

PPP-B-20D  
March 19, 1980  
SUPERSEDING  
PPP-B-20C  
July 16, 1973

FEDERAL SPECIFICATION  
BAGS, COTTON, MAILING

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

1. SCOPE

1.1 This specification covers the requirements for cotton cloth, drawstring, mailing bags.

2. APPLICABLE DOCUMENTS

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

Federal Specification:

PPP-B-636 - Boxes, Shipping, Fiberboard.

Federal Standard:

Fed. Std. No. 751 - Stitches, Seams, and Stitchings.

(Activities outside the Federal Government may obtain copies of Federal specifications, standards and commercial item descriptions, as outlined under General Information in the Index of Federal Specifications, Standards, and Commercial Item Descriptions. The Index, which includes cumulative bimonthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

(Single copies of this specification, other Federal specifications and commercial item descriptions required by activities outside the Federal Government for bidding purposes are available without charge from General Services Administration Business Service Centers in Boston; New York; Philadelphia; Washington, DC; Atlanta; Chicago; Kansas City, MO; Fort Worth; Houston; Denver; Los Angeles; San Francisco; and Seattle, WA.

(Federal Government activities may obtain copies of Federal specifications, standards, commercial item descriptions and the Index of Federal Specifications, Standards and Commercial Item Descriptions from established distribution points in their agencies.)

Military Standard:

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.

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

3. REQUIREMENTS

3.1 Materials.

3.1.1 Sheeting. The unbleached cotton sheeting shall have 47 yarns in the warp direction and 46 yarns in the filling direction. The weight shall be not less than 3.8 oz per square yard with a minimum break of 48 pounds in the warp direction and 35 pounds in the filling direction (see 4.4.2 for test requirements).

PPP-B-20D

3.1.2 Tags. The tags shall be of white cotton cloth-lined paper stock. The cloth shall have a thread count of not less than 24 ends and 20 picks per inch. The paper stock shall have a hard finish suitable for pen-and-ink addressing on the face side of the tag. Dimensions before insertion in the bags shall be 3 by 5-1/2 inches, plus or minus 1/16 inch (see 4.4.1 for test requirements).

3.1.3 Thread. The thread shall be 3-ply cotton, not less than 6,441 yards per pound, 3-pounds minimum break and with a natural finish.

3.1.4 Drawstring. The drawstring shall be 12-ply cotton twine, 1,500 feet per pound, and with a 24-pound tensile strength. Twine shall be polished. Alternatively, when specified (see 6.2), the drawstring may be hard-finish (polished) twine of not less than 30 ply construction with a breaking strength of approximately 25 - 30 pounds.

3.2 Construction. The bags shall be of the end-opening type with a drawstring, as specified in 3.1.4, inserted through the hem at the open end. The drawstring shall project not less than 3 inches from each edge of the bag when the bag is opened and laid flat. A tag, as specified in 3.1.2, shall be securely sewn into the bottom seam of the bag. The tag shall be inserted 3/8-inch + 1/16-inch from the bottom edge of the bag. All seams shall be sewn with stitch type 401, seam type EFa-1 of Fed. Std. No. 751, with 4 to 6 stitches per inch. The side and bottom seam shall have 1/4-inch gauge, and the top seam shall have a 3/8-inch gauge to allow for insertion of the drawstring.

3.2.1 The bag dimension shall have a + 3/8-inch and a minus 1/4-inch tolerance, as follows:

Width	Height	Width	Height
3	4	6	9
3	5	5-1/2	14
4	9	6-1/2	10
4-1/2	8	7-1/2	18
5	7	8	10

3.3 Workmanship. The bags shall be free from defects which affect their serviceability.

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein.

4.2 Sampling for examination and tests. Sampling for examination, inspection, and physical test shall be performed using the procedures prescribed by MIL-STD-105.

