



WOOD PALLETS:

Detail Number	Length	Width	Weight (Lbs.)		Illustration on Page
			Pallet	Product	
¹ / A	42"	52"	25	1153	6 of 26
² / B	42"	48"	24	1295	7 of 26
BCAN	48"	42"	23	1554	8 of 26
C	60"	42"	27	945	9 of 26
F	72"	42"	35	2251	10 of 26
G	130"	42"	66	2823	11 of 26
H	84"	42"	43	1865	12 of 26
I	96"	42"	49	2087	13 of 26
Q	120"	42"	59	2746	14 of 26

Detail Number	Length	Width	Weight (Lbs.)		Illustration on Page
			Pallet	Product	
R	72"	45"	36	1588	15 of 26
S	84"	45"	45	1667	16 of 28
T	96"	45"	51	2087	17 of 28
U	45"	48"	25	1295	18 of 28
V	110"	45"	57	2324	19 of 28
W	84"	62"	54	983	20 of 28
X	96"	62"	61	1367	21 of 28
Y	110"	62"	68	1381	22 of 28
Z	98"	50"	58	1300	23 of 28

¹/ Division standard - should be used whenever possible. A new pallet number (PSN0004) has been established and the physical pallets may display either 1660B or PSN0004, and either are acceptable for use.


²/ Canadian unique - should be used whenever shipping into Ford of Canada Parts Distribution Centers.

Note: These weight limits are needed for safety purposes to ensure the integrity of material handling equipment and shelving/racking used in FCSD's Parts Distribution Center.

NOTE: SUPPLIER/PACKAGER RESPONSIBILITY

- It is the supplier/packager's responsibility to place a corrugated slip sheet over the top pallet deckboards to ensure stability when palletizing small containers or loose parts that could potentially fall into the spaces between the deckboards.
- The corrugated slip sheet must be sized to completely cover the pallet footprint.

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PALLET 1660 - CONSTRUCTION STANDARDS

Note: All pallets must be heat treated and stamped in accordance with the International Standards For Phytosanitary Measures (ISPM No.15). Refer to page 5 for illustration. Click on link http://www.tis-gdv.de/tis_e/verpack/holz/export/isp15.pdf to view International Standards For Phytosanitary Measures (ISPM No.15).

SPECIFICATIONS

1. General — These are minimum specifications. Pallets of lower specifications are not acceptable.
2. Type — Type No. 5 - Double face, double wing, non-reversible.
3. Design — Four-way
4. Species — Lumber used in the 1660 pallet construction must be from the species listed below and shall be sound, square-edged, free of decay, and free of knots with an average diameter greater than one-third of the width of a piece. Season checks, pin-worm holes, mineral streaks, stain, and wane of bark edge (not greater than one-fourth the thickness and one-sixth the width of any piece) do not effect the structural strength of pallets and are permissible defects. No piece shall contain any other defect or combination thereof which would materially weaken the strength of the piece, or hinder its proper fastening.

GROUP IV

Ash, White	Elm, Rock	Oak, Red
Beech	Hackberry	Oak, White
Birch	Maple, Hard	Pecan
	Hickory	

GROUP III

Ash (except White)	Maple, Soft
Elm, Soft	Sycamore
Gum, Sweet	Tupelo

GROUP II

Douglas, Fir	Larch, Western
Hemlock, Eastern	Pine, Southern Yellow
Hemlock, Western	Tamarack


GROUP I

* Aspen (Popple)	Redwood
Cottonwood	Spruce
Magnolia	Poplar, Yellow

* Excludes lowland swamp Popple - also known as Bomgehliia, which is not acceptable in any manner.

5. Moisture Content — Grade "AA" - Deckboards to have maximum of 25% moisture content. Stringers may be of any degree of seasoning.
6. Deckboards — The edge boards of the pallet shall not be less than a minimum 5-1/2" wide. The balance of the deckboards shall be a minimum 3-1/2" wide. All deckboards shall be not less than a minimum thickness of 1/2" and shall be of uniform thickness. Holes to be staggered. Pre-drilling not necessary when nailing machines are used in assembly. Spacing of deckboards on top-deck to be minimum 2", maximum 3-1/2". Spacing of bottom deckboards as indicated. Mitered corners of top leading deckboards are not required.
7. Runner Notch Opening — Notch opening should be 9" wide plus 1" minus 1/4" and should not be closer than 6" from the ends of the runner, ± 1/4". Runner notches should have a depth of 1-1/2". Center runner should be parallel to and equal in distance between outside stringers.

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PALLET 1660 - CONSTRUCTION STANDARDS

SPECIFICATIONS (continued)

FASTENERS

1. Nails —Use a 2" No. 6 full flat head, diamond point or blunt tip drive screw (helically threaded nail), having the following requirements:

- Length: 2" plus or minus 1/16"
- Wire Diameter: .110" plus or minus .002"
- Threaded Body Outside Diameter: .138" plus or minus .005"
- Head Diameter: Full head 9/32" plus or minus 1/32"
- Point: Diamond - 5/32" long plus or minus 1/16" or blunt
- Thread: Spiral - minimum 4 flutes - helical angle of thread to be such that the projection of the thread across the axis of the nail shall make an angle of 60 degrees plus or minus 5 degrees with the axis of the nail.


As an alternate, use a No. 10 wire gauge x 2" annular ring nail with the following requirements:

- Length: 2" plus or minus 1/16"
- Wire Diameter: .135" plus or minus .002" (hardened .120" plus or minus .002")
- Threaded Body Outside Diameter: .150" plus or minus .005"
- Head Diameter: Full head 9/32" plus or minus 1/32"
- Point: Diamond - 5/32" long plus or minus 1/16"
- Thread: Annular Ring - 20 per inch - running entirely around the nail having a top surface perpendicular or approximately perpendicular to the axis of the nail, and a bottom surface that is a tapered cone tapering toward the point of the nail.

2. The correct number of nails (nails are to be staggered) to be employed at all bearing points for the various widths of deckboards is as follows:

Width of Deckboard	Number of Nails
3-1/2" to 5"	2 (either type)
5-1/8" to 7"	3 (either type)
7-1/8" to 9"	4 (either type)

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PALLET 1660 - CONSTRUCTION STANDARDS

SPECIFICATIONS (continued)

3. Staples — As an alternate, the 2" long, semi-flat, galvanized, Senco coated staple with the following minimum requirements is acceptable:

- Length: 2" long
- Wire Diameter: Width .074" Thickness .067"
- Gauge: 15 gauge galvanized steel wire
- Crown: 7/16"
- Point: Short symmetric wedge points
- Coating: Senco's NWPCA approved plastic-polymer coating applied to inside and outside of staple legs with a minimum coverage of 1" measured from staple point ends.

4. The correct number of staples to be employed at all bearing points for the various widths of deckboards is shown below.

Width of Deckboard	Number of Staples
— to 3-1/2"	2
3-5/8" to 5-1/2"	3
5-5/8" to 7-3/8"	4
7-1/2" to 9"	6


CONSTRUCTION

1. Workmanship — Workmanship shall be equal to accepted modern practices. The construction shall conform minutely to the requirements specified.

2. Defects — The following are considered defects in workmanship as they relate to pallet life and proper functioning:

- "Out of Square" deviation
- Deviation in overall pallet length
- Deviation in overall pallet width
- Deviation in deckboard or runner dimensions
- Deviation in fasteners (nails or staples)

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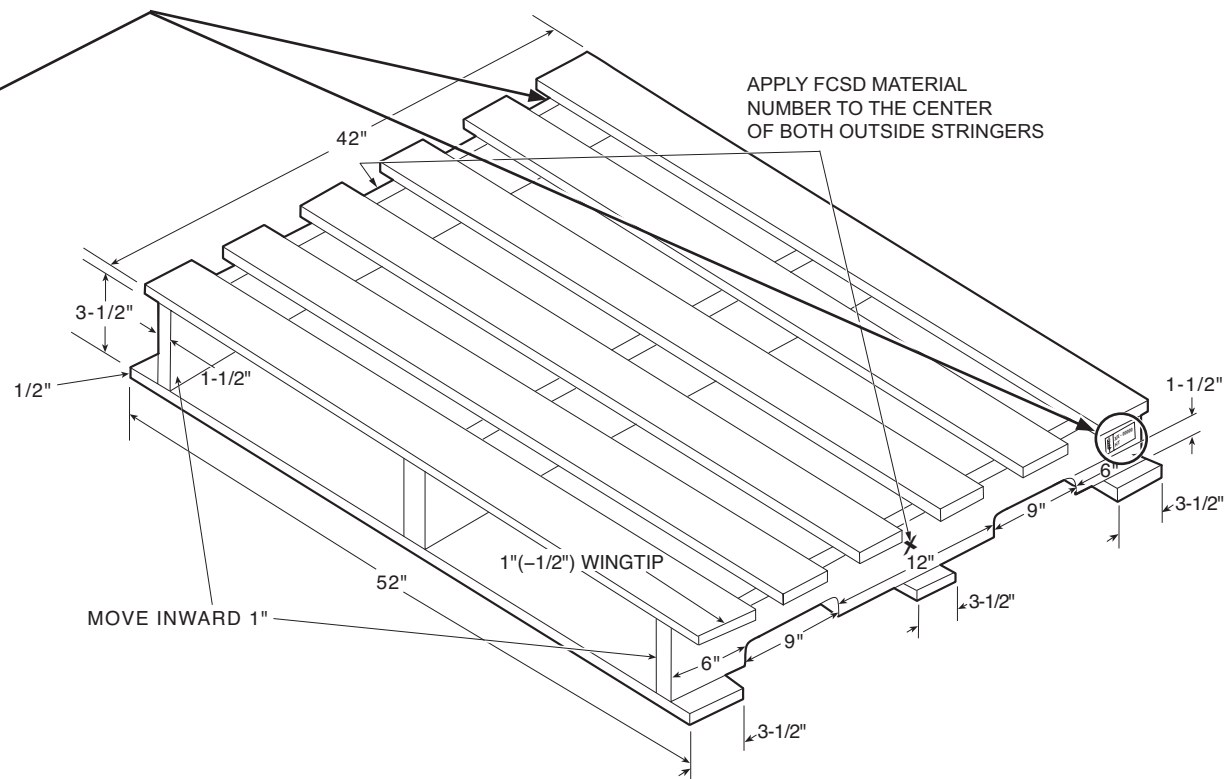
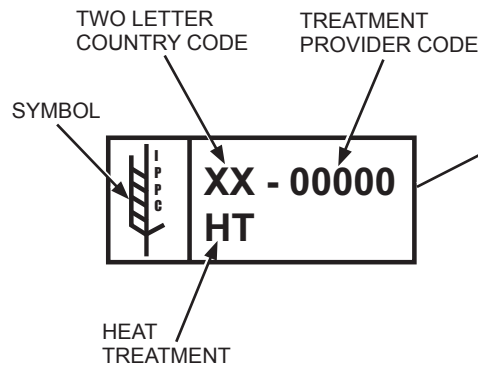


