

FEDERAL STANDARD STOCK CATALOG

Section IV

(Part 5)

FEDERAL SPECIFICATION

FOR

GRIDDLES; CAST-IRON

This specification was approved on the above date by the Director of Procurement, for the use of all departments and establishments of the Government, and shall become effective not later than December 15, 1940. It may be put into effect, however, at any earlier date after promulgation.

A. APPLICABLE SPECIFICATION.

A-1. The following Federal Specification, of the issue in effect on date of invitation for bids, shall form a part of this specification:

QQ-M-151—Metals; General Specification for Inspection of.

B. TYPES AND SIZES.

B-1. Griddles shall be of two types and sizes described hereinafter, as specified in the invitation for bids.

Type I—Rectangular griddles.

Sizes: 25 inches by 13½ inches.

30 inches by 20 inches (with grease groove).

Type II—Round griddles.

C. MATERIAL AND WORKMANSHIP.

C-1. Material.—Griddles shall be made of close grained cast iron, free from blowholes, porous spots, cracks, or other defects which affect appearance or may affect serviceability.

C-2. Workmanship shall be first class. Griddles shall be free from sharp or irregular edges.

D. GENERAL REQUIREMENTS.

D-1. Griddles, including the handles, shall be cast in one piece. The top or cooking surface shall be flat, ground smooth, and clean. The bottom shall be free from warp and twist.

D-2. Figures 1, 2, and 3 show the general designs of griddles desired but are not intended to preclude the acceptance of griddles otherwise meeting specification requirements.

D-3. Coating.—Griddles shall be coated with a non-toxic rust preventive compound. Each griddle shall be accompanied by a label or instructions for removing this coating before the griddle is placed in use.

E. DETAIL REQUIREMENTS.**E-1. Type I rectangular griddles (25" × 13½") (see fig. 1.)**

E-1a. Size.—Griddles shall be 13½ inches (plus or minus 1 inch) in width and 25 inches (plus or minus 2 inches) in length, exclusive of handles. The thickness of the griddle plate as measured without the ribs or raised edges, shall be ¼ inch (plus or minus ⅛ inch). The weight of griddle shall be approximately 20 pounds. Top and bottom surfaces shall be parallel.

E-1b. The corners of the griddle shall be uniformly rounded to a 2¼-inch (plus or minus ½ inch) radius. The top and underside shall have a uniform raised edge ⅜ inch (plus or minus ⅛ inch) in width, and thickness, extending entirely around the griddle. The raised edge on the top side and the inside coved edge between the working sur-

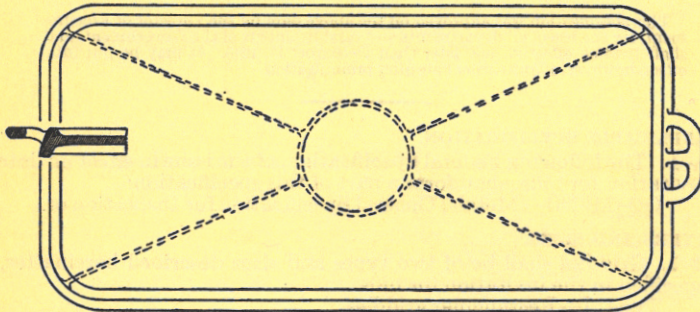


FIGURE 1

face and the raised edge, shall be slightly rounded. The under side of the griddle may have suitable ribs.

E-1c. Handles.—There shall be two handles of durable construction, and so shaped as to permit a secure and comfortable grip for lifting the griddle. Handles shall have no sharp corners or edges, and shall be approximately 3 inches in length by 1½ inches in width. Handles shall be located in the center at opposite ends of the griddle and shall be so formed that the fingers can be readily inserted under them for the purpose of lifting when the griddle is lying on a flat surface.

E-2. Type I rectangular griddles (30 inches × 20 inches) (with grease groove) (see fig. 2).

