

PPP-T-681D

March 5, 1974

SUPERSEDING

Fed. Spec. PPP-T-681C

August 10, 1970

FEDERAL SPECIFICATION

TAPE, GUMMED, 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 Scope. This specification covers the requirements for the packaging and packing of gummed 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 Specification:

PPP-B-636 - Boxes, Shipping, Fiberboard.

Federal Standard:

FED-STD-123 - Marking for Domestic Shipment (Civil Agencies).

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

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

FSC-PACK

PPP-T-681D

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

Military Specification:

MIL-B-43666 - Boxes, Shipping Inserts 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" X 48" Pallets.

(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 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.)

U.S. Postal Service Manual

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

(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.)

PPP-T-681D

3. REQUIREMENTS

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

3.1.1 Level A. Rolls of tape, of the same specification, type, class, and size and in the quantity as specified (see 6.2) shall be packaged in a close-fitting clear polyethylene film bag having a thickness of 0.002-inch (+ 20 percent tolerance). The bag shall be formed with heat sealed seams that are straight, continuous and perpendicular to the adjacent formed edges of the bag. The bag may be fabricated from polyethylene film tubing or sheeting. Closure of the bag shall be accomplished by heat sealing or by means of a mechanical tie (paper or plastic covered soft steel wire, aluminum band, etc.). Prior to or during the closure operation, excess air shall be expelled from the bag.

3.1.2 Level B. Rolls of tape shall be packaged in accordance with 3.1.1 (see 6.2).

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 6.2).

3.2.1 Level A. Rolls of tape, of the same specification, type, class, and size, 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, grade V2s of PPP-B-636. Each shipping 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.

3.2.2 Level B. Rolls of tape, of the same specification, type, class, and size, 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, grade 275 of PPP-B-636. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

TABLE I. Packing quantities

| Width of tape in inches | No. of rolls per shipping container |
|-------------------------|-------------------------------------|
| 5/8 | 48 |
| 3/4 | 40 |
| 1 | 30 |

PPP-T-681D

TABLE I. Packing quantities (cont'd)

| Width of tape in inches | No. of rolls per shipping container |
|-------------------------|-------------------------------------|
| 1-1/4 | 24 |
| 1-1/2 | 20 |
| 2 | 15 |
| 2-1/2 | 12 |
| 3 | 10 |
| 4 | 7 |
| 5 | 6 |

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

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 US Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

3.3 Containerization. When specified (see 6.2), rolls of tape packed as specified in 3.2 shall be consolidated into a container conforming to type I, II or III, style and size optional of MIL-B-43666.

3.4 Palletization. When specified (see 6.2), rolls of tape of one description only, packed as specified in 3.2, 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. 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.

3.5 Marking.

3.5.1 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.

PPP-T-681D

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

3.5.3 Polyethylene bagged packages. Polyethylene bagged packages shall have the required identification information legibly printed or stamped in black directly on the bag across the center face or on a white paper label inserted within the bag so as to permit ready identification.

3.5.4 Precautionary marking. The following precautionary marking shall be included on two opposite sides of each shipping container:

"STORE IN A COOL DRY PLACE.

DO NOT REMOVE CONTENTS UNTIL

READY FOR USE."

In addition, each shipping container shall be marked with the word "UP" with an arrow toward the top of the container.

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 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 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 Examination 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 the packaging, packing, and marking comply with the section 3 requirements. Defects shall be scored in accordance

PPP-T-681D

with the list below. The sample unit shall be one shipping container fully prepared for delivery with the exception that it need not be closed. Defects of closure listed below shall be examined on shipping containers fully prepared for delivery. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5, expressed as defects per hundred units.

| <u>Examine</u> | <u>Defect</u> |
|---------------------------------|---|
| Marking (exterior and interior) | Omitted, incorrect, illegible, of improper size, location, sequence or method of application. |
| Materials | Any component missing, damaged or not as specified. |
| Workmanship | Inadequate application of components, such as: incomplete closure of container flaps, loose strapping, improper taping, or inadequate stapling. Improper heat sealed seams and closure of polyethylene bag. Incorrectly fabricated bag. Bulged or distorted container. |
| Content | Number of rolls per package is more or less than required. Number of rolls per shipping container is more or less than required. Contains tape or more than one specification, type, class, or size. |

4.2.2.2 Examination for palletization. An examination shall be made to determine that the palletization complies with the section 3 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully prepared for delivery. The lot size shall be the number of palletized unit loads in the end item inspection lot. The inspection level shall be S-1 and the AQL shall be 6.5, expressed as defects per hundred units.

| <u>Examine</u> | <u>Defect</u> |
|--------------------|---|
| Finished dimension | Length, width, or height exceeds specified maximum requirement. |

PPP-T-681D

| <u>Examine</u> | <u>Defect</u> |
|----------------|--|
| Palletization | Not as specified. Pallet pattern not as specified. Interlocking of loads not as specified. Load not bonded with required straps as specified. |
| Weight | Exceeds maximum load limits. |
| Marking | Omitted; incorrect; illegible; of improper size, location, sequence or method of application. |

5. PREPARATION FOR DELIVERY

(not applicable)

6. NOTES

6.1 Intended use. This document is intended for use in packaging and packing gummed tapes.

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) Selection of applicable levels of packaging and packing (see 3.1 and 3.2).
- (c) Quantity required (see 3.1.1).
- (d) When weather-resistant grade fiberboard shipping containers are required for level B packing (see 3.2.2.1).
- (e) When containerization is required (see 3.3).
- (f) When palletization is required (see 3.4).
- (g) When level B packaging is required for civil agencies (see 3.1.2).
- (h) Marking requirements (see 3.5).

6.3 Storage. The tape should be stored in the original container, preferably 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. and relative humidity of 40 to 50 percent are most desirable.

STANDARD 33-442 - 0 AFTER : REFINED JUNCTION IDENTIFICATION 12 .0

PPP-T-681D

Custodians:

Army - GL
Navy - SA
Air Force - 84

Preparing activity:

Army - GL

Civil Agency Coordinating Activities:

Review activities:

Army - SM
Navy - AS
Air Force - 69
DSA-GS

USDA-AMS
DC Gov't-DCG
HEW-FEC
INTERIOR-BLM
JUSTICE-FPI
VA-DMS
GSA-FSS

User activities:

Army - MU
Navy - MC, YD, OS

Project No. PACK-0405

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 15 cents each.

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