

**NO1 APPLICABLE TO INTERPLANT SHIPMENTS (A)**

<b>SPECIAL PACKAGING INSTRUCTION(SPI) (A)</b>						NATIONAL STOCK NUMBER 5965-01-443-5488	
NOMENCLATURE <b>MICROPHONE POSITIONER AND GASKET ASSEMBLY</b>					UI EA	QUP 1	SPI NUMBER (PN) P5-1-3359
Cleaning & Drying shall be in accordance with MIL-STD-2073-1							
MILITARY PRESERVATION REQUIREMENT (MIL-STD-2073-1, Method 1)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
Cushioning	(B) 1	PPP-C-795				1	6 x 6
Tape	(B) 2	ASTM D5486		V			See note (B) below
Container (bag)	(C) 3	MIL-DTL-117	2	III		B	5 x 7
Closure	(D)(E)(F) 4						Heat Seal, Tape or Staple
INTERMEDIATE PACKAGING AND PACKING <input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1 <input type="checkbox"/> As specified hereon.					MARKING <input checked="" type="checkbox"/> In accordance with MIL-STD-129 <input type="checkbox"/> As specified hereon.		
QUALITY PERFORMANCE and TESTING REQUIREMENTS <input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1 <input checked="" type="checkbox"/> As specified hereon. <b>SEE NOTE (G)</b>							
Specifications, standards, and drawings listed hereon of the issue in effect on date of invitation for bid form a part of this Instruction. Applicable general and referenced requirements of specification MIL-STD-2073-1 form part of this Instruction. Unless otherwise specified, materials will be minimum size IAW MIL-STD-2073-1. Tolerances shall be in accordance with material specifications.							
<b>UNIT PACK LOGISTICS DATA</b> (Approximate unit pack weight and size)							
WEIGHT (POUNDS) .13 lbs.		CUBE (CUBIC FEET) .011 cu. ft.		SIZE (EXTERIOR FEET) .28 x .48 x .08			
REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.							
<p><b>(A) – This SPI is not applicable for Interplant shipments.</b> Packaging and marking for interplant shipment is for supplies and materials that do not directly enter the military supply system. Typical interplant shipments are shipments from a vendor to a subcontractor or a prime contractor, or between contractors and subcontractors, or from a vendor or contractor to a military arsenal, plant, or other activity for evaluation, immediate use, or further processing as specified in the applicable contract.</p> <p><b>(B) – Fold over one inch of cushioning material to form a double thickness, on either end. Place the connector end of the microphone positioner and gasket assembly on this end of the cushioning. Wrap item in specified cushioning and fold over any excess on the opposite end. Secure with specified tape conforming to ASTM D5486, Type V, size 1 inch. Tape shall not come in contact with the item.</b></p>							
Original Preparer: J.D.Stallings			Date: Dec 1995		Revised by: R.Poole		Date: 17 June 2004
<b>ITEM DATA</b> (APPROX) ITEM CODE - 123 ITEM SIZE - 4 3/8 x 1 x 3/4 inches ITEM WEIGHT - .06 lbs.		RDECOM 81361 AMSRD-ECB-ENA-P		<b>DRAFT</b>			
		PAGE NUMBER 1	NUMBER OF PAGES 4	RP	JDS 123-0034-018	123-036 (A)	25 JULY 02
				APPROVAL	REVISION	DATE	

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Attachment 003

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- (C) – Insert cushioned microphone positioner and gasket assembly into specified bag (step 3) and close (step 4).
- (D) – The heat seal closure (step 4) shall be accomplished in accordance with the bag or material manufacturer's recommendations for dwell, pressure and temperature requirements. Sufficient air shall be evacuated from the bagged assembly to cause the bag to be taut without causing damage to the item or bag.
- (E) – **Unit pack container (bag) leakage.** The unit pack container bags shall show no sign of leakage, as evidenced by a continuous stream of bubbles which appear at any surface, when tested in accordance with Part V, 501 of the PQAP of this SPI.
- (F) – **Unit pack (bag) heat-seal seam.** The heat-seal seam of the empty container (bags) shall show no sign of heat seam separation when tested in accordance with Part V, 502 of the PQAP of this SPI.
- (G) – **Packaging Quality Assurance Provisions (PQAP).**