E-2a. Size.—Griddles shall be 20 inches (plus or minus 1 inch) in width and 30 inches (plus or minus 2 inches) in length, exclusive of handles. The thickness of the griddle plate as measured without the ribs or raised edges, shall be ¼ inch (plus or minus ⅛ inch). Griddles shall have a smoothly finished continuous groove on the upper side, extending around the inside of the edge, ⅝ inch (± ⅛ inch) in width and having a radius of ¼ inch (± ⅛ inch) as measured from the top surface of the griddle. The weight of griddle shall be approximately 45 pounds.

E-2b. The corners of the griddle shall be uniformly rounded to a 2½ inch (plus or minus ½ inch) radius. The top surface shall have a uniform raised edge ¼ inch (± ⅛ inch) high and ¼ inch (± ⅛ inch) wide, extending entirely around the griddle. The bottom shall have a uniform raised edge base ⅝ inch (± ⅛ inch) wide and not less than ⅜ inch thick, extending entirely around the griddle. The bottom of the base shall be flanged to increase the thickness at least ⅛ inch. The bottom of the griddle shall also have a ribbed reinforcement ¼ inch (± ⅛ inch) high at the center and ½ inch (± ⅛ inch) wide and be of the design indicated by figure 2. The ribs shall have tapered sides,

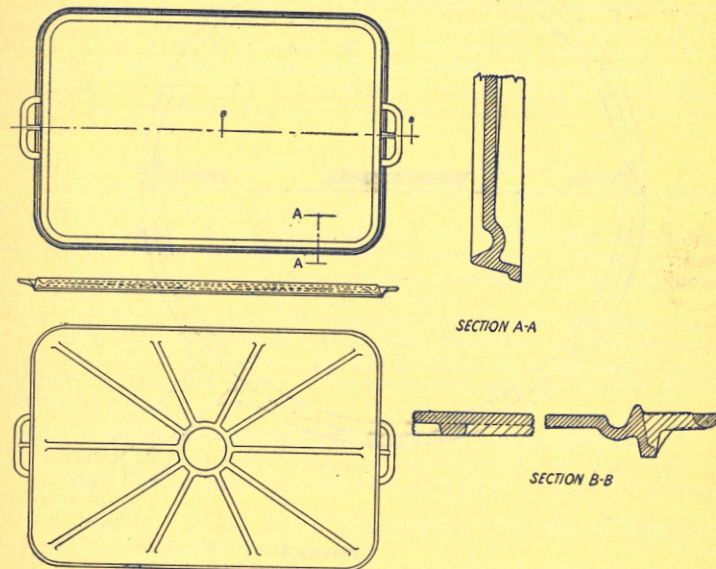


FIGURE 2

and shall also gradually taper in height from the center of the griddle to the surface as it approaches the sides of the griddle. The circular ribbed reinforcement shall be ¾ inches (± ½ inch) in diameter. All edges shall be rounded.

E-2c. Handles.—There shall be two handles 5½ inches (± ¼ inch) in length, and 1¼ inches (± ¼ inch) in width, and not less than ½ inch in diameter, except the center reinforcement which shall be not less than ⅜ inch in diameter. The design of handles shall be similar to that in figure 2, and handles shall be located in the center at opposite ends of the griddle. Handles shall be so shaped and constructed as to permit the fingers to be readily inserted under them and assure a secure

and comfortable grip for the purpose of lifting the griddle when it is lying on a flat surface.

E-3. *Type II round griddles.*—(See fig. 3.)

E-3a. Round griddles shall be 10½ inches (plus or minus ½ inch) in outside diameter. The cooking (or top) surface shall be 9¾ inches plus or minus ¼ inch) in diameter. The griddle plate (not including

