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PPP-P-1134D
October 28, 1983
SUPERSEDING
Int. Fed. Spec. PPP-P-001134C(GL)
September 23, 1981 and
Fed. Spec. PPP-P-1134B
October 4, 1974

FEDERAL SPECIFICATION

PACKAGING OF COTTON AND COTTON-SYNTHETIC FIBER BLEND FABRICS (EXCLUDING DUCK FABRICS)

This specification is approved by the Assistant Administrator, Office of Federal Supply and Services, General Services Administration, for the use of all Federal agencies.

1. SCOPE

1.1 Scope. This specification covers the preservation, packing, and marking of cotton and cotton-synthetic fiber blend fabrics for shipment and storage.

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:

A-A-203	-	Paper, Kraft, Untreated
V-T-276	-	Thread, Cotton
QQ-S-781	-	Strapping, Steel, and Seals
CCC-C-429	-	Cloth, Osnaburg, Cotton
CCC-C-467	-	Cloth, Burlap, Jute (or Kenaf)
PPP-B-576	-	Boxes, Wood, Cleated, Veneer, Paper Overlaid
PPP-B-591	-	Boxes, Shipping, Fiberboard, Wood-Cleated
PPP-B-601	-	Boxes, Wood, Cleated-Plywood
PPP-B-640	-	Boxes, Fiberboard, Corrugated, Triple-Wall
PPP-F-320	-	Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes
PPP-P-291	-	Paperboard, Wrapping and Cushioning
PPP-S-760	-	Strapping, Nonmetallic (and Connectors)
PPP-T-45	-	Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing
PPP-T-60	-	Tape, Packaging, Waterproof

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Federal Standards:

FED-STD-101 - Test Procedures for Packaging Materials
FED-STD-123 - Marking for Shipment (Civil Agencies)
FED-STD-191 - Textile Test Methods
FED-STD-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 monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, US Government Printing Office, Washington, DC 20402.

(Single copies of this specification, other Federal specifications, standards, 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, MA; New York, NY; Philadelphia, PA; Washington, DC; Atlanta, GA; Chicago, IL; Kansas City, MO; Fort Worth, TX; Houston, TX; Denver, CO; San Francisco, CA; Los Angeles, CA; and Seattle, WA.

(Federal Government activities may obtain copies of Federal standardization, documents and the Index of Federal Specifications, Standards and Commercial Item Descriptions from established distribution points in their agencies.)

Military Specifications:

MIL-B-121 - Barrier Material, Greaseproofed, Waterproofed, Flexible
MIL-L-10547 - Liners, Case, and Sheet, Overwrap; Water-Vaporproof or Waterproof, Flexible
MIL-T-40625 - Tubing, Bias Sewn (Burlap or Osnaburg), Cloth

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 a 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.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 3951 - Standard Practice for Commercial Packaging

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

AMERICAN IRON AND STEEL INSTITUTE (AISI)

Type number 304 - Stainless and Heat Resistant Steel

Type number 316 - Stainless and Heat Resistant Steel

(Application for copies of Steel Product Manual should be addressed to the American Iron and Steel Institute, 150 East 42nd St., New York, NY 10017.)

(Industry 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 General.

3.1.1 Material. The material shall be as hereinafter specified.

3.1.2 Identification. Each roll or flat folded piece shall have a piece ticket (identification tag) attached to the selvage with not finer than 5-ply cotton string doubled to not less than 8 inches long or a plastic tag hanger 5-inch minimum length. The piece ticket shall be made of not less than 15 point paper stock and the finished surface shall not be calendered or pigmented to the degree which would cause the obliteration of printed, stamped, or typed markings. The piece ticket shall have a reinforced eyelet for attaching the tying cord or hanger, and shall be legibly printed with water insoluble ink with the markings shown on figure 1. Entries on piece tickets (tags) shall be printed, stamped, or typed. The entries shall be complete and responsive with respect to the information required by the piece ticket legend (see figure 1). Hand lettered entries are permitted, but hand written entries are not permitted.

3.2 Put-up. Put-up shall be level A or Commercial as specified (see 6.1).

3.2.1 Level A flat-folded pieces (bolts). Fabrics shall be folded, open-width, in approximately 1-yard folds with the face inward. Pieces shall then be folded in half with the crease at right angles to the warp. The put-up shall be completed by using the free end of the fabric to encircle the piece. Each piece shall then be tied with cotton tape or string placed approximately 6 inches from each edge. Tying with cotton tape or string is not required when each flat folded piece (bolt) is wrapped in accordance with 3.3.2.

