

**NOT APPLICABLE TO INTERPLANT SHIPMENTS (A)**

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
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| <b>SPECIAL PACKAGING INSTRUCTION(SPI) (A)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |       |                                   |                     |                                                               |                                                                                                                                | NATIONAL STOCK NUMBER<br>5330-01-441-5499 |                              |
| NOMENCLATURE<br><b>GASKET-SIDE PORT</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |       |                                   |                     |                                                               | UI<br><b>PG</b>                                                                                                                | QUP<br>1                                  | SPI NUMBER (PN)<br>P5-1-2918 |
| Cleaning & Drying shall be in accordance with MIL-STD-2073-1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
| MILITARY PRESERVATION REQUIREMENT<br><small>(MIL-STD-2073-1, Method 10)</small>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | STEPS | DRAWING OR SPECIFICATION          | STYLE/<br>* VARIETY | TYPE                                                          | GRADE                                                                                                                          | CLASS                                     | SIZE AND REMARKS<br>(INCHES) |
| Stiffener                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | (C) 1 | ASTM D 4727                       | SW*                 | CF                                                            | 125                                                                                                                            | DO                                        | 2 x 2 (10 pcs)               |
| Tape (step 1)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | (C) 2 | ASTM D 5486                       |                     | V                                                             |                                                                                                                                |                                           | See Sketch No. 1 on page 2   |
| Container (bag)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | (C) 3 | MIL-DTL-117                       | 2                   | III                                                           |                                                                                                                                | B                                         | 6 x 6                        |
| Closure (step 3)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | (D) 4 |                                   |                     |                                                               |                                                                                                                                |                                           | Heat Seal                    |
| INTERMEDIATE PACKAGING AND PACKING<br><input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1<br><input type="checkbox"/> As specified hereon.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |       |                                   |                     |                                                               | MARKING<br><input checked="" type="checkbox"/> In accordance with MIL-STD-129<br><input type="checkbox"/> As specified hereon. |                                           |                              |
| QUALITY PERFORMANCE and TESTING REQUIREMENTS<br><input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1 <b>(Intermediate packaging and packing only)</b><br><input checked="" type="checkbox"/> As specified hereon. <b>SEE NOTE (E) ON PAGE 2</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
| Specifications, standards, and drawings listed hereon of the issue in effect on date of invitation for bid form a part of this Instruction. Applicable general and referenced requirements of specification MIL-STD-2073-1 form part of this Instruction. Unless otherwise specified, materials will be minimum size IAW MIL-STD-2073-1. Tolerances shall be in accordance with material specifications.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
| <b>UNIT PACK LOGISTICS DATA</b> (Approximate unit pack weight and size)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
| WEIGHT (POUNDS)<br>.03 lbs.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |       | CUBE (CUBIC FEET)<br>.006 cu. ft. |                     | SIZE (EXTERIOR FEET)<br>.49 x .31 x .04                       |                                                                                                                                |                                           |                              |
| REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
| <p><b>(A) - This SPI is not applicable for Interplant shipments.</b> 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>(B) - Unit of Issue is package (PG), consisting of five (5) port gaskets (5-1-2918).</b></p> <p><b>(C) - Place each gasket between two stiffeners (step 1) and secure as shown on Sketch No. 1. Insert five stiffener assemblies into bag (step 3) and close (step 4). Bag to be fabricated of A-A-3174 material as specified in MIL-DTL-117. Bag material shall conform to A-A-3174 as specified in MIL-DTL-117. Closure shall be accomplished by heat sealing or taping in accordance with note (D) below. Optionally, a commercially equivalent bag, minimum thickness of 4 mils, with an interlocking (zip lock) closure is also acceptable. Close interlocking seal bags by applying pressure</b></p> |       |                                   |                     |                                                               |                                                                                                                                |                                           |                              |
| Original Preparer: D. Hansen                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |       |                                   |                     | Revised by: JD Stallings/Contr DAA05-01-P1303 Date: 9 June 04 |                                                                                                                                |                                           |                              |
| <b>ITEM DATA</b> (APPROX)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |       | SBCCOM 81361                      |                     |                                                               |                                                                                                                                | <b>DRAFT</b>                              |                              |
| ITEM CODE - 123                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |       | AMSRD-ECB-ENA-P                   |                     | JDS                                                           | 123-0034-009                                                                                                                   | B                                         | 20 JUN 02                    |
| ITEM SIZE - 1 7/16 DIA x 1/16 inches                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |       |                                   |                     | JGS                                                           | 123-0001-014                                                                                                                   | 123-005/A                                 | 5 MAR 97                     |
| ITEM WEIGHT - .01 lbs.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       | PAGE NUMBER                       | NUMBER OF PAGES     | NMK                                                           |                                                                                                                                | 123-001                                   | 5 NOV 96                     |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |       | 1                                 | 3                   | APPROVAL                                                      |                                                                                                                                | REVISION                                  | DATE                         |

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with the fingers across the interlocking seal area until completely closed. Remove as much air as practical prior to final closure.

**(D)** - Closure (step 4) shall be accomplished by heat sealing 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.**

**(E) – 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

MIL-STD-3010 – Test Procedures for Packaging Materials

**PART II – QUALITY PROVISIONS.**

**1. First Article Inspection.** The first article packaging sample shall be pulled from the first article sample of gaskets (drawing 5-1-2918) specified in QAP5-1-2918. The sample gaskets shall be packaged and subjected to all of the examinations specified in this PQAP and shall be inspected for compliance with 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. 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 QAP5-1-2918, except that the gaskets shall be packaged in accordance with the military preservation requirements 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) 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.**

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P5-1-2918**CLASSIFICATION OF CHARACTERISTICS**

| <u>Category</u> | <u>Characteristic</u>                                          | <u>Sampling and acceptance criteria</u> | <u>Inspection method</u> |
|-----------------|----------------------------------------------------------------|-----------------------------------------|--------------------------|
| <u>Major:</u>   | None defined                                                   |                                         |                          |
| <u>Minor:</u>   |                                                                |                                         |                          |
| 101             | Item completely clean and dry prior to unit packaging          | VL-III                                  | VI                       |
| 102             | Stiffener (step 1) and closure [note (C)] evident and correct  | VL-III                                  | VI and CE                |
| 103             | Unit pack container (bag), step 3, evident and correct         | VL-III                                  | VI and CE                |
| 104             | Unit pack container (bag) closure (step 4) evident and correct | VL-III                                  | VI and CE                |
| 105             | Unit pack assembly marking evident, correct, and legible       | VL-III                                  | VI and CE                |

**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. |