

DEPARTMENT OF COMMERCE
NATIONAL INSTITUTE OF STANDARDS AND TECHNOLOGY
OFFICE OF STANDARDS SERVICES

**PRODUCT STANDARD PS25-70
HEAVY-DUTY ALPHA-CELLULOSE-FILLED
MELAMINE TABLEWARE**

Product Standard PS25-70, Heavy Duty Alpha-Cellulose-Filled Melamine Tableware, was withdrawn by the U.S. Department of Commerce on January 20, 1982.

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For guidance and assistance for additional information and related materials and other sources, please contact:

American Society for Testing and Materials (ASTM)
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Phone: (610) 832 -9585
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The Society of the Plastics Industry (SPI)
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NSF International (NSF)
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General Services Administration
1800 F Street, NW
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National Bureau of Standards**Status Report on Voluntary Product Standards**

AGENCY: National Bureau of Standards; Commerce.

ACTION: Maintenance, retention, replacement, and withdrawal of certain voluntary product standards

On August 19, 1980, the Department of Commerce (Department) announced in the Federal Register (45 FR 55250-2) the status of 80 documents classified as Voluntary Product Standards. The announcement was made in accordance with the revised Procedures for the Development of Voluntary Product Standards (15 CFR Part 10). Section 10.0(b) of the Procedures specifies six criteria that must be met for the Department to sponsor the development or maintenance of a Voluntary Product Standard.

Numerous requests to retain or maintain various standards were received in response to the August 19, 1980, notice. A number of the requests specified retention of standards for fixed periods of time that have now elapsed. The current status of all such standards is indicated below.

Based on proposals from the proponent organizations identified after the following titles, the following product standards will continue to be sponsored by the Department:

- PS 1-74, Construction and Industrial Plywood; American Plywood Association
- PS 20-70, American Softwood Lumber Standard; American Lumber Standards Committee
- PS 72-76, Toy Safety; Toy Manufacturers of America
- PS 73-77, Carbonated Soft Drink Bottles; Glass Packaging Institute
- TS 231, Proposed Voluntary Product Standard, Production of Carbonated Soft Drinks In Glass Bottles; National Soft Drink Association

Based on documented activity within a private standards-writing organization, the following standards will be retained by the National Bureau of Standards for the periods of time stated below to permit the orderly transfer of sponsorship of such standards from the Department to the identified organizations. The periods of time stated below shall commence from the date this notice is published in the Federal Register and supersede the periods of time stated for those standards in the August 19, 1980 notice.

- PS 30-70, School Chalk; the Crayon, Water Color and Craft Institute, Inc.; 6 months
- PS 36-70, Body Measurements for the Sizing of Boys' Apparel; Mail Order Association of America; 12 months

- PS 42-70, Body Measurements for the Sizing of Women's Patterns and Apparel; Mail Order Association of America; 12 months
- PS 45-71, Body Measurements for the Sizing of Apparel for Young Men (Students); Mail Order Association of America; 12 months
- PS 46-71, Flame-Resistant Paper and Paperboard; American Society for Testing and Materials; 6 months
- PS 51-71, Hardwood and Decorative Plywood; Hardwood Plywood Manufacturers Association; 12 months
- PS 54-72, Body Measurements for the Sizing of Girls' Apparel; Mail Order Association of America; 12 months
- PS 63-75, Latex Foam Mattresses for Hospitals; American Society for Testing and Materials; 12 months
- PS 64-75, School Paste; The Crayon Water Color and Craft Institute, Inc.; 6 months
- PS 65-75, Paints and Inks for Art Education in Schools; The Crayon, Water Color and Craft Institute, Inc.; 6 months
- PS 67-76, Marking of Gold Filled and Rolled Gold Plate Articles Other Than Watchcases; Jewelers Vigilance Committee; 24 months
- PS 68-76, Marking of Articles Made of Silver in Combination with Gold; Jewelers Vigilance Committee; 24 months
- PS 69-76, Marking of Articles Made Wholly or in Part of Platinum; Jewelers Vigilance Committee; 2 months
- PS 70-76, Marking of Articles Made of Karat Gold; Jewelers Vigilance Committee; 24 months
- PS 71-76, Marking of Jewelry and Novelties of Silver; Jewelers Vigilance Committee; 24 months
- CS 98-62, Artists Oil Paints; Artists Equity Association, Inc.; 6 months
- CS 130-60, Color Materials for Art Education in Schools; the Crayon, Water Color and Craft Institute, Inc.; 6 months
- CS 151-50, Body Measurements for the Sizing of Apparel for Infants, Babies, Toddlers and Children (for the Knit Underwear Industry); Mail Order Association of America; 12 months
- R 192-63, Crayons and Related Art Materials for School Use (Types, Sizes, Packages and Colors); The Crayon, Water Color and Craft Institute, Inc.; 6 months

