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FEDERAL SPECIFICATION

CONTAINERS, PLASTIC, MOLDED
(FOR LIQUIDS, PASTES AND POWDERS): OVERPACKED

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 a combination unit consisting of a molded plastic container and a fiberboard box for overpacking.

1.2 Classification.

1.2.1 Types and classes. The fiberboard box shall be one of the following types (see table I). The plastic container shall be one of the following classes and capacities (see table I) and shall be made of high or low density polyethylene as specified (see 6.2) (see tables II and III).

TABLE I. Classification

Fiberboard box	Class Capacity	A 1 qt.	B 1 gal.	C 2-1/2 gal.	D 5 gal. (low density)	E 5 gal. (high density)
Type I, domestic service.		X	X	X	X	
Type II, weather resistant.			X	X	X	
Type III, weather resistant, impregnated.			X	X	X	
Type IV, domestic service.						X

2. APPLICABLE DOCUMENTS

2.1 Specifications and standards. The following specifications and standards, 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-601 - Boxes, Wood, Cleated Plywood
 PPP-B-636 - Box, Fiberboard
 PPP-B-638 - Boxes, Liners and Sleeves, Fiberboard Knocked Down, Flat; Packing of
 PPP-B-1163 - Box, Corrugated Fiberboard, High Compression Strength, Weather-Resistant, Wax-Resin
 Impregnated
 PPP-F-320 - Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes

Federal Standard:

Fed. Std. No. 123 - Marking for Domestic Shipment (Civilian 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 Officer, Washington, D. C. 20402.)

(Single copies of this specification and other product specifications required by activities outside the Federal Government for bidding purposes are available without charge at the General Services Administration Regional Offices in Boston, New York, Washington, D. C., Atlanta, Chicago, Kansas City, Mo., Fort Worth, Denver, San Francisco, Los Angeles, and Seattle, Wash.)

(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.)

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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 contractors 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 otherwise indicated, the issue in effect on date of invitation for bids or request for proposal shall apply:

Department of Transportation

Code of Federal Regulations, Title 49, Transportation Parts 178.24 (DOT Specification 2U)

(Application for copies should be addressed to the Superintendent of Documents, U. S. Government Printing Office, Washington, D. C. 20402.)

Technical Association of the Pulp and Paper Industry:

Testing Methods, Recommended Practices and Specifications

(Application for copies should be addressed to the Technical Association of the Pulp and Paper Industry, 360 Lexington Ave., New York, N. Y. 10017.)

American Society for Testing Materials (ASTM) Standards:

D1238-65T - Measuring Flow Rates of Thermoplastics by Extrusion Plastometer (Tentative)
 D1505-63T - Test for Density of Plastics by Density Gradient Technique (Tentative)
 D638-64T - Test for Tensile Properties of Plastics (Tentative)

(Application for copies should be addressed to the American Society for Testing Materials, 1916 Race St., Philadelphia, Pennsylvania 19103).

National Classification Board:

National Motor Freight Classification.

(Applications for copies should be addressed to the National Classification Board, 1616 P Street N. W., Washington, D. C. 20036.)

Uniform Classification Committee:

Uniform Freight Classification.

(Application for copies should be addressed to the Uniform Classification Committee, 202 Union Station, 516 West Jackson Boulevard, Chicago, Illinois 60606.)

(Technical society and technical association specifications and standards are generally available for reference from libraries. They are also distributed among technical groups and using Federal agencies.)

3. REQUIREMENTS

3.1 Plastic containers. Plastic containers shall be made of polyethylene compounds and shall conform to the following properties as listed in table II when tested in conformance with 4.4.2.2.

TABLE II. Properties of polyethylene compounds

Property	Low density	High density
Specific gravity 23°/23°C. range inclusive	0.910 to 0.925	0.941 to 0.965
Melt index, maximum grams per 10 minutes	2.6	1.2
Tensile strength, minimum p.s.i. - 23°C.	1500	3000
Ultimate elongation, minimum percent - 23°C.	400	75

3.1.1 Construction. The plastic container shall be blow-molded or thermoformed and meet the requirements of table III. The high density container, class E shall have edges and corners rounded to a 1-1/2 inch minimum radius.