3.2.1.1 Rolls. Fabrics shall be rolled open-width with the face to the inside on a convolute or spiral-wound chipboard tube. The tube shall have an outer cover of kraft paper glued to the surface or an equivalent smooth finish surface that will prevent the fibers of the chipboard from transferring to the fabric. The tube shall have a minimum wall thickness of 0.1875 inch with a minimum inside diameter of 1.5

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inches. The ends of the tube shall be flush with or extend not more than 1-inch beyond each side of the maximum width of the rolled fabric (see figure 2). Rolls of fabric shall be restrained from unwinding by securing the fabric with cloth tape, cotton tape, stainless steel (AISI type number 304 or number 316, see 2.2) pins, tin or nickel plated brass pins, aluminum clips, or plastic fasteners. Rolls 36 inches or less in width shall be secured approximately 1/6 the distance from each end. Rolls exceeding 36 inches shall have an additional fastening at the center of the roll. When two or more pieces are put-up in a roll, the ends shall be lapped or butted, single-ply through-out. When specified (see 6.1), the kraft paper wrapping shall not be required for each roll of fabric. There shall be no splices unless otherwise specified in the fabric specification. Unless otherwise specified in the fabric specification, the weight of each roll shall not exceed 125 pounds, except when the weight of the specified yardage in one continuous piece exceeds 125 pounds.

3.2.2 Commercial. Fabrics shall be put-up in flat folds or roll form in accordance with the industry's standard practice.

3.3 Preservation. Preservation shall be level A, B or Commercial as specified (see 6.1).

3.3.1 Level A.

3.3.1.1 Flat-folded pieces (bolts). No preservation is required.

3.3.1.2 Rolls. Each roll of fabric, except as specified in 3.3.1.2.1 and 3.3.1.2.2, shall be wrapped with 70 pounds per ream (24 x 36 - 500) minimum basis weight kraft paper conforming to A-A-203. The roll shall be wrapped so that the paper shall completely encircle the roll at least once with a minimum overlap of 3 inches, and the width of the paper shall be sufficient to fold over and protect the ends of the roll. Gummed paper tape, 2-1/2 inches minimum width conforming to type III, grade C of PPP-T-45, shall be applied on the overlap seam the full length of the roll, across each end, and extend along the side opposite the overlap seam 2-1/2 inches. Strips of tape shall be applied crosswise over the ends and shall extend a minimum of 2-1/2 inches along the length of the roll (see figure 2).

3.3.1.2.1 Alternative unit packing of rolls.

a. Each roll of fabric shall be inclosed within a double-wall (2-ply) paper tube or bag fabricated of 50 pounds per ream (24 x 36 - 500) minimum basis weight kraft paper conforming to A-A-203. The tube shall be of sufficient size to effect top and bottom closures specified herein. Bottom closure of the bag or tube shall be effected by folding 1-1/2 inches (single turnover) on one end and sewing approximately 3/4 inch from the bottom of the fold. The bag or tube bottom closure may also be made by evenly folding a strip of paper tape over the open end and sewing through all walls of paper a minimum of 3/8 inch to a maximum of 3/4 inch from the bag end. The tape shall be a minimum 2-1/8 inches wide made from creped or

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uncreped kraft paper having a minimum basis weight of 70 pounds and shall extend across the bag to protrude not less than 1/2 inch beyond both edges of the bag. Sewing thread shall be ticket No. 12, 4-ply, type IA1 conforming to V-T-276. Stitching shall be spaced not less than 3 nor more than 6 stitches to the inch using a lock or chain stitch. Top closure shall be effected by folding over and securely sealing by the application of gummed paper tape 2-1/2 inches minimum width conforming to type III, grade C of PPP-T-45, 2-inch tape conforming to PPP-T-60, or by sewing as specified for bottom closure (see figure 2).

or

b. Each roll of fabric shall be inclosed in a close-fitting polyethylene film tube with a minimum thickness of 0.004 inches. The tube shall be secured by heat-sealing, or by means of a mechanical tie (paper or plastic covered soft steel wire or aluminum band), or by plastic ties with a lock end.

3.3.1.2.2 Fabrics exceeding a width of 48 inches and weighing 100 pounds or less. Rolls of fabric exceeding a width of 48 inches and weighing 100 pounds or less shall be individually enclosed in a one-piece wrap of paperboard cushioning conforming to type III, style 1 of PPP-P-291. The wrap shall be applied with the cushioned surface inward and shall have a minimum circumferential overlap of 3 inches. The end overlap shall be equal to 1/2 the diameter of the roll plus 3 inches. The overlap along the length of the roll shall be completely sealed with a strip of 3-inch minimum width reinforced gummed paper tape conforming to type II, class 2 of PPP-T-45 evenly applied over the seam area. The overlap on each end shall be formed into a full pleat fold and shall be secured with three strips of 3-inch minimum width tape. The tape shall be applied over the end and each of the two diagonals of the pleated fold with the end of each tape extending not less than 4 inches along the length of the roll.

3.3.2 Level B flat-folded pieces (bolts) (Civil agencies). Each bolt shall be wrapped in 50 pound minimum basis weight kraft paper conforming to A-A-203. The kraft paper wrap shall be secured with gummed paper tape. Alternatively, the wrap shall be a plastic film not less than 0.002 inch thick (± 20 percent tolerance).

3.3.3 Commercial. Fabrics shall be preserved in accordance with ASTM D 3951.

3.4 Packing. Packing shall be level A, B, or Commercial as specified (see 6.1).

3.4.1 General. Only one style or type of container shall be used for the fabric of one description, width, weight, finish, and shade on any specific contract or order. The inside length of shipping containers shall be the length of the roll or folded pieces and the inside width of the containers shall be the sum of the diameter of the rolls (see figure 4) or the width of the folded pieces, as applicable. Rolls or folded pieces packed per container shall be of a sufficient quantity to produce a full and even height pack. Insofar as quantity permits, shipping containers shall be uniform in size and shall contain approximately the same number of rolls or flat folded pieces.

