

PPP 8 650J
 July 3, 1975
 SUPERSEDING
 Fed. Spec. PPP-3-100A
 May 17, 1964

FEDERAL SPECIFICATION

BOXES, CORRUGATED FIBERBOARD, SPECIAL PURPOSE (RECORDS RETIRING)

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 new special purpose fiberboard boxes designed for use as storage containers for retiring Federal records (see 6.1).

1.2 Classification. The boxes covered by this specification shall be furnished in the following styles and sizes, as specified (see 6.2).

Style I - Regular Slotted Box

- Size 1 - 14-3/4" x 12" x 9-1/2"
- Size 2 - 15" x 12" x 10"
- Size 3 - 14-3/4" x 9-1/2" x 4-7/8"

Style II - Tuck Bottom Box

- Size 1 - 14-3/4" x 12" x 9-1/2"
- Size 2 - 14-3/4" x 11-3/4" x 11-3/4"

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 Specifications:

- PPP-B-636 - Boxes, Shipping, Fiberboard.
- PPP-B-638 - Boxes, Caps, Liners and Sleeves, Fiberboard, Knocked Down, Flat; Packing of.
- PPP-F-320 - Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes.

Federal Standard:

- Fed. Std. No. 123 - Marking for Shipment (Civil Agencies).

(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 at established distribution points in their agencies.)

PPP-B-6508

Military Standards

MIL-SFD-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.

3.1.1 Fiberboard The corrugated fiberboard used in the fabrication of boxes described by this specification shall conform to PPP-F-320, type CF, class domestic, variety SW, B-flute, grade 275, except that the grade for style I, size 2 and size 3 boxes shall be grade 200.

3.1.2 Metal fastenings. The metal fastenings shall be either steel staples or steel stitching wire having a commercially applied coating or plating such as zinc (galvanized) or copper wash. The steel staples or stitching wire shall be either 0.103-inch wide by 0.020-inch thick or the size known commercially as 0.103 by 0.017. The 0.103-inch by 0.020-inch fastening shall have a tolerance on the width of plus 0.001-inch, minus 0.005-inch, and on the thickness of plus unlimited, minus 0.001-inch. The 0.103 by 0.017 fastening shall have a minimum width of 0.098-inch and a minimum thickness of 0.016-inch; the arched section, after being formed, shall have a minimum width of 0.090-inch and a minimum thickness of 0.024-inch.

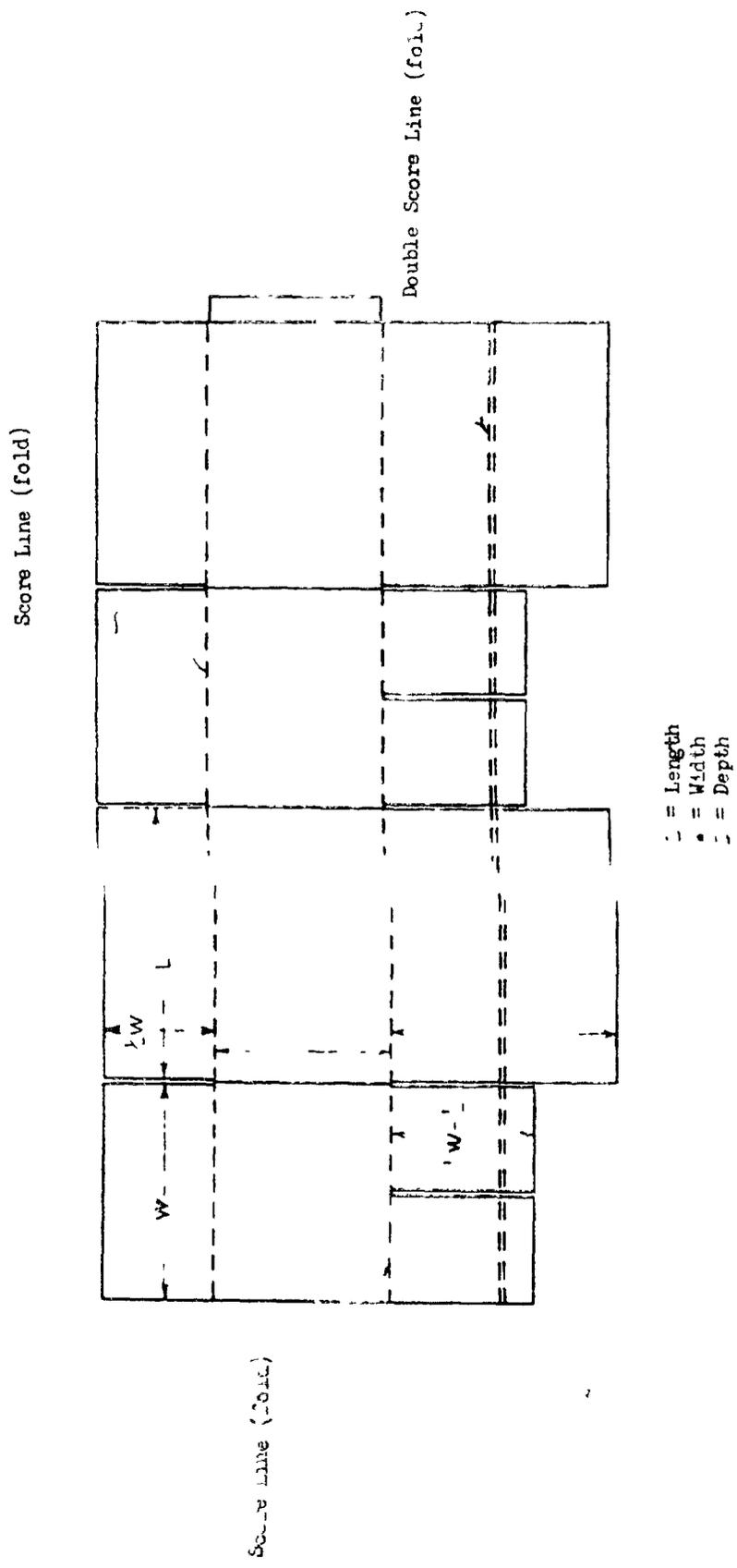
3.2 Box construction.

