

SPECIAL PACKAGING INSTRUCTION		NATIONAL STOCK NUMBER 5965-01-414-2257
NOMENCLATURE DETACHABLE MICROPHONE	PAGE NUMBER 2 of 4	SPI NUMBER (PN) P5-1-3339
<p>(C) – Closure (step 3) shall be accomplished in accordance with the barrier bag or barrier material supplier's recommendations for dwell, pressure and temperature requirements. The volume of trapped air within the bag (step 2) shall be kept to a minimum by compressing the bag around the contents, or carefully drawing a vacuum inside the bag, prior to final heat sealing. Caution shall be taken to prevent damage to the item or rupture of bag.</p> <p>(D) – Unit pack container (bag) leakage. The unit pack assembly(steps 1–3) 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 this PQAP.</p> <p>(E) – Heat seal seam. The heat seal seam of the unit pack bag (step 3) shall show no sign of heat seam separation when tested in accordance with Part V, 501 of this PQAP.</p> <p>(F) – Packaging Quality Assurance Provisions (PQAP).</p> <p style="text-align: center;">Part I – Applicable Documents</p> <p><u>Military standards</u> MIL-STD-2073-1 – Standard Practice For Military Packaging MIL-STD-1916 – Department Of Defense Test Method Standard</p> <p style="text-align: center;">Part II – Quality Provisions.</p> <p>1. First Article Inspection. The first article packaging sample shall be taken from the sample of microphones (5-1-3339) specified in QAP5-1-3339; however these samples shall be packaged in accordance with the military preservation requirements as specified herein. The sample packaged microphones shall be examined for characteristics 101 through 106 of the classification of characteristics in Part III of this PQAP, except for characteristic 101, each unit pack assembly (steps 1–3) in the sample shall be subjected to the nondestructive test in accordance with Part V, 501. In addition, 3 empty unit pack container (bags) shall be removed from the lot of bags and subjected to the destructive test in accordance with Part V, 502. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this PQAP and shall be inspected for compliance with any or all of the requirements of this SPI.</p> <p style="padding-left: 40px;">a. Acceptance Criteria. If any first article sample fails to comply with any of the 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.</p> <p>2. Conformance Inspection.</p> <p style="padding-left: 40px;">a. Lotting. Lotting shall be as specified in QAP5-1-3339, except that the masks shall be packaged as specified herein.</p>		

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b. Sampling. Sampling shall be conducted in accordance with the attributes sampling plan of MIL-STD-1916, using the verification levels (VLs) specified herein. The unit packed microphones shall be subjected to the nondestructive test in accordance with Part V, 501. In addition, 3 empty unit pack container (bags), packaging steps 1 and 2, shall be removed from the lot of bags and subjected to the destructive test in accordance with Part V, 502. The sample of empty unit pack containers (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.

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.		
Major	None Defined.		
Minor			
101	Item completely clean and dry prior to unit packing.	VL-III	VI
102	Unit pack container (bag) evident and correct	VL-III	VI and CE
103	Unit pack container (bag) assembly and closure evident and correct	VL-III	VI and CE
104	Unit pack container marking evident, correct, and legible	VL-III	VI and CE
105	Unit pack container leakage	Part III, 301	Part V, 501
106	Unit pack container seam (of empty container)	Part III, 301	Part V, 501

NOTES:
 VI = Visual inspection
 CE = Commercial inspection equipment

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SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

301 Unit pack container (bag) leakage. Three unit packed container (bags) and their contents shall be selected after the start of each daily production and 3 unit pack containers and their contents shall be selected at the end of each daily production, from each heat sealing machine(s) used, and tested in accordance with Part V, 501. Failure of any sample to meet the leakage requirement shall be cause for rejection of the lot from which the sample was drawn.

302 Empty unit pack container (bag) seam (destructive test). Three empty unit pack container (bags) shall be selected at random from those being used for each lot of bags and tested in accordance with Part V, 502. 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 assembly leakage. The microphone container 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 container (bag), shall be tested in accordance with MIL-STD-2073-1, Appendix G (heat-seal seam test).