GENERAL SERVICES ADMINISTRATION

HHH–C–571a
23 March 1954

SUPERSEDING
Int. Fed. Spec. HHH–C–00571 (GSA-FSS)
31 August 1953, and
Fed. Spec. HHH–C–571
31 March 1931

FEDERAL SPECIFICATION
COFFEE

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. CLASSIFICATION
1.1 Types and qualities.—Coffee covered by this specification shall be of the following types and qualities, as specified:
Type I.—Green, whole bean
  A. Santos
  B. Colombian
Type II.—Roasted, whole bean
  A. From type I–A
  B. A blend from type I–A and type I–B
Type III.—Roasted, ground
  A. From type II–A
  B. From type II–B

2. APPLICABLE SPECIFICATIONS AND OTHER PUBLICATIONS
2.1 Specifications.—There are no other specifications applicable to this specification, except those referenced in section 7 by individual departments.

2.2 Other publications.—The following publications, of the issues in effect on date of invitation for bids, form a part of this specification:
Governmental:
  Simplified Practice Recommendation R231–48 for Coffee Grinds.
Nongovernmental:
  Official Methods of Analysis of the Association of Official Agricultural Chemists.

3. REQUIREMENTS
3.1 Type I, green, whole, bean.
3.1.1 Type I–A.—This quality shall be Bourbon, medium to good bean, good roast, strictly soft, solid bean, greenish color, good cup quality. The grade shall be Santos 4's or 3's and 4's, according to the New York Coffee and Sugar Exchange Standard.
3.1.2 Type I–B.—This quality shall be of usual good quality Colombians of one or any
combination of the following growths: Medellín excelso, Manizales excelso, Armenia excelso, Girardot excelso, Servilla excelso.

3.2 Type II, roasted, whole bean.—The green coffee shall be thoroughly cleaned, roasted in accordance with good commercial practice without the addition of water except in sufficient quantity to prevent burning, and thoroughly stoned. An excess of 1 gallon of water per 100 pounds of green bean should not be considered good commercial practice.

3.2.1 Type II-A.—This type shall be type I-A, roasted in accordance with 3.2.

3.2.2 Type II-B.—This type shall be a blend of type I-A and type I-B in the proportion as specified, and shall be roasted in accordance with 3.2. The coffee shall be medium roast, of high quality, rich, full body, medium to sharp acidity and have an excellent flavor and aroma.

3.3 Type III, roasted, ground.—Unless otherwise specified, the coffee shall be drip grind in accordance with Simplified Practice Recommendation R231-48. Type III-A quality shall be ground from the whole bean quality II-A and type III-B shall be ground from II-B.

3.4 Federal Food, Drug, and Cosmetic Act.—All deliveries shall conform in every respect to the provisions of the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder.

3.5 Workmanship.—Coffee, bulk, bagged, or repackaged, shall be held and handled under sanitary conditions in accordance with good commercial practice.

4. SAMPLING, INSPECTION, AND TEST PROCEDURES

4.1 Sampling.

4.1.1 Green bean.—Each individual lot or chop shall be sampled.

4.1.2 Roasted whole bean and roasted ground.—Representative samples shall be taken from the delivery, if desired, and at the roasting plant during operation to determine compliance with the requirements.

4.2 Inspection.

4.2.1 General.—Inspection shall be made by the procuring agency or duly authorized representative at the time and place designated by the procuring agency. It may be made at any suitable point in transit or after delivery to the point of destination in either or both the green bean state or roasted, as specified.

4.2.2 Final inspection.—Unless otherwise specified, final inspection shall be made at point of destination.

4.2.3 GSA procedure utilizing commercial roasting.—The award shall be based upon a bid sample of one pound of whole green bean, properly identified to show the growth, grade and invitation number and, if a blend, the amounts of Santos and Colombian coffees. About one-half of the sample is used by the Government agency making test in performing the necessary tests and the other half is retained for future tests. A sample from the contract coffee freshly roasted is taken by an inspector after first having verified the identity of the green bean. The Government agency making test is notified to roast the remainder of the bid sample at the same time, thus permitting a comparison of the contract sample against the bid sample on hand. The sample taken from the delivery is likewise compared with a portion of the bid sample. Any evidence of substitution or adulteration shall be cause for rejection of the shipment.