TABLE I Construction requirements

Class and capacity	Minimum thickness	Percent outage	DOT specification 1/
Class A, 1 quart	0.006	15	--
Class B, 1 gallon	0.007	15	--
Class C, 2-1/2 gallon	0.010	15	2U
Class D, 5 gallon (low density)	0.010	15	2U
Class E, 5 gallon (high density)	0.015	15	--

1/ DOT-2U covers sizes over 1 gallon, except high density.

3.1.1.1 Design. The plastic container shall be rectangular in shape and shall be designed to accommodate the closure described in 3.2, as specified (see 6.2). The high density class E container shall have a threaded closure opening with a leak-proof screw cap. The inside dimension of the threaded opening shall be at least 2 inches and the threaded neck shall be located so that its front edge is no more than 3/4 inch from the front face of the plastic container. An integrally molded handle shall be included on the top surface of the plastic container just behind the threaded opening.

3.2 Closures.

3.2.1 Non-integral spout. A non-integrally molded spout shall be capable of being inserted into or attached to the flange so as to form a leak-proof seal, when tested in conformance to 4.4.2.1.

3.2.1.1 Flexible spout. A flexible spout shall be molded of commercial quality polyethylene. A diaphragm of the same material shall be molded as an integral part to the pouring end of the spout. That portion of the spout closure attaching to the plastic container flange shall be molded so that the plastic material shall form a leak-proof seal around the flanges. The preformed opening shall provide an opening in the container of not less than 2.7 inches to receive the flexible spout closure. The spout shall be collapsed inward and have a metal tamperproof cap made of 70 lb base weight stock which must be destroyed to remove. The spout shall be flexible enough to extend upward from collapsed position to pouring position. The pouring end of the spout shall have a plastic screw cap, made of the same material as the spout, for reclosing. The plastic screw cap shall have a bail or other suitable finger grip for lifting spout to a pouring position. The bail shall be molded as an integral part of the cap.

3.2.2 Integral spout. An integrally molded spout shall have a leak-proof cap, or be capable of being heat sealed to make a leak-proof seal when tested in conformance to 4.4.2.1.

3.2.2.1 Reclosure clip. When specified, heat sealed spouts shall be furnished with a metal or plastic clip seal for reclosure purposes after the heat seal has been opened.

3.3 Performance requirements. The plastic containers and fiberboard boxes shall meet the following performance requirements:

3.3.1 Drop resistance at standard low temperature. The plastic container when placed in the shipping container as specified and filled and closed as for shipment shall not rupture or leak when tested as described in 4.4.1.1.

3.3.2 Drop resistance at special low temperature. When specified (see 6.2), the plastic container, when placed in the shipping container as specified, and filled and closed as for shipment, shall not rupture or leak when tested as described in 4.4.1.2.

3.3.3 Drop resistance at room temperature. The plastic container, when placed in the shipping container as specified, filled and closed as for shipment, shall not rupture or leak when tested as described in 4.4.1.3.

3.3.4 Drop resistance at high temperature. When specified (see 6.2), the plastic container, when placed in the shipping container as specified, filled and closed as for shipment, shall not rupture or leak when tested as described in 4.4.1.4.

3.3.5 Wet strength. When the plastic containers are furnished in type III, water resistant, wax-resin impregnated boxes, the assembled containers shall withstand the compression load as applied in accordance with 4.4.1.5.

3.3.6 Leakage. The filled and sealed containers shall not leak when tested as described in 4.4.2.1.

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3.4 Fiberboard boxes. The boxes may have perforations or cutouts to facilitate pouring and handling. The perforations or cutouts shall not decrease the protection provided for the plastic container. The length and width of the fiberboard box shall form a snug fit with the plastic containers.

3.4.1 Type I boxes. Type I domestic service fiberboard boxes shall meet the requirements of PPP-B-636, class domestic.

Class A boxes shall be variety SW, grade 125.

Class B boxes shall be variety SW, grade 200.

Class C boxes shall be variety SW, grade 275.

Class D boxes shall be variety SW or DW, grade 250.

3.4.2 Type II boxes. Weather-resistant fiberboard boxes shall meet the requirements of PPP-B-636, class weather resistant.

Class B boxes shall be variety SW, grade W6c.

Class C boxes shall be variety SW, grade W5c.

Class D boxes shall be variety SW, grade V3c.