The following standard has been replaced by a standard being developed or published by a private standards-writing organization and, therefore, Department of Commerce sponsorship is no longer need for it:

- PS 17-69, Polyethylene-sheeting (construction, industrial and agricultural applications); Society of the Plastics Industry

→ In the absence of any request for retention or maintenance, the following standards are withdrawn:

- PS 13-69, Uncorded Slab Urethane Foam for Bedding and Furniture Cushioning
- PS 15-69, Custom Contact-Molded Reinforced Polyester Chemical-Resistant Process Equipment
- PS 23-70, Horticultural Grade Perlite

- PS 24-70, Melamine Dinnerware (Alpha-Cellulose Filled) for Household Use
- PS 25-70, Heavy-Duty Alpha-Cellulose-Filled Melamine Tableware
- PS 27-70, Mosaic-Parquet Hardwood Slat Flooring
- PS 29-70, Plastic Heat-Shrinkable Film
- PS 31-70, Polystyrene Plastic Sheet
- PS 34-70, Fluorinated Ethylene-Propylene (FEP) Plastic-Lined Steel Pipe and Fittings
- PS 52-71, Polytetrafluorethylene (PTFE)
- PS 53-72, Glass-Fiber Reinforced Polyester Structural Plastic Panels
- PS 56-73, Structural Glued Laminated Timber
- PS 57-73, Cellulosic Fiber Insulation Board
- PS 58-73, Basic Hardboard
- PS 59-73, Prefinished Hardboard Paneling
- PS 60-73, Hardboard Siding
- PS 62-74, Grading of Diamond Powder in Sub-Sieve Sizes
- CS 138-55, Insect Wire Screening
- CS 192-53, General Purpose Vinyl Plastic Film
- CS 201-55, Rigid Polyvinyl Chloride Sheets
- CS 227-59, Polyethylene Film
- CS 245-62, Vinyl-Metal Laminates
- CS 257-63, TFE-Fluorocarbon (Polytetrafluorethylene) Resin Molded Basic Shapes
- CS 268-65, Hide-Trim Pattern for Domestic Cattlehides
- CS 274-68, TFE-Fluorocarbon Resin Sintered Thin Coatings for Dry Film Lubrication
- R2-62, Bedding Products and Components

In accordance with § 10.1(e) of the revised Procedures for the Development of Voluntary Product Standards and by agreement with the Consumer Product Safety Commission, the Department will retain sponsorship of the following Voluntary Product Standard for the period of time stated below to allow for arrangements to be made for its sponsorship by a private standards writing organization.

- PS 66-75, Safety Requirements for Home Playground Equipment; 12 months

For further information contact Eric A. Vadelund, Office of Engineering Standards, National Bureau of Standards, Washington, D.C. 20234. Telephone: (301) 921-3272.

Dated: January 13, 1982.

Ernest Ambler,

Director.

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WITHDRAWN

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NBS

**Voluntary
Product
Standard**

A UNITED STATES
DEPARTMENT OF
COMMERCE
PUBLICATION

DO NOT REMOVE
~~XXXXXXXXXX~~

PS 25-70

Withdrawn 1/20/82

**U.S.
DEPARTMENT
OF
COMMERCE

National
Bureau
of
Standards**

VOLUNTARY PRODUCT STANDARDS

Voluntary Product Standards are standards developed under procedures established by the Department of Commerce (15 CFR Part 10, as amended). The standards may include (1) dimensional requirements for standard sizes and types of various products, (2) technical requirements and (3) methods of testing, grading, and marking. The objective of a *Voluntary Product Standard* is to establish requirements which are in accordance with the principal demands of the industry and, at the same time, are not contrary to the public interest.

