MIL-S-1285D
15 April 1974

SUPERSEDING
MIL-S-1285C
12 October 1965

MILITARY SPECIFICATION

SPOUT, CAN, FLEXIBLE

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

1. SCOPE

1.1 This specification covers one type of flexible can spout for 5-gallon cans.

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

PPP-B-601	- Boxes, Wood, Cleated-Plywood.
PPP-B-636	- Boxes, Shipping, Fiberboard.

Military

MIL-P-116	- Preservation-Packaging, Methods of.
MIL-C-1283	- Can, Gasoline, Military, 5-Gallon.

STANDARDS

Military

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

DRAWINGS

ME

TA13219E2600	- Spout, Can, Flexible.

(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 the American Trucking Associations, Inc., ATTN: Tariff Order Section, 1616 P Street NW, Washington, DC 20036.)

UNIFORM CLASSIFICATION COMMITTEE, AGENT

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, ATTN: Tariff Publishing Officer, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

3. REQUIREMENTS

3.1 Description. The flexible can spout shall be in accordance with Top Assembly TA13219E2600 and as specified herein.

3.1.1 Drawings. The drawings forming a part of this specification are end product drawings. No deviations from the prescribed dimensions or tolerances is permissible without prior approval of the contracting officer. Any data (e.g. shop drawings, layouts, flow sheets, processing procedures, etc.) prepared by the supplier or obtained from a vendor to support fabrication and manufacture of the production item shall be made available, upon request, for inspection by the contracting officer or his designated representative.

3.2 First article (first-produced model). The supplier shall furnish one or more spouts as specified (see 6.2), for examination and testing within the time frame specified (see 6.2), to prove prior to starting production, that his production methods will produce spouts that comply with the requirements of this specification. Examination and tests shall be as specified in Section 4 and shall be subject to surveillance and approval by the Government (see 6.3).

3.3 Material. Material shall be as specified herein and as shown on the applicable drawings. Materials not specified shall be selected by the supplier and shall be subject to all provisions of this specification.

3.4 Construction. The construction of all components and assemblies of the flexible spout covered by this specification shall conform to the requirements specified herein and the design, dimensions and material classification, shown on Top Assembly TA13219E2600.

3.5 Flexible tubing. The flexible tubing shall be full four-wall-interlocked, asbestos-packed, 0.015-inch electro-galvanized steel, 32 to 40 convolutions per foot. Packing shall be Grade 10 cut, 2 ply asbestos (80 percent asbestos and 20 percent organic). The flexible tube shall be cemented to the sleeve specified and as shown in the drawing, and shall show no evidence of gasoline leakage when tested as specified in 4.5.2.1.

3.6 Flexibility. The flexible spout assembly shall be capable of flexing a minimum of 60 degrees without binding or straining the convolutions when tested as specified in 4.5.2.2.

3.7 Cam assembly. The cam assembly shall consist of components specified in the drawing and shall be assembled as shown on the drawing. The assembly shall be capable of locking the spout when inserted in place into the cam. The cam shoulder rivets shall pass through the cam and be securely fastened to the inside of the sleeve as shown on the drawing, and shall show no evidence of leaking when tested as specified in 4.5.2.1.

3.8 Finish. Each steel component part except the flexible tubing, neck, and cap, shall be zinc-plated prior to assembly, and as specified on the drawing.

3.9 Marking for identification. Each cam lever shall be permanently stamped with the letters "US" in characters 1/4 inch high and the supplier's identification of such known character as to be identifiable in the location shown on the drawing.

3.10 Workmanship. The finished flexible spout shall conform to the quality and grade of product established by this specification. There shall be no evidence of scale, burrs, cracks, or warped surfaces. All sharp edges and corners shall be removed.

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.

4.1.1 Component and material inspection. The supplier is responsible for insuring that components and materials used are manufactured, examined, and tested in accordance with referenced specifications and standards.

4.2 Classification of inspections. Inspections shall be classified as follows:

(a) First-produced spout inspection (see 4.3).
(b) Quality conformance inspection (see 4.4).
(c) Inspection of preparation for delivery (see 4.6).

4.3 First-produced spout inspection.

4.3.1 Examination. The first-produced spout shall be examined as specified in 4.5.1. Presence of one or more defects shall be cause for rejection.

4.3.2 Tests. The first-produced spout shall be tested as specified in 4.5.2.1 and 4.5.2.2. Failure of either test shall be cause for rejection.

4.4 Quality conformance inspection.

4.4.1 Sampling. Sampling for examination and tests shall be in accordance with MIL-STD-105.

4.4.2 Examination.

4.4.2.1 Samples. Samples selected in accordance with 4.4.1 shall be examined for the major and minor defects specified in 4.5.1. Acceptable Quality Level (AQL) shall be 2.5 percent defective for major defects and 10.0 percent defective for minor defects.

4.4.3 Tests.

4.4.3.1 Samples. Samples selected in accordance with 4.4.1 shall be tested as specified in 4.5.2.1 and 4.5.2.2. Inspection Level shall be S-2. AQL shall be 4.0 percent defective.

4.5 Inspection procedure.

4.5.1 Examination. The spout shall be examined as specified herein for the following defects:

Major

101. Dimensions not as specified.
102. Material not as specified.
103. Construction not as specified.
104. Flexible tubing not as specified.
105. Cam assembly not as specified.
106. Zinc-plating not as specified.
107. Workmanship not as specified.

