

Corrugated Fiberboard, Triple Wall Box Specification

8-1/8 x 8-1/8 x 8-1/8 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, Triplewall, with 2 support dividers, UN 4G /Y 30/ S , Size: 8-1/8 x 8-1/8 x 8-1/8 inches	02-114-9900	LMTPM-CHK-42 (for Hazmat use) or ORNL-PKG-06 (for RAMSPAC use)	ORNL

Mfg. Details per: ORNL Packaging Specifications
No. 631-4GO-0002
Issue Date: December 10, 1997
Revised Date: November 15, 1999

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Oak Ridge National Laboratory (ORNL)

Packaging Specifications

Triple-wall Corrugated Box

Specification No. 631-4GO-0002

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1.0 GENERAL DESCRIPTION

Box, Shipping, Regular Slotted Carton (RSC), Fiberboard, Triple-Wall 42/26/42/26/42/26/42 lbs /MSF (thousand square feet) Basis Weight construction, A/A/A flute, 700 pound test board, as UN single packagings, for dry solid product/material.

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

1.1 United Nations Designation – UN 4G /Y 30/ S * [per 49 CFR, ¶178.503]

- 4G** = Fiberboard box.
- Y** = Suitable for Packing Group II & III materials.
- 30** = Maximum allowable gross weight in kilograms for which the Box was tested (66 lbs.)
- 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 the ORNL “minimum” UN requirements.

1.2 Size:

Inside Dimensions: 8-1/8 x 8-1/8 x 8-1/8 Inches

[as specified in the Catalog Description for the referenced catalog number]

1.3 Tare Weight:

1.75 pounds (*box and dividers*)

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, 700 pound test board.

2.2 Linerboard:

4-facings, 42/42/42/42 lbs./ MSF Basis weight (168 lbs minimum).

2.3 Corrugating Medium:

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

2.4 Manufacturer's Joint:

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

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2.5 Box Flaps:

It must be taken into account that due to the small size of this box, in conjunction with its triplewall construction, the scoring/cutting for the full flaps of the box must be such that flaps **will** meet appropriately at the center of the box at set-up, and without the use of "extreme force".

2.6 Support Dividers (for Type A use):

350 lb. Doublewall corrugated board, A/C Flute
2 each, 19 x 8-1/8 inches, slotted and scored
Scored at 7¼ - 4½ - 7¼ inches
Slotted for 4¼ inch compartment (@ 2-1/8 on center)
Reference: Attached [sketch supplement](#).

2.7 Water Resistance:

The outer surface must have a water absorption rate not greater than 155 g/m² 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.

2.8 Closure:

Manufacturer/supplier must furnish ORNL, in writing, closure requirements, as performed for the UN design test; per 49CFR, &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.]

2.9 Interior finish:

None; natural fiber interior.

2.10 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)}*].

2.11 Printing (See &5.0, Marking):

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

The required markings for the UN certification as specified in the Catalog Description/Purchase Order, and set forth in &1.1 of this specification.

2.12 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.

2.13 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).

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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).

[This box construction, as part of a combination packaging, has already been qualified as a DOT 7A, Type A package]

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.

3.2 Performance Tests:

This triplewall box requires the **US Department of Transportation** UN performance criteria for design qualification testing, periodic retesting, and production tests as 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 he 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 Inspections:

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.

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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 flush 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	Support Dividers	Two each doublewall furnished per box with order.
		Corrugated board is scored, and cut for assembly.
9	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).
10	Printing	Printing on the box is of the specified size, is sharp, contains no smears, and is located according to specifications.
		Length x Width x Height; CATN—plus last four (4) digits of catalog number on bottom per &2.11.
		Closing instructions on top flap of box, per &2.11.

Catalog Number 02-114-9900

P.O. Number _____

Total Units Received _____

Inspection Method: Per ORNL PkgOps QC 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.

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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.

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

Specific box closing instructions on the inside top flap per &2.11.

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.

[NOTE: In addition, this **box construction** has been previously approved for DOT 7A, Type A packaging.]

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.

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9.0 DISTRIBUTION OF UN PERFORMANCE TEST REPORTS (per &3.1) and CLOSURE INSTRUCTIONS (per &2.8)

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**

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SIGNATURE W. C. Wood

DATE 10/19/98 /10/21
REV.

