

SPECIAL PACKAGING INSTRUCTION

NATIONAL STOCK NUMBER
5930-01-173-5869

NOMENCLATURE **THERMOSTAT – HIGH TEMPERATURE
CUTOFF – BURNER**

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SPI NUMBER (PN)
P5-45-5183

- (D)– Trapped air shall be kept to a minimum by compressing the bag or by a mechanical evacuation process to the extent practicable, prior to accomplishing the final heat seal. Do not evacuate to the point of puncturing the barrier material wrapped around the item or the heat sealed bag.
- (E)– **Supplemental container and closure.** Place one thermostat–high temperature cutoff–burner, heat sealed in barrier bag as specified in steps 1 and 2, into a supplemental container (step 3). Closure (step 4) shall be accomplished with tape conforming to ASTM D5486, type V, size 1 WD. X 3 LG. (2 pcs.), applied centered over each tucked closure of container onto the adjacent box panels.
- (F)– **Unit pack container (bag) leakage.** The unit pack container (bag–step 2) shall no signs of leakage, as evidenced by a continuous stream of bubbles which appear at any surface when tested in accordance with the PQAP of this SPI.
- (G) – **Heat seal seam.** The heat seal seam of the unit pack container (bag–step 2) shall no sign of separation when tested in accordance with PQAP of this 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 sample shall consist of three thermostat–high temperature cutoff–burner assemblies (drawing 5–45–5183); however the thermostat–high temperature cutoff–burner assembly shall be packaged as specified herein. **Note: when the packaging sample and item are produced at the same time, the packaging sample shall be take from the item first article sample, except that the sample shall be packaged as specified herein.** In addition, 3 empty unit pack barrier bags 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. Lotting. A lot shall consist of the items and packaging produced by one manufacturer, at one plant, from the same materials, under essentially the same manufacturing conditions, and at essentially the same time. **However; when the packaging sample is produced at the same time as the item sample, lotting shall be as specified for the item, except that the items 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.

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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.

CE – Commercial inspection equipment

VI – Visual inspection

PART III – INSPECTION REQUIREMENTS

CLASSIFICATION OF CHARACTERISTICS

PACKAGING CHARACTERISTICS

CATEGORY	CHARACTERISTICS	SAMPLING and ACCEPTANCE CRITERIA	INSPECTION METHOD
Critical	None Defined.		
Minor			
101	Item completely clean and dry prior to unit packing.	VL III	VI
102	Unit pack (bag) evident and correct.	VL III	VI and CE
103	Unit pack (bag) closure evident and correct.	VL III	VI and CE
104	Unit pack (bag) marking evident, correct and legible.	VL III	VI and CE
105	Supplemental container evident and correct.	VL III	VI and CE
106	Supplemental container closure evident and correct.	VL III	VI and CE
107	Supplemental container marking evident, correct and legible.	VL III	VI and CE

NOTES:

VI = Visual inspection

CE = Commercial inspection equipment

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SPI NUMBER (PN)
P5-45-5183**SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA**

301 Unit pack container (bag) leakage. Three unit pack container (bags) and their contents, 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 (bag) seam (destructive test). Three unit pack container (bag) shall be selected at random from those being used for each lot of thermostat–high temperature cutoff–burner assemblies 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.

PART V – TEST METHODS AND PROCEDURES

501 Unit pack container (bag) leakage. The unit pack containers (bags) and their contents 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 unit pack containers (bags), shall be tested in accordance with MIL-STD-2073-1, Appendix G (heat–seal seam test).

