

<b>SPECIAL PACKAGING INSTRUCTION(SPI) (A)</b>						NATIONAL STOCK NUMBER 4240-01-443-2476	
NOMENCLATURE CANISTER, BAFFLE ASSEMBLY				UI EA	QUP 1	SPI NUMBER (PN) P5-1-2857	
<b>Cleaning &amp; Drying shall be in accordance with MIL-STD-2073-1</b>							
MILITARY PRESERVATION REQUIREMENT (MIL-STD-2073-1, Method 10)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
<b>Container</b>		MIL-DTL-117	2	III		B	3 x 3
<b>Closure</b>							Heat Seal, staple or tape
<b>INTERMEDIATE PACKAGING AND PACKING</b>		<b>MARKING</b>					
<input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1 <input type="checkbox"/> As specified hereon.		<input checked="" type="checkbox"/> In accordance with MIL-STD-129 <input type="checkbox"/> As specified hereon.					
<b>QUALITY PERFORMANCE and TESTING REQUIREMENTS</b>							
<input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1 <input checked="" type="checkbox"/> As specified hereon. SEE NOTE (C)							
Specifications, standards and drawings listed hereon in effect on date of invitation for bid form a part of this Packaging Instruction. Rrquirements of MIL-STD-2073-1 and MIL-STD-1916 are part of this packaging instruction. Tolerances shall be in accordance with material specifications, unless otherwise specified hereon.							
<b>UNIT PACK LOGISTICS DATA (Approximate unit pack weight and size)</b>							
WEIGHT (POUNDS)		CUBE (CUBIC FEET)		SIZE (EXTERIOR FEET)			
<b>.03 lbs.</b>		<b>.006 cu. ft.</b>		<b>.31 x .28 x .07</b>			
<b>REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.</b>							
<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) – Insert one canister baffle assembly into specified bag (step 1). Bag to be constructed of A-A-3174 material, 0.003 mil thick, as specified in MIL-DTL-117. Closure shall be accomplished by staple, tape, or heat sealing as follows: Taped closures shall be accomplished by folding the excess material at the opening of the bags, secure with tape in accordance with ASTM D5846 Type 2, Class 2. Tape shall not come into contact with cable assembly. Staple closures shall be accomplished by folding the excess material at the opening of the bags, secure with staples. Heat sealed closures shall be accomplished IAW the barrier bags, or barrier material supplier’s recommendations for dwell, pressure and temperature requirements. Trapped air shall be kept to a minimum by compressing the bag or by a</p>							
Original Preparer: <b>C.Williamson</b> <b>Sept 96 (njm)</b>				Revised by: <b>R.Poole</b> Date: <b>8 April 2003</b>			
ITEM DATA (APPROX) ITEM CODE – 123 ITEM SIZE – 1 7/16 DIA x 3/4 inches ITEM WEIGHT – .01 lbs.		SBCCOM 81361 AMSSB-REN-SE-PK				<b>DRAFT</b>	
		PAGE NUMBER <b>1</b>	NUMBER OF PAGES <b>3</b>	NMK		123-001	5 NOV 96
				APPROVAL		REVISION	DATE

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**mechanical evacuation process to the extent practicable, prior to accomplishing the final closure. Do not evacuate to the point of damaging or deforming the item.**

(C) – Packaging Quality Assurance Provisions (PQAP).

Part I – Applicable Documents

**Military standards**

**MIL-STD-1916 – Department Of Defense Test Method Standard**

**MIL-STD-2073-1 – Standard Practice For Military Packaging**

Part II – Packaging Quality Provisions.

1. First Article Inspection. **The first article sample shall be in accordance with QAP5-1-2857; however, the sample shall be packaged as specified herein. 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 packaging 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. **Lotting shall be as specified in QAP5-1-2857, except that the canister, baffle assembly shall be packaged as specified herein.**

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

c. 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.

**VI = Visual inspection**

**CE = Commercial inspection equipment**

**AD = Army designed special acceptance inspection equipment**

**CD = Contractor designed special acceptance inspection equipment**

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**PART III – INSPECTION REQUIREMENTS**

**PACKAGING CHARACTERISTICS**

CATEGORY	CHARACTERISTICS	SAMPLING and ACCEPTANCE CRITERIA	INSPECTION METHOD
<b>Critical</b>	None Defined.		
<b>Major</b>	None Defined.		
<b>Minor</b>			
<b>101</b>	Item completely clean and dry prior to unit packaging	VL-III	VI
<b>102</b>	Unit pack (bag) container evident and correct.	VL-III	VI and CE
<b>103</b>	Unit pack (bag) assembly and closure evident and correct.	VL-III	VI and CE
<b>104</b>	Unit pack container (bag) marking evident, correct and legible.	VL-III	VI and CE

**NOTES:**  
**VI = Visual inspection**  
**CE = Commercial inspection equipment**  
**AD = Army designed special acceptance inspection equipment**  
**CD = Contractor designed special acceptance inspection equipment**

**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>COMPLY WITH</u>
401	Packaging material	Applicable specification or standard specified in this SPI.