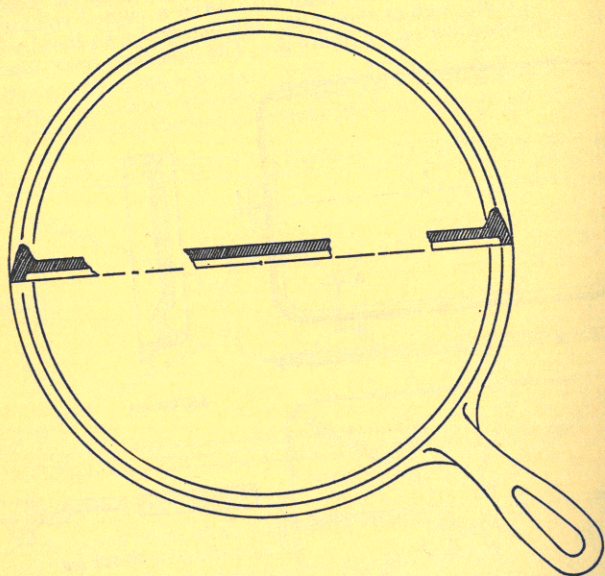


FIGURE 3

raised edges) shall be ⅜ inch (plus or minus ⅛ inch) in thickness. There shall be a raised edge on each side of the griddle extending around the outer edge, approximately ¼ inch in height and width. The raised edge on the working side shall be rounded and smooth. Griddle shall weigh approximately 5 pounds.

E-3b. *Handle.*—Shall be 4½ inches (plus or minus ½ inch) in length, and taper in the width from approximately ⅞ inch near the body of the griddle to not more than 1½ inches near the end. There shall be a hole in the handle approximately 2 inches in length by ½ inch in width. The handle shall be rounded and shall be so located as to permit the hand to grip it without touching a flat surface upon which the griddle rests.

F. METHOD OF SAMPLING, INSPECTION AND TESTS.

F-1. One or more griddles of each type shall be taken from each lot of 500 or fraction thereof delivered, for inspection and test, to determine compliance with the requirements of this specification.

F-2. *Tests for handles.*—Griddles shall show no signs of breaking or permanent set when lifted by the handle or handles while supporting on the cooking surface a weight at least five times the weight of the griddle.

F-3. *Test for griddle.*—The griddle shall be supported flatwise on a span of 8 inches for round griddles and 20 inches for rectangular griddles, and a 3-pound ball of ferrous metal shall be dropped from a height of 18 inches above the center of the cooking surface of the griddle. The bearing surfaces of the supporting edges shall be of metal, shall be in full contact with the griddle and shall not be more than ¼ inch wide. Signs of breaking or cracking as a result of the test will be considered as failing to meet requirements of the specification.

G. PACKAGING, PACKING, AND MARKING FOR SHIPMENT.

G-1. *Packaging.*—Unless otherwise specified, commercial packages are acceptable under this specification.

G-2. *Packing.*—Unless otherwise specified, the subject commodity shall be delivered in standard commercial containers, so constructed as to insure acceptance by common or other carriers, for safe transportation, at the lowest rate, to the point of delivery.

G-3. *Marking.*—Unless otherwise specified, shipping containers shall be marked with the name of the material, the type, and the quantity contained therein, as defined by the contract or order under which shipment is made, the name of the contractor, and the number or the contract or order.

H. REQUIREMENTS APPLICABLE TO INDIVIDUAL DEPARTMENTS.

H-1. The following departmental specifications of the issue in effect on the date of invitation for bids shall form a part of this specification:

H-1a. *Army.*—U. S. Army Specification No. 100-2, Standard Specification for Marking Shipments.

H-1b. *Navy.*—Navy Department General Specifications for Inspection of Material, copies of which may be obtained without cost upon application to the Bureau of Supplies and Accounts, Navy Department, Washington, D. C.

I. NOTES.

I-1. Purchasers should exercise any desired options offered herein and specify type and size required.

I-2. It is believed that this specification adequately describes the characteristics necessary to secure the desired material, and that normally no samples will be necessary prior to award to determine compliance with this specification. 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, the specification to apply in all other respects.

I-3. This specification covers only the types, classes, grades, sizes, etc., of the commodity as generally purchased by the Federal Government, and is not intended to include all of the types, etc., which are commercially available.

I-4. An index of Federal Specifications may be purchased as noted in the paragraph below, price to be obtained from the Superintendent of Documents.

I-5. Copies of this specification and of QQ-M-151 may be obtained upon application, accompanied by money order, or coupon, or cash, to the Superintendent of Documents, Government Printing Office, Washington, D. C., price 5 cents each.

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.