

**PURCHASE SPECIFICATION**  
**INJECTION MOLDING REQUIREMENTS**  
**NAVY HANDLE CLIP TYPE A**  
**NAVY HANDLE CLIP TYPE B**

1. SCOPE

1.1 Scope. This purchase specification establishes requirements for the manufacture of a Type A and a Type B Handle Clip as detailed herein for shipboard use.

2. APPLICABLE DOCUMENTS

2.1 Specifications/Standards

ASTM D3951	Standard Practice for Commercial Packaging (DoD) adopted 10 November 1998
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Society of Plastics, Inc.	Cosmetic Specifications of Injection Molded Parts 1994 Version A
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Mil-STD-105	Sampling Procedures and Tables for Inspection By Attributes
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2.2 Other Documents

NAVSSES Sketches “Type A Handle Clip” and “Type B Handle Clip”

3. REQUIREMENTS

3.1 The Handle Clips shall be manufactured using Delrin AF (White) through a plastic molding process in accordance with the NAVSSES Sketches entitled “Type A Handle Clip” and Type B Handle Clip.” The Contractor shall design and fabricate an injection mold or molds suitable for molding the quantities of Handle Clips to be furnished. The mold will be designed such that it will balance and maximize filling while minimizing waste and flashing. The mold shall minimize or eliminate knitlines. Polish mold areas to produce a Society of Plastics Inc. (SPI) A-3 as a minimum and plate. To protect molding surfaces and to ensure good release, it is necessary to plate all polished surfaces. Surfaces to be plated shall include cores, cavities, core pins, ends of ejector pins, runner blocks, vents, and parting lines.

3.2 The contractor will furnish AUTOCAD drawings (AUTOCAD 2004 compatible) for the proposed mold identifying, as a minimum, the type of steel to be used for the mold, the hardness of the steel, the style of the mold, and the placement and style of ejection for review and approval by the Government prior to manufacture of the Handle Clips.

3.3 The First Article Samples shall be subjected to a 100% inspection by the contractor prior to delivery to the Government. The inspection shall include verifying the material, all dimensional requirements, an examination for cosmetic effects (i.e., surface voids), and sink/warp areas. If any First Article Sample handle clips are found deficient,

the entire lot will be rejected. The contractor shall provide a report, detailing the results of its inspection of the First Article Samples together with the First Article Samples.

3.4 The First Article Samples shall be subjected to a 100% inspection by the Government to determine compliance with the specification requirements. The inspection will include verifying material, dimensional requirements, examination of cosmetic defects and sink/warp areas and other inspections and examinations deemed necessary to determine compliance with the specification requirements.

3.5 All production Handle Clips shall be subjected to sample lot inspections in accordance with Mil-Std-105. The Acceptable Quality Level (AQL) level shall be 4.0, General Inspection Level, Level 2. Production lots not in compliance with AQL 4.0, General Inspection Level 2, shall be rejected. The lot size for the production quantity shall be 1,000 Handle Clips. The contractor shall furnish a report to the Government detailing the results of the inspection performed on each production lot.