PALLET 1660 - CONSTRUCTION STANDARDS

IDENTIFICATION

FCSD material number must be applied to the center of both of the outside stringers. Paint, stencil, engraving, etc., may be used to provide this identification. Each pallet must display a "Heat Treat" stamp on the outside face of the two (2) outer stringers at the same end of the pallet.

HEAT TREATMENT MARKINGS THAT MUST BE ON ALL PALLETS



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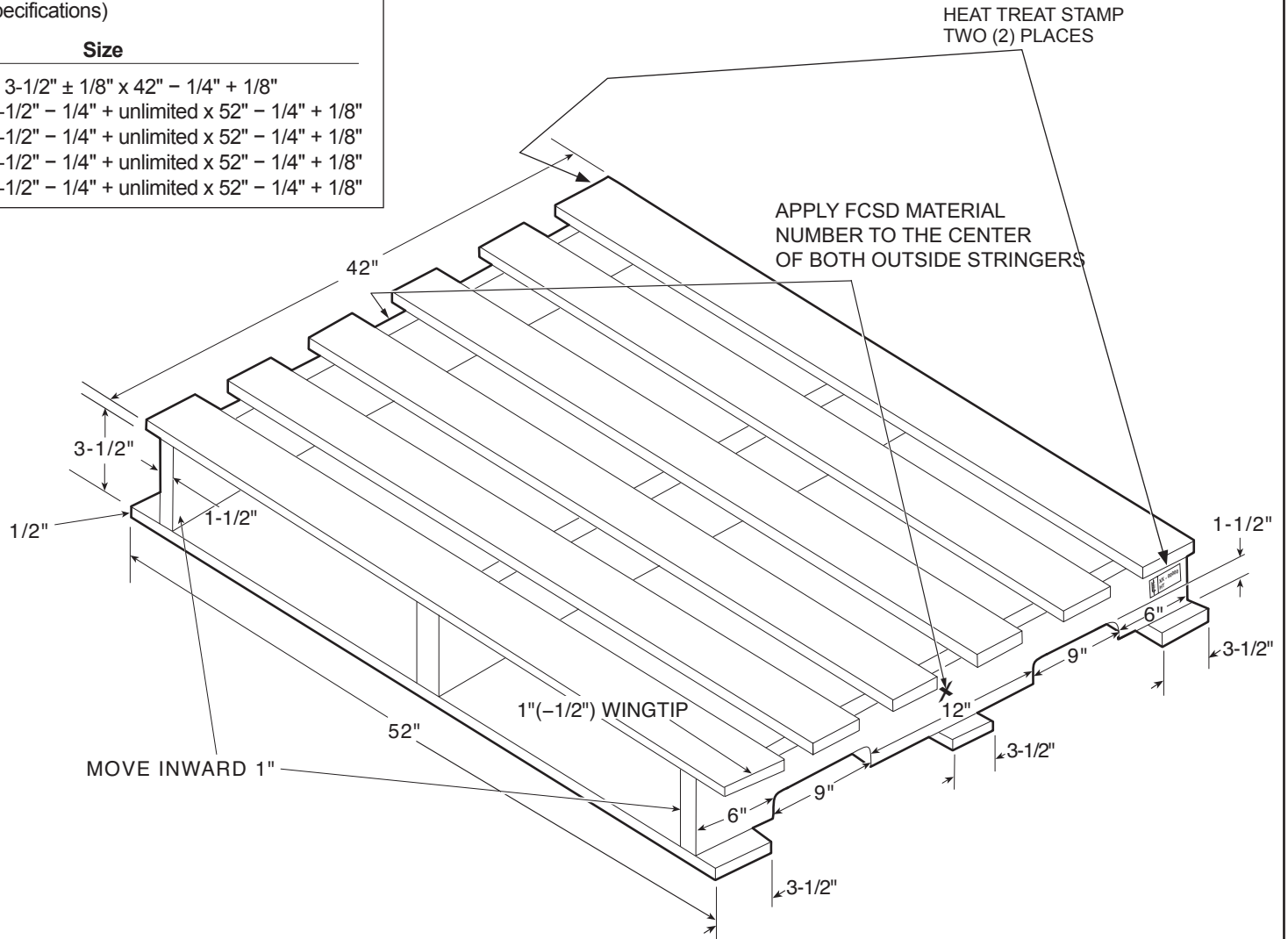
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DETAIL A - TYPICAL CONSTRUCTION STANDARDS

1660A 42" x 52"
BILL OF MATERIAL
(Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 42" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 52" - 1/4" + 1/8"
Top Center	4	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 52" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 52" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 52" - 1/4" + 1/8"



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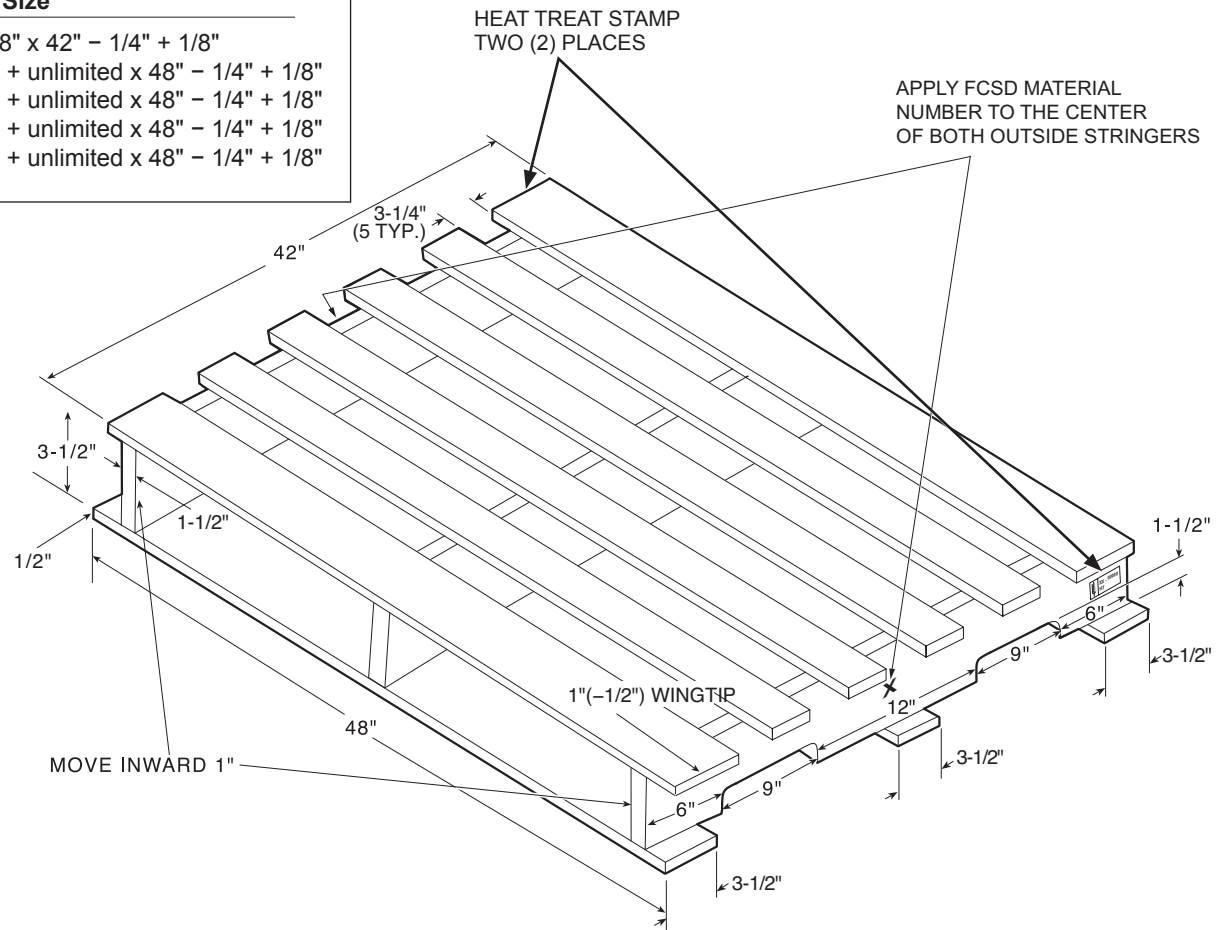
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DETAIL B - TYPICAL CONSTRUCTION STANDARDS

1660B 42" x 48" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 42" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"
Top Center	4	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"