4.3 Tests.

4.3.1 Physical tests.—The quality of the green bean and the quality of the roasted coffee shall be determined by the application of recognized and accepted methods of grading and cup test.

4.3.2 Chemical analyses.—Chemical analyses, if desired by the purchaser, shall be made in accordance with the methods of the Association of Official Agricultural Chemists in effect on date of invitation for bids, or in accordance with methods that give equivalent results.

5. PREPARATION FOR DELIVERY

5.1 Packaging.—Unless otherwise specified, commercial packaging is acceptable. Santos in the green bean shall be delivered in original bags of approximately 132 pounds net, and Colombians in the green bean shall be delivered in the original bags of approximately 154 pounds net.

5.2 Labeling.—Any commercial labeling or
additional labeling as specified, that complies with the Federal Food, Drug, and Cosmetic Act, and regulations promulgated thereunder, is acceptable.

5.3 Packing.—Unless otherwise specified, the product shall be packed in substantial commercial containers of the type, size, and kind commonly used for the purpose, so constructed as to insure acceptance and safe delivery by common or other carriers, at the lowest rate, to the point of delivery called for in the contract or purchase order.

5.4 Marking of shipment.—Unless otherwise specified, shipping containers shall be marked with the name of the product, quantity and size of packages in the container as defined by the contract or order under which the shipment is made, the name of the contractor, the number of contract or order, the date of roasting, processing, and other pertinent information as specified by individual agencies.

5.5 Roasted coffee deliveries.—Roasted coffee shall be shipped as soon as possible after roasting and in no case later than 48 hours.

6. NOTES

6.1 Ordering data.—Invitations for bids should state the type, the method of inspection to be used, and the size, and kind of packaging required.

6.2 If for any particular purpose, samples with bids are necessary, they should be specifically asked for in the invitation for bids, and the particular purpose to be served by the bid sample should be definitely stated.

6.3 Contractor's inspection.—The contractor should be required to assure that the product conforms with the specification prior to submission to the Government for final inspection.

6.4 Destination inspection.—When the finished product has been inspected and passed at point other than destination, the contract should require that the product be inspected at destination for condition and quantity only.

Patent notice.—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

7. DEPARTMENTAL REQUIREMENTS

7.1 The following specifications and standards of the issues in effect on date of invitation for bids, and special requirements, form a part of this specification for purchases made under this specification by the respective departments.

7.2 Army, Navy, and Air Force.

7.2.1 Applicable specifications and standard. Federal Specifications:

NN-B-621—Boxes; Wood, Nailed and Lock-Corner.

NN-B-631—Boxes; Wood, Wirebound (For Domestic Shipment).

LLL-B-631—Boxes; Fiber, Corrugated (For Domestic Shipment).

LLL-B-636—Boxes; Fiber, Solid (For Domestic Shipment).

Military Specifications:

JAN-P-108—Packaging and Packing for Overseas Shipment—Boxes; Fiberboard (V-Board and W-Board), Exterior and Interior.

MIL-L-1497—Labeling of Metal Cans for Subsistence Items.

MIL-C-10506—Coatings, Exterior, for Tinned Food Cans.

Military Standard:

MIL-STD-129—Marking of Shipments.

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

7.2.2 Application.—Packaging, packing, and marking requirements specified herein apply to direct purchases by or direct shipments to the Department of Defense. The product shall be packaged and packed for domestic shipment (immediate use), domestic shipment (storage), or overseas shipment, as specified (see 7.2.7).

7.2.3 Domestic shipment (immediate use).

7.2.3.1 Type III.—Type III coffee shall be vacuum packed in metal containers which (together with packaging, wrapping, and inner
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packing) are acceptable by common or other carriers for safe transportation to point of destination specified in shipping instructions at the lowest transportation rate for such supplies.

