

PPP-T-680E
 November 17, 1975
SUPERSEDING
 Fed. Spec. PPP-T-680D
 April 16, 1971

FEDERAL SPECIFICATION

TAPE, PRESSURE-SENSITIVE ADHESIVE: PACKAGING AND PACKING OF

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

1. SCOPE

1.1 This specification covers the requirements for the packaging, packing, and marking of pressure-sensitive adhesive tapes, except electrical and foam type tapes.

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:

Federal Specifications:

| | |
|-----------|--------------------------------|
| UU-P-134 | - Paper, Wrapping, Wet-Waxed |
| UU-P-268 | - Paper, Kraft, Wrapping |
| UU-P-270 | - Paper, Wrapping, Waxed (Dry) |
| PPP-B-566 | - Boxes, Folding, Paperboard |
| PPP-B-636 | - Boxes, Shipping, Fiberboard |
| PPP-B-676 | - Boxes, Setup |

Federal Standard

FED-STD-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.

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(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 Specifications:

- MIL-B-117 - Bags, Sleeves and Tubing, Interior Packaging
- MIL-B-131 - Barrier Materials, Water-Vaporproof, Flexible, Heat-Sealable
- MIL-B-43666 - Boxes, Shipping, Consolidation

Military Standards:

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage
- MIL-STD-147 - Palletized Unit Loads for 40" by 48" Pallets

(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 Packaging. Packaging shall be level A, B, or C as specified (see 6.1).

3.1.1 Level A. Each roll of tape, except utility style roll tape, shall be individually packaged as specified in 3.1.1.1 through 3.1.1.3, as applicable. Utility style roll tapes shall be packaged as specified in 3.1.1.4. Alternatively, rolls of tape narrower than 3/4 inch may be packaged in quantities as specified (see 6.1) with a waxed paper separator, conforming to UU-P-270 or UU-P-134, or other materials having at least equal non-blocking properties, placed between the rolls.

3.1.1.1 Cellophane tape. Each individual roll of cellophane tape shall be protected by any method specified in 3.1.1.1.1 through 3.1.1.1.4.

3.1.1.1.1 Paperboard box with water-vaporproof bag. The tape shall be packaged in a paperboard box conforming to variety 1, classification optional of PPP-B-566 or variety 1, classification optional of PPP-B-676. The box shall be completely inclosed in a close-fitting water-vaporproof bag conforming to type II, class E, style optional of MIL-B-117. The bag shall be heat sealed. Excess air shall be expelled before the final seal.

3.1.1.1.2 Metal or plastic box. The tape shall be packaged in a commercial type, two-piece design, metal or plastic box with a friction top normally used for the specific tape being packaged. The diameter of the box shall be slightly larger than the outside diameter of the roll of tape. Each box shall be sealed with one complete wrap of water-vaporproof pressure-sensitive adhesive tape around the closure.

3.1.1.1.3 Water-vaporproof bag with paperboard box. The tape shall be packaged in a close-fitting water-vaporproof bag conforming to type II, class E, style optional of MIL-B-117. The bag shall be heat sealed. Excess air shall be expelled before the final seal. The bagged tape shall then be packaged in a snug-fitting paperboard box conforming to variety 2, classification optional of PPP-B-566 or variety 2, classification optional of PPP-B-676. Each box shall be closed in accordance with the appendix of the applicable box specification.

3.1.1.1.4 Paperboard box with water-vaporproof wrapper. The tape shall be packaged in a paperboard box conforming to variety 1, classification optional of PPP-B-566 or variety 1, classification optional of PPP-B-676. The box shall be completely inclosed in a water-vaporproof wrapper conforming to class 1 of MIL-B-131, and the wrapper heat sealed. Alternatively, a laminate of aluminum foil to paper, laminated with wax or polyethylene, may be used in lieu of the material complying with MIL-B-131.