3.4.3 Type III boxes. High compression strength, weather-resistant wax-resin impregnated fiberboard boxes shall meet the requirements of PPP-B-1163

Class B boxes shall be type SW, grade 200.

Class C boxes shall be type DW, grade 275.

Class D boxes shall be type DW, grade 275.

3.4.4 Type IV boxes. Domestic service fiberboard boxes for use with high density polyethylene containers shall meet the requirements of PPP-B-636, class domestic, variety SW or DW, grade 350. The fiberboard box shall provide a snug fit for the side walls of the plastic container and shall provide a minimum clearance between the handle and screw cap of the plastic container and the inside of the top flaps when closed. The flaps on style RSC boxes shall be closed by gluing. Steel strapping is not required.

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, the supplier may utilize his own facilities or any commercial laboratory acceptable to 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.

4.2 Inspection provisions.

4.2.1 Regular production lot. A regular production lot shall consist of the plastic containers of one type and class, produced by one manufacturer from the same material and under essentially the same manufacturing conditions and offered for delivery at one time. The inspection lot of fiberboard boxes shall consist of all material of the same type, style, class variety, and grade submitted for inspection and delivery at the same time.

4.2.2 Sampling.

4.2.2.1 Non-destructive examination and testing. Sampling for non-destructive examination shall be conducted in accordance with MIL-STD-105 using inspection level S-4.

4.2.2.2 Performance testing. Samples for performance testing shall be as specified by the procuring activity.

4.2.3 Examination and tests.

4.2.3.1 Examination. Sample plastic containers shall be examined in accordance with the classification of defects and with MIL-STD-105.

4.2.3.2 Tests. The sample plastic containers taken in accordance with 4.2.2.1 shall be tested in accordance with 4.4.

2.4 Classification of examination defects

2.4.1 Plastic containers.

Categories and defects.

Major - AQL 1.0 percent defective: style or size incorrect, sidewall, bottom and top thickness does not meet minimum, dimensions incorrect, component missing, incorrect, or incorrectly assembled; threads incorrect.

4.3 Inspection of the end item.

4.3.1 Examination of the end item. The examination of the end item shall be made in accordance with the classification of defects, inspection levels, and acceptable quality levels (AQL's) set forth below. The lot size for purpose of determining the sample size in accordance with MIL-STD-105, shall be expressed in units of plastic containers complete with spout and closure for examinations in 4.3.1.1 and 4.3.1.3, and in units of knock-down fiberboard boxes for examination in 4.3.1.3 and 4.3.1.4. For examination in 4.3.1.5 the lot size shall be expressed in units of shipping containers of plastic containers or knocked down fiberboard boxes, as applicable.

4.3.1.1 Examination of the plastic container for defects in material, construction appearance and workmanship. The sample unit for this examination shall be one complete plastic container with spout and closure.

Examine	Defect
Material	Any material or component not as specified.
Construction and appearance	Any material missing or malformed. Not rectangular in shape. Closure not as specified. Spout (When not integrally molded in the container) does not uniformly fit flange to form a leak-proof seal. NOTE: When in doubt as to the leakproofness of spout or spout cap, the plastic container shall be filled with water and inverted or tipped to test the closure for evidence of leaking. Diaphragm for flexible spout not uniformly and completely molded to pouring end of spout as specified. Tamperproof metal cap for flexible spout not uniformly and securely fastened to spout. Plastic screw cap for flexible spout does not fit uniformly and securely. Bail for cap not uniformly and securely molded as integral part of the cap. Integrally molded spout not capable of being closed as specified. Metal or plastic reclosure clip seal, when required, not as specified. Any hole, crack, blister, wrinkle, pinhole, tear, sharp crease, heel break, nick or cut, unfused resin particles or foreign matter, or other defect in the plastic which will impair serviceability of the plastic container. NOTE: Sporadic unfused resin particles, no larger than 1/32 inch in diameter, unless occurring in a seam or fold, will be acceptable. No more than one defect will be permitted in any one plastic container.
Workmanship	Any fabrication feature or characteristic of the plastic container or components or the fiberboard box not in true alignment which renders parts incompatible. Any seam or seal in the plastic container construction not uniform, straight and continuous. Threads, where applicable in plastic container spout assembly incorrect or otherwise defective affecting compatibility. Not clearly embedded foreign matter in plastic container.

