

NOT APPLICABLE TO INTERPLANT SHIPMENTS (A)

SPECIAL PACKAGING INSTRUCTION(SPI) (A)						NATIONAL STOCK NUMBER 4140-00-510-0325			
NOMENCLATURE Fan, Centrifugal				UI EA	QUP 1	SPI NUMBER (PN) P5-19-2260			
Cleaning & Drying shall be in accordance with MIL-STD-2073-1									
MILITARY PRESERVATION REQUIREMENT (MIL-STD-2073-1, Method 42)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)		
Intimate Wrap	(B)1	MIL-PRF-121		I			16 x 18		
Container	(C)2	ASTM D 5118	RSC	CF	W5c	WR	6 1/2 x 5 1/2 x 5		
Closure	3	ASTM D 1974					Method 2B7		
Barrier Bag	4	MIL-DTL-117	1	II		E	12 x 14		
Closure	(D) 5						Heat Seal		
Container	6	ASTM D 5118	RSC		W5c	WR	7 1/4 x 6 1/4 x 5 1/2		
Closure	(E)7	ASTM D 1974					Method 2B7		
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 type="checkbox"/> As specified hereon.					
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 (F), (G) (H) 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)					
6.36 lbs.		0.170 cu ft		.63 x .54 x .50					
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) – Wrap the centrifugal fan in specified material and secure with tape conforming to Type 4 of ASTM D5486, size as required. Tape shall not contact item.</p> <p>(C) – Staples shall not be used for the assembly or closure of the fiberboard container (steps 2 and 3).</p> <p>(D) – Evacuate excess air from barrier bag prior to closure.</p> <p>(E) – Do not use staples for assembly or closure of the container (steps 6 and 7). Prior to closure apply fiberboard filler pads as required to restrict movement of the barrier within the outer container. Fiberboard filler pads shall be Type I, Class weather resistant, variety single wall, Grade W5c in accordance with ASTM D 4727. Top and bottom pads shall be 7 x 6 inches. The side pads shall be 6 1/2 x 5 inches. The end pads shall be 5 x 5 1/2. Pads shall only be applied as needed.</p>									
Original Preparer: Nancy Matassa				Revised by: Dean Hansen 18 Mar 2003					
ITEM DATA (APPROX) R64 ITEM CODE – 318, 350, 564 552, 558, 349 ITEM SIZE – 5 x 5 3/8 x 6 inches ITEM WEIGHT – 5.38 lbs.		SBCCOM 81361 AMSSB-REN-SE-PK							
				DVH	564-0144-001	C	13 June 03		
		PAGE NUMBER		NUMBER OF PAGES		JLM	564-0143-001	B	30 Jan 02
		1		4		JLM	R64-0008-001	A	3 Dec 01
				APPROVAL		REVISION			
						DATE			

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(F) – Unit pack container (bag) leakage. The unit pack container (bag) shall show 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.

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

(H) – 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 Centrifugal fans, specified in MIL-F-50084; however these samples shall be packaged as specified herein. In addition, 3 empty unit pack barrier bags (step 5) 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 Centrifugal fans, shall be subjected to the following nondestructive test. In addition, 3 empty unit pack barrier bags (step 5) 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-III	VI
102	Intimate wrap (step 1) evident and correct	VL-III	VI and CE
103	Container (step 2) evident and correct	VL-III	VI and CE
104	Closure (step 3) evident and correct	VL-III	VI and CE
105	Barrier Bag (step 4) evident and correct	VL-III	VI and CE
106	Barrier bag closure (step 5) evident and correct	VL-III	VI and CE
107	Container (step 6) evident and correct	VL-III	VI and CE
108	Closure (step 7) evident and correct	VL-III	VI and CE
109	Unit pack container marking evident, correct, and legible	VL-III	VI and CE

SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

301 Unit pack container leakage. Three unit packed Centrifugal fans, and their contents (Step 5), 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) shall be selected at random from those being used for each lot of Centrifugal fans 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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501 Unit pack container (bag) leakage. The packaged Centrifugal fans, barrier bags 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 Centrifugal fans, barrier bags, shall be tested in accordance with MIL-STD-2073-1, Appendix G (heat-seal seam test).