

PPP-B-26E

February 24, 1975

SUPERSEDING

Fed. Spec. PPP-B-26D

February 3, 1969

FEDERAL SPECIFICATION

BAG, PLASTIC, (GENERAL PURPOSE)

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 the requirements for plastic film bags (see 6.1).

1.2 Classification.

1.2.1 Types. The bags shall be furnished in the following types as specified (see 6.2).

Type I - Square.

Type II - Flat.

1.2.2 Styles. The bags shall be furnished in the following styles, as specified (see 6.2). When no style is specified, style 1 shall be furnished.

Style 1 - heat seal closure.

Style 2 - Wire tie closure.

Style 3 - Interlocking seal closure.

Style 4 - Heat shrinkable.

Style 5 - Heat shrinkable and weatherable.

2. APPLICABLE DOCUMENTS

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

FSC 8105

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Federal Specifications:

L-P-378 - Plastic Sheet and Strip, 1/16 in Gauge, Polyolefin.
 PPP-B-566 - Boxes, Folding, Paperboard.
 PPP-B-636 - Boxes, Shipping, Fiberboard.
 PPP-B-676 - Boxes, Setup.
 PPP-I-45 - Tape, Gummed, Paper, Reinforced and Plain, For Sealing and Securing.

Federal Standards:

Fed. Std. No. 123 - - Marking for Domestic Shipment of
 (Civil agencies).
 Fed. Std. No. 406 - Plastics, Method of Testing.

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly 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 and other Federal Specifications required by activities outside the Federal Government for bidding purposes are available without charge from Business Service Centers at the General Services Administration Regional Offices in Boston, New York, Washington, DC, Atlanta, Chicago, Kansas City, MO, Fort Worth, Denver, San Francisco, Los Angeles, and Seattle, WA.

(Federal Government activities may obtain copies of Federal Specifications, Standards, and handbooks and the Index of Federal Specifications and Standards from established distribution points in their agencies.)

Military Specification:

MIL-A-43702 - Ties, Ribbon, Twist.

Military Standards:

MIL-STD-105 - Sampling Procedures and Tables for Inspection by
 Attributes.
 MIL-STD-129 - Marking for Shipment and Storage.

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

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply.

National Motor Freight Traffic Association, Inc., Agent

National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Associations, Inc., Tariff Order Section, 1616 P Street, N.W., Washington, DC 20036.)

Uniform Classification Committee, Agent

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

3. REQUIREMENTS

3.1 Material. The bags shall be made from plastic film tubing or sheets in flat form or rolls conforming to L-P-378, type I, II, III, IV or V, class 1, 3 or 4, grade A, B or C, finish 1 or 2 and color as specified (see 6.2).

3.1.1 Thickness of film. The film shall be furnished in ranges of 0.001 to 0.009 inch as specified (see 6.2). The thickness of film shall be within the tolerance specified in L-P-378. When no film thickness is specified, a nominal thickness of 0.003 inch shall be supplied.

3.1.2 Tubing and sheets. Plastic film tubing and sheets shall be clean and free of extraneous matter. Care shall be exercised to eliminate undue tension of rolls in creasing side edges of tubing during the manufacturing process or winding the tubing on rolls.

3.2 Construction. Bags fabricated from two sheets shall have two side seams and one bottom seam. Alternatively, gusseted bags shall have a seam in the middle of the front and back panel in place of side seams. Bags formed by folding one sheet of material shall be made with two seams, one side and one bottom. Alternatively, for gusseted bags, a front or back seam shall be used in place of the side seam. Seams shall be parallel with the parallel outer edges of the bag. All seams shall be continuously sealed by means of electronic, thermal impulse, jaw, rotary, or band type sealers.

3.2.1 Seam strength. The seam strength of the bag, when tested as specified in 4.3.1, shall be not less than 60 percent of the breaking strength of the plastic film from which the bag is fabricated.

