

SPECIAL PACKAGING INSTRUCTION

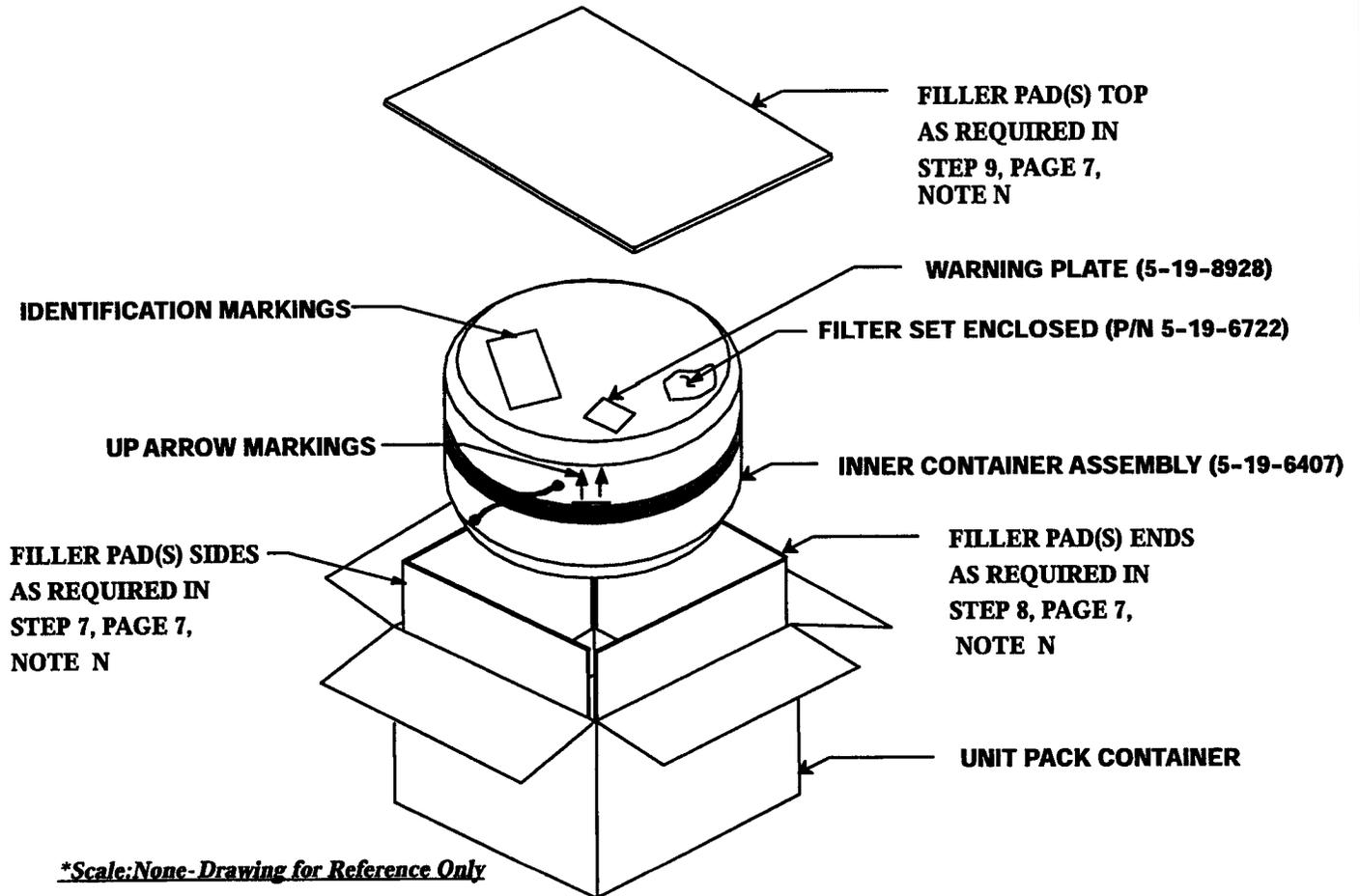
NATIONAL STOCK NUMBER
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NOMENCLATURE
FILTER SET, GAS-PARTICULATE: NBC, 200 CFM

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ALTERNATE LEVEL A CONFIGURATION ASSEMBLY



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P5-19-6722**LEVEL B UNIT PACK REQUIREMENTS****(See Note P Below)**

UNIT PACK LEVEL A REQUIREMENTS MIL-STD-2073-1.METHOD 41	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	CLASS	SIZE AND REMARKS (INCHES)
Pad Container	(O) 1	5-19-6410				Eight required
Container	(R)(S) 2	MIL-DTL-117	1	1	E	40 x 44
Closure	(T) 3					Heat Seal
Container	(R)(U) 4	MIL-DTL-117	1	1	E	40 x 44
Closure	(T) 5					Heat Seal
Top / Bottom Pad	(V) 6	MIL-P-19644	1	1		26 x 26 x 1 (2 required)
End Pad	(V) 7	MIL-P-19644	1	1		25 x 13 x 1 (4 required)
Corner Pad	(V) 8	MIL-P-19644	1	1		See Sketch on Page 12
Container	(W) 9	ASTM D 5118	RSC		WR	26 1/4 x 26 1/4 x 15 3/8
Closure	10	ASTM D 1974				Sealing Method C, Reinforcement Method 2E

(P) – Level B Unit Pack. This packaging design is only to be used to package filters for immediate domestic shipment and domestic usage.