7.2.4 For domestic shipment (storage).

7.2.4.1 Packaging.

7.2.4.1.1 One-pound vacuum-packaged unit.—When specified (see 7.2.7), 1 pound of type III product shall be filled into any of the three sizes of cans as shown in table I. The cans shall be made from commercial 0.25-pound electrolytic tin plate, and shall be round, open-top style, with soldered side seams and compound-lined, double-seamed ends. The top shall be designed to fit into the body or over a collar having an opening to provide reclosure, and the body shall have a suitably scored key-opening band near the top. A suitable corrosion-resistant key shall be attached to the can. The hermetic seal shall be effected after a minimum vacuum of 28 inches referred to a 30-inch barometer has been drawn on the product at the instant of closure.

<table>
<thead>
<tr>
<th>Can size Net weight</th>
<th>Number per case</th>
<th>Arrangement</th>
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<tbody>
<tr>
<td>502 by 308</td>
<td>1</td>
<td>24</td>
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<td>502 by 310</td>
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<td>906 by 906</td>
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7.2.4.1.2 Two-pound vacuum-packaged unit.—When specified (see 7.2.7), 2 pounds of type III product shall be packaged as specified in 7.2.4.1.1, except that the cans shall be provided with reinforcement beads, which shall be incorporated in the body of the can during the manufacturing process.

7.2.4.1.3 Twenty-pound vacuum-packaged unit.—Twenty pounds of type III product shall be filled into a square 5-gallon can having the dimensions of 9% by 9% by 13% or 13% inches. The cans shall have soldered side seams and compound-lined, double-seamed ends, soldered top and bottom. The cans shall be made throughout from commercial 0.50-pound electrolytic tin plate, and shall have suitable paneling. Further, the can shall be fabricated from base metal having a minimum base weight of plate of 112 pounds per base box, the temper of the plate being adequate to withstand the vacuum required. The top of the can shall be provided with a cover not less than 6% inches in diameter, compound-lined and double-seamed in position. Alternatively, the cover may be 6% inches in diameter, compound-lined and rolled or clinched over a flared flange opening in the can forming a joint inclining outward approximately 20 degrees from the vertical. A hermetic seal shall be effected after a minimum vacuum of 27 inches referred to a 30-inch barometer has been drawn on the product at the instant of closure.

Table I.—Can size, weight, number, and arrangement in shipping case

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7.2.4.2 Packing.

7.2.4.2.1 Vacuum-packaged unit—1- and 2-pound sizes.—Twenty-four 1-pound units of twelve 2-pound units, arranged as specified in table I, shall be packed on end in a snug-fitting corrugated fiberboard, solid fiberboard, nailed wood, or wirebound wood box, constructed in accordance with Federal Specifications LLL-B-631, LLI^B-636, NN-B-621, NN-B-631, respectively. The flaps of the fiberboard container shall be securely sealed with an adhesive commercially used for the specific product being packed, applied throughout the entire area of contact between the flaps; or by a combination of stitching one set of flaps prior to packing and sealing the other flaps with the adhesive. When flaps are stitched, the stitches shall be distributed so as to fasten all flaps securely together over the entire area of contact between the inner and outer flaps and to prevent lifting of free edges and corners of the outer flaps.

7.2.4.2.2 Vacuum-packaged unit—20-pound size.—Two 20-pound cans of vacuum-packaged coffee shall be placed side by side in a snug-fitting shipping container made from 275-pound test, double-faced corrugated fiberboard. The container shall be of a special, full-flap, slotted construction, made and constructed in accord-
ance with Federal Specification LLL-B-631, style OLC, except that when in a closed position the inner flaps shall meet at the center, and the length of the outer flaps, when measured from the outer edge of the flap to the center line of the score, shall be not less than the inside width of the box minus 1/4 inch, nor more than the inside width of the box minus 3/4 inch. The flaps of the container shall cover the top and bottom of the can.

7.2.5 For overseas shipment.
7.2.5.1 Packaging.—The product shall be packaged in accordance with 7.2.4.1.3, except that the exterior of the cans shall be enameled with a coating complying with types I, II, or III of Military Specification MIL-C-10506, as specified (see 7.2.7).