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3.3 Type I, square bags. Type I, square bags shall be bags having a folded bottom with gussets on the sides. The bottom may or may not have gussets.

3.4 Type II, flat bags. Type II, flat bags shall be bags having no gussets. Unless otherwise specified (see 6.2), individual flat bags with side seams shall have a 1/2 inch long lip (plus or minus 1/4 inch tolerance) extending beyond the open end on one face of the bag.

3.5 Style 1, heat seal closure. Style 1 bags shall be capable of being closed by heat sealing the open end. Unless otherwise specified (see 6.2), style 1 bags shall be made of material conforming to L-P-378, type I or II, grade A or B, finish 1 or 2.

3.6 Style 2, wire tie closure. Style 2 bags shall be furnished with wire ties specified in 3.6.1, for closure of bags when filled. Unless otherwise specified (see 6.2), style 2 bags shall be made of material conforming to L-P-378, type II, grade C, finish 1.

3.6.1 wire ties. The wire ties shall conform to MIL-T-43702, color as specified (see 6.2). Each tie shall be not less than 4 inches in length. The appropriate number of ties shall be placed with each dispenser box or within each roll core.

3.7 Style 3, interlocking seal closure. Style 3 bags shall be furnished with an interlocking seal on one side of the bag not less than 1/2 inch and not more than 3/4 inch from the top of a type II bag. The interlocking seal shall be effected by applying pressure with the fingers to the seal area. Unless otherwise specified (see 6.2), style 3 bags shall be made of material conforming to L-P-378, type I, grade A, finish 1 or 2 or of type II, grade A or C, finish 1 or 2 with a nominal 0.003 inch thickness.

3.8 Style 4, heat shrinkable bags. Style 4 bags shall be capable of being closed by heat shrinking. Bags shall be made of material conforming to L-P-378, type IV, class 3 or 4, grade A or B, finish 1 or 2.

3.9 Style 5, heat shrinkable and weatherable. Style 5 bags shall be capable of being closed by heat shrinking. Bags shall be made of material conforming to type V, class 3 or 4, grade A or B, finish 1 or 2 of L-P-378.

3.10 Form (put-up). Bags shall be furnished as individual bags or in rolls as specified, (see 6.2).

3.10.1 Individual bags. The individual bags, type I or II shall be furnished with all seams sealed except for the open or closure seam.

3.10.2 Rolls. Rolls of types I and II bags in bulk form or in dispenser box shall be uniformly and smoothly wound on chipboard tubes of not less than

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1 inch diameter. The length of the tube shall be equal to the specified width of the roll with a plus 1/2 inch tolerance. Perforations shall be cut between each bag on the roll. Perforations shall be straight, continuous, and cut clean throughout the width of each bag. The perforations shall be made not more than 1 inch below the seal seam and shall not be located to impair the strength of the sealed seam.

3.11 Dimensions. Bag dimensions shall be the inside measurements, exclusive of seals or seams (see 6.2). Bags shall be supplied in dimensions specified in the contract or purchase order with tolerances of width and length as shown in table I. Dimensions for type I, square bags shall be given by face width, by gusset, by length, by bottom gusset (if applicable). Dimensions for type II, flat bags shall be given by face width by length by lip (if applicable).

TABLE I. Dimension tolerances (length and width 1/)

Area of one side of bag (square inches)	Tolerances,	inch
Up to 25, incl	- 1/16	+ 1/8
26 to 200, incl	- 1/8	+ 1/4
201 to 500, incl	- 1/4	+ 1/4
501 and over	- 1/4	+ 1/2

1/ Tolerance for gussets \pm 1/8 inch.

3.12 Workmanship. The bags shall be uniformly made, free from pinholes, tears, cuts, creases, wrinkles, or extraneous matter which might impair their usefulness.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order the supplier may utilize his own facilities or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.

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4.2 Quality conformance inspection. Except as otherwise specified herein, sampling for inspection shall be performed in accordance with the provisions set forth in MIL-STD-105.

