

**SPECIAL PACKAGING INSTRUCTION** (AMCCOM Suppl 1 to AR 700-15) **NATIONAL STOCK NUMBER**  
4240-01-365-0982

**NOMENCLATURE**  
FILTER, GAS, 10 CFM, M18A1 (ASZM-TEDA) **UI (A)** **CLEANING/DRYING**  
**BOX** C1/ANY **SPI NUMBER (PN)**  
P5-19-2300

LEVEL A UNIT PACK REQUIREMENTS (MIL-P-116 METHOD IA-5)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
Container	(C) 1	MIL-C-10464		I			5 15/32 dia x 11 5/8
Blocking	(D) 2	ASTM D4727	SW	CF	175	DO	5 7/16 dia (15 pcs)
Closure	3	MIL-C-10464					Appendix
Container	(E) 4	ASTM D5118	RSC		W6c	WR	11 1/2 x 5 5/8 x 12
Separator	(F) 5	ASTM D4727	SW	CF	175	DO	5 5/8 x 12
Closure	(E) 6	ASTM D5118					Sealing method A, Reinforcement method 2A

LEVEL B (METHOD )  NOT APPLICABLE  SEE NOTE (G)  IAW MIL-STD-2073-1  
 LEVEL C (METHOD IA-5)  NOT APPLICABLE  SEE NOTE  IAW MIL-STD-2073-1  
 COMMERCIAL PACKAGING  NOT APPLICABLE  SEE NOTE  IAW ASTM D3951

**UNIT PACK LOGISTICS DATA** (Weights and Sizes Approximate)

LEVEL	UNIT PACK QUANTITY	UNIT PACK WEIGHT	UNIT PACK CUBE	UNIT PACK SIZE (EXTERIOR) FEET
A	(A) 1	12.00 lbs	.499 cu. ft.	.98 x .49 x 1.04
C	(A) 1			

Intermediate packaging and packing will be in accordance with specification MIL-STD-2073-1 or as otherwise specified hereon.

Marking will be in accordance with MIL-STD-129 (H)

Specifications, standards, and drawings listed hereon of the issue in effect on date of invitation for bid form a part of this data sheet. The applicable general and referenced requirements of specification MIL-STD-2073-1 form part of this data sheet. Unless otherwise specified, materials will be minimum size IAW MIL-STD-2073-1.

Tolerances shall be in accordance with material specifications. Quality performance and testing requirements shall be in conformance with MIL-P-116 or as specified hereon. (I) (J)

REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

- (A) - Packaging and marking (commercial) for interplant shipment may only be used when shipping the item from a vendor or supplier to a prime contractor for immediate use of further processing, or from a prime contractor to a military facility for review or evaluation as specified in the contract or order.
- (B) - Unit of issue is box. Unit pack quantity is one box. Each unit pack box contains two filters, each in a hermetically sealed can.
- (C) - Two cans are required.
- (D) - Cut 1 3/16 inch diameter holes on center in each disc. Place discs over ends of filter to prevent movement and to isolate filter from ends of can.

<i>Original Preparer: nj matassa</i>		<i>Revised by: J.D. Stallings/Contr DAA05-01-P1303</i>			
<b>ITEM DATA</b> (APPROX) <b>ITEM CODE</b> - 318, 349 <b>ITEM SIZE</b> - 5 1/8 dia x 10 1/2 inches (one filter) <b>ITEM WEIGHT</b> - 5.40 lbs (each)	AMCCOM 81361				
	SCBRD-ENE-S		JDS	349-016A1-003	B 9 JUL 02
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	1	5	APPROVAL		REVISION DATE

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- (E) – Supplemental container and closure.
- (F) – Place separator between the two cans.
- (G) – Unit pack the same as Level A, except the ASTM D5118 box shall be style RSC, grade 125 (min), class domestic.
- (H) – Lot numbers and shelf life markings shall be applied.
- (I) – **Unit pack container leakage.** The unit pack container shall show no sign of leakage, as evidenced by a continuous stream of bubbles which appear at any surface when tested in accordance with MIL-F-51193.
- (J) – The preproduction (first article) and quality conformance inspection and testing requirements for level A unit packing shall be in accordance with quality conformance inspection and testing requirements of this SPI. Packing inspection shall be in accordance with quality conformance inspection requirements of MIL-STD-2073-1.

### QUALITY INSPECTION AND TESTING SECTION

#### PART I--QUALITY PROVISIONS

1. **Responsibility for inspection.** Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) 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 herein where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.
2. **Responsibility for compliance.** All items shall meet all requirements of of this SPI. The inspection set forth in this SPI shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in this SPI shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.
3. **Contractor assurance of compliance.** The contractor's quality program or detailed inspection plan shall provide assurance of compliance of all characteristics with this SPI's requirements using, as a minimum, the conformance criteria specified herein.
4. **Alternative inspection provisions.** Alternative inspection procedures, methods, or equipment, such as statistical process control, tool control, and other types of sampling procedures may be used by the contractor when they provide, as a minimum, the level of quality assurance required by the inspection provisions specified herein. Prior to applying such alternative procedures, methods, or equipment, the contractor shall describe them in a written proposal submitted to the Government for evaluation and approval. When required, the contractor shall demonstrate that the effectiveness of each proposed alternative is equal to or better than the quality assurance

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provisions specified herein. In cases of dispute as to whether the contractor's proposed alternative provides equal quality assurance, the provisions of this SPI shall apply. All approved alternative inspection provisions shall be specifically incorporated into the contractor's quality program plan or detailed inspection system, as applicable.