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3.4.2 Level A packing.

3.4.2.1 Flat-folded pieces (bolts). Flat-folded pieces of fabric, put-up as specified, shall be packed in a snug-fitting wood-cleated plywood, wood-cleated fiberboard, or wood-cleated veneer container constructed, closed, and strapped in conformance with PPP-B-601, overseas type, grade A, type 3 load. Each shipping container shall be provided with a type I, grade B case liner conforming to MIL-L-10547, except that the barrier material shall be type I, class 1, grade A of MIL-B-121. The net weight of contents in shipping containers shall not exceed 250 pounds.

3.4.2.2 Rolls, weighing 250 pounds or less. Rolls of fabric, weighing 250 pounds or less, preserved as specified, shall be packed in snug-fitting wood boxes constructed, closed and strapped in conformance with overseas type, grade A, type 3 load of PPP-B-601; class II, type 3 load of PPP-B-591; or wood-cleated veneer box conforming to style A or B, class 2, type 3 load of PPP-B-576. Prior to packing, the rolls of fabric shall be overwrapped with one of the following waterproofed barrier materials:

(a) 0.004-inch thick (± 20 percent tolerance) polyethylene film or tubing.

(b) Barrier material with outside portion of the liner made from kraft paper having a basis weight of not less than 60 pounds per ream (24 by 36-500) creped in one direction with not less than 7 percent minimum stretch. The inside portion of the kraft paper shall be coated with polyethylene not less than 1-1/2 mils (22-1/2 pounds per ream) in thickness. The coating shall be uniformly applied to the kraft paper and shall be free from defects that may impair the function of the barrier material.

All seams and joints of the overwrap shall be sealed with minimum 2-inch width tape conforming to PPP-T-60 or by heat sealing. Alternatively, each shipping container may be provided with a type I, grade B case liner conforming to MIL-L-10547, except the barrier material shall be type I, class 1, grade A of MIL-B-121. The net weight of contents in shipping containers shall not exceed 250 pounds.

3.4.2.3 Rolls exceeding 250 pounds. When a single roll of fabric, preserved as specified, exceeds 250 pounds, it shall be overwrapped with one of the waterproof barrier materials specified in 3.4.2.2 and packed in bias-sewn tubing as specified in 3.4.2.3.1; or it shall be packed in laminated tubing as specified in 3.4.2.3.2. When such outer coverings are used, no additional packing is required.

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3.4.2.3.1 Bias-sewn tubing. Bias-sewn tubing shall be made from cotton osnaburg cloth conforming to class 2 of CCC-C-429, jute (or kenaf) burlap cloth conforming to class 3 of CCC-C-467, or woven polypropylene fabric. Cotton osnaburg or burlap tubing shall conform to MIL-T-40625. Woven polypropylene tubing shall be made from minimum 2.1 ounces per square yard material and shall conform to the following requirements. Tensile breaking strength of the fabric shall be 90 pounds minimum in the warp direction and 70 pounds minimum in the filling direction. The fabric shall retain 70 percent of the original minimum tensile breaking strength in each direction after 150 hours exposure to ultraviolet light when tested as specified in 4.3.3. The tubing shall have a continuous sewn side seam. Fabric edges not incorporated into a seam shall be finished by a selvage, a heat seal, or a heat cut to prevent unravelling. Stitching shall be straight and continuous. Ends of stitches shall be effectively secured. Seams formed at fabric edges which are not selvaged shall be compound seams conforming to type EFb-1, SSn-1, or SSae-2 of FED-STD-751. Alternatively, the cotton, burlap, or polypropylene fabric tubing may be in bag form with one end presewn. Each open end of the tubing or bag shall be closed with two wire ties. At least 5 inches of surplus wrapping, measured from the center of the roll base, shall be gathered together with the first wire tie applied as close to the base of the roll as possible. The second wire tie shall be applied approximately 1-inch from the first wire tie with the twisted ends positioned opposite the ends of the first wire tie. Wire ties shall be not less than 6 inches long, 0.072-inch thick galvanized soft iron or steel wire with a 1/2-inch diameter formed eye at each end.

3.4.2.3.2 Laminated tubing (laminated tubing fabricated from 10 ounce burlap laminated to kraft paper coated with polyethylene). The burlap shall be continuously and uniformly laminated to the kraft paper with an average of not less than 60 pounds of asphaltum per ream (24 by 36-500). The kraft paper shall have a minimum basis weight of 40 pounds per ream (24 by 36-500), and the polyethylene coating shall have a minimum basis weight of 20 pounds per ream (24 by 36-500). The tubing shall be formed from one piece of material folded, and the superimposed edges stitch-seamed with a single row of stitches. Prior to stitch seaming, the superimposed edges shall be folded back over the body of the material approximately 3/4 inch. The sewing line shall be indented approximately 3/8 inch from the edge of the tubing. The thread for seaming the tubing shall be IAl conforming to V-T-276. Needle thread shall be ticket No. 12, 4-ply and looper thread shall be ticket No. 16, 4-ply. Stitching shall be spaced not less than 3 nor more than 6 stitches to the inch. Tubing shall be closed as specified in 3.4.2.2.1.1.