Development of a VOLUNTARY PRODUCT STANDARD

The Office of Engineering Standards Services of the National Bureau of Standards pursuant to appropriate delegation of authority from the Department of Commerce works closely with scientific and trade associations and organizations, business firms, testing laboratories, and other appropriate groups to develop *Voluntary Product Standards*. The Bureau has been assigned the following role in the development process: It (1) provides editorial assistance in the preparation of the standard; (2) supplies such assistance and review as is required to assure the technical soundness of the standard; (3) acts as an unbiased coordinator in the development of the standard; (4) sees that the standard is representative of the views of producers, distributors, and users or consumers; (5) seeks satisfactory adjustment of valid points of disagreement; (6) determines the compliance with the criteria established in the Department's procedures cited above; and (7) publishes the standard.

Industry customarily (1) initiates and participates in the development of a standard; (2) provides technical counsel on a standard; and (3) promotes the use of, and support for, the standard. (A group interested in developing a *Voluntary Product Standard* may submit a written request to the Office of Engineering Standards Services, National Bureau of Standards, Washington, D. C. 20234.)

A draft of a proposed standard is developed in consultation with interested trade groups. Subsequently, a Standard Review Committee is established to review the proposed standard. The committee, appropriately balanced, includes qualified representatives of producers, distributors, and users or consumers of the product being standardized. When the committee approves a proposal, copies are distributed for industry consideration and acceptance. When the acceptances show general industry agreement, and when there is no substantive objection deemed valid by the Bureau, the Bureau announces approval of the *Voluntary Product Standard* and proceeds with its publication.

Use of a VOLUNTARY PRODUCT STANDARD

The adoption and use of a *Voluntary Product Standard* is completely voluntary. *Voluntary Product Standards* have been used most effectively in conjunction with legal instrumentalities such as sales contracts, purchase orders, and building codes. When a standard is made part of such a document, compliance with the standard is enforceable by the purchaser or the seller along with other provisions of the document.

Voluntary Product Standards are useful and helpful to both purchasers, manufacturers, and distributors. Purchasers may order products that comply with *Voluntary Product Standards* and determine for themselves that their requirements are met. Manufacturers and distributors may refer to the standards in sales catalogs, advertising, invoices, and labels on their product. Commercial inspection and testing programs may also be employed, together with grade labels and certificates assuring compliance, to promote even greater public confidence. Such assurance of compliance promotes better understanding between purchasers and sellers.

Nat. Bur. Stand. (U.S.), Prod. Stand. 25-70, 8 pages (Aug. 1970)

CODEN: XNPSA

Heavy-Duty Alpha-Cellulose-Filled Melamine Tableware

Effective April 1, 1970 (See section 6)

(This voluntary Standard, initiated by The Society of the Plastics Industry, Inc., has been developed under the *Procedures for the Development of Voluntary Product Standards*, published by the Department of Commerce. See Section 7, *History of Project*, for further information.)

1. PURPOSE

The purpose of this Product Standard is to establish quality requirements for heavy-duty alpha-cellulose-filled plastic melamine tableware, and to provide a nationally recognized standard for the information and use of producers, distributors, and users.

2. SCOPE

2.1. This Product Standard covers the thickness, properties, and methods of test for heavy-duty tableware molded from alpha-cellulose-filled melamine-formaldehyde and other amino-triazine-formaldehyde plastic materials.¹ Requirements for the finish and decoration are also covered by the Standard. Methods for identifying melamine tableware complying with the requirements of this Standard are provided.

2.2. This Standard does not cover the design, size, or color of the melamine tableware.

3. REQUIREMENTS

3.1. **Materials**—The tableware shall be molded from alpha-cellulose-filled melamine-formaldehyde and other amino-triazine-formaldehyde resins.

3.2. **Thickness**—The tableware shall have a thickness of not less than 0.100 inch over not less than 90 percent of the surface area, with the remainder not less than 0.090 inch in thickness. The thickness shall be determined in accordance with the method described in 4.5.1

3.3. **Finish**—The surface of all tableware, including decorations, shall be representative of that produced by good molding practice and free from readily perceptible imperfections, such as orange peel, pits, flow lines, unfused areas, and contamination. Flash and parting lines only shall be buffed.

