

MIL-S-12875B
4 March 1969
SUPERSEDING
MIL-S-12875A(1)
30 June 1958

MILITARY SPECIFICATION
SHEETS, PERFORATED, METAL

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

1. SCOPE

1.1 Scope. This specification covers seven types of metal perforated sheets.

1.2 Classification. The sheets covered by this specification and the respective base sheet specifications shall be as specified (see 6.2) and are as follows:

- Type I - Brass:
 - Class a - QQ-B-613
 - Class b - QQ-B-639
- Type II - Aluminum Alloy:
 - Class a - QQ-A-250/2
 - Class b - QQ-A-250/8
- Type III - Tinplate: QQ-T-425
- Type IV - Terne Sheet: QQ-T-191
- Type V - Sheet Steel: QQ-S-698
 - *Zinc coatings (Finish No. 1.9, MIL-STD-171)
- Type VI - Nickel-Copper Alloy: QQ-N-281
- Type VII - Steel, Sheet and Strip, Low-Carbon: QQ-S-698
 - Class a - Hot rolled
 - Class b - Cold rolled

*Procurement documents to specify (see 6.2).

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2. APPLICABLE DOCUMENTS

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

SPECIFICATIONS

FEDERAL

- QQ-A-250/2 - Aluminum Alloy 3003, Plate and Sheet.
- QQ-A-250/8 - Aluminum Alloy, 5052, Plate and Sheet.
- QQ-B-673 - Brass, Leaded and Non-Leaded, Plate, Rolled Bar, Sheet and Strip.
- QQ-B-639 - Brass, Naval, (Flat Products), Plate, Bar, Sheet and Strip.
- QQ-N-281 - Nickel-Copper-Alloy Bar, Plate, Rod, Sheet, Strip, Wire, Forgings and Structural and Special Shaped Sections.
- QQ-S-698 - Steel, Sheet and Strip, Low-Carbon.
- QQ-T-191 - Terne Sheet (Long and Short Ternes).
- QQ-T-425 - Tinplate (Hot Dip and Electrolytic).

MILITARY

- MIL-C-3993 - Copper and Copper Base Alloy Mill Products, Packaging of.

STANDARDS

MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
- MIL-STD-129 - Marking for Shipment and Storage.
- MIL-STD-163 - Steel Mill Products Preparation for Shipment and Storage.
- MIL-STD-171 - Finishing of Metal and Wood Surfaces.
- MIL-STD-649 - Aluminum and Magnesium Products Preparation for Shipment and Storage.

(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.)

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2.2 Other publications. The following document forms 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.

UNIFORM CLASSIFICATION COMMITTEE

Uniform Freight Classification

(Application for copies of these ratings, rules and regulations should be addressed to Uniform Classification Committee, 202 Union Station, 516 West Jackson Boulevard, Chicago, Illinois 60606.)

3. REQUIREMENTS

3.1 Material. All materials used in the manufacture of the sheets shall conform to the specifications and applicable drawings forming a part of this specification (see 6.2).

3.2 Manufacture. The sheets shall be manufactured as specified on the applicable drawing and procurement document.

3.3 Perforations.

3.3.1 Size and arrangement. The size and arrangement of the perforations shall be as specified on the applicable drawing or procurement document.

3.3.2 Imperfections. The perforated sheets shall be kept in the same condition in which the unperforated sheets were received (see 3.5).

3.4 Unperforated sheet.

3.4.1 Size. The size of the sheets shall be as specified in the material specification (2.1) or procurement document. Tolerances in sizes allowed in the material specifications shall apply to the perforated sheets furnished under this specification.

3.4.2 Thickness. The thickness of the unperforated sheet shall be as specified in the material specification and procurement document.

3.5 Workmanship. The perforated sheets shall be free from foreign matter (dirt, oil or grease) and damage such as cracks, or deformation which could affect their use.

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4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection.

4.1.1 Supplier's responsibility. 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 specified requirements.

4.1.2 Objective evidence. The supplier shall provide objective evidence acceptable to the contracting officer that the requirements of 3.1 and section 5 for which specific inspection has not been provided in this specification have been satisfied.

4.2 Quality conformance inspection.

4.2.1 Lotting. A lot shall consist of the perforated sheets produced by one manufacturer, at one plant, from the same materials, under essentially the same manufacturing conditions. However, no more than one lot of unperforated sheets shall be represented in any one lot of finished perforated sheets.

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

4.2.3 Inspection procedure.

4.2.3.1 For examination. Sample perforated sheets shall be examined in accordance with the classification of defects and MIL-STD-105.

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4.2.3.2 Classification of defects.(a) Sheet, perforated, metal (Dwg as specified (see 6.2)).

<u>Categories</u>	<u>Defects</u>
<u>Critical:</u>	None defined
<u>Major:</u>	AQL 1.0 percent defective
101	Perforations missing, incomplete, or wrong size
102	Perforations incorrectly located
103	Sheet size incorrect
104	Sheet thickness incorrect
105	Burrs or rough edges
106	Workmanship (3.5)
<u>Minor:</u>	AQL 2.5 percent defective
201	Protective finish missing (when applicable)

5. PREPARATION FOR DELIVERY

5.1 Preservation, packaging and packing. Perforated sheet of type ordered (see 6.2) shall be prepared for delivery in the level specified (see 6.2) as applicable as noted below:

- Type I - In accordance with MIL-C-3993
- Type II - In accordance with MIL-STD-649.
- Type III to VII - In accordance with MIL-STD-163.

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

6. NOTES

6.1 Intended use. The metal perforated sheets are for use in the manufacture of canisters, grills, strainers and similar items.

6.2 Ordering data. Procurement documents should specify the following:

- (a) The title, number and date of this specification.
- (b) The title, number and date of the applicable drawing.

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- (c) The size and thickness of unperforated sheet if not on drawing.
- (d) The type and class sheet required.
- (e) The level of preservation, packaging and packing required.

Custodians:

Army - MU
Navy - SH

Preparing activity:

Army - MU(EA)

Project No. 9515-0098

Review activity:

Navy - SH, AS, OS

User interest:

Army - ME, MI, GL, MR