3.4.3 Level B packing.

3.4.3.1 Flat-folded pieces (bolts). Flat-folded pieces of fabric, put-up as specified, shall be packed in a snug-fitting double-wall fiberboard (see figure 3), wood-cleated plywood, wood-cleated solid fiberboard, or triple-wall fiberboard container as specified in 3.4.3.1.1, 3.4.3.1.2, 3.4.3.1.3, or 3.4.3.1.4, respectively. Each shipping container shall be lined with 60 pounds per ream

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(24 x 36 - 500) minimum basis weight kraft paper conforming to type I of A-A-203. All seams, joints, and folds shall overlap not less than 3 inches. The net weight of contents in all fiberboard type containers shall not exceed 325 pounds and in plywood containers 425 pounds. Shipping containers shall be strapped as specified in 3.4.3.1.5, as applicable.

3.4.3.1.1 Double-wall fiberboard containers. Double-wall fiberboard containers shall be of the type known as double cover and shall consist of a body, or joined liner, and two covers, and shall conform to the material requirements of PPP-F-320, type CF, class domestic, variety DW, minimum grade 500. Any combination of flutes may be used, except BB. The body joint shall be lapped not less than 1-1/2 inches, shall be stitched or stapled with metal fasteners not more than 2-1/2 inches between centers, and shall be double stitched at each end of the joint. The metal fasteners shall be centered on the overlap with a permissible minus tolerance of 1/8 inch from the edge. The lap joint shall be formed on the inside. The corrugations shall run parallel to the score. When necessary, the body or joined liner may be fabricated from two pieces of fiberboard with the body joints positioned at opposite diagonal corners. Each cover shall consist of a scored and slotted sheet with the flaps positioned as shown on figure 3. Each cover flap shall be fastened with five metal fasteners positioned and spaced as shown on figure 3. Cover corrugations shall run parallel to the width of the cover. The depth of each cover shall be not less than 6 inches. Metal fastenings shall be either steel staples or steel stitching wire at the option of the contractor. The covers shall fit the body in a snug tight-fitting manner. Prior to closure of the containers, the packed cloth shall project above the top of the container body not less than 1-1/2 inches and not more than 3-1/2 inches. Folded pieces shall be packed with folded edges of the pieces positioned alternately on each side of the container.

3.4.3.1.2 Wood-cleated plywood containers. Wood-cleated plywood containers shall conform to PPP-B-601, domestic type, style A, grade B.

3.4.3.1.3 Wood-cleated solid fiberboard containers. Wood-cleated solid fiberboard containers shall conform to PPP-B-591, class I, style A.

3.4.3.1.4 Triple-wall fiberboard containers. Triple-wall fiberboard containers shall conform to PPP-B-640, class 1, style E.

3.4.3.1.5 Strapping.

3.4.3.1.5.1 Double-wall fiberboard containers. Double-wall fiberboard containers measuring less than 24 inches in length shall be strapped with three flat metallic straps not less than 1/2 by 0.020-inch conforming to finish A or B of QQ-S-781 or three flat non-metallic straps not less than 7/16 by 0.030-inch conforming to type II of PPP-S-760 or 7/16 by 0.023-inch conforming to type III of PPP-S-760. Two straps shall be applied girthwise over the sides, top and bottom, approximately four inches from each end of the container. The third strap shall be applied lengthwise centered over the ends, top and bottom. Containers which exceed 24 inches in length shall have an additional strap applied girthwise, positioned midway between the two end straps.

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3.4.3.1.5.2 Wood-cleated containers. Wood-cleated plywood and wood-cleated fiberboard containers shall be strapped in accordance with the appendix of the applicable container specification. At least three metal straps (flat or round) shall completely encircle the container girthwise. Containers shall have two straps placed over the cleats on the ends of the panel and one strap in the center over the center cleats. Flat strapping shall be 3/4 inch by 0.020 inch and round strapping shall be 0.0915 inch in diameter (No. 13 gage).

3.4.3.1.5.3 Triple-wall fiberboard containers. Triple-wall fiberboard containers shall be closed with flat strapping in accordance with the appendix of the container specification.

3.4.3.2 Rolls. Rolls of fabric, preserved as specified (when applicable), shall be packed in a snug-fitting double-wall fiberboard (see figures 3 and 4), wood-cleated plywood, wood-cleated solid fiberboard, or triple-wall fiberboard container as specified in 3.4.3.1.1, 3.4.3.1.2, 3.4.3.1.3, and 3.4.3.1.4, respectively. Shipping containers packed with unwrapped (unpackaged) rolls shall be lined with kraft paper as specified in 3.4.3.1. The net weight of contents in all fiberboard type containers shall not exceed 325 pounds and in plywood containers 425 pounds. Shipping containers shall be strapped as specified in 3.4.3.1.5, as applicable. No packing is required when individual rolls are alternatively unit packed within a double-wall (2-ply) paper tube or bag as specified in 3.3.1.2.1.