3.4. **Decorations**—When foil decorations are used, they shall consist of only an amino-triazine resin-impregnated foil incorporated in such a manner as to become an integral part of the molded piece, and to be completely covered by a resinous surface, as durable as the undecorated surface.

3.5. **Resistance to boiling sulfuric acid**—The tableware shall show no chalking, defined as a dry chalklike appearance or deposit on the surface, or loss of gloss that is readily perceptible without close examination, when tested in accordance with 4.5.2.

3.6. **Resistance to boiling water**—The tableware shall not de-

¹ Dinnerware for household use is covered by Product Standard PS 24-70, *Melamine Dinnerware (Alpha-Cellulose-Filled) for Household Use*.

velop cracks, nor show surface chalking or other defects that might impair the serviceability or appearance of the tableware, when tested in accordance with 4.5.3.

3.7. Resistance to dry heat—The tableware shall show no cracks, warpage, or other defects that might impair the serviceability or appearance of the tableware, when tested in accordance with 4.5.4.

4. INSPECTION AND TEST PROCEDURES

4.1. General—The methods of test are especially designed so that they can be conducted by producers, distributors, or users without the use of costly equipment, and by personnel that need not be specially trained. Meeting the tests described in 4.5.2, 4.5.3, and 4.5.4 is evidence of proper molding.

4.2. Quality control practice—Each producer shall keep such essential records and other information to document his claim that the requirements of this Standard are met with a high degree of assurance. This requirement does not preclude additional sampling and testing that may be agreed upon between the parties concerned to verify the validity of the claim.

4.3. Sampling—Specimens shall be chosen at random from each lot of the same shape and size for testing to determine the conformance of the tableware with each of the requirements of section 3. Three specimens shall be used for each of the tests described in 4.5.2, 4.5.3, and 4.5.4. If one of the three specimens fails to meet the requirements of a given test, three additional specimens shall be subjected to that test, all of which shall be required to pass the test in order to indicate conformance of the tableware with this Product Standard. If more than one of the original three specimens for a given test fails, the tableware shall be reported as failing to conform with this Product Standard.

4.4. Visual inspection—The specimens shall be visually inspected to determine their conformance with the requirements of 3.4.

4.5. Test procedures

4.5.1. Thickness—The thickness of the tableware shall be determined to the nearest 0.001 inch, using a screw thread comparator micrometer.

4.5.2. Sulfuric acid test

4.5.2.1. Materials

- (a) An aqueous solution of sulfuric acid 0.8 percent by weight is required. This solution can be obtained from a local drug or chemical supply house.
- (b) A porcelain-enameled or stainless-steel pail, with cover, about 2- to 3-quart capacity should be used. Enameled ware must not be used if the inside surface is chipped, exposing bare metal.
- (c) A heater, preferably a gas burner of about 4 to 5 inches in diameter, should be used. The heater should have sufficient capacity to keep the acid solution boiling fairly vigorously.

4.5.2.2. Procedure

- (a) Three untested specimens shall be used for this test. From the molding to be tested, cut a cross-section strip about 3 inches wide, if a plate, dish, or saucer is being tested. If testing a cup, cut a section of about one-half of the molded part, taking for the test that part which includes the handle.

The entire piece of tableware may be used if it is desired not to destroy it by cutting. Heat to boiling a fresh portion of acid solution, keeping the container covered. Immerse the test pieces and re-cover the vessel. Keep boiling. Remove the test pieces after 10 ± 0.5 minutes of boiling, rinse in cold water, and air-dry for 15 to 30 minutes. Inspect each specimen for conformance with 3.5.

4.5.2.3. Precautions

- (a) The acid solution is corrosive, and care should be taken that it is not splashed on one's person or clothing, or about the premises. The concentrated acid should be added to cold water in preparing the solution. *Do not add water to the acid* because of the violent chemical reaction.
- (b) Use fresh acid solution for each test run.
- (c) The solution must be kept boiling during the 10 minutes of the test. If too many test pieces are put in at once, the solution will be cooled to such an extent that it will stop boiling, thus endangering the accuracy of the test. By trial and error, one can determine the maximum number of parts which can be properly tested at one time.
- (d) Test pieces can be attached to fairly heavy cord or string, and be removed by this means when the test is completed.
- (e) Test pieces should be kept separated during boiling so that the acid bath has free access to all surfaces.
- (f) Dispose of waste acid solution by allowing it to cool, then flushing it in an adequate disposal system, using plenty of water.