#### 4.3 Inspection of the end item.

4.3.1 Examination of the end item. The sample unit for this examination shall be one bag of each type and style. The inspection level shall be S-2 with an acceptable quality level (AQL) of 4.0 expressed in terms of percent defective.

4.3.1.1 Examination of the end item for visual defects and workmanship. The sample unit shall be one bag selected at random and taken from any one shipping container. Defects in appearance shall be holes, cuts, or tears in fabric; tags wrinkled or creased; open seams; wrong seams or stitch type, margin of stitching less than specified, too loose or too tight stitching, and number of stitches not as specified; missing components, stains on bag or tag, and not properly trimmed; and malfunction in closing of bag.

4.3.1.2 Examination for dimensional defects. Defects in dimensions shall be not meeting tolerances as specified; tags not inserted within specified tolerances in bottom seam of the bag.

4.3.1.3 Examination of preparation for delivery. An examination shall be made to determine compliance with the requirements of section 5. The sample unit shall be one container fully prepared for delivery. Sampling shall be in accordance with MIL-STD-105. The inspection level shall be S-2 with an AQL of 4.0 expressed in terms of percent defective.

PPP-B-20D

4.4 Test methods. The following tests shall be conducted for yarns per inch and breaking strength of cloth used in the fabrication of the bags. Failure of any test shall be cause for rejection.

4.4.1 Yarns per inch. The procedure involve the counting of the number of warp and filling yarns per inch constituting the cloth construction. This is accomplished by the use of a pick glass and pointer to facilitate counting.

4.4.2 Breaking strength. The specimens of woven cloth (4 by 6 inches with long dimensions parallel to the direction being evaluated) shall be tested as follows: Each specimen shall be placed in a machine which is equipped with a constant rate of moving straining mechanism. The distance between the clamps at the start of each test shall be 3 inches, and the clamps shall travel at a uniform rate of 12 inches  $\pm$  0.5 inch per minute. The force required to break the specimens shall be read from the recording mechanism. The breaking strength shall be the average of the results and reported to the nearest pound.

## 5. PREPARATION FOR DELIVERY

5.1 Packaging. Packaging shall be level A or commercial, as specified (see 6.2).

5.1.1 Level A. Mailing bags of one size only shall be securely wrapped or tied in bundles in quantities as specified (see 6.2).

5.1.2 Commercial. Bags of one size only and quantities specified (see 6.2) shall be packaged in accordance with normal commercial practice. The complete package shall be designed to protect the item against damage during shipment, handling, and storage.

5.2 Packing. Packing shall be level A or commercial as specified (see 6.2).

5.2.1 Level A. Bags of one size only shall be packed in a close-fitting box conforming to PPP-B-636, class weather resistant. The box shall be closed, waterproofed, and reinforced in accordance with the appendix of PPP-B-636.

5.2.2 Commercial. The packaged bags shall be packed in fiberboard boxes to insure delivery at destination, to provide for redistribution by the initial receiving activity, and shall be acceptable by common carrier under National Motor Freight Classification and Uniform Freight Classification.

5.3 Marking. Marking shall be as specified in the contract or order.

## 6. NOTES

6.1 Intended use. This specification describes cotton cloth drawstring bags for mailing small parts.

6.2 Ordering data. Purchasers should select the preferred options permitted herein, and include the following information in procurement documents:

- (a) Title, number, and date of this specification.
- (b) Bag dimensions required (see 3.2.1).
- (c) Type drawstring required (see 3.1.4).
- (d) Quantities required (see 5.1.1 or 5.1.2).
- (e) Level of packaging and packing (see 5.1 and 5.2).

### MILITARY CUSTODIANS:

Army - GL  
Navy - SA  
Air Force - 69

### CIVIL AGENCY COORDINATING ACTIVITIES:

TVA - TVA  
Preparing Activity:  
GSA-FSS

Orders for this publication are to be placed with General Services Administration, acting as an agent for the Superintendent of Documents. See section 2 of this specification to obtain extra copies and other documents referenced herein.