

NOT APPLICABLE TO INTERPLANT SHIPMENTS (A)

SPECIAL PACKAGING INSTRUCTION(SPI) (A)						NATIONAL STOCK NUMBER	
NOMENCLATURE Repair Strap					UI EA	QUP 1	SPI NUMBER (PN) P5-19-11499
Cleaning & Drying shall be in accordance with MIL-STD-2073-1							
UNIT PACK LEVEL A REQUIREMENTS (MIL-STD-2073-1, Method 31)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
Container	1	MIL-B-117	1	II		B	15 1/2 x 6 1/2
Closure	(B)2						Heat Seal
Level B (Method)		See Note		In accordance with MIL-STD-2073-1			
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							
<input checked="" type="checkbox"/> As specified hereon.							
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 (Weights and Sizes Approximate)							
LEVEL	UNIT PACK QUANTITY	UNIT PACK WEIGHT	UNIT PACK CUBE	UNIT PACK SIZE (EXTERIOR) FEET			
A	1	.030 lbs.	.0278 cu.ft.	1.29 x .54 x .04			
REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.							
<p>(A) - This SPI is not applicable for Interplant shipments. Interplant shipment. 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) - Closure of the barrier bag shall be accomplished by heat sealing in accordance with the manufacturers instructions. Excess air shall be removed from the barrier bag prior to heat sealing.</p> <p>(C) - SHELF LIFE. Shelf life markings shall be applied.</p>							
ITEM DATA (APPROX)		Original Preparer: Dean V Hansen		Revised by: D. Hansen 4 Jan 2002			
ITEM SIZE - 13 1/2 x 3 x 3/8 inches		SBCCOM 81361					
ITEM CODE - Z36, Z37, Z38, Z39, R29, Z40, Z48		AMSSB-REN-SS					
ITEM WEIGHT -		PAGE NUMBER	NUMBER OF PAGES	DVH	Z24-0417-013	Z24-134(A)	4 Jan 2002
		1	1	RP	Z24-0399-0004	Z24-0399	27 SEPT 01
				APPROVAL	REVISION	DATE	

DISTRIBUTION STATEMENT A: Approved for public release, distribution unlimited.

Attachment 011

QUALITY ASSURANCE PROVISIONS (QAP)
(DARCOM-R 702-10)

1. COMMAND AGENCY:

U.S. ARMY EDGEWOOD CHEMICAL BIOLOGICAL CENTER

2. THESE QAP'S FORM PART OF DRAWING/SPECIFICATION 5-19-11499 AS SPECIFIED IN THE CONTRACT. INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS

3.
PART I -- APPLICABLE DOCUMENTS

DRAWINGS

- 5-19-11226 - Laminate, Saranex, HDPE Scrim, LDPE Coating
- 5-19-11499 - Repair Strap
- 5-19-11609 - Tape, Saranex

PART II -- QUALITY PROVISIONS

1. First article inspection.

a. Submission. A first article sample shall be required when specified in the contract. The first article sample shall consist of twenty repair straps (Drawing 5-19-11499). 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 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.

b. 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. The contractor shall obtain written approval from the contracting activity prior to proceeding with regular production.

2. Quality conformance inspection.

a. Lotting. A lot shall consist of the items produced by one manufacturer, at one plant, from the same materials, under the same manufacturing conditions, and at the same time. The lot shall not contain more than one lot of Saranex laminate (Drawing 5-19-11226) and one lot (or batch) of adhesive.

REVISIONS

4. RELEASE NUMBER																			
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REVISION STATUS OF SHEETS	6. REVISION																		
	7. SHEET	1	2	3	4	5													
	6. REVISION																		
	7. SHEET																		

8. QAP FOR:

REPAIR STRAP

9. SUBMITTED BY: C. SHERWOOD /S/ AMSSB-REN-SS										10. QAP NO.: 5-19-11499														
11. DATE: 7 Mar 2001					12. APPROVED: J. GREBE /S/ AMSSB-REN-SS					13. RELEASE NO.: Z24-133					14. PAGE NO.: 1					15. NO. OF PAGES: 4				

QUALITY ASSURANCE PROVISIONS (QAP)

(DARCOM-R 702-10)

b. Sampling. Samples shall be selected at random. Sampling shall be conducted in accordance with Table I using the inspection levels specified in Part III of this QAP. Special sampling, inspection, and acceptance criteria are contained in Part III of this QAP.

c. Inspection characteristics. Critical characteristics are characteristics whose nonconformance to specified requirements is likely to result in hazardous or unsafe conditions for individuals who use or maintain the product. Characteristics whose nonconformance to specified requirements is likely to prevent performance of the tactical function of a major end item are also critical characteristics. 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 III and Part IV of this QAP. All other quality characteristics not specifically listed herein are subject to inspection under the contractor's quality or inspection system.

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.

16. REVISION SYMBOL AND DATE	Rev. 0						10. QAP NO.:
	7 Mar 2001						5-19-11499
							14. PAGE NO.:
							2

QUALITY ASSURANCE PROVISIONS (QAP)

(DARCOM-R 702-10)

3. Inspection equipment coding.

- AD – Army designed special acceptance inspection equipment
- CD – Contractor designed special acceptance inspection equipment
- CE – Commercial inspection equipment
- VI – Visual inspection

PART III – – INSPECTION REQUIREMENTS

CLASSIFICATION OF CHARACTERISTICS

(a) Repair Strap (Drawing 5-19-11499)

<u>Category</u>	<u>Characteristic</u>	<u>Sampling and acceptance criteria</u>	<u>Inspection method</u>
<u>Critical</u>	None defined		
<u>Major</u>			
101	Dimensions correct	Table I, level IX	VI & CE
102	Components evident and correct	Table I, level IX	VI & CE
103	Components correctly assembled	Table I, level IX	VI & CE
104	Adhesive evident and correct	Table I, level IX	VI & CE
105	Release liner evident and correct	Table I, level IX	VI & CE
<u>Minor</u>			
201	Workmanship	See category 301	VI & CE

SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

301 Workmanship. The repair straps shall be sampled in accordance with Table I, level XI and visually inspected for workmanship. The snap button and socket shall be assembled with no dents, flattening or damage to the tape or LDPE strap. The snap button neck shall be rolled over the snap socket opening smoothly with no rough, uneven or sharp edges. The snap socket shall be securely fastened to the snap button. The tape backing (Saranex laminate per Drawing 5-19-11226) shall be free of foreign matter (dirt, grease, oil, and viscous material) and damage (punctures and tears), and shall exhibit no scores (scratches or superficial incisions) greater than one inch in length. The tape shall adhere smoothly to the release liner with no wrinkling or voids. The release liner shall peel away from the tape without delamination or tearing of either the release liner or the tape, and without removing the adhesive from the tape backing. The adhesive shall be applied smoothly and evenly over the entire area of the tape backing with no lumps, bare spots, blisters, voids or foreign particles.

16. REVISION SYMBOL AND DATE	Rev. 0					10. QAP NO.:
	7 Mar 2001					5-19-11499
						14. PAGE NO.:
						3

QUALITY ASSURANCE PROVISIONS (QAP)
(DARCOM-R 702-10)

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	Saranex laminate	Drawing 5-19-11226
402	Adhesive	Drawing 5-19-11609
403	Release liner	Drawing 5-19-11609

*Actual test results required

PART V -- TEST METHODS AND PROCEDURES

Not applicable

PART VI -- NOTES

Not applicable

16. REVISION SYMBOL AND DATE	Rev. 0					10. QAP NO.:
	7 Mar 2001					5-19-11499
						14. PAGE NO.:
						4