4.5.3. Resistance to boiling water—Three specimens which have not been subjected to the tests in 4.5.2 and 4.5.4 shall be used for this test. The specimens of tableware shall be placed in boiling water for 30 minutes, removed, and allowed to stand for 1 hour at room temperature. This procedure shall be immediately repeated three times to give a total of four such cycles. The tableware shall then be allowed to stand for 48 hours in air at room temperature. Inspect each specimen of the tableware for conformance with 3.6. In disputed cases the specimen should stand for 48 hours in air at a temperature maintained at 23 ± 2 °C (73.4 ± 3.6 °F) and a relative humidity of 50 ± 5 percent, and then inspected for conformance with 3.6.

4.5.4. Resistance to dry heat—Three specimens which have not been subjected to the tests in 4.5.2 and 4.5.3 shall be used for this test. Place the tableware in a circulating-air oven for 8 hours at 76.7 ± 2.8 °C (170 ± 5 °F). Cool to room temperature, and inspect for conformance with 3.7.

5. IDENTIFICATION

In order that purchasers may identify products complying with all requirements of this Voluntary Product Standard, producers choosing to produce such products in conformance with this voluntary Standard may include a statement in conjunction with their name and address on labels, invoices, sales literature, and the like. The following statement is suggested when sufficient space is available:

This tableware conforms to all of the requirements established in Product Standard PS 25-70, developed cooperatively with the industry and published by the National

Bureau of Standards under the Voluntary Product Standards procedures of the U.S. Department of Commerce. Full responsibility for the conformance of this product with the standard is assumed by (name and address of producer or distributor).

The following abbreviated statement is suggested when available space on labels is insufficient for the full statement:

Conforms to PS 25-70, (name and address of producer or distributor).

6. EFFECTIVE DATE

The effective date of a Voluntary Product Standard is the date upon which reference to the Standard may be made by producers, distributors, users and consumers, and other interested parties. Compliance by producers with the requirements of a Product Standard may not actually occur until some time after the effective date. Products shall not be labeled or otherwise described as conforming to a Product Standard until such time as all applicable requirements established in the Standard are met. The effective date of this Standard is April 1, 1970.

7. HISTORY OF PROJECT

On April 26, 1949, The Society of the Plastics Industry, Inc., requested the cooperation of the National Bureau of Standards in the establishment of a Commercial Standard for heavy-duty alpha-cellulose-filled melamine tableware. This recommended Commercial Standard was circulated to the industry on September 18, 1950, for consideration and acceptance. Sufficient acceptances were received to assure success of the Standard, and CS 173-50 became effective on December 15, 1950.

Current Revision

A revision of Commercial Standard CS 173-50 was requested by The Society of the Plastics Industry, Inc., February 21, 1966. The revision provides (1) additional requirements for foil decorations and for finish, (2) methods for determining compliance with the thickness requirements, (3) clarification of the procedures required to be used in the sulfuric acid and dry heat tests, and (4) additional precautionary measures for the handling of sulfuric acid.

The proposed revision was reviewed by the Office of Engineering Standards Services and the Standing Committee. Adjustments were made to the satisfaction of all groups involved and the recommended Product Standard TS 106, *Heavy-Duty Alpha-Cellulose-Filled Melamine Tableware*, was circulated to the trade for acceptance in February 1969.

The response to the February 1969 circulation indicated that a consensus of acceptability, as defined under the *Procedures for the Development of Voluntary Product Standards*, existed within the industry with regard to the Standard. In August and September 1969, the Standing Committee and the acceptors were balloted concerning the deletion of the "hallmark" from the Standard. The response to this balloting indicated that a consensus of acceptance had again been achieved, and on March 10, 1970, the Standard, designated PS 25-70, *Heavy-Duty Alpha-Cellulose-Filled Melamine Table-*

ware, was approved for publication by the National Bureau of Standards to be effective April 1, 1970.

