

# Corrugated Fiberboard, Triple Wall Box Specification 18 x 18 x 12 Inches

Press **QC Check List** to see Check List only.

Description	Stores Catalog Number	Packaging Filling Instructions	Plant
Box, Shipping, Regular Slotted Carton (RSC), Corrugated Fiberboard, Triple Wall, UN 4G /Y 125/S, Size: 18 x 18 x 12 inches	02-114-5800	LMTPM-CHK-42	Y-12

Mfg. Details Per: ORNL Packaging Specifications  
No. 630-4GO-0003  
Issue Date: December 10, 1993  
Revised Date: November 15, 1999



- [1.0 GENERAL DESCRIPTION](#)
- [2.0 MATERIAL DETAILS](#)
- [3.0 CONTAINER PERFORMANCE CRITERIA](#)
- [4.0 QUALITY ASSURANCE](#)
- [5.0 MARKING](#)
- [6.0 INTENDED USE](#)
- [7.0 SUGGESTED MANUFACTURERS](#)
- [8.0 AUTHORIZED CHANGES](#)
- [9.0 DISTRIBUTION OF UN PERFORMANCE TEST REPORTS \(per ¶ 3.1\)](#)

# Oak Ridge National Laboratory (ORNL)

## Packaging Specifications

### Triple-wall Corrugated Boxes

Specification No. 630-4GO-0003

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Page 1 of 6

## 1.0 GENERAL DESCRIPTION

Box, Shipping, Regular Slotted Carton (RSC), Fiberboard, Triple-Wall 69/26/26/26/26/69 lbs /MSF (thousand square feet) Basis Weight construction, A/A/A flute, 900 pound test board, as UN single packagings, for dry solid product/material.

*[This specified construction, as stated in this specification, **has been** previously tested/approved for use in DOT 7A, Type A packaging.]*

### 1.1 United Nations Designation – UN 4G /Y \*\*/ S \* [per 49 CFR, &178.503]

- 4G** = Fiberboard box.
- Y** = Suitable for Packing Group II and III materials.
- \*\*** = Maximum allowable gross weight in kilograms for which the Box was tested.
- S** = Designation indicates packaging is for solid materials [*or combination packaging*].
- \*** = The last 2 digits of the calendar year in which the container was manufactured.

Specific UN Markings are specified in the Catalog Description for the referenced catalog number for each specific box, which are ORNL "minimum" UN requirements.

### 1.2 Size:

Inside Dimensions: Length x Width x Height  
[as specified in the Catalog Description for the referenced catalog number]

## 2.0 MATERIAL DETAILS

Box construction must comply with Title 49, Code of Federal Regulations (49 CFR), &178.516 (latest edition) for Fiberboard boxes, and the following minimum requirements. Manufacturer shall document appropriate quality control on incoming raw material. No significant changes to the manufacturing process or raw material is allowed without prior approval of the Company.

### 2.1 Triple-Wall Box:

Corrugated construction, RSC style, 900 pound test board.

### 2.2 Linerboard:

4-facings, 69/42/42/69 lbs./MSF Basis weight ( 222 lbs minimum ).

### 2.3 Corrugating Medium:

3-interleaved, 26/26/26 lbs./MSF Basis weight, A/A/C Flute.

### 2.4 Manufacturer's Joint:

Metal stitched overlap tab; no protruding edges/ends inside.

# TRIPLE-WALL CORRUGATED BOXES

Specification No. 630-4GO-0003

Issued: December 10, 1993

Revised: November 15, 1999

Page 2 of 6

## 2.5 Water Resistance:

The outer surface must have a water absorption rate not greater than 155 g/m<sup>2</sup> when tested over a 30 minute period by the Cobb method per UN requirements [49 CFR, &178.516(b)(1)]. Upon request, the manufacturer must be capable of providing documentation as to the exterior liner board meeting these requirements.

## 2.6 Closure:

**Manufacturer/supplier** must furnish ORNL, in writing, closure requirements, as performed for the UN design test; per 49 CFR, &178.2(c)(1). It must be identified on the closure instructions specifically as to the ORNL box to which the instructions apply. Ref: &9.0 for distribution.

*[NOTE: Packages prepared for shipment must be sealed by the same method to be in compliance with the UN markings/certification.]*

## 2.7 Interior finish:

None; natural fiber interior.

## 2.8 Exterior finish:

Natural kraft exterior linerboard, with Michelman X-300 water resistant treatment, **or** a comparable coating/treatment to give an exterior surface water resistance to the board *[such that the box continues to meet the DOT 7A Type A "water spray test" {49CFR, &173.465(b)}]*.