4.3.1.2 Examination of the plastic container for dimensional defects. The sample unit for this examination shall be one complete plastic container with spout and closure.

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Examine	Defect
Capacity	Does not contain volume specified (see table III).
Container wall thickness	Not as specified (see table III). NOTE: The average of 10 measurements made on sidewall, bottom, and top head of the plastic container and 5 measurements made of the area adjacent to the forming opening for closure, as applicable, shall represent the wall thicknesses and shall be within plus or minus 10 percent of the specified thickness. The minimum thickness of any one determination shall be not more than 15 percent less than the specified thickness.)

4.3.1.3 Examination of the fiberboard box for defects in material, construction, and workmanship. The sample unit for this examination shall be one fiberboard box with fiberboard liner, as applicable for type I, II, III, or IV boxes. Examination shall be performed in accordance with the quality assurance provisions of the applicable box specification.

Examine	Defect
General (all box and plastic containers)	Not clean, unused material. Presence of foreign matter.
Plastic container (when applicable)	Tear, split, puncture, or other defect affecting serviceability.

4.3.1.4 Examination of the fiberboard container for dimensional defects. The sample unit for this examination shall be one fiberboard box with plastic container, as applicable. This examination shall be performed in accordance with the quality assurance provisions of the applicable box specification.

Examine	Defect
Overall size	Does not contain component plastic container uniformly and compactly.
General	Plastic containers, when applicable, are either too large or too small to fit box.

4.3.1.5 Examination of preparation for delivery. An examination shall be made to determine that packaging, packing and marking meet all requirements of section 5 and the appendix to this specification. The sample units shall be one shipping container of plastic containers or one shipping container of knock-down fiberboard boxes, as applicable, fully packed and selected just prior to closing operation. Shipping containers fully prepared for delivery shall be examined for closure defects. The inspection level shall be S-2 and the AQL shall be 4.0 defects per hundred units as required by MIL-STD-105

Examine	Defect
Material	Any packaging or packing material or component not as specified Any component missing or malformed.
Packaging of plastic containers	Not collapsed and nested, if specified and packed with spouts and closures uniformly and compactly in the shipping container to prevent abrasion or shifting during shipment and handling. Less than the specified number of plastic containers, complete with spouts and closures as applicable per shipping container.
Packaging of Knocked-down fiberboard boxes	Not neatly and uniformly stacked in shipping container to prevent shifting of contents during shipment and handling Less than the specified or indicated number of boxes per shipping container.
Packing	Inadequate application of components, such as incomplete closure of container flaps, loose or crooked strapping or banding. Bulge or distortion of container.
Marking	Omitted; incomplete; illegible, or improper size; location, method or sequence and application.

4.3.1.6 Inspection levels and AQLs for examinations The inspection levels for the purpose of determining sample size and AQLs expressed in defects per hundred units shall be as follows:

<u>Examination paragraph</u>	<u>Inspection level</u>	<u>AQLs</u>
4.3.1.1	I	1.5
4.3.1.2	S-3	2.5
4.3.1.3	S-4	4.0
4.3.1.4	S-2	4.0
4.3.1.5	S-2	4.0

NOTE: The inspection levels and AQLs for type I, II, III and IV fiberboard boxes shall be as indicated in the quality assurance provisions of the applicable box specification.

4.3.2 Design-proof testing of the end item. Tests shall be performed on samples of the end item for characteristic requirements as indicated in 4.4. The sample unit shall be one complete plastic container assembly with spout and closure, as applicable and its accompanying fiberboard box. Tests shall be conducted by the manufacturer of the plastic container. Test reports shall be made available to the contractor and to the U. S. Government inspector to indicate conformance with design requirements. Tests will be repeated at no greater than 4-month intervals for confirmation of design. Also, changes of construction or design will require retesting. A minimum of three samples shall be used for each test required.

4.4 Tests

4.4.1 Performance tests.

4.4.1.1 Drop resistance test (standard low temperature of boxes and plastic containers). The plastic container shall be placed in a box of the specified type and class (3.4.1 through 3.4.4). The plastic container shall be filled to 98 percent of capacity with liquid which is compatible with polyethylene and will remain liquid at 0°F. The filled shipping container shall then be sealed as for shipment and conditioned for 24 hours at 0°F. Immediately after conditioning, the sealed shipping container shall be dropped from a height of 48 inches onto a steel, concrete, or stone surface of sufficient mass to absorb the shock without deflection so that the corner of the shipping container absorbs the full force of the fall. This test shall be repeated on top and bottom, and two other sides of the shipping container. The fall shall be a free fall, in that no ropes or other suspending media are attached to the shipping container during the fall.