**Part I – Applicable Documents**Military standards

- MIL-STD-2073-1 – Standard Practice For Military Packaging  
MIL-STD-1916 – Department Of Defense Test Method Standard  
MIL-STD-3010 – Test Procedures For Packaging Materials

**Part II – Quality Provisions.**

**1. First Article Inspection.** The first article packaging sample shall consist of five microphone positioner and gasket assemblies (drawing 5-1-3359). However, these samples shall be packaged in accordance with the military preservation requirements of this SPI. The first article sample shall consist of five unit packed microphone positioner and gasket assemblies and five empty unit pack containers. The first article packaging sample shall be submitted for inspection and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this PQAP and be inspected for compliance with any or all of the requirements of this SPI.

**a. Acceptance Criteria.** If any first article sample fails to comply with any of the 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. The contractor shall obtain written approval from the contracting activity prior to proceeding with regular production.

**2. 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 the same time.

**b. Sampling.** Sampling shall be conducted in accordance with the attributes sampling plan of MIL-STD-1916, using the verification levels (VLs) specified herein. The bagged assemblies of

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microphone positioner and gasket assemblies shall be subjected to the nondestructive test in accordance with Part V, 501. In addition, five empty bags, packaging step (3) shall be removed from the lot of bags and subjected to the following destructive test. The sample of empty bags, packaging shall be produced using the same methods, materials, and equipment as will be used during regular production. If required, special sampling, inspection and acceptance criteria are contained in Part III of this PQAP.

**3. Inspection equipment coding.**

- CE – Commercial inspection equipment
- VI – Visual inspection

**PART III – INSPECTION REQUIREMENTS**

CLASSIFICATION OF CHARACTERISTICS

**PACKAGING CHARACTERISTICS**

CATEGORY	CHARACTERISTICS	SAMPLING and ACCEPTANCE CRITERIA	INSPECTION METHOD
Major	None Defined.		
Minor			
101	Item completely clean and dry prior to unit packing.	VL III	VI
102	Cushioning evident and correct.	VL III	VI and CE
103	Cushioning secured with tape evident and correct.	VL III	VI and CE
104	Unit pack container (bag) evident and correct.	VL III	VI and CE
105	Unit pack container (bag) closure evident and correct.	VL III	VI and CE
106	Unit pack container (bag) marking evident, correct and legible.	VL-III	VI and CE
107	Unit pack bag leakage.	Part III, 301	VI and CE
108	Unit pack container bag heat-seal seam strength	Part III, 302	VI and CE

**NOTES:**

VI = Visual inspection

CE = Commercial inspection equipment

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P5-1-3359**SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA**

**301 Unit pack container (barrier bag) leakage.** Five unit pack containers (bags) and their contents, packed for shipment, shall be selected at random from each lot and tested in accordance with Part V, 501 of this PQAP. Failure of any sample to meet the leakage requirement shall be cause for rejection of the lot from which the sample was drawn.

**302 Unit pack container (barrier bag) heat-seal seam (destructive test).** Five unit pack containers (empty bags) shall be selected at random from those being used for each lot of items and tested in accordance with Part V, 502 of this PQAP. Failure of any sample to meet the seam requirement shall be cause for rejection of the lot from which the sample was drawn.

**PART IV – CERTIFICATION REQUIREMENTS**

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.

<b><u>Number</u></b>	<b><u>Characteristic</u></b>	<b><u>To comply with</u></b>
401	Packaging material	Applicable specification or standard specified in this SPI.

**PART V – TEST METHODS AND PROCEDURE**

**501 Unit pack container (barrier bag) leakage.** The microphone positioner and gasket assembly bags and their contents shall not leak when tested in accordance with MIL-STD-2073-1, appendix G (hot water technique), except that FED-STD-101 is replaced by MIL-STD-3010.

**502 Unit pack container (barrier bag) heat-seal seam strength.** Prepare the closure seam of the empty bags under the same conditions used for the unit pack assemblies. The heat seal seam of the empty microphone positioner and gasket assembly bags, shall be tested in accordance with MIL-STD-2073-1, Appendix G (heat-seal seam test), except that FED-STD-101 is replaced by MIL-STD-3010.