Minor

201. Identification marking missing, incomplete, in wrong location, wrong size, illegible or not permanent.

4.5.2 Tests.

4.5.2.1 Functional leak. Two 5-gallon cans conforming to MIL-C-1283 shall be used. The spout shall be flexed 60 degrees and installed in the pouring position in can Number 1, containing 5 gallons of gasoline. The 5 gallons of gasoline shall be transferred through the spout to can Number 2. The spout shall be removed from can Number 1, rotated 90 degrees relative to its previous position and installed in can Number 2. The spout shall be flexed 60 degrees to the pouring position, and the fuel shall be transferred back to can Number 1. This test shall be repeated through the full 360 degrees a total of four times. Evidence of gasoline dripping from the convolutions or between the spout assembly and the can shall constitute failure of the test.

4.5.2.2 Flexibility. The flexible spout shall be placed in a holding device and shall be flexed 60 degrees four times at each 90 degree position around its center line. Evidence of binding or straining of the convolutions shall be cause for failure of the test.

4.6 Inspection of preparation for delivery.

4.6.1 Quality conformance inspection of pack.

4.6.1.1 Unit of product. For the purpose of inspection, a completed pack prepared for shipment shall be considered a unit of product.

4.6.1.2 Sampling. Sampling for examination shall be in accordance with MIL-STD-105.

4.6.1.3 Examination. Samples selected in accordance with 4.6.1.2 shall be examined for the following defects. AQL shall be 2.5 percent defective.

108. Materials, method, or containers not as specified. Each incorrect material, method, or container shall constitute one defect.
109. Intermediate packaging not as specified.
110. Strapping not zinc-coated for Level A.
111. Marking illegible, incorrect, incomplete, or missing.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A.

5.1.1.1 Unit package. Each spout shall be preserved in accordance with MIL-P-116, Method IC-1.

5.1.1.2 Intermediate packaging. Spouts preserved as specified in 5.1.1.1 shall be intermediate packaged, in quantities of 10, in close-fitting boxes conforming to PPP-B-636, W6c, style optional. Closure of the boxes shall be in accordance with the appendix to the box specification, Method V. Strapping shall not be required.

5.1.2 Level C. Spouts shall be preserved and packaged to afford protection against deterioration and damage during shipment and handling from the supplier to the first receiving activity. The supplier may use his standard practice when it meets these requirements.

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

5.2.1 Level A. Spouts, preserved and packaged as specified in 5.1, shall be packed in close-fitting boxes conforming to PPP-B-601, Overseas Type, style optional, Grade B. Strapping shall be zinc-coated.

5.2.2 Level B. Packing shall be as specified for Level A, except that boxes shall be domestic type and strapping will not be required to be zinc-coated. As an alternate for small quantities, close-fitting boxes conforming to PPP-B-636, V3c, V11c, V13c, or V15c, style optional, shall be used when the quantities required do not exceed the weight limitation of the boxes.

5.2.3 Level C. Spouts, preserved and packaged as specified in 5.1 shall be packed to insure carrier acceptance and safe delivery to destination at the lowest rating in compliance with Uniform Freight Classification rules or National Motor Freight Classification rules.

5.3 Marking. Marking shall be in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. The flexible spout covered by this specification is intended for pouring liquid petroleum products from 5-gallon containers conforming to MIL-C-1283.

6.2 Ordering data. Procurement documents should specify the following:

(a) Title, number and date of this specification.
(b) Time frame required for submission of first-produced flexible spout, and number of spouts required (see 3.2).
(c) Level of preservation and packaging and level of packing required (see 5.1 and 5.2).

6.3 First-produced model. Any changes or deviations of production spouts from the approved first-produced model during production will be subject to the approval of the contracting officer. Approval of the first-produced model will not relieve the supplier of his obligation to furnish spouts conforming to this specification.

Custodians:

Army - ME
Navy - YD
Air Force - 84

Review activity:

Army - MD

User activity:

Army - GL
Navy - SH

Preparing activity:

Army - ME

Project No. 7240-0187

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

OMB Approval
No. 22-R255

INSTRUCTIONS: The purpose of this form is to solicit beneficial comments which will help achieve procurement of suitable products at reasonable cost and minimum delay, or will otherwise enhance use of the document. DoD contractors, government activities, or manufacturers vendors who are prospective suppliers of the product are invited to submit comments to the government. Fold on lines on reverse side, staple in corner, and send to preparing activity. 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. Attach any pertinent data which may be of use in improving this document. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity.

DOCUMENT IDENTIFIER AND TITLE MIL-S-1285D Spout, Can, Flexible

NAME OF ORGANIZATION AND ADDRESS	CONTRACT NUMBER
	MATERIAL PROCURED UNDER A ☐ DIRECT GOVERNMENT CONTRACT ☐ SUBCONTRACT

1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?
   A. GIVE PARAGRAPH NUMBER AND WORDING.

   B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2. COMMENTS ON ANY DOCUMENT REQUIREMENT CONSIDERED TOO RIGID

3. IS THE DOCUMENT RESTRICTIVE?

   ☐ YES ☐ NO *(If "Yes", in what way?)*

4. REMARKS

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