7.2.5.2 Packing (20-pound cans only).—Two 20-pound vacuum-packaged cans shall be placed side by side in a snug-fitting shipping container made of V3s or V3c fiberboard. Containers made from other grades of fiberboard meeting the minimum requirements for V3s or V3c fiberboard will be acceptable. The shipping container shall be a special full-flap, slotted shipping container, constructed in accordance with Military Specification JAN-P-108, style SFF, except that when in a closed position, the inner flaps shall meet at the center, and the length of the outer flaps when measured from the outer edge of the flap to the center line of the score, shall be not less than the inside width of the box minus 1/4 inches nor more than the inside width of the box minus 3/4 inch. The flaps of the container shall cover the top and bottom of the cans. The container shall be strapped in accordance with Military Specification JAN-P-108, except that two straps shall be applied girthwise over the top, sides, and bottom; one strap centered over each can.

7.2.6 Labeling and marking.
7.2.6.1 Cans.—Cans shall be labeled in accordance with method A or B of Military Specification MIL-L-1497, as specified (see 7.2.7), except that the name "COFFEE" may be used for hand stamping and printing. For embossing, the abbreviation "COFEE" may be used.

7.2.6.2 Shipping containers.—Shipping containers shall be marked in accordance with Military Standard MIL-STD-129.

7.2.7 Ordering data.—In addition to the information required in 6.1, procurement documents should specify the following:
(a) Whether the product is to be packaged and packed for domestic shipment (immediate use), domestic shipment (storage), or overseas shipment (see 7.2.2), as follows:
1. Domestic shipment (immediate use).—Applies to that material required for immediate use without storage or reshipment by the initial domestic receiving activity.
2. Domestic shipment (storage).—Applies to that material for storage and reshipment to a domestic receiving activity not involving sea transportation.
3. Overseas shipment.—Applies to that material to be transported by oceangoing or coastwise vessel and handled, issued, and stored in the military supply system.
(b) When type III coffee is to be packaged in 1- or 2-pound units (see 7.2.4.1.1 and 7.2.4.1.2).
(c) Type of can coating required (see 7.2.5.1).
(d) Method of can labeling required (see 7.2.6.1).

ARMY INTEREST: Q M
NAVY INTEREST: S MC

HHH-C-571a
This amendment, which forms a part of Federal Specification HHH-C-571a, dated 25 March 1954, was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

Pages 1 and 2, paragraph 3.1.2. Delete and substitute the following:

3.1.2 Type I-B.—This quality shall be of the usual good quality Colombian Excelsos of one or any combination of the following growths: Medellin, Manizales, Armenia, Girardot, Sevilla, Bogota, Honda, Tolima, Ibague, Libano.

Page 3, paragraph 5.5: Delete and substitute:

5.5 Roasted whole bean or ground coffee in bags or cartons shall be shipped as soon as possible after roasting and in no case later than 48 hours. Vacuum packed units of roasted and ground coffee shall be shipped as soon as possible but not later than fifteen (15) days after production, inspection, and acceptance of each transportation unit load (carload or truckload).

Pages 3 through 5, paragraphs 7.2.1 through 7.2.7. Delete and substitute:

7.2.1 Applicable specifications and standard.

Federal Specifications:

PPP–B–636—Boxes, Fiber.

Military Specifications:

MIL–L–1497 — Labeling of Metal Cans for Subsistence Items.
MIL–P–1501 — Packaging and Packing of Canned Subsistence Items, Overseas Shipment.

Military Standard:


(Copies of Military specifications and standards required by contractors in connection with specific procurement functions should be obtained from the procuring agency or as directed by the contracting officer.)

7.2.2 Packaging (type III product only).— The product shall be packaged in accordance with 7.2.2.1 or 7.2.2.2, as specified (see 7.2.5).

7.2.2.1 Level A.—One, 2, 3, 4, or 20 pounds of the product, as specified (see 7.2.5), shall be packaged in accordance with 7.2.2.1.1 or 7.2.2.1.2, as applicable for the size specified.