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3.1.1.2 Single and double coated cloth and paper tape. Each roll of tape shall be packaged in a paperboard box conforming to variety 2, classification optional of PPP-B-566 or variety 2, classification optional of PPP-B-676. A centering device shall be provided in each box to prevent the outside lap of the tape roll from contacting the side of the box. Each box shall be closed in accordance with the appendix of the applicable box specification. When specified (see 6.1) each package of tape shall be completely inclosed in a water-vaporproof wrapper as specified in 3.1.1.1.4.

3.1.1.3 Other than cellophane, and single and double coated cloth and paper tapes. Each roll of tape shall be packaged as specified in 3.1.1.2, except that the centering device may be omitted.

3.1.1.4 Utility style rolls of tape (see 6.3). Twelve utility style rolls of tape of one description only, shall be packaged in a snug-fitting box conforming to variety 2; classification optional of PPP-B-566, variety 2, classification optional of PPP-B-676, or class weather-resistant, style RSC of PPP-B-636. Each box shall be closed in accordance with the appendix of the applicable box specification, except that the closure for fiberboard boxes shall be in accordance with method IV.

3.1.1.5 Intermediate packaging. Tape of one description only, individually roll packaged, shall be packaged in the quantities shown in table I in a snug-fitting fiberboard box conforming to class weather-resistant, style RSC of PPP-B-636. Each box shall be closed in accordance with method IV as specified in the appendix of PPP-B-636. Unit packages of the utility style rolls shall not require intermediate packaging.

TABLE I. Number of rolls to intermediate package and shipping container

| Tape | Number of rolls per intermediate package | Number of intermediate packages to shipping container | Rolls per shipping container |
|----------------------------|--|---|------------------------------|
| Cellophane and Cellulose | | | |
| Acetate | | | |
| 72-Yard rolls: | | | |
| 1 inch and under | 12 | 6 | 72 |
| Over 1 inch through 3 inch | none | none | 12 |
| 36-Yard rolls: | | | |
| 3/4 inch and under | 12 | 12 | 144 |
| 1 inch | 12 | 4 | 48 |
| Over 1 inch through 3 inch | none | none | 12 |
| All other tapes: | | | |
| 1 inch and under | 12 | 4 | 48 |
| over 1 inch through 3 inch | none | none | 12 |

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3.1.2 Level B. Tape, except utility style roll tape, shall be packaged as specified in 3.1.2.1 through 3.1.2.3 (see 6.1). Utility style roll tapes shall be packaged as specified in 3.1.2.1.4.

3.1.2.1 Individual roll. Each roll of tape, not more than 3 inches wide, and not more than 72 yards long, shall be individually packaged in accordance with the requirements of 3.1.2.1.1 through 3.1.2.1.3, as applicable. Alternatively, rolls of tape narrower than 3/4 inch may be packaged in quantities as specified (see 6.1) with a waxed paper separator conforming to UU-P-270 or UU-P-134, or other material having at least equal non-blocking properties, placed between the rolls.

3.1.2.1.1 Cellophane tape. Cellophane tape shall be packaged as specified in 3.1.1.1.

3.1.2.1.2 Single and double coated cloth and paper tape. The tape shall be packaged in a paperboard box conforming to variety 1, classification optional of PPP-B-566 or variety 1, classification optional of PPP-B-676. A centering device shall be provided in each box to prevent the outside lap of the tape roll from contacting the side of the box. Each box shall be closed in accordance with the appendix of the applicable box specification.

3.1.2.1.3 Other than cellophane, and single and double coated cloth and paper tapes. The tape shall be packaged as specified in 3.1.2.1.2, except that the centering device may be omitted.

3.1.2.1.4 Utility style rolls (see 6.3). Twelve utility style rolls of tape of one description only, shall be packaged in a box conforming to variety 1, classification optional of PPP-B-566, variety 1, classification optional of PPP-B-676, or style RSC, type CF (variety SW), class domestic of PPP-B-636. Each box shall be closed in accordance with the appendix of the applicable box specification.