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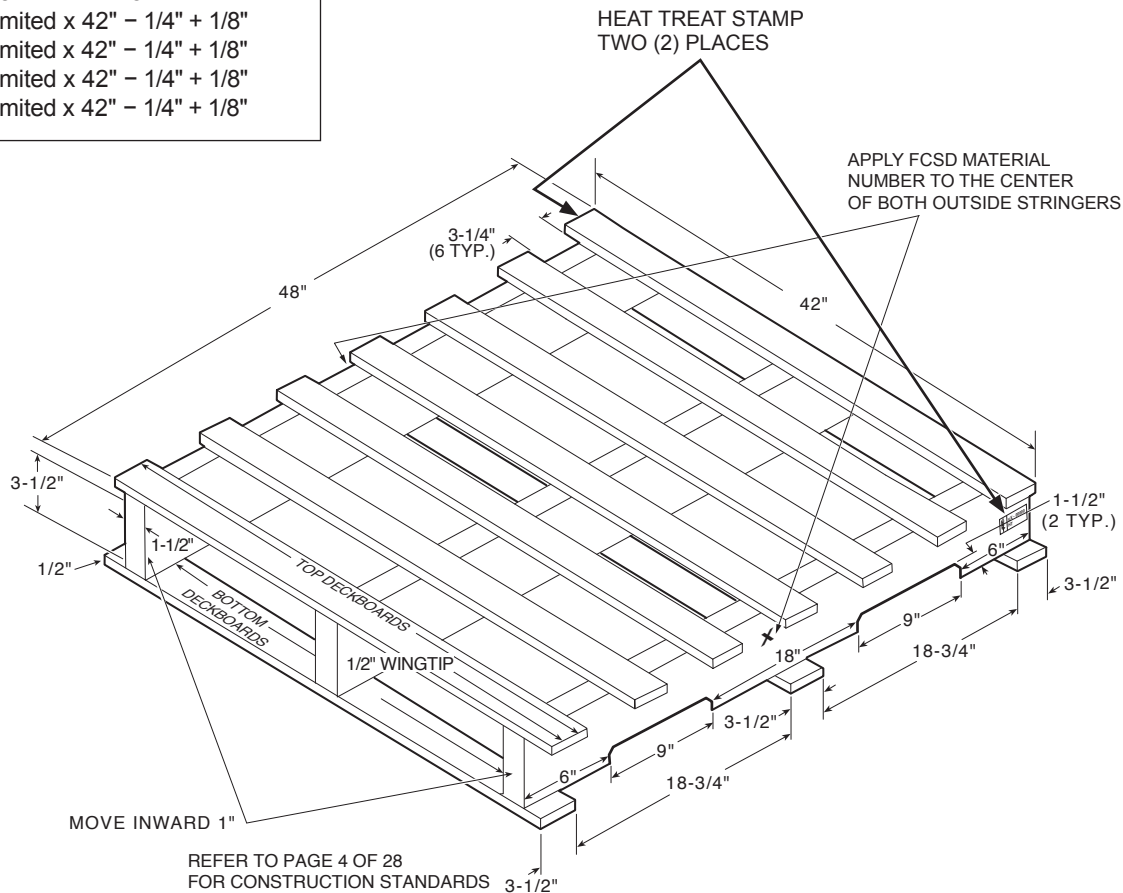


DETAIL BCAN - TYPICAL CONSTRUCTION STANDARDS

1660BCAN 48" x 42"
BILL OF MATERIAL
 (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 48" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	5	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"

NOTE: This 1660BCAN pallet is to be used only for shipments into the Ford Bramalea PDC in Canada due to its unique racking configurations. Because this pallet will only hold a maximum product weight of 1,196 lbs., suppliers/packagegers must adjust the presently specified pallet quantity for parts being shipped to an amount that will not exceed this maximum weight. This note will serve as a blanket deviation to allow Canadian shipments to differ from the present FCSD Packaging Specification on file relative to the pallet and the pallet quantity when needed to meet pallet weight limit. Separate deviations will not be issued by FCSD Packaging Engineering to cover this condition.



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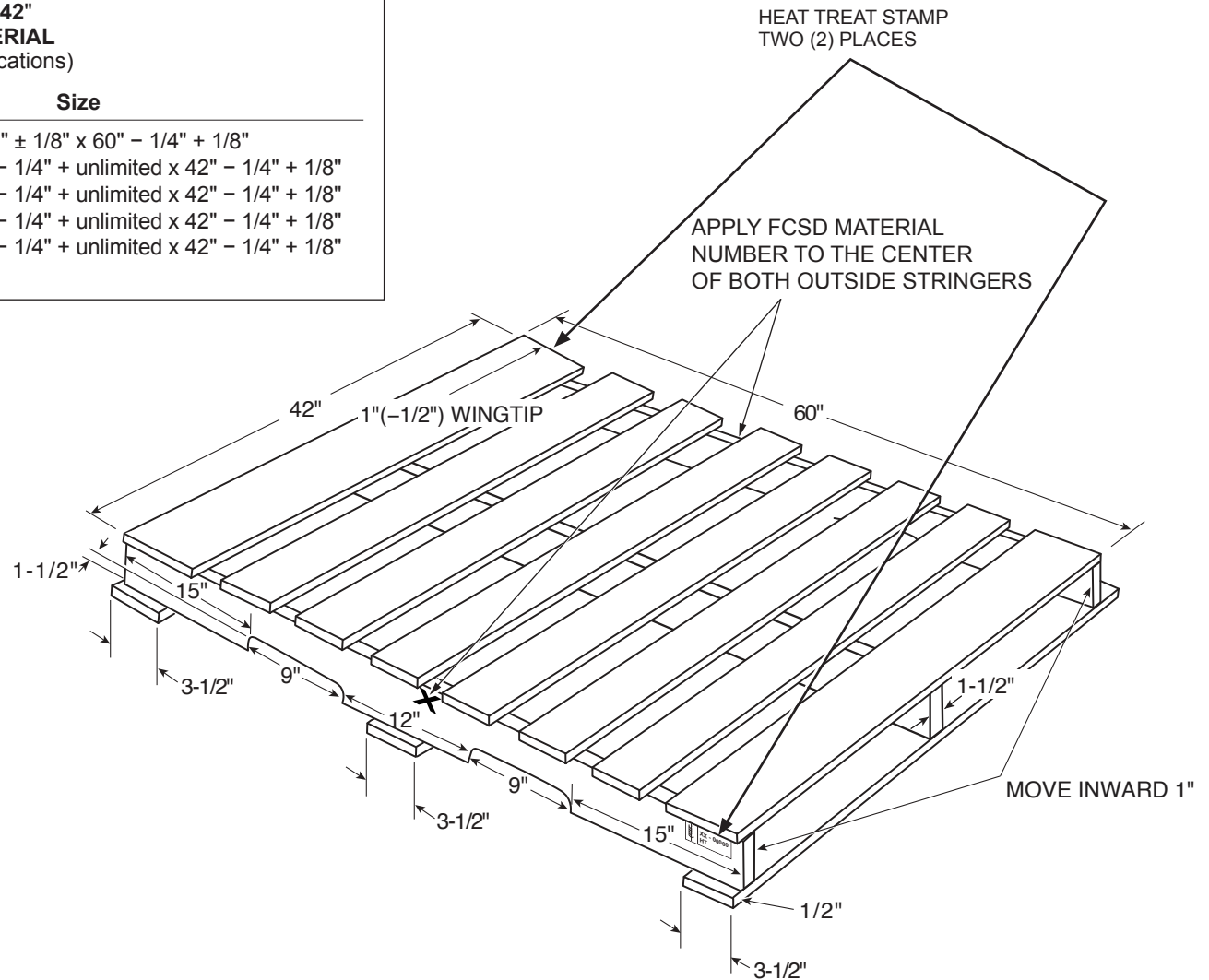
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DETAIL C - TYPICAL CONSTRUCTION STANDARDS

1660C 60" x 42"
BILL OF MATERIAL
(Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 60" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	6	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"