4.2.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

4.2.2 End item inspection. The end item inspection lot shall be all bags, rolls, or shipping containers of the same type, style, color, grade and finish, offered for inspection at one time. The inspection levels and acceptable quality levels (AQL) expressed in terms of defects per hundred units, shall be as specified in table II.

TABLE II. Inspection levels

<u>Inspection paragraph</u>	<u>Inspection level</u>	<u>AQL</u>	
		<u>Major</u>	<u>Total</u>
4.2.2.1	S-3	2.5	10.0
4.2.2.2	S-3	--	2.5
4.2.2.3	S-2	2.5	10.0

4.2.2.1 Examination of the end item for defects in construction and workmanship. The sample unit for this examination shall be one bag or roll of bags, as applicable. The inspection level and AQL shall be as listed in table II.

TABLE III. Examination of construction and workmanship

<u>Examine</u>	<u>Defect</u>	<u>Category</u>	
		<u>Major</u>	<u>Minor</u>
Construction	Thickness of material not as specified (see 3.1.1 and 6.2).	101	
	Not fabricated in type or style specified.	102	
	Dimensional tolerances more or less than specified (see table I).	103	

TABLE III. Examination of construction and workmanship (cont'd)

Examine	Defect	Category	
		Major	Minor
Construction (cont'd)	Not clear and colorless, or if color specified not proper shade (see 3.1).		201
	Not put-up in form specified.	104	
Individual bags (when applicable)	Lip missing (when applicable), or dimensional tolerances more or less than specified (see 3.4).		202
Rolls (when applicable)	Chipboard tube missing or dimensions less than specified.	105	
	Perforations missing between bags.	106	
	Perforations not straight or not cut clean throughout width of roll.		203
	Perforations more than 1 inch below seal seam.		204
Wire tie (when applicable)	Less than 4 inches long.		205
	Not furnished when specified.	107	
Workmanship	Seams not straight, continuous, or parallel to edges.	108	
	Tear, cut, or holes.	109	
	Scuff mark, sharp wrinkles or creases, or chafed marks in body or sealed areas.		206
Closure	Not style specified.	110	
	Interlocking seal (when specified) less than 1/2 or more than 3/4 inch from top of bag.		207

4.2.2.2 Testing of end item. Testing shall be performed for the applicable characteristics indicated in table V on samples randomly selected from each lot of bags offered for Government acceptance. The sample unit shall be one bag for each test indicated in table IV. The inspection level and AQL shall be as listed in table II.

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TABLE IV. Testing of the end item

Characteristic	Reqmts. para.	Test method	Reqmts. appl. to sample unit	No. of deter-minations	Pass or fail
Seam strength	3.2.1	4.3.1	X	1	X

4.2.2.3 Inspection of preparation for delivery. An examination shall be made to determine that the packaging, packing and marking complies with the section 5 requirements. Defects shall be scored in accordance with table IV. The sample unit shall be one shipping container fully prepared for delivery except that it need not be closed. Defects of closure in table V shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level and AQL shall be as listed in table II.

TABLE V. Examination of preparation for delivery requirements

Examine	Defect	Category	
		Major	Minor
Packaging (when applicable)	Not level specified.	101	
	Bags not packaged as specified.	102	
	Package not close-fitting.		201
	Number of wire ties less than number of bags (when applicable).		202
	Bags not of like description.	103	
Packing	Not level specified.	104	
	Container not type specified.	105	
	Bags not of like description.	106	
	Weight of contents per container is more than specified.	107	
Marking (exterior and interior)	Omitted, incomplete, incorrect, illegible, of improper size, location, sequence, or method of application.	108	

4.2.2.4 Examination of shipping containers. When shipping containers are required to be in accordance with PPP-B-636, examination for closure and strapping shall be in accordance with the appendix of the box specification.