3.1.2.1.5 Intermediate packaging. Tape of one description only, individually roll packaged, shall be packaged in the quantities shown in table I, in a snug-fitting fiberboard box conforming to style RSC, type CF (variety SW), class domestic of PPP-B-636. Each box shall be closed in accordance with the appendix of PPP-B-636. Alternatively, a container conforming to variety 1, classification optional of PPP-B-566 or variety 1, classification optional of PPP-B-676 or a kraft paper wrapping conforming to UU-P-268 may be used. Each box or paper wrap shall be securely closed. Unit packages of the utility style rolls shall not require intermediate packaging.

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3.1.2.2 Multiple rolls.

3.1.2.2.1 Masking, drafting, acetate fiber, filament reinforced and polyester tapes in rolls of 60 and 72 yard lengths on 3 inch cores only. Rolls of tape of one description only, in the quantities specified in table II shall be wrapped in kraft paper (minimum basis weight of 40 pounds) conforming to UU-P-268 or in extensible paper (minimum basis weight of 35 pounds) with a stretch factor of 5 to 8 percent, or placed in a polyethylene bag, 0.0015 inch minimum thickness (20 percent tolerance). A waxed paper separator, conforming to UU-P-270 or UU-P-134, or other material having at least equal non-blocking properties, shall be placed between the rolls. The paper overwrap shall be tucked into each end of the stack a minimum of 2 inches and further secured at the seam by means of tape or adhesive to prevent unrolling of the wrap. The open end of the polyethylene bag shall be tucked into the end of the stack a minimum of 2 inches or secured with a mechanical tie (paper or plastic covered soft steel wire).

TABLE II. Packaging and packing quantities

| Width of tape | Quantity per multiple roll package* | Quantity per shipping container | |
|---------------|---|------------------------------------|-----------------|
| | | Cloth tapes** | All other tapes |
| 1/4 | 36 | 192 | 144 |
| 1/2 | 18 | 96 | 72 |
| 3/4 | 12 | 64 | 48 |
| 1 | 9 | 48 | 36 |
| 1-1/2 | 6 | 32 | 24 |
| 2 | 6 | 24 | 24 |
| 2-1/2 | 3 | 20 | 12 |
| 3 | 3 | 16 | 12 |
| 4 | 2 | 12 | 8 |
| 6 | 2 | 8 | 8 |

*This part of the table applies only to rolls packaged as described in 3.1.2.2.1.

**This part of the table applies to rolls of cloth tape which are not multiple roll packaged as specified in 3.1.2.2.1.

3.1.2.3 All other tapes. All other tapes shall require no packaging.

3.1.3 Level C (Commercial Packaging). Rolls of tape 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.

3.2 Packing. Packing shall be level A, B, or C as specified (see 6.1).

3.2.1 Level A. Rolls of tape of one description only, unit and intermediate packaged as specified in 3.1, shall be packed in the quantities specified in table I in a snug-fitting shipping container conforming to style RSC, grade V2s of PPP-B-636. Each fiberboard container shall be closed in accordance with method III, waterproofed in accordance with method V and reinforced as specified in the appendix of PPP-B-636.

3.2.1.1 Military requirements. When specified (see 6.1) tape, packed in fiberboard shipping containers as specified in 3.2.1, shall be consolidated into a container conforming to type I or II, style and size optional of MIL-B-43666. Each consolidation box shall be assembled, closed and reinforced in accordance with the appendix of MIL-B-43666.

3.2.2 Level B.

3.2.2.1 Individual rolls. Rolls of tape of one description only, unit and intermediate packaged as specified in 3.1, shall be packed in the quantities specified in table I in a snug-fitting fiberboard shipping container conforming to style RSC, type CF (variety SW) or SF, class domestic of PPP-B-636. Each shipping container shall be closed in accordance with the appendix of PPP-B-636.