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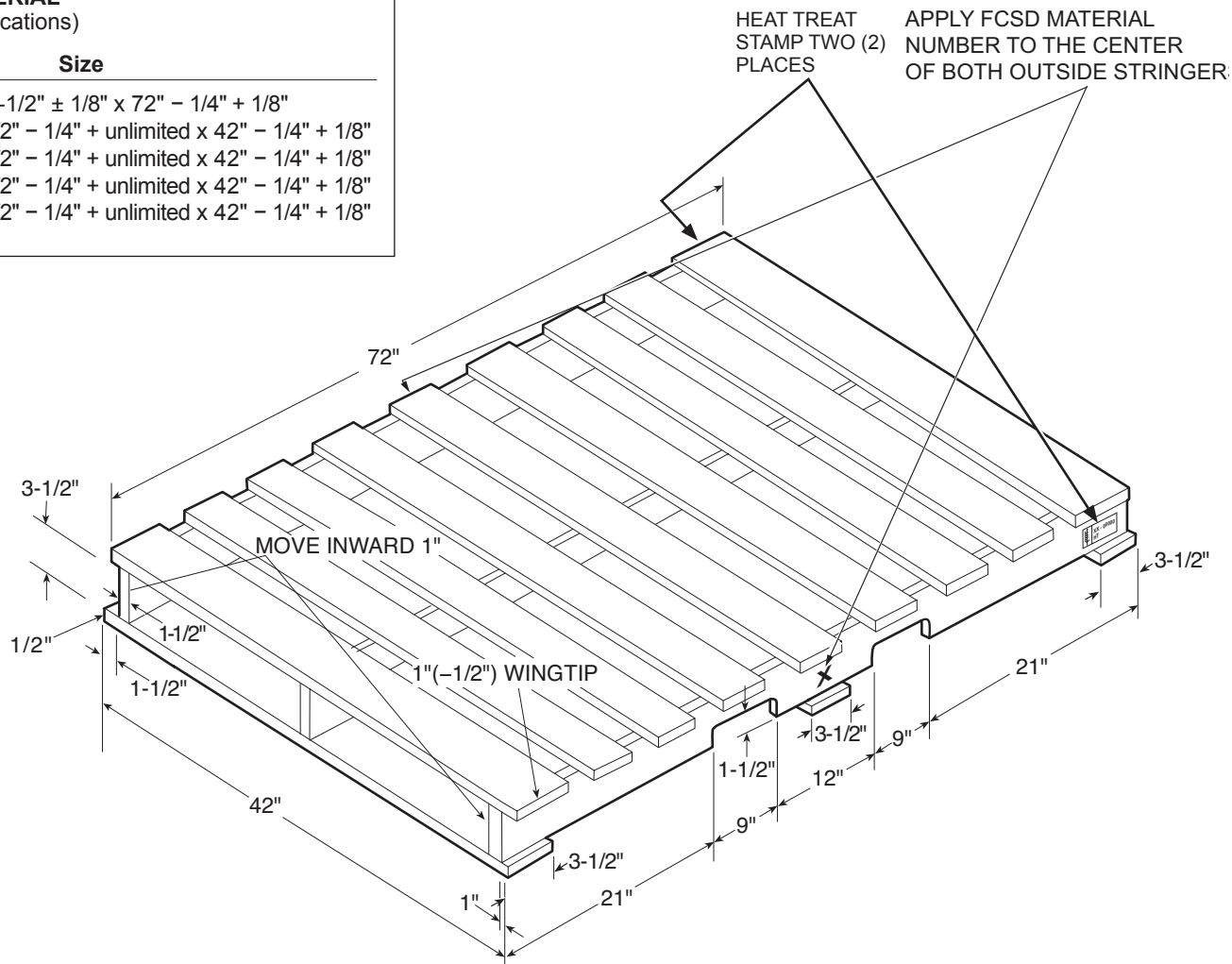
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DETAIL F - TYPICAL CONSTRUCTION STANDARDS

1660F 72" x 42"
BILL OF MATERIAL
(Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 72" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	7	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"



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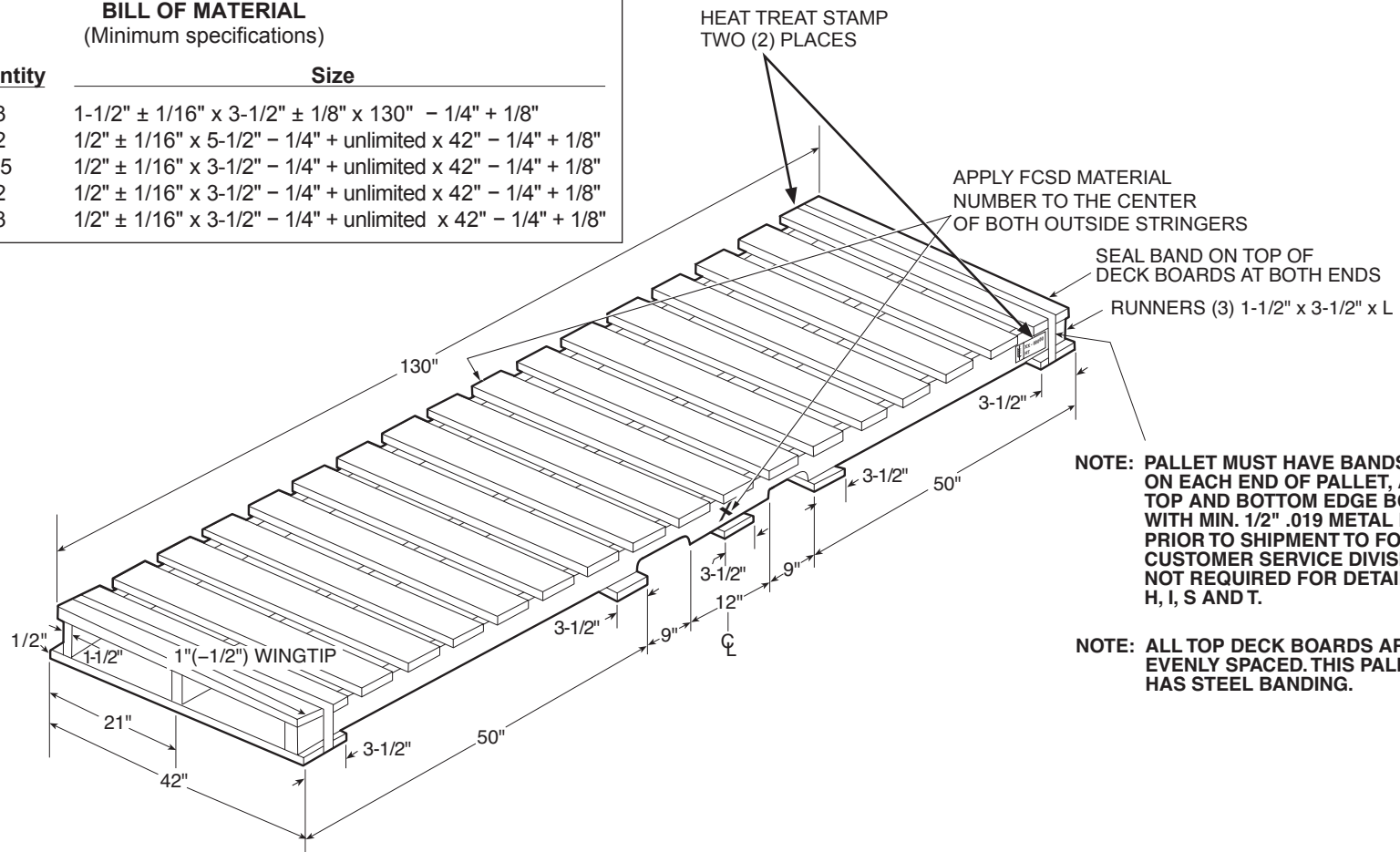
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DETAIL G - TYPICAL CONSTRUCTION STANDARDS

1660G 130" x 42" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 130" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	15	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"



NOTE: PALLET MUST HAVE BANDS ON EACH END OF PALLET, AROUND TOP AND BOTTOM EDGE BOARDS WITH MIN. 1/2" .019 METAL BANDING PRIOR TO SHIPMENT TO FORD CUSTOMER SERVICE DIVISION - NOT REQUIRED FOR DETAILS H, I, S AND T.

NOTE: ALL TOP DECK BOARDS ARE EVENLY SPACED. THIS PALLET HAS STEEL BANDING.

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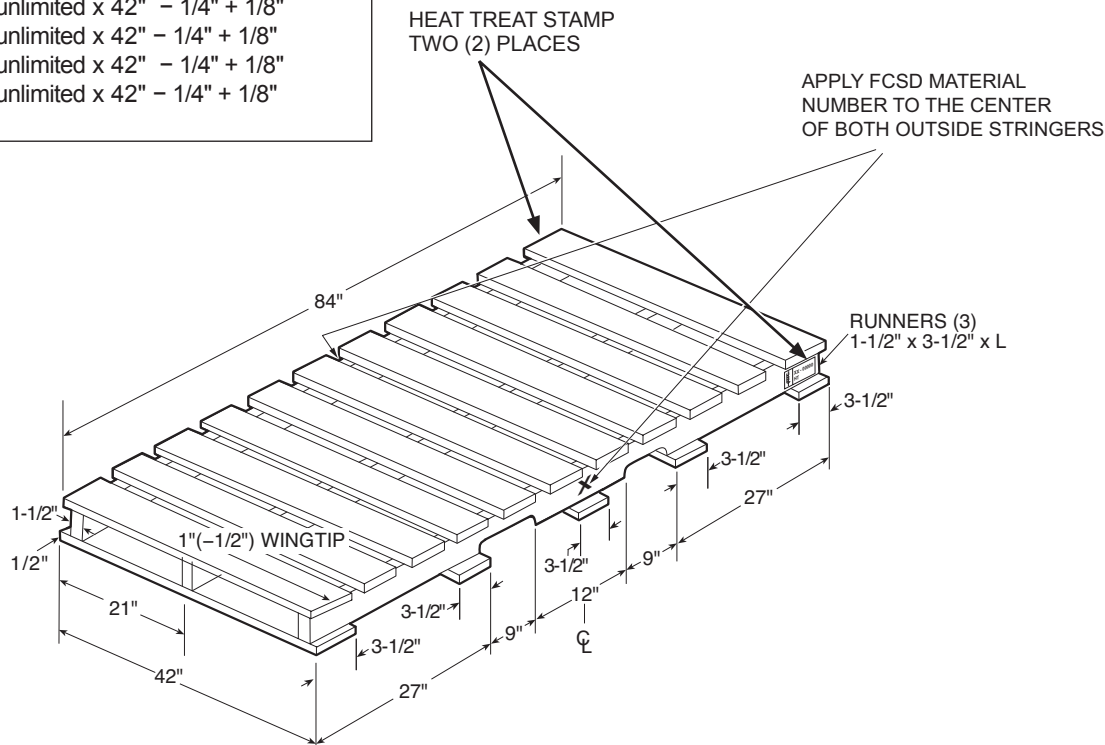
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DETAIL H - TYPICAL CONSTRUCTION STANDARDS

1660H 84" x 42"
BILL OF MATERIAL
(Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 84" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	9	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"