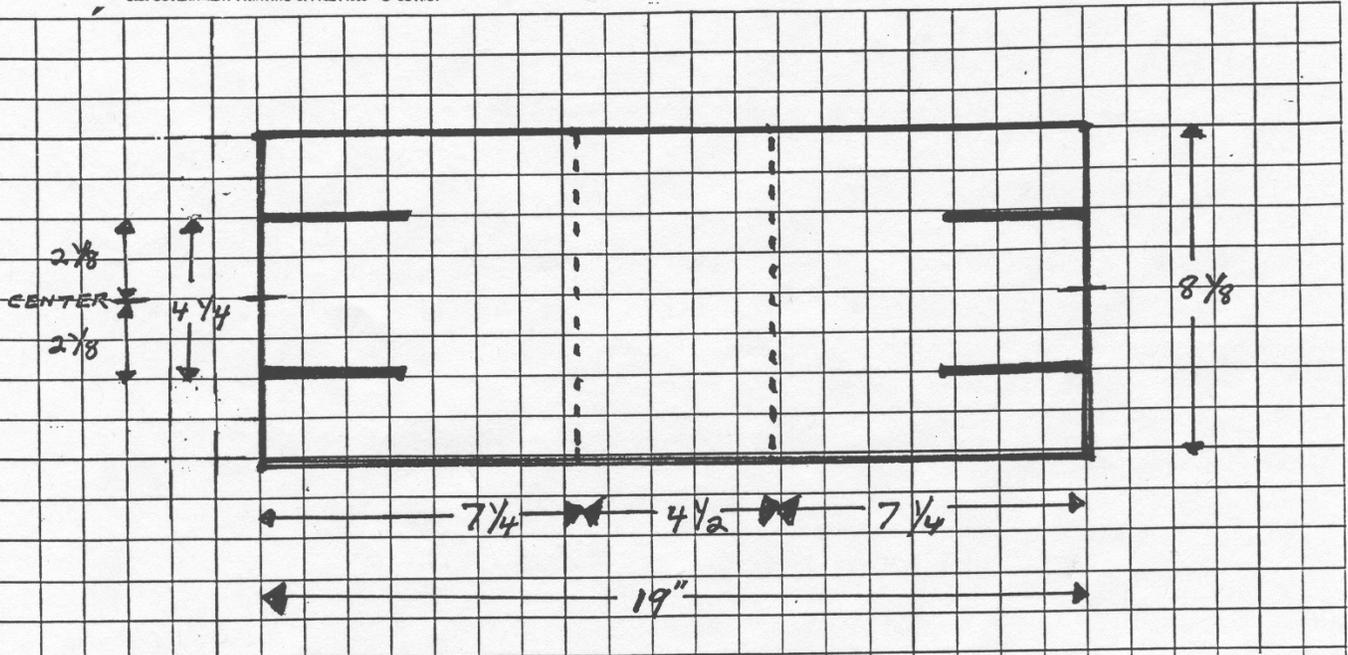
TITLE **TRIPLE-WALL CORRUGATED BOX**

Supplement to: 631-4GO-0002

SUBJECT **Double-wall Corrugated Partition Support Compartment**

SHEET No. 1 of 1

U.S. GOVERNMENT PRINTING OFFICE: 1963-O-681087



- 2.6 Support Dividers: 350 lb. Doublewall corrugated board, A/C Flute
2 each: 19 x 8-1/8 inches, slotted & scored
Scored for: 7-1/4, 4-1/2, 7-1/4 x 8-1/8 inch panels
Slotted on panel ends: for 4-1/4 inch compartment (@ 2-1/8 off centerline)
[Forms a 4-1/4 x 7-1/4 inch inner support compartment for an inner container]

Double-wall corrugated partition dividers (2 ea)
are assembled together to form an inner
4-1/4 in. x 7-1/4 in. inner support compartment
for holding a container inside the compartment.

To yield a 8-1/8 x 8-1/8 x 7-1/2 inch double-wall cube, to securely
fit inside the 8-1/8 x 8-1/8 x 8-1/8 inch triple-wall RSC box.