3.4.3.2.1 Rolls exceeding 48 inches in width and weighing 100 pounds or less. No packing is required when individual rolls are packaged within a wrap of paperboard cushioning as specified in 3.3.1.2.2.

3.4.4 Commercial packing. Fabrics, preserved as specified, shall be packed in accordance with ASTM D 3951.

3.5 Marking.

3.5.1 Rolls and flat folded pieces (bolts). Each roll and flat folded piece (bolt) shall have a piece ticket (tag) affixed containing identification information as specified in 3.1.2 and figure 1.

3.5.2 Unit packed rolls and flat folded pieces (bolts). Each wrapped or over-wrapped roll or flat folded piece shall be clearly marked on the wrapping at the end where the identification tag is attached as follows:

"TAG HERE"

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3.5.3 Shipping containers.

3.5.3.1 General. In addition to the marking requirements specified below for specific shipments, the following precautionary markings shall be applied so as not to interfere with the shipment markings.

3.5.3.1.1 Shipping container inscription. Each shipping container (including the double-wall paper tube or bag and the one-piece paperboard cushioning wrap) shall have the inscription "DO NOT STAND ON END" stenciled in 1-inch black block letters on each side or side panel.

3.5.3.2 Civil agencies. In addition to any special marking required by the contract or order, shipments shall be marked (including bar code marking, see figure 1) in accordance with FED-STD-123 or ASTM D 3951, as applicable.

3.5.3.3 Military requirements. In addition to any special marking required by the contract or order, shipments shall be marked (including bar code marking, see figure 1) in accordance with MIL-STD-129 or ASTM D 3951, as applicable. The cover roll identification marking shall include the fabric piece number. Labels may be used on double cover fiberboard containers. Both the gross and net yardage shall be indicated on all shipping containers. In addition, each shipping container shall be clearly marked on both side faces with the legend "USE NO HOOKS" in letters not less than 1-1/2 inches in height and also with the corresponding symbol as outlined in MIL-STD-129. If the required exterior markings for rolls cannot be applied because of restricted marking area, markings shall be shown on a tag securely affixed to one end of the roll

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. Except as otherwise specified in the contract or purchase order, the contractor 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 supplies and services conform to prescribed requirements.

4.1.1 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

4.2 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.2.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected 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.

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4.2.1.1 Component and material certification. Components and materials listed below shall be accepted on the basis of a contractor's certification of compliance with the indicated requirements:

Characteristic	Requirement paragraph	Test method
Barrier material:		
Basis weight of kraft paper	3.4.2.2	Method 5022 1/
Stretch of creped kraft paper	3.4.2.2	Method 2038 1/
Basis weight of polyethylene	3.4.2.2	Method 5022 1/
Polypropylene tubing:		
Material identification	3.4.2.3.1	Laboratory analysis
Weight	3.4.2.3.1	Method 5041 2/
Breaking strength	3.4.2.3.1	Method 5100 2/
Ultraviolet light resistance	3.4.2.3.1	Method 5804 2/
Edge finish	3.4.2.3.1	Visual
Laminated tubing:		
Asphaltum weight per ream	3.4.2.3.2	-
Basis weight of kraft paper	3.4.2.3.2	Method 5022 1/
Polyethylene coating basis weight	3.4.2.3.2	-
Burlap weight	3.4.2.3.2	Method 5040 2/

1/ FED-STD-101

2/ FED-STD-191

4.2.1.2 Examination of double-wall fiberboard containers (applicable to level B container described in 3.4.3.1.1). When containers are in accordance with 3.4.3.1.1 an examination shall be performed to determine conformance to requirements as concerns style and construction of the box. The sample unit shall be one complete box. The sample size shall be the number of boxes indicated by inspection level S-2. The acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5. Defects shall be scored in accordance with the following list:

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Examine	Defect
Style of box	Not in accordance with figure 3. Not a double cover with joined liner.
Type of board (check edges where fluting, etc. is visible)	Not double-walled corrugated fiberboard.
Construction	Body joint lapped less than 1-1/2 inches. Lapped joint not formed on the inside. Corrugations in body section not parallel with the scores. Fasteners not as specified, less than number specified, or positioned incorrectly. Depth of covers less than 6 inches. Covers fit loose.

4.2.2 Examination of the end item for preservation, packing, and marking. The preserved, packed, and marked products shall be inspected for conformance in accordance with the material specification or contract. When the material specification does not contain inspection provisions for the packing, the following shall apply: An examination shall be made to determine compliance with the put-up, preservat##isted below shall be examined on shipping containers or rolls fully packaged. The lot size shall be the number of shipping containers or rolls in the end item inspection lot. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

Examine	Defect
Marking (exterior and interior)	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application. Bar code marking not machine readable.
Piece ticket (identification tag)	Missing.
Materials	Any component missing, damaged or not as specified.