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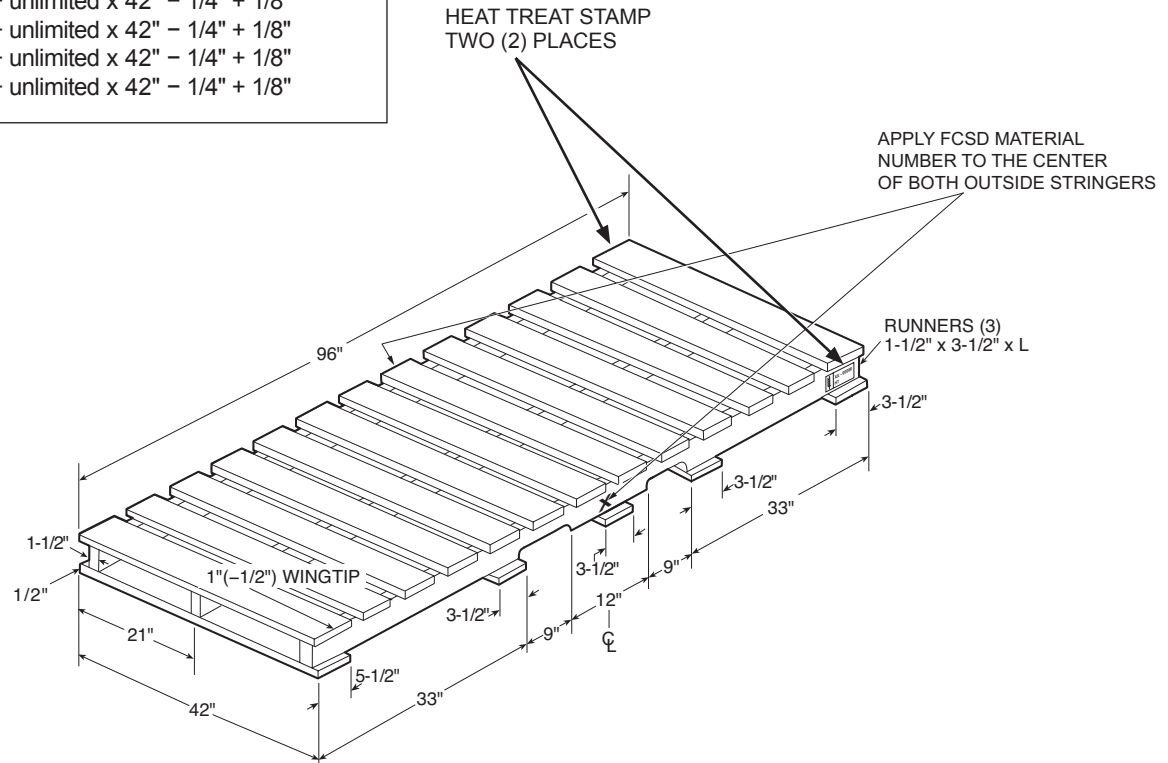
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DETAIL I - TYPICAL CONSTRUCTION STANDARDS

1660I 96" x 42"
BILL OF MATERIAL
 (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 96" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	11	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"



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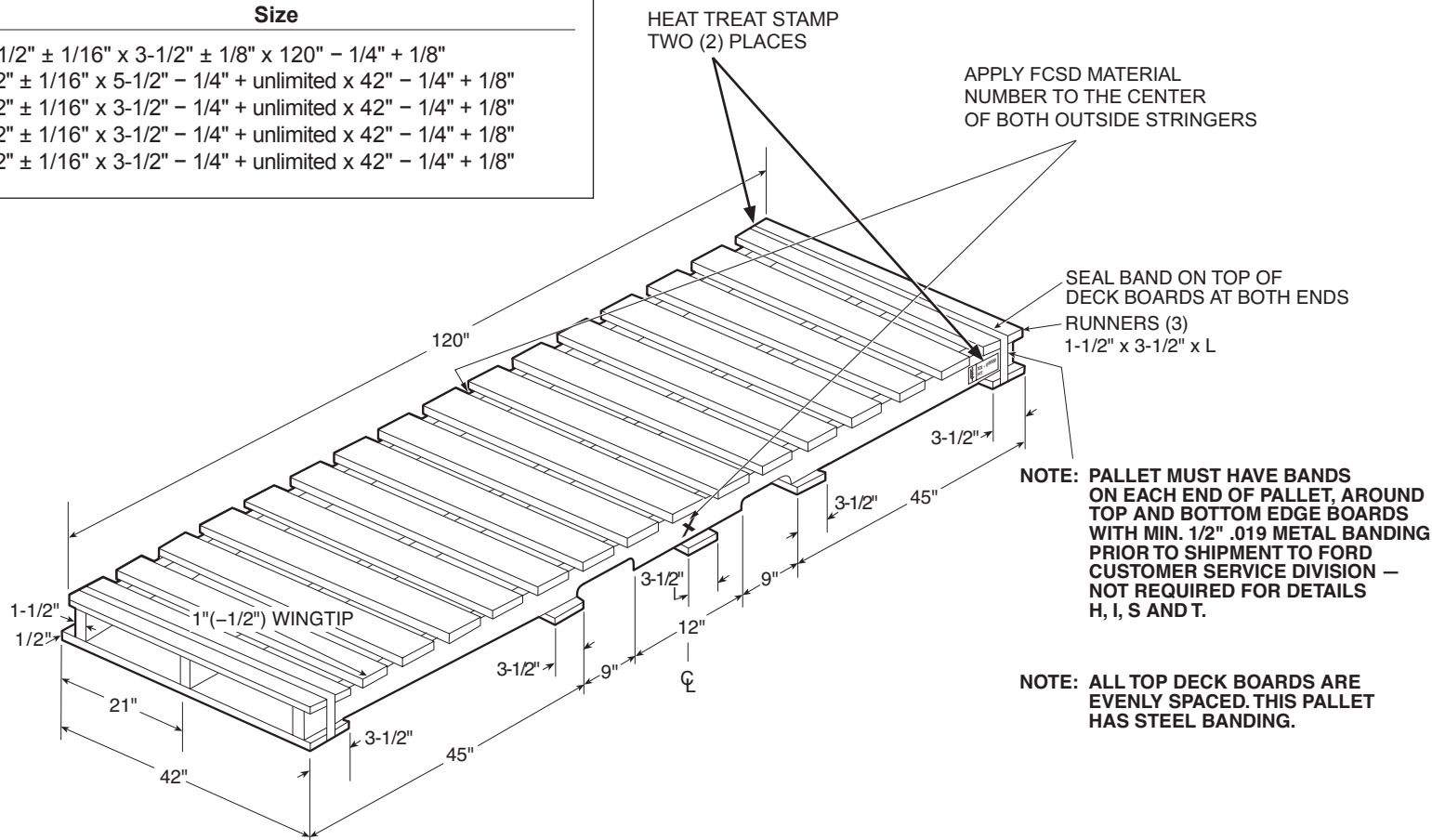
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DETAIL Q - TYPICAL CONSTRUCTION STANDARDS

1660Q 120" x 42" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 120" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Top Center	14	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 42" - 1/4" + 1/8"



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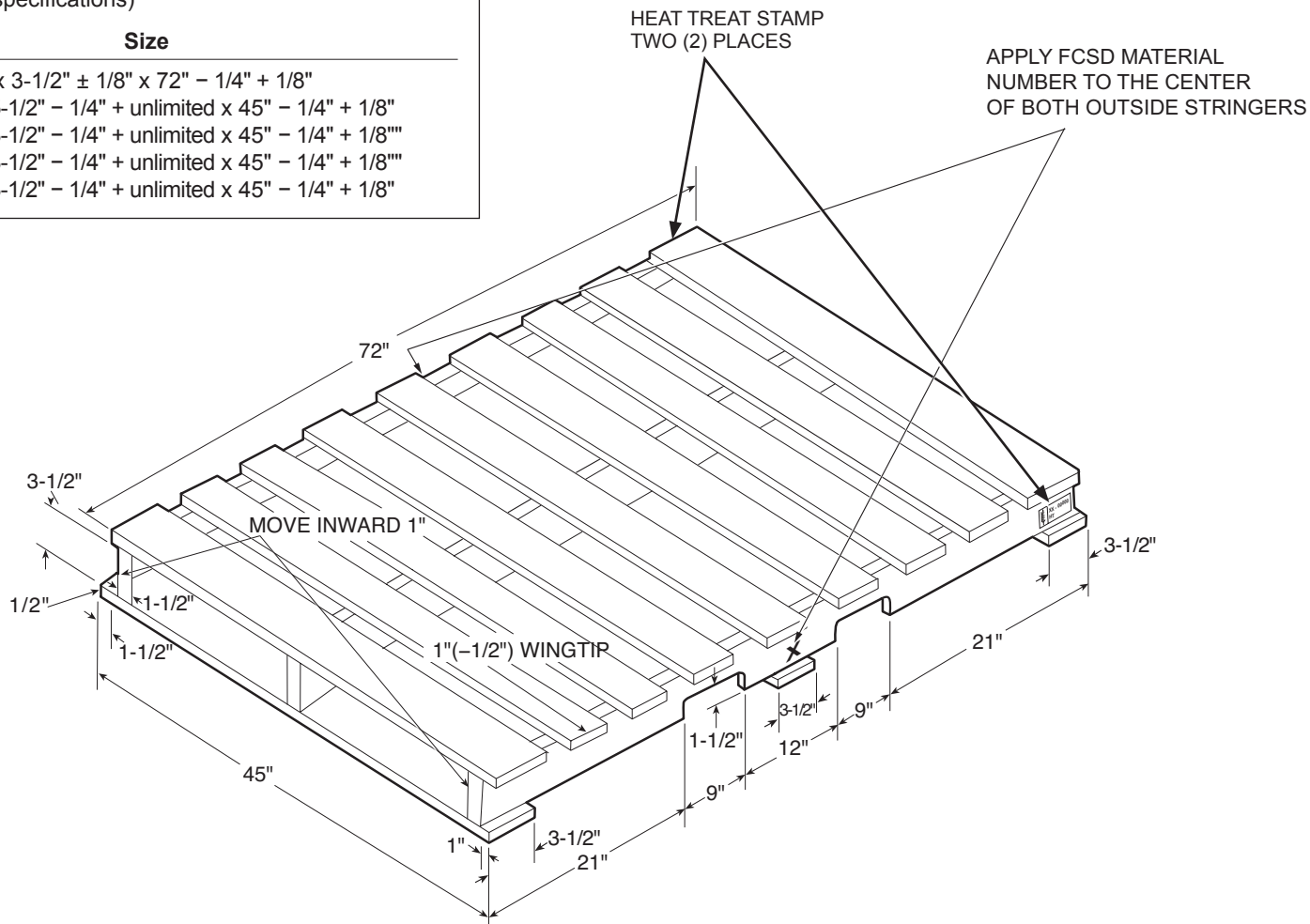
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DETAIL R - TYPICAL CONSTRUCTION STANDARDS