### 5. First article inspection.

a. **Submission.** The first article sample shall consist of three Gas Filters, (Drawing 5-19-2300) unit packed in accordance with this SPI. The first article sample shall be submitted for inspection and approval in accordance with the terms of the contract. As determined by the Government, the sample of packed items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any or all of the requirements of the applicable drawings and of this SPI.

b. **Packaging acceptance criteria.** If any first article sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

### 6. Quality conformance inspection.

a. **Lotting.** A lot shall consist of the items produced by one manufacturer, at one plant, from the same materials, under essentially the same manufacturing conditions, and at essentially the same time.

b. **Sampling.** Samples shall be selected at random. Sampling shall be conducted in accordance with table I using the inspection levels specified in Part II of this SPI. If required, special sampling, inspection, and acceptance criteria are contained in Part II of this SPI.

c. **Inspection characteristics.** Critical characteristics are characteristics whose nonconformance to specified requirements is likely to result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product or whose nonconformance to specified requirements is likely to prevent performance of the tactical function of a major end item. Major characteristics are characteristics whose nonconformance to specified requirements is likely to result in failure or to reduce materially the usability of the item for its intended purpose. Minor characteristics are characteristics whose nonconformance to specified requirements is not likely to reduce materially the operation or usability of the item for its intended purpose.

d. **Inspection.** Inspection shall consist of examination and test of all the characteristics contained in Part II and Part III of this SPI.

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TABLE I. Sampling

Lot size	Inspection levels and sample sizes										
	I	II	III	IV	V	VI	VII	VIII	IX	X	XI
2 to 8	*	*	*	*	*	*	*	*	5	3	2
9 to 15	*	*	*	*	*	*	13	8	5	3	2
16 to 25	*	*	*	*	*	20	13	8	5	3	3
26 to 50	*	*	*	*	32	20	13	8	5	5	5
51 to 90	*	*	*	50	32	20	13	8	7	6	5
91 to 150	*	*	125	50	32	20	13	12	11	7	6
151 to 280	*	*	125	50	32	20	20	19	13	10	7
281 to 500	*	315	125	50	48	47	29	21	16	11	9
501 to 1200	*	315	125	75	73	47	34	27	19	15	11
1201 to 3200	1250	315	125	116	73	53	42	35	23	18	13
3201 to 10000	1250	315	192	116	86	68	50	38	29	22	15
10001 to 35000	1250	315	294	135	108	77	60	46	35	29	15
35001 to 150000	1250	490	294	170	123	96	74	56	40	29	15
150001 to 500000	1250	715	345	200	156	119	90	64	40	29	15
500001 and over	1250	715	435	244	189	143	102	64	40	29	15

\*Indicates one hundred percent inspection. If sample size exceeds lot size, perform one hundred percent inspection.  
Accept the lot represented on zero nonconforming characteristics and reject the lot represented on one or more nonconforming characteristics for all inspection levels.

**7. Inspection equipment coding.**

- a. AD - Army designed special acceptance inspection equipment
- b. CD - Contractor designed special acceptance inspection equipment
- c. CE - Commercial inspection equipment
- d. VI - Visual inspection

**8. Inspection requirements for packaging.** Any inspection requirements for packaging are applicable only when military packaging is required by the contract.

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## PART II -- INSPECTION REQUIREMENTS

### PACKING INSPECTION

<u>Category</u>	<u>Characteristic</u>	<u>Sampling and acceptance criteria</u>	<u>Inspection method</u>
<u>Major</u>			
101	Unit packing container leakage	Part II, 201	Part III, 301
102	Item completely clean and dry prior to unit packing	Table I, level IX	VI
103	Blocking correct	Table I, level IX	VI and CE
104	Separator correct	Table I, level IX	VI and CE
105	Unit pack container and closure correct	Table I, level IX	VI and CE
106	Supplemental Container closure correct	Table I, level IX	VI and CE
107	Unit packing container marking correct	Table I, level IX	VI and CE

### SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

**201 Unit pack container leakage.** Three unit pack containers and their contents, unit packed for shipment, shall be selected at random from each lot and tested in accordance with Part III, 301 of this quality section. Failure of any sample to meet the leakage requirement shall be cause for rejection of the lot from which the sample was drawn.

### PART III -- TEST METHOD AND PROCEDURES

**301 Unit pack leakage.** The cans shall not leak when tested in accordance with the Elevated Temperature Test Fluid Method of ASTM E515.

### PART IV -- CERTIFICATION REQUIREMENTS

Not applicable

Certification shall be required for each characteristic specified below and shall include actual examination and test results when required herein. Results of examinations and tests shall be on file at the contractor's facility and shall be available to the Government for review.

<u>Number</u>	<u>Characteristic</u>	<u>To comply with</u>
401	Packaging material	Applicable specification or standard as specified herein.

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