3.2.1 Dimensions. Boxes shall be furnished in the sizes specified in 1.2. Those dimensions are given in the sequence of length, width and depth, and are inside dimensions. A tolerance of plus or minus 1/8 inch shall be permitted for each dimension.

3.2.2 Box body.

3.2.2.1 Style I boxes. The box body shall be constructed as specified in PPP-B-636 for style RSC. The box body shall be constructed from one piece of fiberboard, die cut or rotary scored to form the box. The direction of the flutes shall be parallel to the manufacturer's joint.

3.2.2.2 Style II boxes. The box body shall be constructed as specified in 3.2.2.1 except that the bottom side flaps shall be the full width of the box double scored at the center along the length of the flap. The bottom end flaps shall be center slotted the full length of the flap to receive the tuck-in portion of the side flaps when folded and assembled. Scoring, folds, slotting and dimensions shall be as shown in figure 1.



NOTE: Dimensions are from center to center of score lines, and from center of score lines to, and flush with, edge of flaps on box panel, but should contain sufficient scoring clearance to produce the required inside dimensions.

FIG. II - TUCK BOTTOM BOX

PPP-B-c50B

3.2.3 Manufacturer's joint. The manufacturer's joint shall run along one of the four edges perpendicular to the top and bottom flaps. The manufacturer's joint shall be effected with a fiberboard lap which shall overlap inside the adjacent panel not less than 1-1/4 inches and extend the full depth of the box. The lap shall be an extension of either the side or end panel of the box. The lap shall not extend beyond the top and bottom score lines of the adjoining panel and the top and bottom edges of the lap shall not be more than 3/16 inch below the top score line or 3/16 inch above the bottom score line of the panel. The manufacturer's joint shall be fastened with metal fastenings specified in 3.1.2. The number of fastenings required for each box shall be as specified in 3.2.3.1, 3.2.3.2 or 3.2.3.3, as applicable.

3.2.3.1 Style I, sizes 1 and 2 and style II, size 1. The manufacturer's joint shall be fastened with seven (7) metal fastenings evenly spaced over the length of the joint.

3.2.3.2 Style I, size 3. The manufacturer's joint shall be fastened with four (4) metal fastenings evenly spaced over the length of the joint.

3.2.3.3 Style II, size 2. The manufacturer's joint shall be fastened with eight (8) metal fastenings evenly spaced over the length of the joint.

3.3 Boxmaker's certification. Each box shall bear the applicable certificate of the boxmaker in compliance with the requirements of the Uniform Freight Classification rules or National Motor Freight Classification rules, as applicable. The boxmaker's certificate shall be located on the bottom panel of the box.

3.4 Workmanship. The boxes shall be free from imperfections which may affect their utility. All dimensions of the boxmaker's blank shall be accurately cut, scored and slotted so that the assembled box parts fit closely without undue binding. No flap shall project beyond the edge of the box when the box is set up and closed. All metal fastenings shall be flush with the interior and exterior surfaces of the manufacturer's joint.