FSC 8955
COFFEE, INSTANT

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. SCOPE AND CLASSIFICATION

1.1 Scope.—This specification covers an instant coffee, with or without ascorbic acid, for use by agencies of the Federal Government.

1.2 Classification.—Instant coffee covered by this specification shall be of the following types, as specified (see 6.1).

Type I.—Without ascorbic acid.
Type II.—With ascorbic acid.

2. APPLICABLE SPECIFICATIONS, STANDARDS, AND OTHER PUBLICATIONS

2.1 Specifications and standards.—The following specifications and standards, of the issues in effect on date of invitation for bids, form a part of this specification.

Federal Specifications:

NN-B-621—Boxes; Wood, Nailed and Locked Corner.
LLL-B-631—Boxes; Fiber, Corrugated (for Domestic Shipment).
LLL-B-636—Boxes; Fiber, Solid (for Domestic Shipment).
PPP-B-585—Boxes; Wood, Wirebound.

Military Specifications:

JAN-P-106—Packaging and Packing for Overseas Shipment—Boxes; Wood, Nailed.
JAN-P-108—Boxes; Fiberboard Corrugated and Solid (Military Type).
MIL-L-1497—Labeling of Metal Cans for Subsistence Items.
MIL-C-10506—Coatings, Exterior, for Tinned Food Cans.

Military Standards:

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

2.2 Other publications.—The following documents form a part of this specification. Unless otherwise indicated, the issues in effect on date of invitation for bids shall apply.
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**Governmental:**

**Nongovernmental:**
Official Methods of Analysis of the Association of Official Agricultural Chemists.
Methods of Vitamin Assay of the Association of Vitamin Chemists, Inc.
Pharmacopoeia of the United States of the U. S. Pharmacopoeial Convention, Inc.

(Copies of Federal Food, Drug, and Cosmetic Act and General Regulations for Its Enforcement may be obtained upon application, accompanied by money order, coupon, or cash, to the Superintendent of Documents, Government Printing Office, Washington 25, D. C. Prices may be obtained from the Superintendent of Documents.

(Official Methods of Analysis of the Association of Official Agricultural Chemists is published by the Association of Official Agricultural Chemists, P. O. Box 540, Benjamin Franklin Station, Washington 4, D. C.

(Copies of Methods of Vitamin Assay of the Association of Vitamin Chemists, Inc., may be obtained from the Interscience Publishers, Inc., New York, N. Y.

(Copies of the Pharmacopoeia of the United States may be obtained from the U. S. Pharmacopoeial Convention, Inc., 46 Park Avenue, New York, N. Y.)

3. REQUIREMENTS

3.1 Bid sample approval. — Six (unless otherwise specified, see 6.1) individually packaged samples containing a minimum of 2 ounces each, representative of the product which the bidder proposes to furnish, shall be submitted to the contracting officer prior to the bid opening, and will be tested to the extent necessary to properly evaluate the bids. One sample of those selected by the contracting officer shall be used to determine preaward approval by panel testing (see 4.3.5). The remaining 5 samples shall be properly stored and shall serve as the standard reference sample for determining compliance with palatability requirements (see 3.6.5). The approval of any bid sample for palatability will not constitute approval of the sample as meeting the other requirements of 3.6.1 through 3.6.4.

3.2 Materials. — All the materials shall be edible, clean, sound, and wholesome.

3.2.1 Coffee. — The green coffee beans shall be sound and free from Rio or other objectionable flavors and matter.

3.2.2 Ascorbic acid. — Ascorbic acid shall be of U. S. Pharmacopoeia grade.

3.3 All deliveries shall conform in every respect to the provisions of the Federal Food, Drug, and Cosmetic Act and General Regulations for Its Enforcement.

3.4 Type I. — Instant coffee without ascorbic acid shall be dry, water-soluble solids derived from fresh domestically roasted and ground coffee. All utensils and extracting and drying equipment used shall be clean and free from objectionable odors. The coffee extracts shall be dried with the least practicable delay.