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Examine	Defect
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, inadequate nailing and stapling, incomplete closure of rolls, inadequate securing or sealing of wrapping materials, insecure sewing, or loose wire ties. Bulged or distorted container or roll.
Net weight	Net weight not as specified (see 3.4.2 and 3.4.3).
Seams of polypropylene fabric wrapping	Not type specified. Stitching not as specified.

5. PACKAGING

5.1 As specified herein.

6. NOTES

6.1 Ordering data. Purchasers should select the preferred options permitted herein and include the following information in acquisition documents:

(a) Title, number, and date of this specification.
(b) Whether fabric shall be put-up in flat folds or roll form (see 3.2).
(c) Selection of applicable levels of put-up, preservation and packing (see 3.2, 3.3, and 3.4).
(d) Information required on the piece ticket (identification tag) (see 3.5.1).
(e) When kraft paper wrapping is not required for rolls of fabric (see 3.2.1.1).

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MILITARY INTERESTS:

Custodians

Army - GL
Navy - SA
Air Force - 99

Review Activities

Army - MD, SM
Navy - AS, NU
Air Force - 82
DLA - GS

User Activities

Navy - CG, MC

CIVIL AGENCY COORDINATING ACTIVITIES:

GSA - FSS
VA - OSS

PREPARING ACTIVITY:

Army - GL

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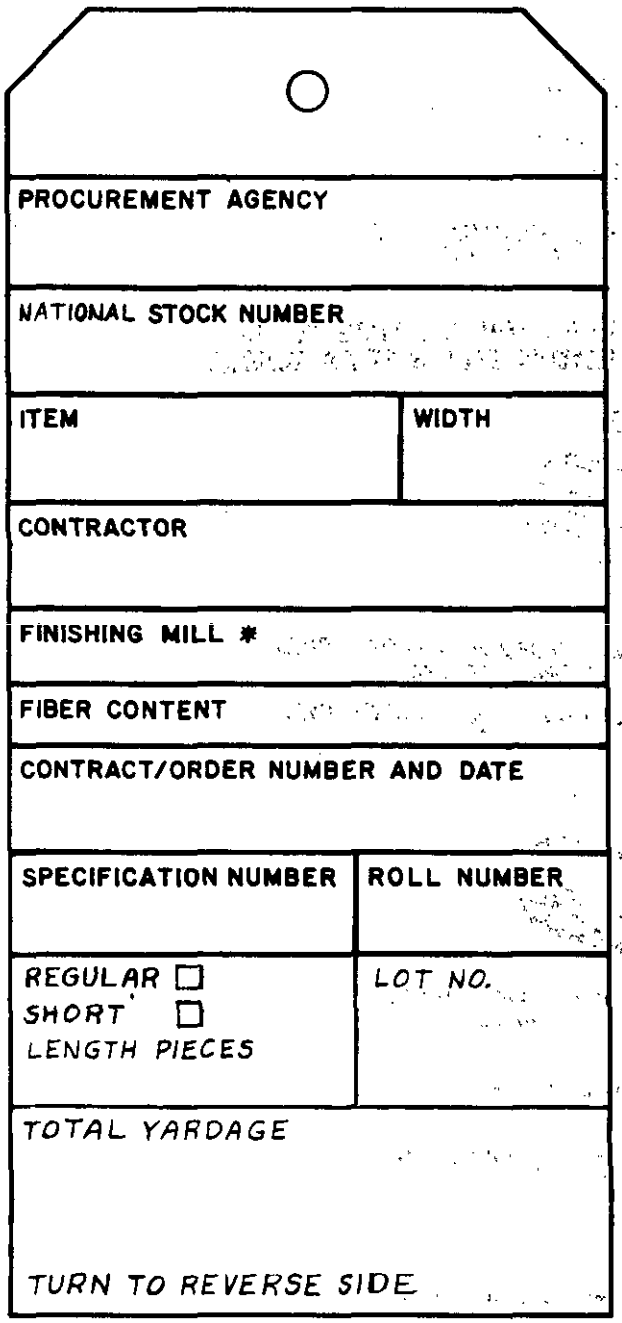
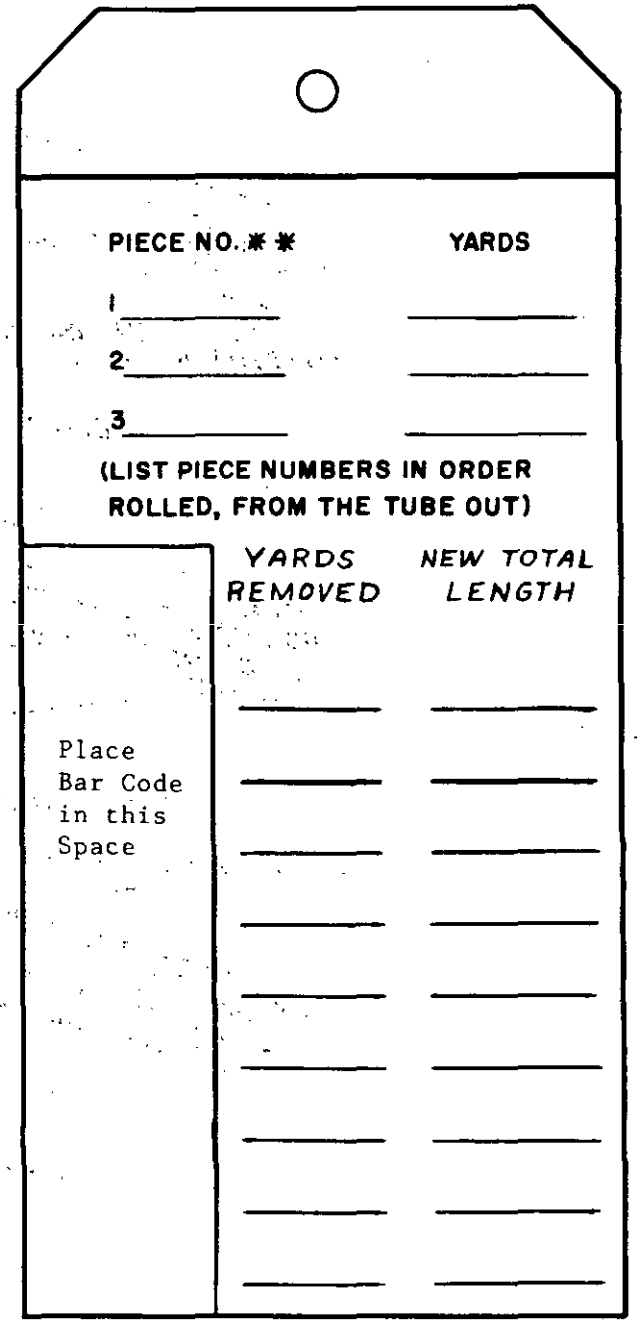
EXAMPLE IS APPROXIMATE TICKET SIZE DESIRED