1660R 72" x 45" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 72" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Top Center	7	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"



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Date

8-1-81

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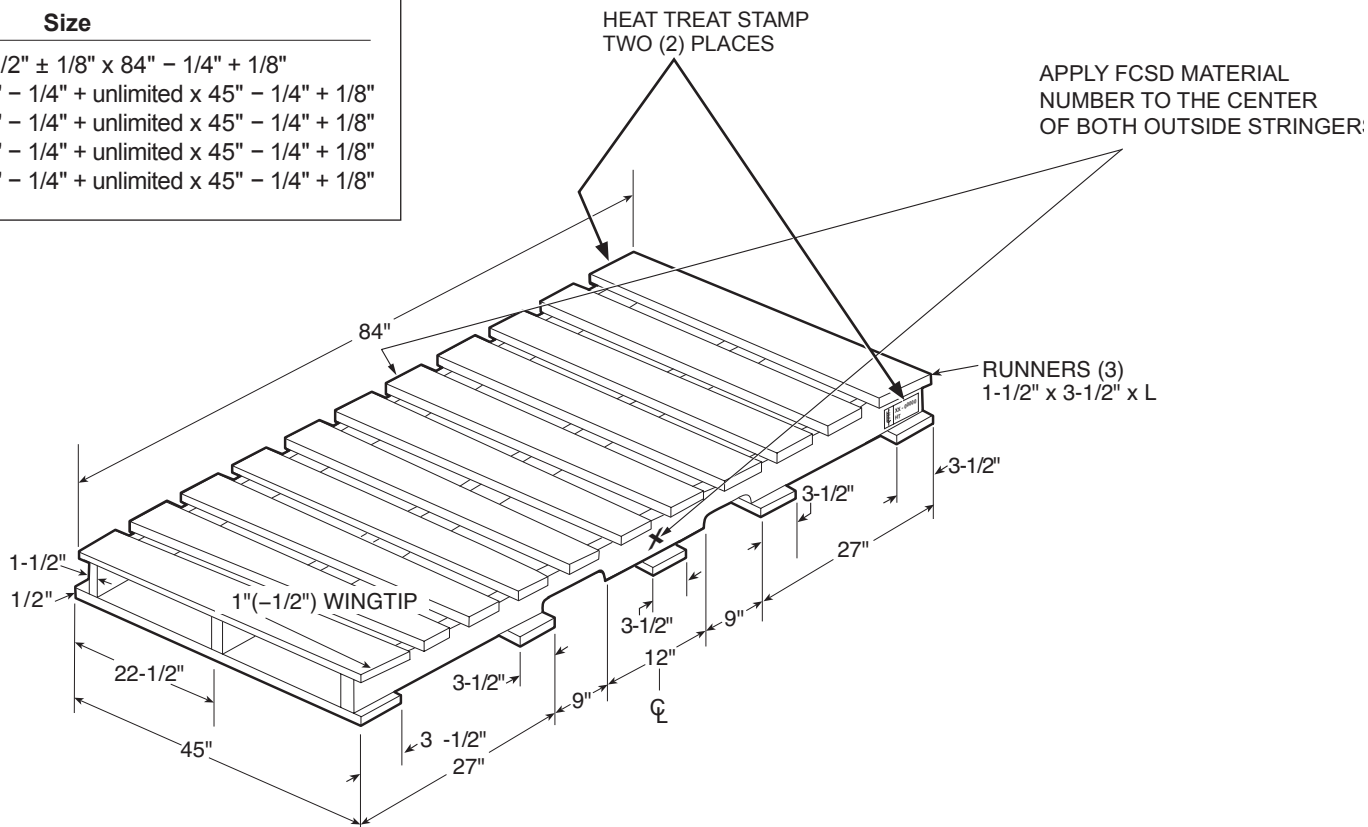
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DETAIL S - TYPICAL CONSTRUCTION STANDARDS

1660S 84" x 45" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 84" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Top Center	9	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"



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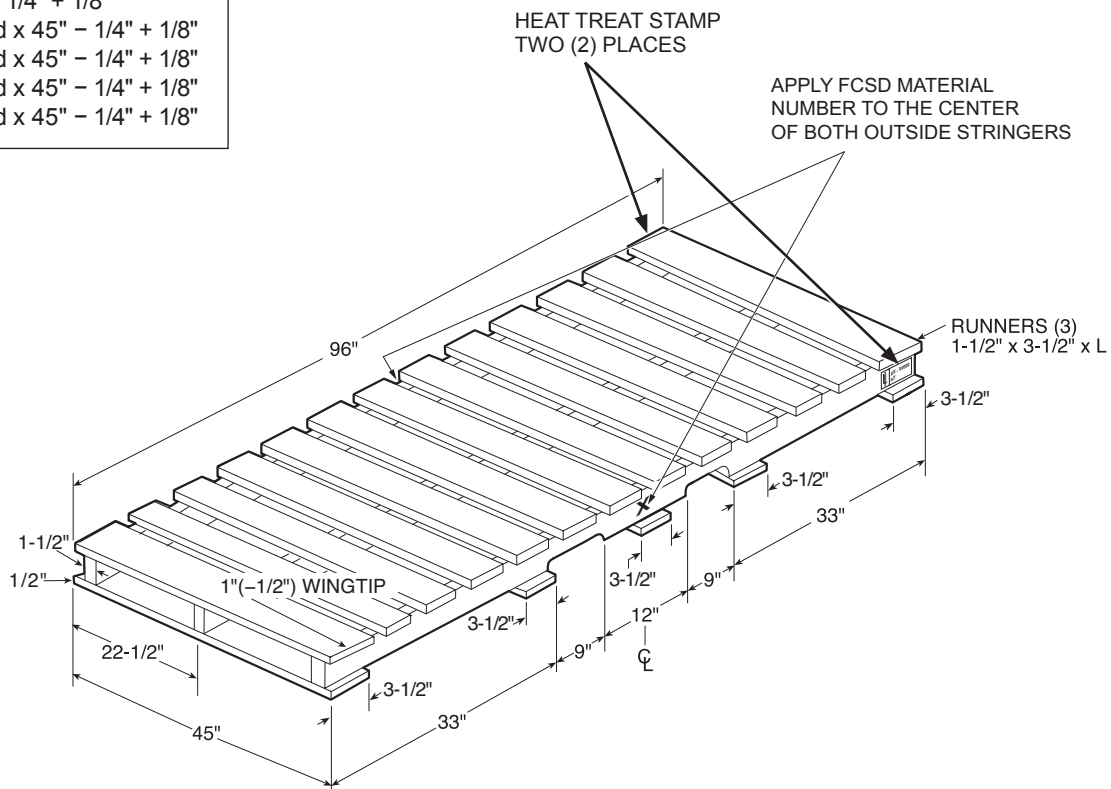
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DETAIL T - TYPICAL CONSTRUCTION STANDARDS

1660T 96" x 45"
BILL OF MATERIAL
(Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 96" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Top Center	11	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"



FORD MOTOR COMPANY, PACKAGING ENGINEERING, FORD CUSTOMER SERVICE DIVISION, 28301 SCHOOLCRAFT ROAD, BUILDING 300, LIVONIA, MI 48150