4.4.1.2 Drop resistance test (special, low temperature). When specified (see 6.2), the plastic container and fiberboard box shall be assembled and filled to rated capacity using a liquid which is compatible with polyethylene, and remains fluid at -40°F. The filled container shall be held at a temperature lower than -40°F, until the contents are at or below -40°F. Immediately after such conditioning, the container shall be dropped twice from a height of 48 inches onto a steel, concrete, or stone surface of sufficient mass to absorb the shock without deflection. Each unit shall be dropped so as to hit once along the top edge adjacent to the closure and one along a bottom edge. This test shall be conducted with individual plastic container and fiberboard box and shall not include an outer shipping container.

4.4.1.3 Drop resistance test (room temperature) of boxed plastic container. The plastic container and fiberboard box as specified in 4.4.1.1 shall be filled to 98 percent of capacity with water. The filled shipping container shall then be sealed as for shipment and conditioned for 24 hours at 75°F. \pm 50°F. The sealed shipping container shall then be given the drop test as described in 4.4.1.1.

4.4.1.4 Drop resistance test (special high temperature). When specified (see 6.2), the plastic container shall be placed in a box of the specified type and class (3.4.1 through 3.4.4). The plastic container shall be filled to 98 percent of capacity with water. The filled shipping container shall then be sealed as for shipment and conditioned for 72 hours at 92.5 \pm 2.5 percent relative humidity at a temperature of 125°F. \pm 50°F. Immediately after conditioning, the sealed shipping container shall be dropped from a height of 48 inches onto a steel, concrete, or stone surface of sufficient mass to absorb the shock without deflection so that the corner of the shipping container absorbs the full force of the fall. This test shall be repeated on top, and bottom and two other sides of the container. The fall shall be a free fall, in that no ropes or other suspending media are attached to the shipping container during the fall.

4.4.1.5 Wet strength test, type III boxes. The plastic container shall be placed in the type III, water-resistant impregnated box of the grade specified. The assembled container shall be filled to rated capacity with water at ambient temperature, closed, and prepared as for shipment. Each of the samples shall then be subject to a constant load of 50 pounds per gallon of nominal capacity (minimum) and soaked with water for one hour by directing a steady stream of water (1 gallon per minute minimum) against the sidewalls of the box. The loaded units shall be allowed to remain undisturbed under the prescribed load for 24 hours and then examined for top and bottom compression. The box must be supporting the load after this period and there shall be no more than 1/2-inch vertical deflection.

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4.4.2 Acceptance tests.

4.4.2.1 Leakage (room temperature). The plastic containers selected for testing (see 4.2.2.1) shall be filled with water which has been strongly colored with ink or other suitable coloring agent which is not a permeator of polyethylene and a 1/10 of 1.0 percent aerosol OT shall also be added to the water as a wetting agent. Caps shall be screwed down and tightened or spouts sealed, as applicable. The plastic container shall then be placed with the spout down upon a sheet of white blotting paper. Examine after 15 minutes. Discoloration of the paper by the colored water is regarded as failure of the test.

4.4.2.2 Tests of the polyethylene. The tests for the properties specified in 3.1 and table II shall be made as shown in table IV.

TABLE IV. Methods of testing polyethylene

Property	Test method (ASTM)
Specific gravity 23°/23°C.	D1505-63T
Melt index	D1238-65T
Tensile strength	D638-64T
Elongation, ultimate	D638-64T

5. PREPARATION FOR DELIVERY

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

5.1.1 Packing unfilled plastic containers.

5.1.1.1 Level A. Unless otherwise specified herein low density plastic containers shall be collapsed, nested and packed with their spouts and closures, as applicable, in fiberboard boxes conforming to PPP-B-636, V2s. Class E, high density plastic containers shall not be collapsed nor nested. They shall be packed in fiberboard boxes, conforming to PPP-B-636, V2s. When specified (see 6.2) the shipping container shall conform to PPP-B-601, styles A, B or J, overseas type.