3.6 The contractor shall establish and maintain a quality control or inspection system acceptable to the government.

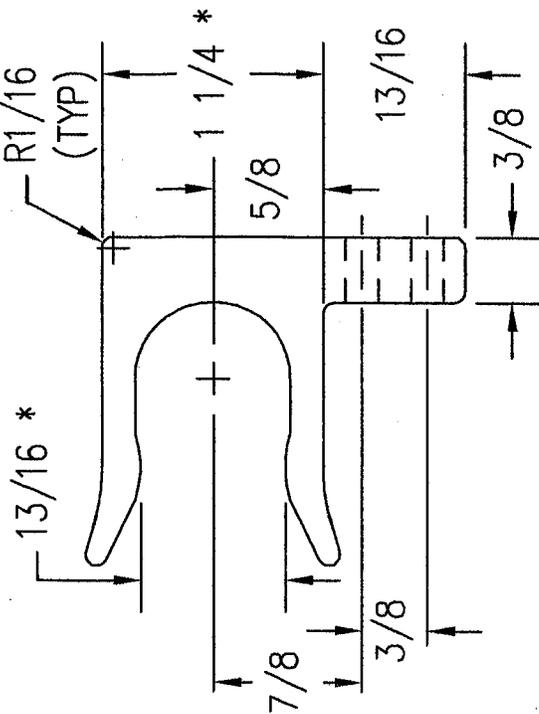
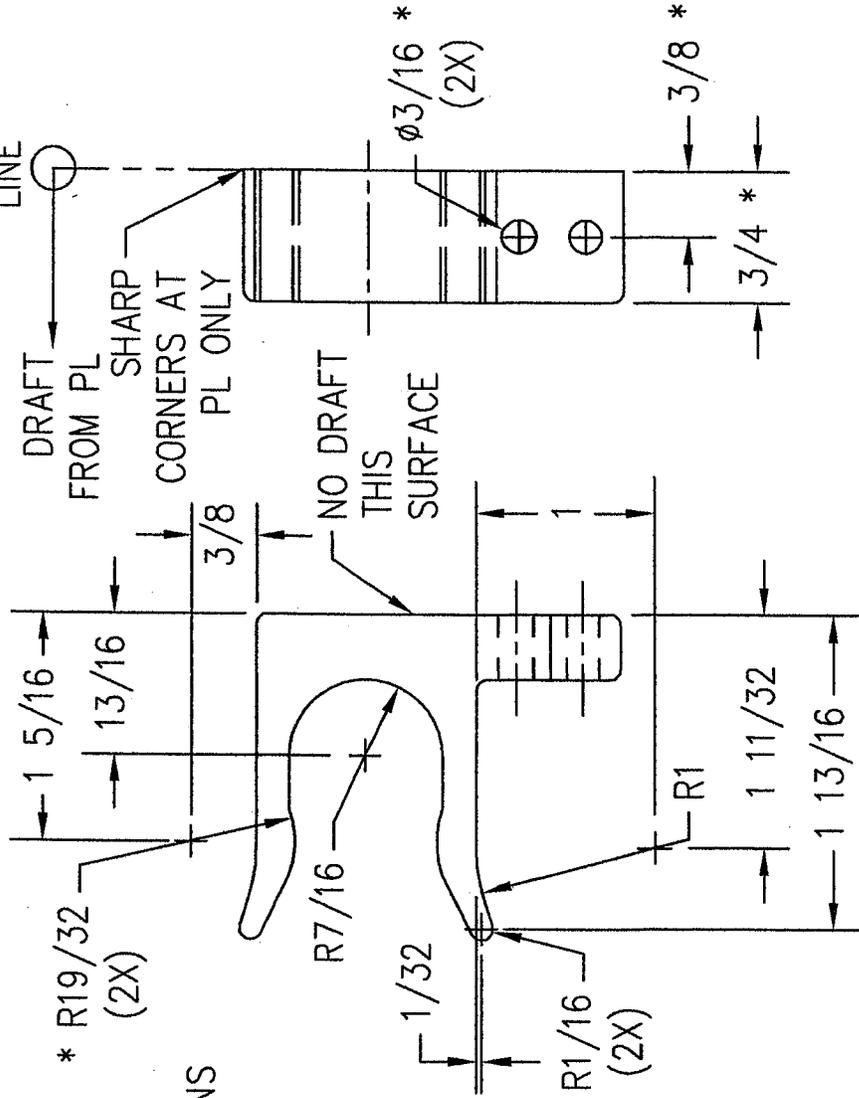
3.7 Packaging

3.7.1 Packaging Requirements. Packaging requirements shall be in accordance with ASTM D3951.

3.7.2 Marking. Marking shall be in accordance with ASTM D3951.

NOTES

1. DIMENSIONS MARKED (\*) ARE CRITICAL DIMENSIONS TO HOLD TAKEN AT PARTING LINE, DRAFT FROM PARTING LINE.
2. TOLERANCE FOR ALL OTHER DIMENSIONS  $\pm .01$ .
3. FINISH SPI A3 OR BETTER.
4. UNSPECIFIED EDGE RADIUS .062.