Designed

DMD

Approved

T.A. Kasper

Date

8-1-81

Revised

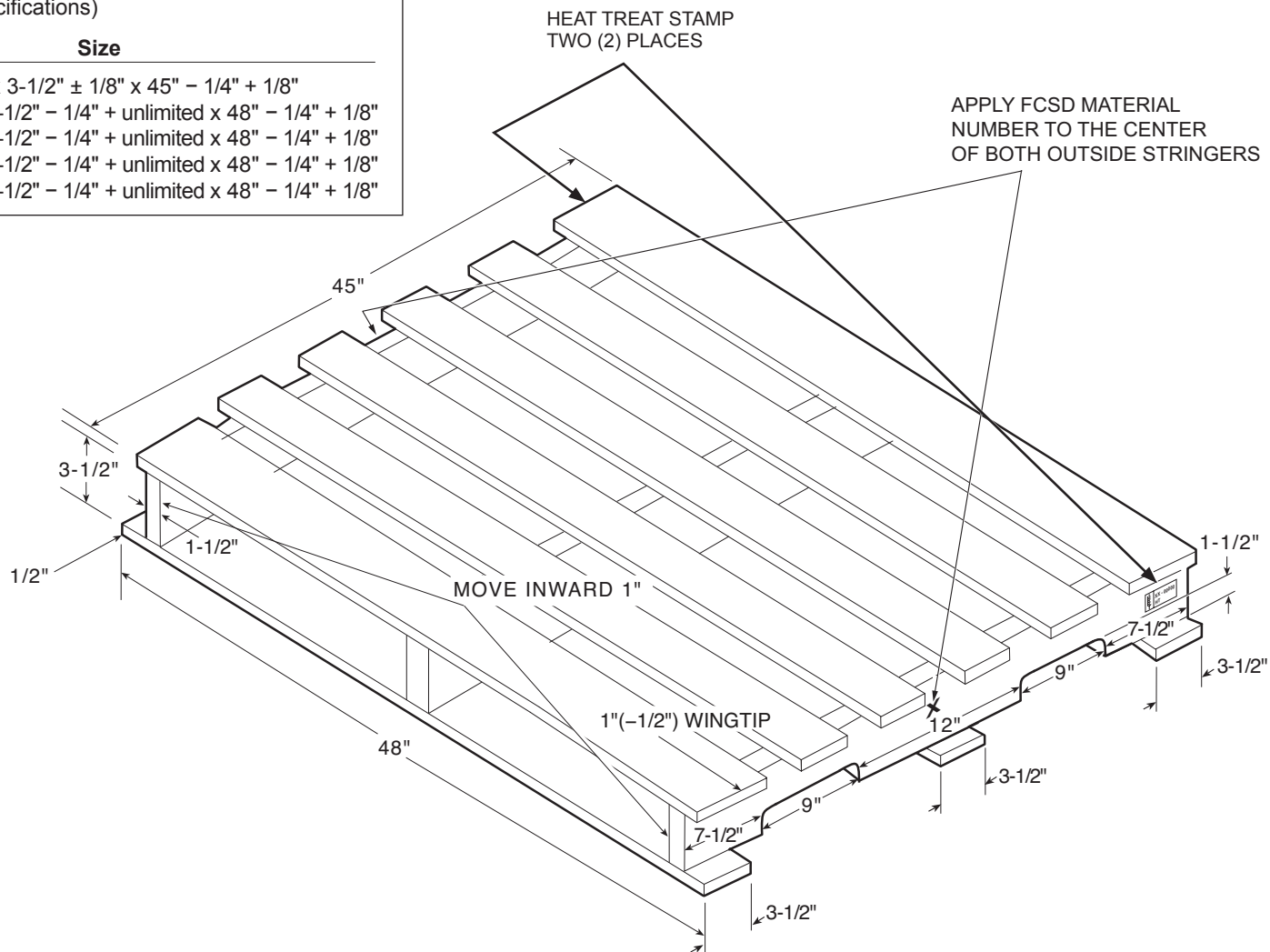
3-15-22



DETAIL U - TYPICAL CONSTRUCTION STANDARDS

1660U 45" x 48" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 45" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"
Top Center	4	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"
Bottom Center	1	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 48" - 1/4" + 1/8"



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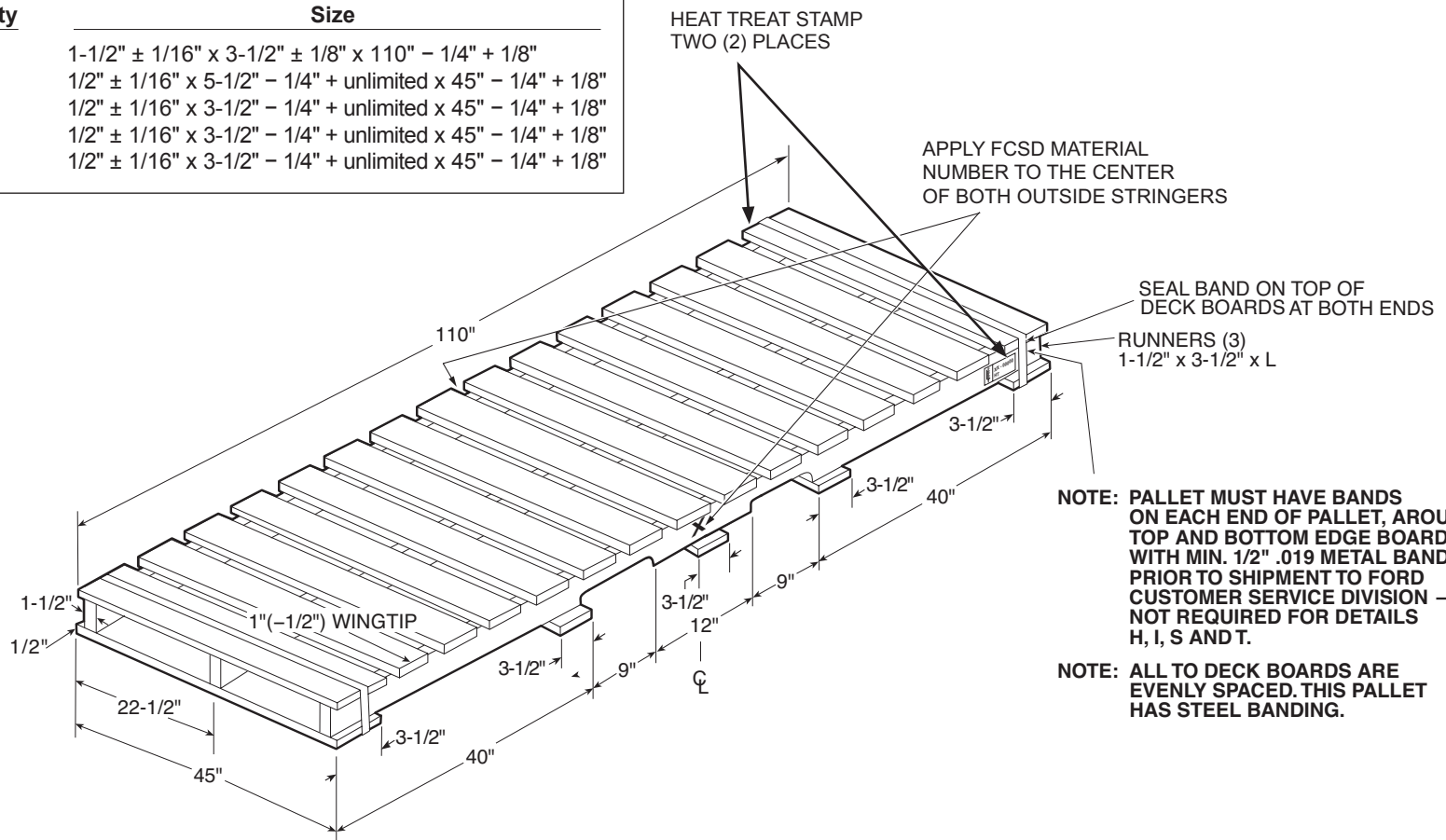
3-15-22



DETAIL V - TYPICAL CONSTRUCTION STANDARDS

1660V 110" x 45" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 110" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Top Center	13	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 45" - 1/4" + 1/8"



NOTE: PALLET MUST HAVE BANDS ON EACH END OF PALLET, AROUND TOP AND BOTTOM EDGE BOARDS WITH MIN. 1/2" .019 METAL BANDING PRIOR TO SHIPMENT TO FORD CUSTOMER SERVICE DIVISION — NOT REQUIRED FOR DETAILS H, I, S AND T.

NOTE: ALL TO DECK BOARDS ARE EVENLY SPACED. THIS PALLET HAS STEEL BANDING.

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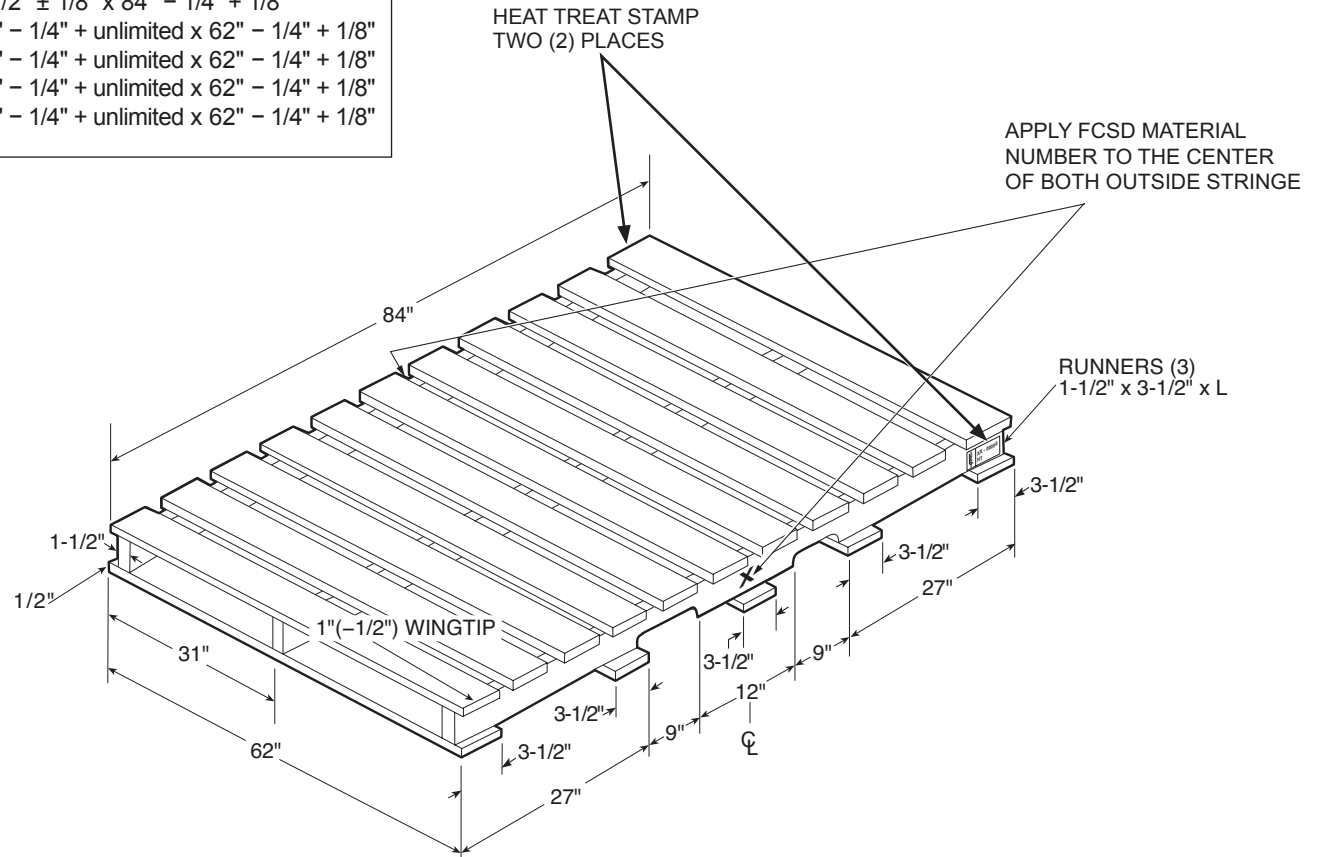
Designed DMD	Approved T.A. Kasper	Date 8-1-81	Revised 3-15-22
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DETAIL W - TYPICAL CONSTRUCTION STANDARDS