5.1.1.2 Level B. Unless otherwise specified herein low density plastic containers shall be collapsed, nested, and packed with their spouts and closures, as applicable, in fiberboard boxes conforming to PPP-B-636, class domestic. High density plastic containers, class E, shall not be collapsed nor nested. They shall be packed in type IV boxes (see 3.4.4). No additional packing is required. When specified (see 6.2) the shipping container shall conform to PPP-B-636, V3c or V3s, or made from material conforming to PPP-F-320, V4s.

5.1.1.3 Level C. Plastic containers shall be packed to assure carrier acceptance and safe delivery at destination in containers complying with the National Motor Freight Classification or Uniform Freight Classification rules as applicable.

5.1.2 Packing of fiberboard boxes (knocked down).

5.1.2.1 Levels A, B, and C. The fiberboard boxes shall be prepared for delivery in accordance with the appropriate levels as specified, in accordance with the requirements of PPP-B-638.

5.2 Marking.

5.2.1 Civil agencies. In addition to the markings required by the contract or order, the fiberboard containers shall be marked in accordance with Fed. Std. No. 123.

5.2.2 Military agencies. In addition to markings required by the contract or order, the fiberboard containers shall be marked in accordance with MIL-STD-129.

5.2.3 Special marking. All fiberboard boxes or other packing containers in which unfilled plastic containers are packed will be clearly legibly and permanently marked as follows:

"THESE CONTAINERS NOT TO BE USED WITH FOOD OR BEVERAGES"

5. INTENDED USE

5.1. Intended use. Plastic containers covered by this specification are intended for use as containers for liquids, powders, or gases. They are not intended for use with some strong oxidizing liquids such as concentrated nitric or sulfuric acids, or aromatic or aliphatic hydrocarbons but are suitable for some organic or inorganic acids, alcohols, and alkalies. In all cases the chemical should not be packed in these plastic containers if the boiling point of the chemical approximates or is lower than the anticipated storage temperature. There shall be no undesirable reaction between the contents and the plastic container. These containers are not to be used for the transportation or storage of food or beverages.

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) Type and class of box and plastic container (see 1.2.1).
- (c) Dimensions of plastic container, if specified (see 1.2.1)
- (d) Type of closure, if specified (see 3.2).
- (e) Type and level packing required (see 5.1).
- (f) Low or high density polyethylene (see table II).
- (g) Method of delivery, setup or knocked-down (see 5.1.2)
- (h) Special test requirements (see 4.4.1.2 or 4.4.1.4)
- (i) When boxes conforming to PPP-B-601 are required (see 5.1.1.1).
- (j) When weather-resistant fiberboard boxes are required for level B shipments (see 5.1.1.2).

Preparing activity:

CSA-FSS

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APPENDIX

REQUIREMENTS FOR CLOSURE AND PACKING OF FILLED CONTAINERS

10. SCOPE

10.1 This appendix covers requirements for closing and packing of filled plastic containers.

10.2 Unless otherwise specified by the procuring activity, filled containers shall be closed and packed in accordance with the appendix.

20. APPLICABLE DOCUMENTS

20.1 Specifications and standards. The following specifications and standards, 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 - Box, Fiberboard

PPP-T-97 - Tape, Pressure-Sensitive Adhesive, Filament Reinforced

Federal Standard:

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

Military Standard:

MLL-STD-129 - Marking for Shipment and Storage

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

Department of Transportation:

Code of Federal Regulations, Title 49, Transportation Parts 178.24 (DOT Specification 2U).

(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, D. C. 20402.)

UNIFORM CLASSIFICATION COMMITTEE:

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, 202 Union Station, 516 West Jackson Boulevard, Chicago, Illinois 60606.)

30. CLOSURE

30.1 Plastic container. The plastic container shall be closed by heat sealing or securing the cap, whichever is applicable, to form a leak-proof seal.

30.2 Boxes.

30.2.1 Type I and II boxes. Type I and II boxes shall be closed as described in the appendix of PPP-B-636, except that steel strapping shall not be required. If stapling is used, top and bottom pads shall be provided to protect the plastic container from damage by the staples.

30.2.2 Type III boxes. Type III boxes shall be closed by using waterproof glue or by stapling. In the event that stapling is used, top and bottom pads shall be provided to protect the plastic container from damage by the staples.