## 2.9 Printing (See &5.0, Marking):

Box size; CATN—(dash) plus last four (4) digits of catalog number on bottom panel.

Specific box closure instructions on inside top flap [use of hot melt, glue, tape – size/type, etc].

The required markings for the UN certification as specified in the catalog description/purchase order, and set forth in &1.1 of this specification.

## 2.10 Cleanliness:

Finished boxes shall be free of ragged edges, loose and/or protruding stitching, dirt, oil stains, or printing smears, and box must be dry.

## 2.11 Freight Classification:

In addition to the requirements contained in 49 CFR, triple-wall boxes must conform to the applicable requirements of Rule 41, of the Uniform Freight Classification (UFC), and Rule 222 of the National Motor Freight Classification (NMFC) and marked with the Manufacturer's "Puncture Test" (Mullen) Certificate (BMC).

## 3.0 CONTAINER PERFORMANCE CRITERIA

The manufacturer shall successfully test and certify that containers meet or exceed the requirements of 49 CFR, &178.600 - 178.608, for Packing Group II. The container herewith specified is to be qualified as **single packagings**, as authorized under 49 CFR, &178.212(c).

## 3.1 Performance Test Documentation:

Upon request, the manufacturer must be capable of providing copies of the performance test documentation for purchased packagings, as required by 49 CFR, &178.601(1) for the UN certification marked packaging. Periodic audit copies will be requested randomly on purchased UN packagings. Ref: &9.0.

# TRIPLE-WALL CORRUGATED BOXES

Specification No. 630-4GO-0003

Issued: December 10, 1993

Revised: November 15, 1999

Page 3 of 6

## 3.2 Performance Tests:

The specified boxes require the **US Department of Transportation** UN performance criteria for design qualification testing, periodic retesting, and production tests established in 49 CFR, &178.600 – 608.

*NOTE TO SELLER: The UN test/marketing Certifications must be made by the box manufacturer or a Department of Transportation approved third party tester.*

## 4.0 QUALITY ASSURANCE

The Seller shall assure, and be responsible, that the quality of boxes furnished under this document are of good quality, as pursuant to industry standard manufacturing practices for corrugated boxes, including the materials and/or components used in the manufacturing of the stated boxes.

The Seller shall meet the requirements stipulated in this document, and the specific requirements of the Catalog Description for the specific box as specified in the Purchase Order.

### 4.1 Manufacturer's Certification:

By the act of placing the UN performance criteria markings on each box purchased, the manufacturer acknowledges, has certified, and accepted responsibility, that the stated box design meets or exceeds the U.S. Department of Transportation's UN performance requirements as stipulated in &3.2 of this document, and in accordance with the markings prescribed in 49 CFR, &178.503.

In addition, this certification marking acknowledges that the box manufacturer has complied with the specific standards for fiberboard boxes specifically listed in 49 CFR, &178.516, including the Cobb Water Absorption Test specifically referenced under 49 CFR, &178.516(b)(1).

### 4.2 Receiver Inspection:

The following inspections will be performed on incoming boxes by receiver to determine the boxes meet quality standards and the requirements of this document. However, the receiver is not limited to the following inspections to determine quality and specification conformance. Conformance will be indicated by a Y or N in the "Y/N" column, and negative responses documented on the Nonconformance Report (NCR), *UCN 11457*, (items 3-21b), attached to the checklist, and submitted to ORNL's Packaging Operations (PkgOps) for necessary action.