4.3 Test procedures.

4.3.1 Seam strength. The breaking strength of heat sealed seams (see 3.2.1), shall be determined in accordance with procedure A or B, Method 1013 of FED-STD-406. The specimen shall be not more than 1 inch in width. The initial jaw separation shall be 2 inches plus or minus 1/16 inch and the seam shall be equidistant plus or minus 1/16 inch between the two jaws.

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A.

5.1.1.1 Individual bags. Bags in multiples of ten of one description only shall be packaged in a snug-fitting paperboard box conforming to variety 1, style III or VIII, type G, class optional of PPP-B-566 or type I or II, variety 1, class C, style optional of PPP-B-676; or fiberboard box conforming to style RSC, type CF (variety SW), class domestic, grade 200 of PPP-B-636. Each box shall be securely closed with 2-inch minimum width gummed paper tape conforming to type III, grade B of PPP-T-45.

5.1.1.2 Bags on rolls or in dispenser boxes. Packaging shall not be required.

5.1.2 Level B. Packaging shall be as specified in 5.1.1.

5.1.3 Level C (Commercial Packaging). Bags shall be packaged to afford adequate protection against physical damage during shipment from the supplier to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the supplier for retail distribution.

5.2 Packing. Packing shall be level A, B or C as specified (see 6.2).

5.2.1 Level A. Bags of one description only, packaged as specified in 5.1 (when applicable), shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, grade V2a of PPP-B-636. Each fiberboard container shall be closed in accordance with method III, water-proofed in accordance with method V, and reinforced as specified in the appendix of PPP-B-636. Weight of contents of each PPP-B-636 container shall not exceed 65 pounds.

5.2.2 Level B. Bags of one description only, packaged as specified in 5.1 (when applicable), shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic, grade 275 of PPP-B-636. Each fiberboard container shall be closed in accordance with method II as specified in the appendix of PPP-B-636. Weight of contents of each PPP-B-636 container shall not exceed 65 pounds.

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5.2.2.1 When specified (see 6.2), the fiberboard shipping container shall be a grade V3c, V3s, or V4s fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with method III as specified in the appendix of the container specification.

5.2.3 Level C (Commercial Packing). Bags, packaged as specified in 5.1 (when applicable), shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The quantity per shipping container shall be the same as that normally used by the supplier for retail distribution. Containers shall comply with the Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

5.3 Marking.

5.3.1 Civil agencies. In addition to any special marking required by the contract or order, interior packages (when applicable) and shipping containers shall be marked in accordance with Fed. Std. No. 123.

5.3.2 Military requirements. In addition to any special marking required by the contract or order, interior packages (when applicable) and shipping containers shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. The bags covered by this specification are intended for use in general purpose packaging applications, shrink wraps for commodities or unitized loads and for use as liners for waste receptacles and refuse cans. Bags covered by this specification are not intended for the packaging of subsistence items (see 1.1).

6.2 Ordering data. Purchasers should exercise any desired options offered herein and procurement documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Type and style of bag required (see 1.2.1 and 1.2.2).
- (c) Type, class, grade, finish and color of material (see 3.1).
- (d) Film thickness, when applicable (see 3.1.1).
- (e) When other lip is required (see 3.4).
- (f) When type, grade, thickness and finish of material for style 1 bags are other than specified (see 3.5).
- (g) When type, grade, and finish of material for style 3 bags are other than specified (see 3.6).
- (h) Color of ties required (see 3.6.1).
- (i) Bag put-up (see 3.10).

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- (j) Bag dimensions (see 3.11).
- (k) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).
- (l) When weather-resistant grade fiberboard shipping containers are required for level 3 shipment (see 5.2.2.1).

Custodians:

Army - GL
Navy - SA
Air Force - 69

Review activities:

Army - SM, MD, ME, MU, WC
Air Force - 82, 84

User activities:

Army - EL
Navy - MC, OS
Air Force - 71

Preparing activity:

Army - GL

Civil Agency Coordinating Activity:

GSA-FSS

Project No. 8105-0246

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. Price 40 cents each.

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