HANDLE CLIP TYPE A

SCALE: FULL

MATERIAL: DELRIN AF (WHITE)

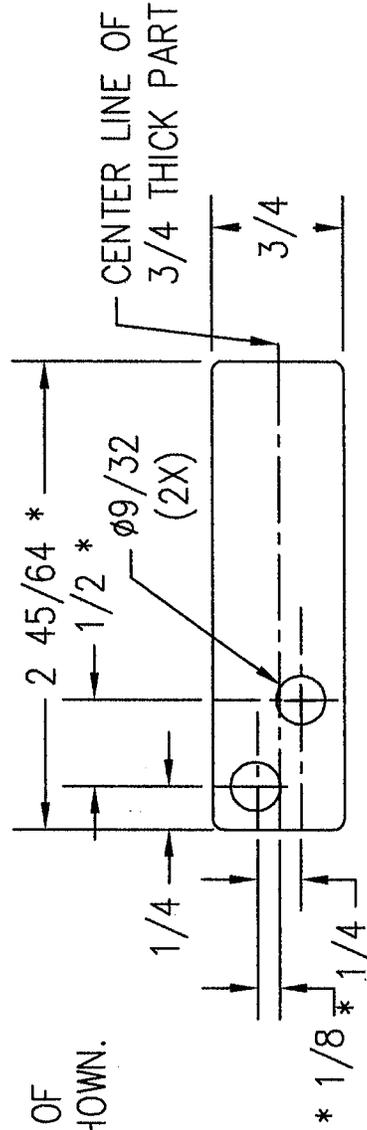
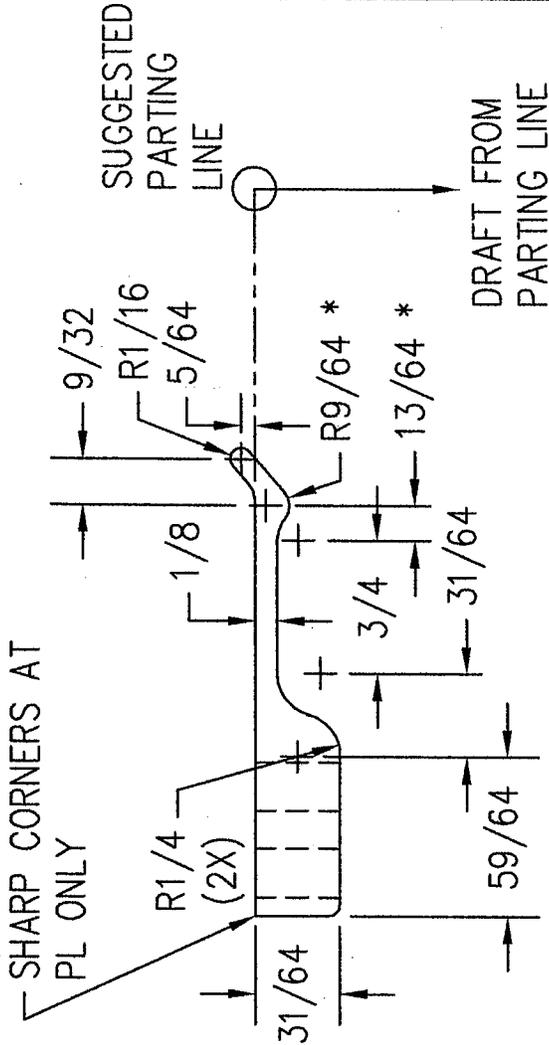
SIZE	CAGE CODE	NAVSES SKETCH	REV
A	89256	TYPE A HANDLE CLIP	-
SCALE: FULL			SHEET 1 OF 1

AUXILLARY TOP VIEW

SCALE: FULL

NOTES

1. DIMENSIONS MARKED (\*) ARE CRITICAL DIMENSIONS TO HOLD TAKEN AT PARTING LINE, DRAFT FROM PARTING LINE.
2. TOLERANCE FOR ALL OTHER DIMENSIONS  $\pm .01$ .
3. FINISH SPI A3 OR BETTER.
4. UNSPECIFIED EDGE RADIUS .062.
5. THE HANDLE CLIP IS MADE UP OF PARTS A AND B. PART A IS SHOWN. PART B IS OPPOSITE.



HANDLE CLIP TYPE B

SCALE: FULL

MATERIAL: DELRIN AF (WHITE)

SIZE	CAGE CODE	NAVSES SKETCH	REV
A	89256	TYPE B HANDLE CLIP	-
SCALE: FULL			SHEET 1 OF 1