(FRONT SIDE)



* GREIGE MILL WHEN PURCHASE IS FOR GREIGE CLOTH

(REVERSE SIDE)



* * PRINTING OPTIONAL FOR SINGLE - PIECE ROLLS.

FIG 1 PIECE TICKET

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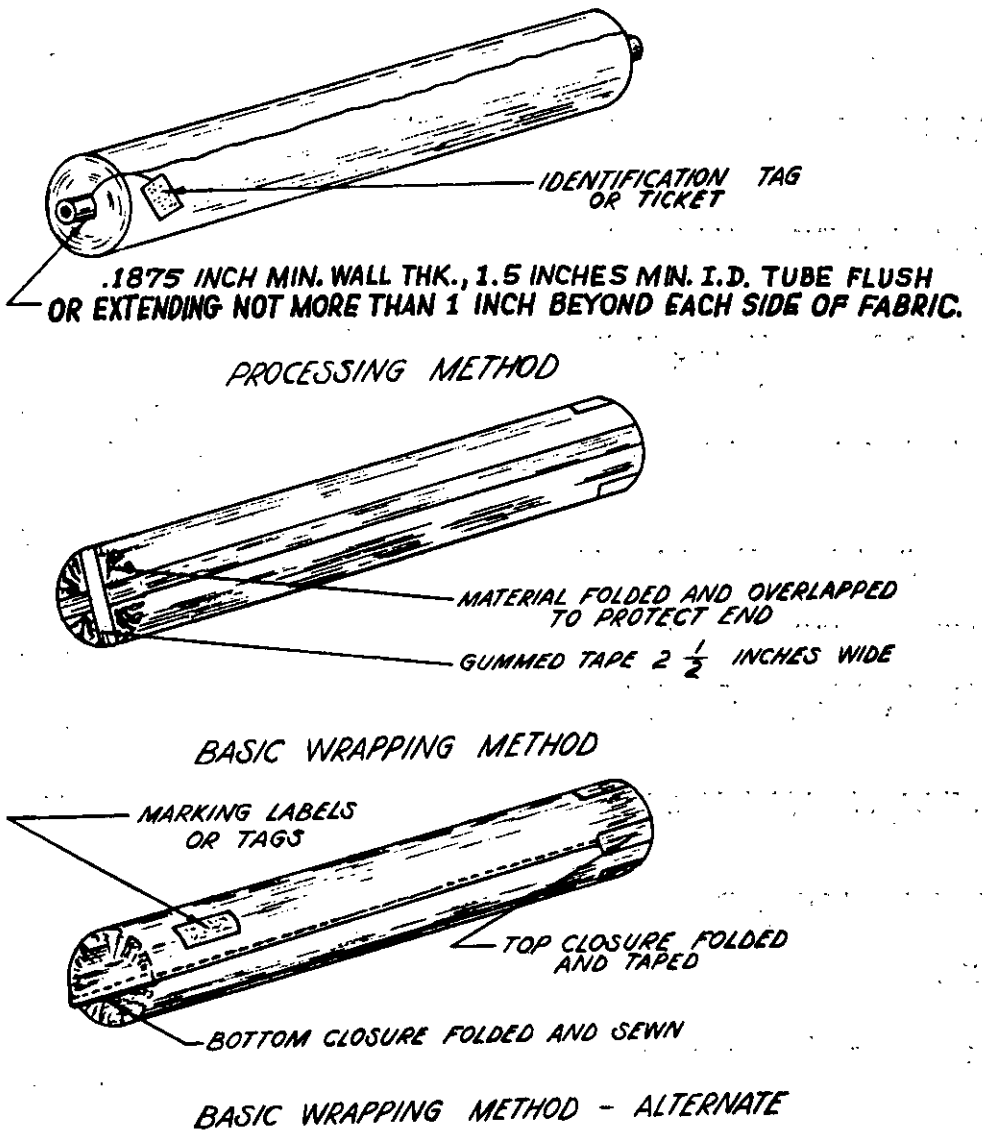

Figure 2. Processing and wrapping of rolls.