Technical Standards Coordinator:

D. R. Stevenson, Office of Engineering Standards Services,
National Bureau of Standards, Washington, D. C. 20234

8. STANDING COMMITTEE

The following individuals comprise the membership of the Standing Committee which is to review all revisions proposed to keep the Standard abreast of progress. Comments concerning the Standard and suggestions for revision may be addressed to any member of the committee or to the Office of Engineering Standards Services, National Bureau of Standards, U.S. Department of Commerce, which acts as secretary for the committee.

Representing Tableware Producers

John L. Burke, Prolon Division of Vistron, Midland Building, Cleveland, Ohio 44115 (Chairman)
John J. O'Leary, Owens-Illinois, Libbey Products Division, P.O. Box 548, Lake City, Pennsylvania 16423
K. D. Meiser, Plastics Manufacturing Company, 2700 South Westmoreland Avenue, P.O. Box 13645, Dallas, Texas 75224
Robert K. Parmacek, Silite, Inc., 2600 North Pulaski Road, Chicago, Illinois 60639

Representing Producers of Resin

Frank Petruccelli, Allied Chemical Corporation, Plastics Division, P.O. Box 365, Morristown, New Jersey 07960
G. B. Sunderland, American Cyanamid Company, Plastics and Resins Division, P.O. Box 425, Wallingford, Connecticut 06493

Representing Distributors

Sam R. Don, Edward Don & Company, 2201 South LaSalle Street, Chicago, Illinois 60616

Representing Users

Clarice G. Taylor, Mrs., 105 North Third Street, Lock Haven, Pennsylvania 17445 (Representing The American Dietetic Association)
J. S. Fassett, American Hotel & Motel Association, 221 West 57th Street, New York, New York 10019
Philip Perlman, Board of Education, 44-36 Vernon Boulevard, Long Island City, New York 11101
Robert M. Porro, General Services Administration, Federal Supply Service, Standardization Division, Washington, D.C. 20406

9. ACCEPTORS

The manufacturers, distributors, users, and others listed below have individually indicated in writing their acceptance of this Product Standard prior to its publication. The acceptors have indicated their intention to use the Standard as far as practicable, but reserve the right to depart from it when necessary. The list is published to show the extent of recorded public support for the Standard.

ASSOCIATIONS
(General Support)

Maryland Consumers Association, Annapolis, Maryland
National Retail Merchants Association, New York, New York
Society of the Plastics Industry, Inc., The, New York, New York

PRODUCERS

Kenro Corporation, Fredonia, Wisconsin
Oneida Ltd., Silversmiths, Sherrill, New York
Owens-Illinois, Inc., Libbey Products, Lake City, Pennsylvania
Plastics Manufacturing Company, Dallas, Texas
Prolon Dinnerware Division of Vistron Corporation, Cleveland, Ohio
Prolon Dinnerware Division of Vistron Corporation, Florence, Massachusetts
Weber Plastics Corporation, Los Angeles, California

DISTRIBUTORS, USERS, AND GENERAL INTEREST

Alaska, State of, Division of Supply, Department of Administration, Juneau, Alaska
Appalachian Regional Hospitals, Williamson, West Virginia
California, State of, Sacramento, California
Chatham Supermarkets, Inc., Warren, Michigan
Beth Israel Hospital, Boston, Massachusetts
Bryn Mawr Hospital, The, Bryn Mawr, Pennsylvania
DuBois Chemicals, Division of W. R. Grace & Company, Sharonville, Ohio
Macy, R. H., & Company, Inc., New York, New York
Minnesota, State of, Division of Procurement, St. Paul, Minnesota
Murphy, G. C., Company, McKeesport, Pennsylvania
New Jersey, State of, Trenton, New Jersey
North Carolina, State of, Raleigh, North Carolina
Ohio, State of, Contracts & Specifications, Division of Purchases, Department of Finance, Columbus, Ohio
Oregon, State of, Purchasing Division, Salem, Oregon
Pennsylvania, Commonwealth of, Harrisburg, Pennsylvania
St. Vincent's Hospital & Medical Center, New York, New York
Sears, Roebuck and Company, Chicago, Illinois
Sillite, Inc., Chicago, Illinois
Southern Illinois University, Carbondale, Illinois
United Christian Missionary Society, Indianapolis, Indiana
Washington Sanitarium & Hospital, Takoma Park, Maryland
Wisconsin, State of, Madison, Wisconsin

FEDERAL GOVERNMENT

General Services Administration, Washington, D.C.