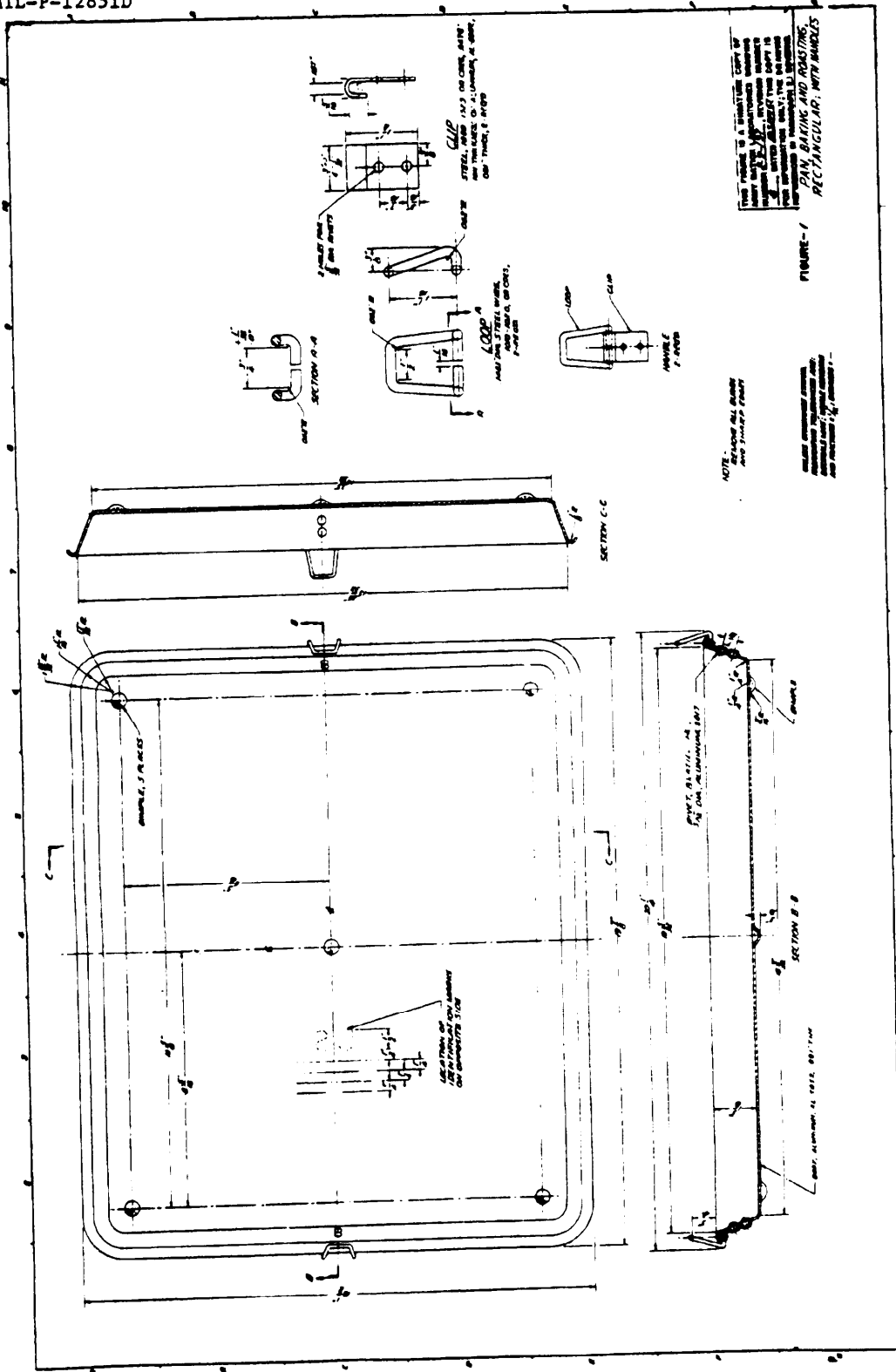


FIGURE-1 PAN, BAKING AND ROASTING, RECTANGULAR, WITH HANDLES

SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
<p>INSTRUCTIONS: This sheet is to be filled out by personnel, either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.</p>		
<p>SPECIFICATION Pan, Baking And Roasting, Rectangular: With Handles MIL-P-12851D</p>		
<p>ORGANIZATION</p>		
<p>CITY AND STATE</p>		<p>CONTRACT NUMBER</p>
<p>MATERIAL PROCURED UNDER A <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT</p>		
<p>1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? A. GIVE PARAGRAPH NUMBER AND WORDING.</p>		
<p>B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES</p>		
<p>2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID</p>		
<p>3. IS THE SPECIFICATION RESTRICTIVE? <input type="checkbox"/> YES <input type="checkbox"/> NO (If "yes", in what way?)</p>		
<p>4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)</p>		
<p>SUBMITTED BY (Printed or typed name and activity - Optional)</p>		<p>DATE</p>

DD FORM 1426
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REPLACES EDITION OF 1 OCT 64 WHICH MAY BE USED.

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