

SPECIAL PACKAGING INSTRUCTION(SPI) (A)						NATIONAL STOCK NUMBER 4240-00-868-7906			
NOMENCLATURE Purifier, Air, M2A2				UI EA	QUP 1	SPI NUMBER (PN) P5-19-1772			
Cleaning & Drying shall be in accordance with MIL-STD-2073-1									
MILITARY PRESERVATION REQUIREMENT (B) <small>(MIL-STD-2073-1, Method 42)</small>	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)		
Container	1	ASTM D 5118	RSC	CF	W5c	WR	13 1/2 x 6 3/4 x 7 3/4		
Cushioning	2	ASTM D 4727	Variety SW	CF	W5c	WR	13 x 6 (5 pcs)		
Closure	(C)3	ASTM D 1974					Closure Method 2B6		
Barrier Bag	4	MIL-DTL-117	1	I		E	18 x 24		
Closure	(D)5						Heat Seal		
Container	6	MIL-DTL-117	1	I		E	20 x 24		
Closure	(D)7						Heat Seal		
Container	(E)8	ASTM D 5118	RSC	CF	W5c	WR	14 1/2 x 7 1/4 x 8 3/4		
Closure	(F)9	ASTM D 1974					Closure Method 2B6		
INTERMEDIATE PACKAGING AND PACKING				MARKING					
<input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1				<input checked="" type="checkbox"/> In accordance with MIL-STD-129					
<input type="checkbox"/> As specified hereon.				<input checked="" type="checkbox"/> As specified hereon. (G)					
QUALITY PERFORMANCE and TESTING REQUIREMENTS									
<input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1/MIL-STD-1916, as applicable.									
<input checked="" type="checkbox"/> As specified hereon. SEE NOTES (H), (I), (J) PAGES 2 THROUGH 4									
Unless otherwise specified, materials shall be minimum size in accordance with MIL-STD-2073-1. Tolerances shall be in accordance with material specifications.									
UNIT PACK LOGISTICS DATA (Approximate unit pack weight and size)									
WEIGHT (POUNDS)		CUBE (CUBIC FEET)		SIZE (EXTERIOR FEET)					
19.35 lbs.		.597 cu. ft.		1.23 x .63 x .77					
REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.									
<p>(A) – This SPI is not applicable for Interplant shipments. 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) – Modified to include use of Additional barrier bag.</p> <p>(C) – Tape over manufacture’s joint on the outside of the Container (step 1) prior to closure.</p> <p>(D) – Evacuate excess air from barrier bag using a vacuum pump prior to closure.</p> <p>(E) – A Grade V3c container may be substituted.</p> <p>(F) – Tape over manufacture’s joint on the inside of the Container (step 1) prior to closure.</p>									
<i>Original Preparer:</i>				<i>Revised by: Dean Hansen 4 Mar 2003</i>					
ITEM DATA (APPROX) R62 ITEM CODE – 552, 350, 564 ITEM SIZE – 14 1/4 x 7 1/2 x 6 1/4 inches ITEM WEIGHT – 18.25 lbs		SBCCOM 81361 AMSSB-REN-SE-PK		DVH	R62-0044	C	6 May 03		
				JGS	S1H3153-0006	B	24 Dec 91		
		PAGE NUMBER 1		NUMBER OF PAGES 4		JGS	S0L3057-0009	A	28 Jan 91
						JGS	C6K2626-0002	-	10 Mar 86
				APPROVAL		REVISION			
						DATE			

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(G) – In addition to the standard marking requirements of MIL – STD – 129 the interior and exterior containers shall be marked with the following special markings:

a. Serial number

b. Shelf life code marking

(H) – Unit pack container (bag) leakage. The unit pack container (bag) shall no signs 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.

(I) – Heat seal seam. The heat seal seam of the unit pack container shall no sign of separation when tested in accordance with this SPI.

(J) – 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

Part II – Quality Provisions.

1. First Article Inspection. The first article packaging sample shall be pulled from the sample of M2A2 air purifiers specified in MIL – DTL – 0051070; however these samples shall be packaged as specified herein. In addition, 6 empty unit pack barrier bags(3 each from step 5 of this SPI and 3 from step 7 of his SPI) shall be removed from the lot of bags and subjected to the following destructive test. The sample of empty bags 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 and 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.

2. Conformance Inspection.

a. Sampling. Sampling shall be conducted in accordance with the attributes sampling plan of MIL – STD – 1916 using the verification levels (VLs) specified herein. The packaged M2A2 air purifiers shall be subjected to the following nondestructive test. In addition, In addition, 6 empty unit pack barrier bags(3 each from step 5 of this SPI and 3 from step 7 of his SPI) shall be removed from the lot of bags and subjected to the following destructive test. The sample of empty bags 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.

b. Inspection. Inspection shall consist of examination and test of all the characteristics contained in Part III and Part IV of this PQAP.

3. Inspection equipment coding.

CE – Commercial inspection equipment

VI – Visual inspection

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CLASSIFICATION OF CHARACTERISTICS

<u>Category</u>	<u>Characteristic</u>	<u>Sampling and acceptance criteria</u>	<u>Inspection method</u>
101	Item completely clean and dry prior to unit packaging	VL-I	VI
102	Container (step 1) evident and correct	VL-I	VI and CE
103	Cushioning evident and correct	VL-I	VI and CE
104	Closure (step 3) evident and correct	VL-I	VI and CE
105	Barrier bag (step 4) evident and correct	VL-I	VI and CE
106	Barrier bag closure (step 5) evident and correct	VL-I	VI and CE
107	Barrier bag (step 6) evident and correct	VL-I	VI and CE
108	Barrier bag closure (step 7) evident and correct	VL-I	VI and CE
109	Container (step 8) evident and correct	VL-I	VI and CE
110	Closure (step 9) evident and correct	VL-I	VI and CE
111	Unit pack container marking evident, correct, and legible	VL-I	VI and CE

SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

301 Unit pack container leakage. Three M2A2 air purifiers and their contents (Step 5) and Three M2A2 air purifiers and their contents (Step 7), shall be selected at random from each lot and tested in accordance with Part V, 502 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 seam (destructive test). Three empty barrier bags (Step 5) and three empty barrier bags (Step 7), shall be selected at random from those being used for each lot of M2A2 air purifiers 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.

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

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PART V – TEST METHODS AND PROCEDURES

501 Unit pack container (bag) leakage. The M2A2 Air Purifier barrier bags (steps 5 and 7) shall not leak when tested in accordance with MIL-STD-2073-1, appendix G (hot water technique).

502 Heat-seal seam strength. The heat seal seam of the empty M2A2 Air Purifier barrier bags (steps 5 and 7) , shall be tested in accordance with MIL-STD-2073-1, Appendix G (heat-seal seam test).