This pack shall only be used to ship and store filters for a maximum of one year from the date Packed. If filters are over the one year storage life contact the item manager for disposition. This level B unit pack does not meet Army Field shipment and storage requirements.

(Q) – Inner Cushioning Pads Pad Assembly. Four pads shall be placed around the diameter of the drum as shown on page 12. Next, insert the Filter Set so that it rests on the pads. Complete the assembly by placing four additional pads on top of the Filter Set as shown on page 12.

(R) – Barrier Bag Construction The barrier bag shall be constructed of a material conforming to MIL-PRF-131, Class 1.

(S) – Barrier Bag and Container Assembly. Place the Filter and the Filler Pads in step 1 into the barrier bag step 2. Insure no damage occurs to the barrier bag and that the pads remain in place. See note (T) for closure.

(T) – Barrier Bag Closure. Closure of the barrier bags shall be accomplished by heat sealing. Heat sealing shall be accomplished in accordance with the barrier bag manufactures instructions. Excess air shall be removed from the barrier bag prior to heat sealing.

(U) – Exterior Barrier Bag. Place the barrier bag and container assembly (step 3) into the second barrier bag. Insure no damage occurs to the barrier bags and that the pads remain in place. See note (T) for closure.

(V) – Cushioning Material. The Top/Bottom Pads, End Pads and Corner Pads shall be of 1 pound per cubic foot density in accordance with MIL-P-19644. Fabricate the corner pads as shown on page 13 of this SPI. Place the pads as shown on page 14. of this SPI.

(W) – Fiberboard Container. In addition The fiberboard container shall be of double wall construction, Variety DW, using V13c material, in accordance with ASTM D 5118.

(X) – MARKING. In addition to any special marking required by the contract or order, the exterior shipping container shall be marked in accordance with MIL-STD-129.

1. Each exterior packaging shall have the following information marked on one side:
 - a. Date packed

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- b. Lot number of the filter set. The lot number for the filter set shall be preceded by the words "LOT NO. " Locate markings on the line following the shelf life markings covered in 1e below.
- c. Filter weight (bare) Gross weight of the inner filter assembly (including filters and packaging components). The weight shall be measured after packaging and applied to the nearest 1/2 ounce. Locate marking on the line following the identification markings.
- d. Serial number of filter set, shall be preceded by the words "SERIAL NO. " Locate markings on the line following the weight markings covered in 1c above. The gas filter serial number shall be applied first.
- e. Shelf life marking for filter set. Locate marking immediately following the serial number markings.
- f. Up arrow markings. Mark the exterior shipping container with up arrows, symbol 2 of ASTM D5445.
- g. The exterior shipping container (Step 10) shall be marked:
 "This Filter is not serviceable after one year for Date Packed. "
 "If the pack is over 1 year past the date of pack, contact the item manager for disposition. "
- h. Mark the top of each Fiberboard container with the following:

"WARNING**DO NOT USE IF THE BARRIER BAGS HAVE BEEN OPENED, HAVE HOLES, HAVE BEEN PUNCTURED OR SHOW SIGNS OF LEAKAGE. KEEP CONTAINER SEALED UNTIL FILTERS ARE REQUIRED. "**

Marking shall be at least 16 point type print. The marking shall be applied on a paper label that is pressure-sensitive and shall be securely affixed with a water-resistant label adhesive or a transparent, waterproof, pressure-sensitive tape. This marking will be applied to the top of the fiber board container and not obstructed by the tape close or tape reinforcement of the container.

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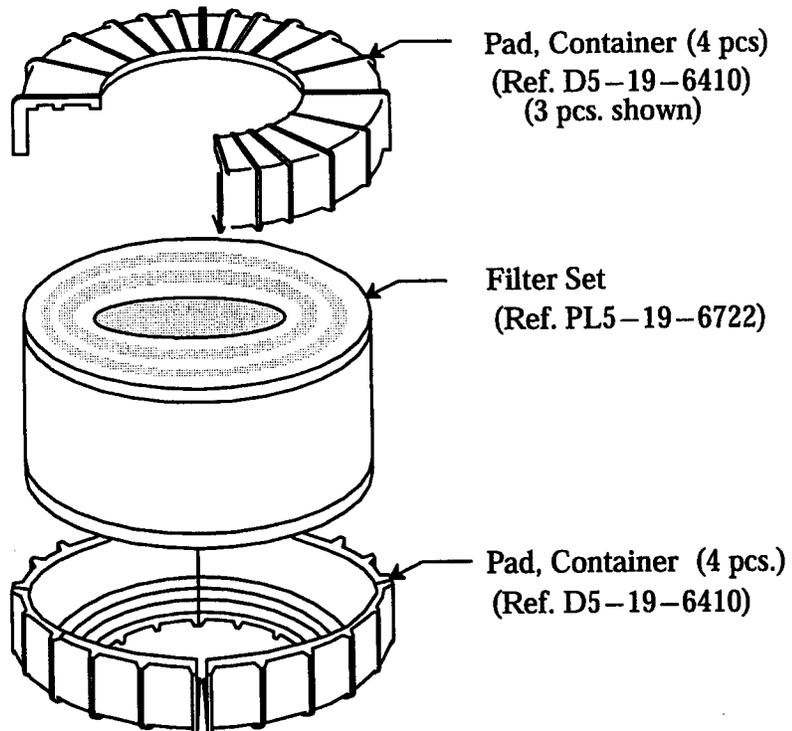
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INNER CUSHIONING CONFIGURATION



**Scale:None- Drawing for Reference Only*