*NOTE: Checklist for this specification on following page.*

## TRIPLE-WALL CORRUGATED BOXES

Specification No. 630-4GO-0003

Issued: December 10, 1993

Revised: November 15, 1999

Page 4 of 6

*This checklist is to be reproduced for QC Inspections.*

### Receiver Inspection Quality Control (QC) Checklist for Incoming Corrugated Boxes

	QC Conformance >>	Y/N	<< "No's" to be documented on form UCN-11457 with checklist
1	Dimensions		Stated inside dimensions (from score) are correct for specified box size.
2	Fiberboard Surface		Clean, no significant scuffing, breaks/cuts in board, corrugation does not protrude past linerboard surface.
3	Scoring/score lines		Uniform, and sufficient depth to allow clean fold, without distortion.
			No surface breaks in the score lines, when flaps folded.
4	Corrugating Medium		Medium not crushed within the assembled box.
5	Box Flaps		When folded along score lines, inside flaps meet along the two inner flaps, and the box and outer flaps fold-up 'square.'
6	Manufacturer's joint		Metal staples closed, without breaking linerboard, and points/edges not protruding to snag/puncture inner packagings.
7	Box Alignment		Assembled box and top are square at corners/edges.
8	Markings		Boxes marked (as a minimum) with ORNL specified UN markings, per Catalog Description.
			Boxes legibly marked (printed) per required UN markings, and with boxmaker's certificate for the specified box strength, and Rule 41/222 markings.
			Markings include the manufacturer's identification -- company name or registered symbol (initials or M-number), or test agency code; after USA/. Ref: 49 CFR, &178.503(a)(8).
9	Printing		Printing on the box is of the specified size, is sharp, contains no smears, and is located according to specifications.
			Closure instructions per &2.6.
			Length x Width x Height; CATN—plus the last four (4) digits of catalog number on bottom per &2.9.
			Closing instructions printed on <b>top flap</b> of box per &2.9.

Catalog Number \_\_\_\_\_

P.O. Number \_\_\_\_\_

Total Units Received \_\_\_\_\_

Inspection Method: Per ORNL PkgOps Inspection Plan

Sample Size \_\_\_\_\_ [Based on ANSI/ASQC Z1.4-1993]

NCR No. \_\_\_\_\_

Inspector/Date \_\_\_\_\_

Additional comments provided on back: \_\_\_ check if yes.

The above QC check list shall be accomplished for each order based on random samples of incoming boxes, by QC personnel to determine manufacturer's conformance to these specified Packaging Specifications.

Shipments of corrugated boxes not meeting specified requirements will be returned to the seller for credit.

QC inspections resulting in non-compliance with the Packaging Specification will be cause for rejection of the entire shipment.

# TRIPLE-WALL CORRUGATED BOXES

Specification No. 630-4GO-0003

Issued: December 10, 1993

Revised: November 15, 1999

Page 5 of 6

## 5.0 MARKING

As a minimum, each Triple-wall box shall be marked in accordance with 49 CFR, &178.2, 178.3 and 178.503 on the exterior surface of the box. Markings shall have a minimum letter height of ½ inch. Markings must include the manufacturer's identification -- company name or registered symbol (initials or M-number), or test agency code, per 49 CFR, &178.503(a)(8).

The UN markings shall be in the upper left-hand corner, on two opposing longest sides.

Length x Width x Height; then CATN—(dash) plus last four(4) digits of catalog number and manufacturer's compliance markings. [ex., 10x10x10; CATN-1234]

Specific box closing instructions on the inside top flap per &2.9 of this specification.

## 6.0 INTENDED USE

Containers (boxes) are intended as **single packagings** for Packing Group II and III hazardous materials in solid form, per 49CFR, &173.212(c). Maximum capacity of the container shall not exceed the tested gross weight, as marked on the box sidewall.

## 7.0 SUGGESTED MANUFACTURERS

The following list of suggested manufacturers have demonstrated ability to comply to the requirements set forth in this document. However this list does not guarantee current or continued availability as a suggested manufacturer source:

- Viking Packing Specialist, Tulsa, Oklahoma

The Seller must advise the Company prior to any change in the current source (manufacturer) of packaging materials described in this Packaging Specification.

Any Manufacturer that satisfactorily demonstrates to the Company the capability to furnish packaging in compliance with this Packaging Specification, may be added to the above listing.

## 8.0 AUTHORIZED CHANGES

Changes/revisions in the requirements specified in this document will only be authorized by ORNL PkgOps as coordinated with Oak Ridge facilities packaging operations.

## TRIPLE-WALL CORRUGATED BOXES

Specification No. 630-4GO-0003

Issued: December 10, 1993

Revised: November 15, 1999

Page 6 of 6

### 9.0 DISTRIBUTION OF UN PERFORMANCE TEST REPORTS (per &3.1) and CLOSURE INSTRUCTIONS (per &2.6)

A) Closure instructions must be furnished for each initial order, and annually (at the minimum) for each type/size package purchased by ORNL, directly to the Packaging Operations Manager at the address below.

B) Upon specific request, UN performance test documentation for each specified order/shipment will be submitted directly to the Packaging Operations Manager at the address below.

**Oak Ridge National Laboratory  
Packaging Operations Manager  
Bldg. 7001, MS 6288  
P.O. Box 2008, 1 Bethel Valley Road  
Oak Ridge, Tennessee 37831-6288**