3.5 Type II. — Instant coffee with ascorbic acid shall conform to 3.4 except that samples shall contain an average of not less than 15 milligrams of ascorbic acid per 2 1/2 grams. Not more than 5 percent of the samples taken from any single delivery shall contain less than 12 milligrams of ascorbic acid per 2 1/2 grams at time of inspection.

3.6 Finished product.

3.6.1 Moisture content. — Samples shall contain not more than 3.0 percent moisture. Not more than 5 percent of the samples taken from any single delivery shall contain more than 3.5 percent moisture at time of inspection.

3.6.2 Caffeine content. — The caffeine content of instant coffee, calculated as anhydrous caffeine, shall be not less than 3.2 percent on a dry solids basis. No added caffeine shall be permitted.

3.6.3 Carbohydrates. — After hydrolysis, the reducing sugars and other reducing matter, calculated as dextrose, shall be not more than 35 percent on a dry solids basis.

3.6.4 Solubility. — When 2.5 grams of instant coffee are placed in a cup and 8 ounces of freshly
boiled water are added, the coffee powders shall be readily soluble, with moderate stirring, within 30 seconds. Any lumping that may occur shall disperse readily. The beverage shall be free from excessive sedimentation in the cup. The product shall also be soluble in cold water (60° F.) within 3 minutes.

3.6.5 Palatability.—All deliveries shall receive a rating equal to or better than the bid samples submitted by the successful bidder.

3.7 Workmanship.—The product shall be prepared, processed, and packaged under modern sanitary conditions and by such methods as will reflect good standards of workmanship and quality in the finished product.

4. SAMPLING, INSPECTION, AND TEST PROCEDURES

4.1 Sampling.—Samples of finished products covered by this specification and samples of any materials, components, or constituents entering into the preparation of the finished products may be taken at any time by the Government inspector to determine compliance with the requirements.

4.2 Inspection.

4.2.1 General.—Inspection shall be made by the procuring agency or a duly authorized representative at the time and place designated by the procuring agency. It may be made at the site of manufacture, both during and after processing, at any suitable point in transit, or after delivery to the point of destination.

4.2.2 Factory inspection.—The passing as satisfactory of any detail of processing or materials shall not relieve the contractor of responsibility for faulty workmanship or materials which may be discovered at any time prior to final acceptance.

4.2.3 Final inspection.—Unless otherwise specified, final inspection shall be made after delivery to the point of destination (see 6.4 and 6.5).

4.2.4 Quality assurance provisions.—Unless otherwise specified, quality assurance provisions in this section are applicable to inspection by and for the Government. Quality assurance provisions for components and materials described herein shall be in accordance with this specification and referenced specifications, to the extent applicable, except that this specification shall govern in the event of conflict.

4.2.4.1 Pre-acceptance inspection (plant sanitation inspection).—Inspection for sanitation of plants producing instant coffee will be conducted upon request of purchasing and contracting officer to the appropriate inspection agency. Award of contracts will be limited to establishments known to maintain proper sanitary conditions and which have received prior sanitary inspection approval recommended by the inspection agency.

4.2.4.2 Acceptance inspection.—Inspections required and determination of acceptability shall be in accordance with provisions set forth in Military Standard MIL-STD-105 and Appendix thereto, except where otherwise indicated hereafter.

4.2.4.2.1 Lot average requirements.—When the requirement is applicable to the lot average and an inspection level listed in table VII of appendix to Military Standard MIL-STD-105 is specified:

(1) Tightened or reduced inspection will not be used.

(2) Material shall be considered acceptable with respect to requirement in question if the average test result is within the specified limits.

4.2.4.2.2 Inspection of components.—In addition to the quality assurance provisions of subsidiary specifications, inspection shall be performed on the components and materials listed below for the following characteristics: Envelopes—thickness of polyethylene, aluminum foil, cellulose acetate, rubber hydrochloride, as applicable; cans—weight of plating and weight of base box, if specified. Test requirements shall be lot average requirements.

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