30.2.3 Type IV boxes. Type IV boxes shall be closed in accordance with the requirements of method II of the appendix to PPP-B-636, except that if the bottom flaps are closed with staples, or metal stitches, a pad shall be provided to prevent damage to the bottom of the plastic container by the metal staple or stitches.

40. PACKAGING

40.1 Packaging shall be specified in 1.2.1 and 3.4.

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50. PAC INQ

50. Level A.

50.1.1 Type I, class D boxes shall require no overpacking.

50.1.2 Types II and III, class B boxes shall be packed six units or less in a box conforming to PPP-B-636, class weather-resistant.

50.1.3 Types II and III, class C boxes shall be packed two units to a box conforming to PPP-B-636, class weather-resistant.

50.1.4 Types II and III, class D boxes shall not require any overpacking but shall be reinforced by PPP-T-97 tape as outlined in the appendix to PPP-B-636. For military procurements all level A packs shall be overpacked in a snapping container conforming to PPP-B-601, styles A, B or J, or PPP-B-591, class 2.

50.2 Level B.

50.2.1 Type I, class A boxes shall be packed 12 units to a box conforming to PPP-B-636, class domestic.

50.2.2 Type I, class B boxes shall be packed 6 units to a box conforming to PPP-B-636, class domestic.

50.2.3 Type I, class C boxes shall be packed 2 units to a box conforming to PPP-B-636, class domestic.

50.2.4 Type I, class D boxes and type IV, class E boxes shall require no overpacking.

50.2.5 When specified (see 6.2) the boxes shall be packed in boxes conforming to PPP-B-636, V3c or V3s (see 5.1.1.2).

50.3 Level C. Unit packages prepared for shipment as specified, shall be packed to insure safe arrival at destination and which will be acceptable to the carrier at lowest rates. Containers and packing shall comply with Department of Transportation Regulations and with Uniform Freight Classification rules or other common carrier regulations applicable to the mode of transportation.

50.4 When specified by the procuring activity, unit packages prepared for shipment as specified shall be packed to insure sufficient absorbent cushioning material, to absorb entire liquid contents in case of leakage or rupture, is placed between unit packages and exterior box.

60. MARKING

60.1 Civil agencies. In addition to any markings specified in contract or order, markings shall be in accordance with Fed. Std. No. 123.

60.2 Military agencies. In addition to any markings specified in contract or order, markings specified shall be in accordance with the requirements of MIL-STD-129 and when applicable, "Hazardous Chemical" markings.

60.3 Labels. The top outer flap of each type III box shall be preprinted with the following legend.
"When the use of labels is required, use only pressure sensitive labels."

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 reference herein. Price 15 cents each.

GENERAL SERVICES ADMINISTRATION - FEDERAL SUPPLY SERVICE

BUDGET BUREAU NO.

SPECIFICATION COMMENT SHEET

29-R0175

INSTRUCTIONS

This form provides a way for users of this specification to inform the originator of problems encountered in its use. It is not to be used to request changes to accommodate proprietary features. All comments will be considered and appreciated, but please do not expect a reply. To comment detach, complete, fold, staple, and mail.

NOTE Comments on this form do not constitute or imply authorization to waive any part of the document or serve to amend contractual requirements

1 SPECIFICATION

PPP-C-569C - Containers, Plastic, Molded (For Liquids, Pastes and Powders):

Overpacked

2. CONTRACT NO (If any)

3 QUANTITY ON CONTRACT (Optional)

4. DOLLAR VALUE (Optional)

5. GENERAL NATURE OF PROBLEM (e.g., inspection difficulties, manufacturers unable to meet tolerances, containers collapse under normal warehousing conditions, etc.)

6 SPECIFIC REQUIREMENTS AFFECTED (Include paragraph number and lines of wording)

7 SPECIFIC PROBLEMS (e.g. tests in 4.2.2 will not assure that the battery will last required time, temperature ranges in table 2 do not conform to commercially available items)

8 RECOMMENDATIONS

9 NAME OF MANUFACTURER, ASSOCIATION, GOVT., AGENCY ETC

10 ADDRESS (Number, Street, City, State and Zip Code)

11 NAME AND TITLE OF SUBMITTER

12 DATE

FOLD

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