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 use his own 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.

4.1.1 Inspection of materials and components. In accordance with 4.1, the supplier is responsible for insuring that materials and components used were tested and inspected in accordance with the requirements of referenced subsidiary specifications and standards to the extent specified, or, if none in accordance with this specification. In the event of conflict, this specification shall govern.

4.2 Sampling for inspection and acceptance. Sampling for inspection and acceptance shall be performed in accordance with the provisions set forth in MIL-STD-105 except where otherwise indicated. For purposes of sampling, an inspection lot for examination shall consist of all material of the same style submitted for delivery at one time. When multiple sizes of one style are submitted, the inspection lot may consist of all sizes presented at one time, in which case sampling shall be in proportion or ratio to the respective sizes in the lot. The acceptable quality level (AQL) shall be applicable to the entire lot regardless of defects as they may occur in any one or more sizes of the box.

4.3 Examination of the end item. Examination of the end item shall be in accordance with the classification of defects, inspection levels, and AQL's set forth in the following. The lot size, for purpose of determining the sample size in accordance with MIL-STD-105, shall be expressed in units of boxes for examinations in 4.3.1 and 4.3.2. For examination in 4.3.3, the lot size shall be in units of shipping containers.

Examine	Defects
Material	Any component or material not as specified Fiberboard torn, split or punctured (affecting serviceability). Staples not coated or treated as specified.
Workmanship	Unduly ragged, uneven or crushed edge. Any ply separation more than 1/2 inch from edge of material (examine visually, measure if in doubt). Less than the specified number of metal fastenings. Any protruding metal fastening. Metal fastenings not flush with surfaces of the manufacturer's joint. Any construction or fabrication feature not in true alignment causing undue binding, flap(s) projecting beyond the edge of the box.
Scoring and score lines	Flutes running in wrong direction. Score not uniform and of insufficient depth to effect fold without distortion. Outer component ply or facing split completely through when folded in normal manner during assembly of box.
Marking	Boxmaker's certificates missing, incomplete, incorrect, or illegible.

4.3.2 Examination of the end item for dimensional defects. The sample unit for this examination shall be one completely fabricated box.

Examine	Defects
Metal Fastenings	Not within tolerance specified.
Box (overall inside dimensions)	Not within tolerance specified.
Flaps, lap joints	Less than size specified Less than overlap specified.

4.3.3 Examination of preparation for delivery. An examination shall be made to determine that markings, materials and workmanship comply with the requirements of section 5 of this specification. The sample unit shall be one shipping container fully packed or one bundle prepared for shipment.

Examine	Defects
Markings	Incorrect, incomplete, illegible, omitted, of improper size, location, sequence, or method of application
Materials	Any nonconforming component, component missing or otherwise defective.
Workmanship	Inadequate application of components; such as incomplete closure of container flaps, loose or inadequate ties on bundles Bulged or distorted containers or bundles.

PPP-B-650B

4.3.4 Inspection levels and AQL's for examination. The inspection levels for the purpose of determining the sample size, and the AQL's expressed in defects per 100 units, shall be as follows:

Examination paragraph	Inspection level	AQL
4.3.1	S-4	10.0
4.3.2	S-1	6.5
4.3.3	S-1	4.0

5. PREPARATION FOR DELIVERY

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

5.1.1 Level A. The boxes shall be packed knocked-down in accordance with the level A requirements of PPP-B-638.

5.1.2 Level B. Twenty-five (25) boxes shall be packed knocked-down flat in a bundle and securely tied or strapped using a minimum of two pieces of twine or strapping.

5.1.3 Level C. The boxes shall be packed knocked-down flat in bundles to afford adequate protection against damage during direct shipment from the supply source to the first receiving activity in compliance with the Uniform Freight Classification or National Motor Freight Classification.

5.2 Marking. Marking shall be in accordance with 5.2.1 or 5.2.2, as specified (see 6.2).

5.2.1 Civil agencies. In addition to any special marking required by the contract or order, shipments shall be marked in accordance with Fed. Std. No. 123.

5.2.2 Military requirements In addition to any special marking required by the contract or order, shipments shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Intended use. Style I boxes and style II, size 1 boxes are used to store paper records in Federal Records Centers. Style II, size 2 boxes are used to store magnetic tape records in Federal Records Centers.

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) Style and size required (see 1.2).
- (c) Level of packing required (see 5.1).
- (d) Marking required (see 5.2).

Military Custodians:

The Department of Defense has waived coordination of this specification.

Civil Agency Coordinating Activity

GSA - NARS

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. Price 30