3.2.2.1.1 Weather-resistant shipping container. When specified (see 6.1), 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.

3.2.2.2 Multiple packaged rolls.

3.2.2.2.1 Masking, drafting, acetate fiber, filament reinforced, and polyester tape. Rolls of tape of one description only, multiple roll packaged as specified in 3.1.2.2.1, shall be packed in the quantities specified in table II in shipping containers as specified in 3.2.2.1.

3.2.2.3 Utility style rolls (see 6.3). Forty-eight packages of tape (576 rolls) shall be packed as specified in 3.2.2.1.

3.2.2.4 All other tapes. Rolls of tape of one description only, furnished without interior boxes or wrapping shall be packed, using commercial centering devices in the quantities specified in table II, in a fiberboard shipping container as specified in 3.2.2.1. A waxed paper separator conforming to UU-P-270 or UU-P-134, or other materials having at least equal non-blocking properties, shall be placed between the rolls.

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3.2.3 Level C (commercial packing). Rolls of tape, packaged as specified in 3.1, 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 or National Motor Freight Classification, as applicable.

3.3 Palletization (military requirement). When specified (see 6.1), rolls of tape of one description only, packed as specified in 3.2, except consolidated containers specified in 3.2.1.1, shall be palletized in accordance with load type I of MIL-STD-147. Each prepared load shall be bonded with primary and secondary straps in accordance with bonding means K and L. Pallet patterns shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the pallet patterns specified in MIL-STD-147, the pallet pattern used shall first be approved by the contracting officer.

3.4 Marking.

3.4.1 Military requirements. In addition to any special marking required by the contract or order, interior packages, shipping containers, consolidation boxes and palletized unit loads shall be marked in accordance with MIL-STD-129.

3.4.2 Civil agencies. In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with FED-STD-123. Each shipping container shall be marked to show the month and year of the date of packing expressed numerically.

3.4.3 Precautionary markings. The following precautionary markings shall appear on two panels of each shipping container:

Recommended Storage Conditions
STORE BEHIND PRESENT STOCK
Store in a clean dry place.
Temperature of 70 degrees Fahr-
enheit (21 degrees Centigrade)
and 40 to 50 percent relative
humidity are recommended.
ROTATE YOUR STOCK

3.5 Workmanship. Packaging, packing and marking shall conform to the quality and grade of product established by this specification.

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 supplies and services conform to prescribed requirements.

4.2 Quality conformance inspection. Sampling for inspection shall be performed in accordance with MIL-STD-105, Except where otherwise indicated hereinafter.

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

4.2.2 Inspection of the end item.

4.2.2.1 Examination of the end item for packaging, packing, and marking. An examination shall be made to determine that packaging, packing and marking of the end item complies with the applicable requirements of section 3. Defects shall be as listed in table III. The sample unit shall be one complete shipping container. The lot shall be expressed in terms of shipping containers of tape of one description for this examination. The inspection level shall be S-2 and the AQL shall be 2.5, expressed in terms of defects per hundred units for this examination.

TABLE III. Examination for packaging, packing and marking

| Examine | Defects |
|--|---|
| <u>Packaging</u> Individual roll packaging | Not packaged in packages as specified Quantity per package not as specified Centering device, as applicable, missing Markings missing or incorrect |
| Multiple roll packaging | Not packaged in water-vaporproof packages (where applicable) Not packaged in accordance with table I or II (where applicable) Separators missing in multiple roll packaging |

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TABLE III. Examination for packaging, packing and marking (cont'd)

| Examine | Defects |
|----------------------------------|--|
| Multiple roll packaging (cont'd) | Not wrapped in kraft or extensible paper or polyethylene film Paper not tucked in both ends of stack a minimum of 2-inches Open end of polyethylene bag not tucked in stack a minimum of 2-inches, (where applicable) Package contains different types, widths, and lengths of tape |
| Packing | Not packed in quantities as specified Not the kind of shipping container specified Centering device missing, as applicable Markings not as specified |

4.2.2.2 Examination of shipping containers. When shipping containers are required to be in accordance with PPP-B-636, examination for defects in closure, waterproofing, and reinforcing shall be in accordance with the appendix of PPP-B-636. When consolidation boxes are required, examination for defects in assembly, closure, and reinforcing shall be in accordance with the appendix of MIL-B-43666.