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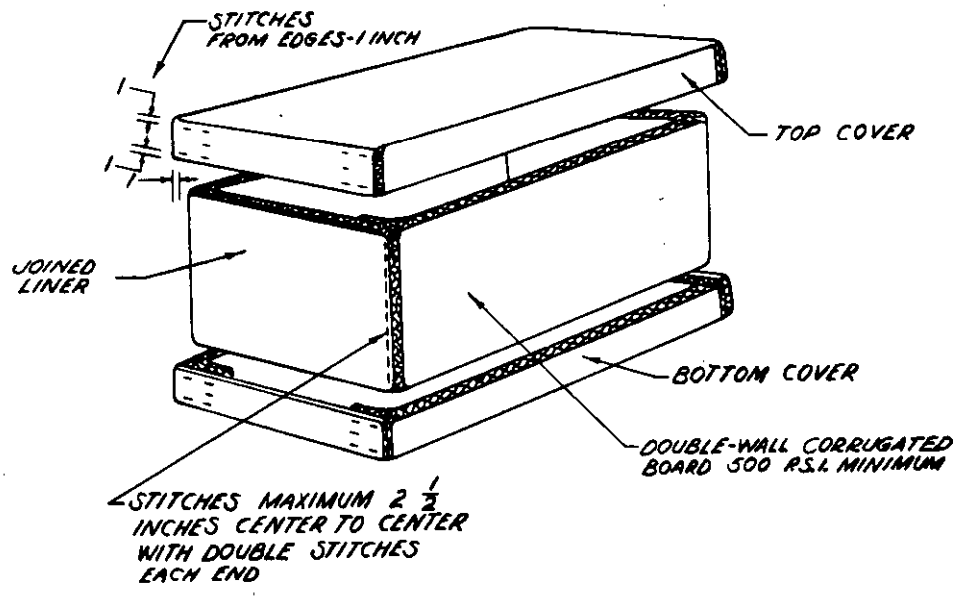

Figure 3. Covers and joined liner of double-wall corrugated fiberboard container.

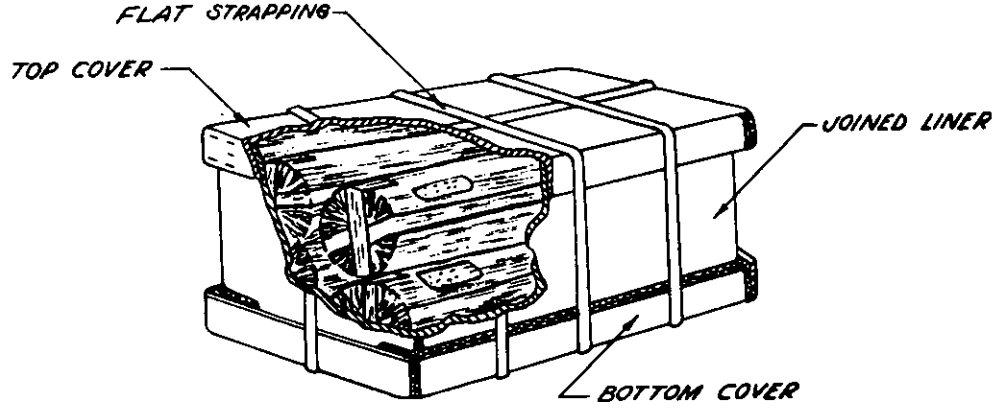

Figure 4. Four rolls packed in a double-wall corrugated fiberboard container.

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions – Reverse Side)

1. DOCUMENT NUMBER	2. DOCUMENT TITLE
PPP-P-1134D	Packaging of Cotton and Cotton-Synthetic Fiber Blend Fabrics (Excluding Duck Fabrics)

3a. NAME OF SUBMITTING ORGANIZATION

b. ADDRESS *(Street, City, State, ZIP Code)*

4. TYPE OF ORGANIZATION *(Mark one)*

- ☐ VENDOR
- ☐ USER
- ☐ MANUFACTURER
- ☐ OTHER *(Specify)*: _____

5. PROBLEM AREAS

a. Paragraph Number and Wording:

b. Recommended Wording:

c. Reason/Rationale for Recommendation:

6. REMARKS

7a. NAME OF SUBMITTER *(Last, First, MI)* – Optional	b. WORK TELEPHONE NUMBER *(Include Area Code)* – Optional
c. MAILING ADDRESS *(Street, City, State, ZIP Code)* – Optional	8. DATE OF SUBMISSION *(YYMMDD)*

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