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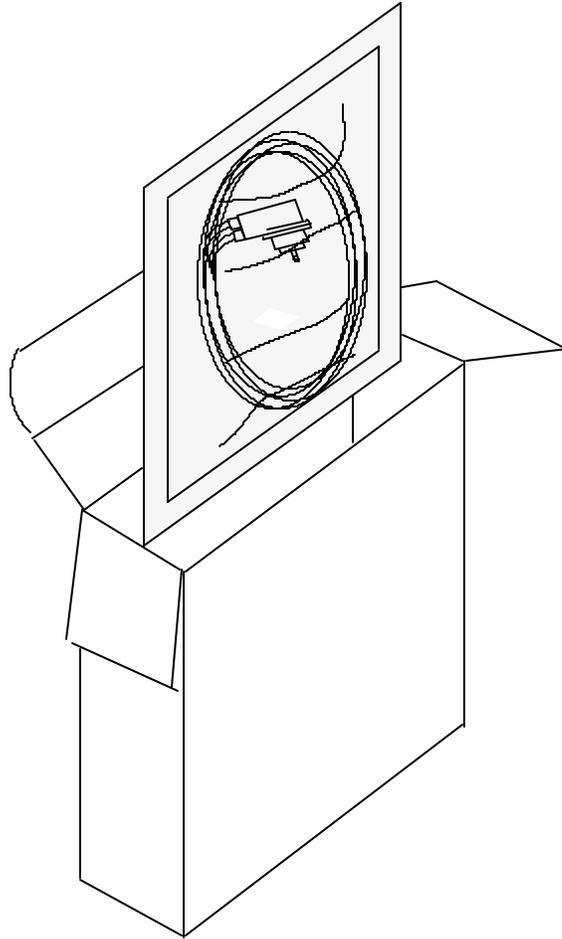
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SKETCH NUMBER 1
ASSEMBLY DETAIL



SCALE: NONE, DRAWING FOR REFERENCE ONLY

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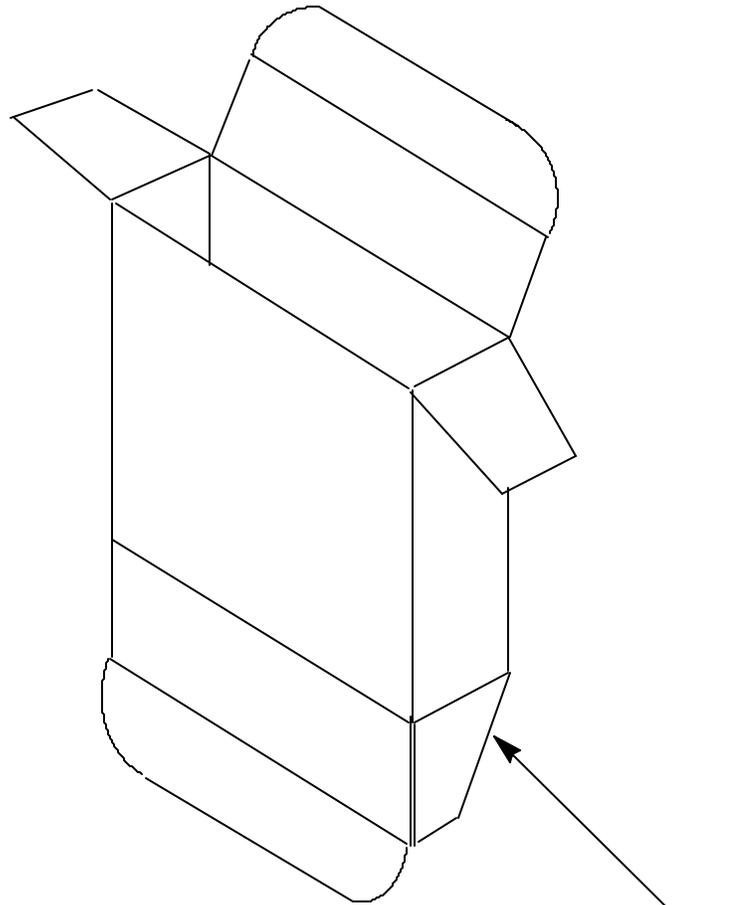
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SKETCH NUMBER 2
CONTAINER ASSEMBLY
REVERSE TUCK BOX / PPP-B-566



REVERSE TUCK BOX
PPP-B-566

SCALE: NONE DRAWING FOR REFERENCE ONLY