4.2.2.3 Examination for palletization. An examination shall be made to determine that palletization complies with 3.3 requirements. Defects shall be scored in accordance with table IV. The sample unit for this examination shall be one palletized unit load fully prepared for delivery. The lot shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 with an AQL of 6.5 expressed in terms of defects per hundred units.

TABLE IV. Examination for palletization

| Examination | Defect |
|--------------------|---|
| Finished dimension | Length, width, or height exceeds specified maximum requirement |
| Palletization | Not as specified Pallet pattern not as specified Interlocking of loads not as specified Load not bonded with required straps specified |
| Weight | Exceeds maximum load limits |
| Marking | Omitted; incorrect; illegible; of improper size, location, sequence or method of application |

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5. PREPARATION FOR DELIVERY

5.1 Not applicable.

6. NOTES

6.1 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) Selection of the applicable levels of packaging and packing (see 3.1 and 3.2).
- (c) When a quantity of rolls narrower than 3/4 inch are desired to be packaged together (see 3.1.1 and 3.1.2.1).
- (d) When water vaporproof protection is required for single and double coated cloth and paper tapes (see 3.1.1.2).
- (e) Whether tape shall be individual roll package or multiple roll package (see 3.1.2).
- (f) When consolidation boxes are required for level A packing (see 3.2.1.1).
- (g) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 3.2.2.1.1).
- (h) When palletization is required by the military (see 3.3).

6.2 Storage. The tape should be stored in the original container in a cool location. It should not be stored in close proximity to steam pipes, radiators, or other sources of heat. Temperature of approximately 70° F with 40 to 50 percent relative humidity is most desirable.

6.3 Utility style rolls. A utility style roll shall, for the purpose of this specification, be defined as a roll of tape on a one inch core, not more than one inch in width, complete with its own integral dispenser.

Custodians:

Army - GL
Navy - SA
Air Force - 84

Preparing activity:

Army - GL

Civil Agency Coordinating Activities:**Review activities:**

Army - MI, SM
Navy - AS
Air Force - 69

GSA-FSS
AGR-APS

Project No. PACK-0380

User activities:

Army - MU, AT
Navy - OS, MC, SH

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 35 cents each.

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

OMB Approval
No. 22-R255

INSTRUCTIONS: The purpose of this form is to solicit beneficial comments which will help achieve procurement of suitable products at reasonable cost and minimum delay, or will otherwise enhance use of the document. DoD contractors, government activities, or manufacturers/vendors who are prospective suppliers of the product are invited to submit comments to the government. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements. Attach any pertinent data which may be of use in improving this document. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity.

DOCUMENT IDENTIFIER AND TITLE TAPE, PRESSURE-SENSITIVE ADHESIVE: PACKAGING AND PACKING OF - PROPOSED PPP-T-680E

NAME OF ORGANIZATION AND ADDRESS

CONTRACT NUMBER

MATERIAL PROCURED UNDER A

 DIRECT GOVERNMENT CONTRACT SUBCONTRACT

1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?

A. GIVE PARAGRAPH NUMBER AND WORDING.

B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES

2. COMMENTS ON ANY DOCUMENT REQUIREMENT CONSIDERED TOO RIGID

3. IS THE DOCUMENT RESTRICTIVE?

 YES NO (If "Yes", in what way?)

4. REMARKS

SUBMITTED BY (Printed or typed name and address - Optional)

TELEPHONE NO.

DATE

DD FORM 1426
1 JAN 72

REPLACES EDITION OF 1 JAN 66 WHICH MAY BE USED