1660W 84" x 62" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 84" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Top Center	9	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"



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T.A. Kasper

Date

8-1-81

Revised

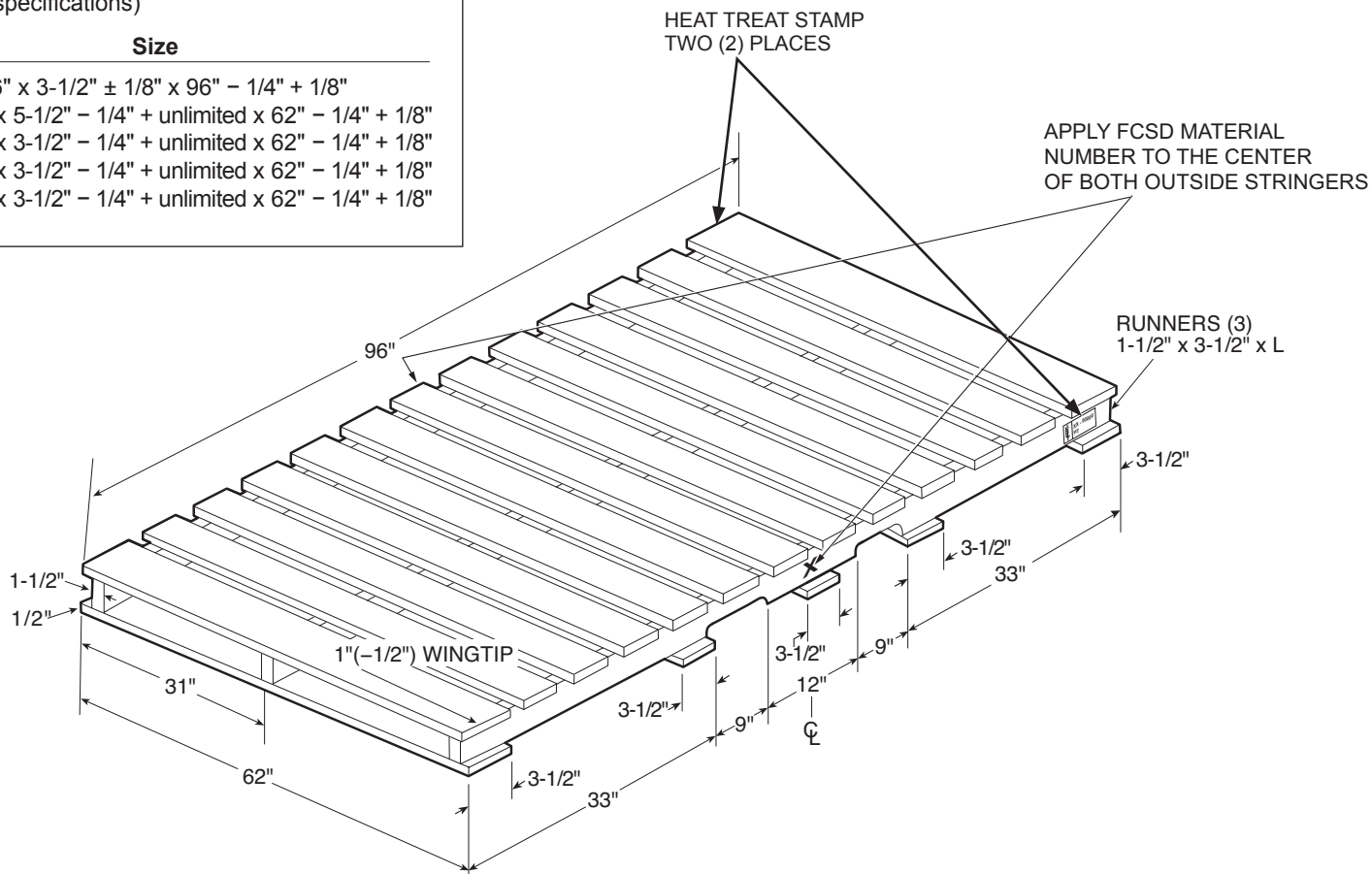
3-15-22



DETAIL X - TYPICAL CONSTRUCTION STANDARDS

1660X 96" x 62" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 96" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Top Center	11	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"



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T.A. Kasper

Date

8-1-81

Revised

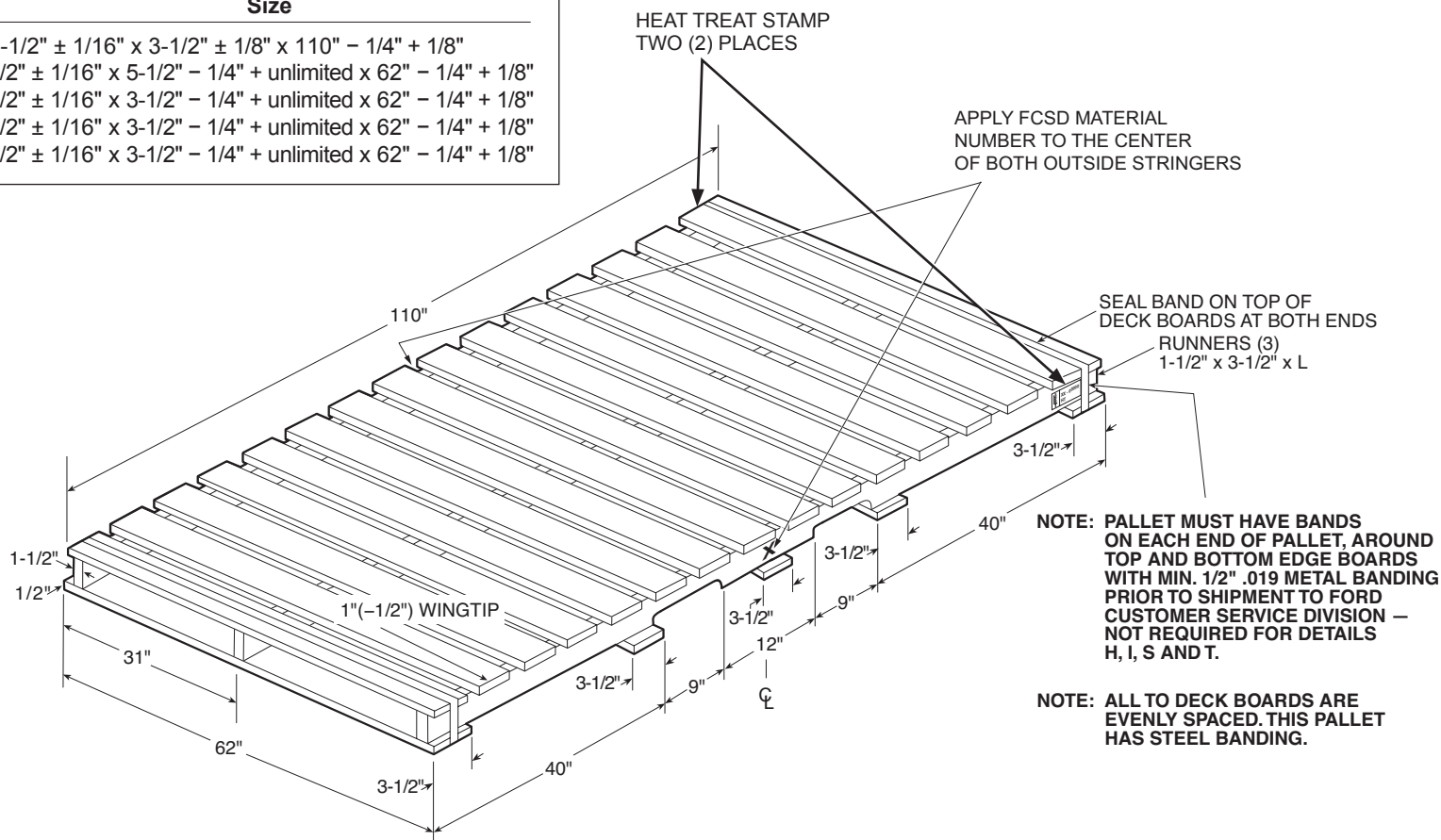
3-15-22



DETAIL Y - TYPICAL CONSTRUCTION STANDARDS

1660Y 110" x 62"
BILL OF MATERIAL
 (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 110" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Top Center	13	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 62" - 1/4" + 1/8"



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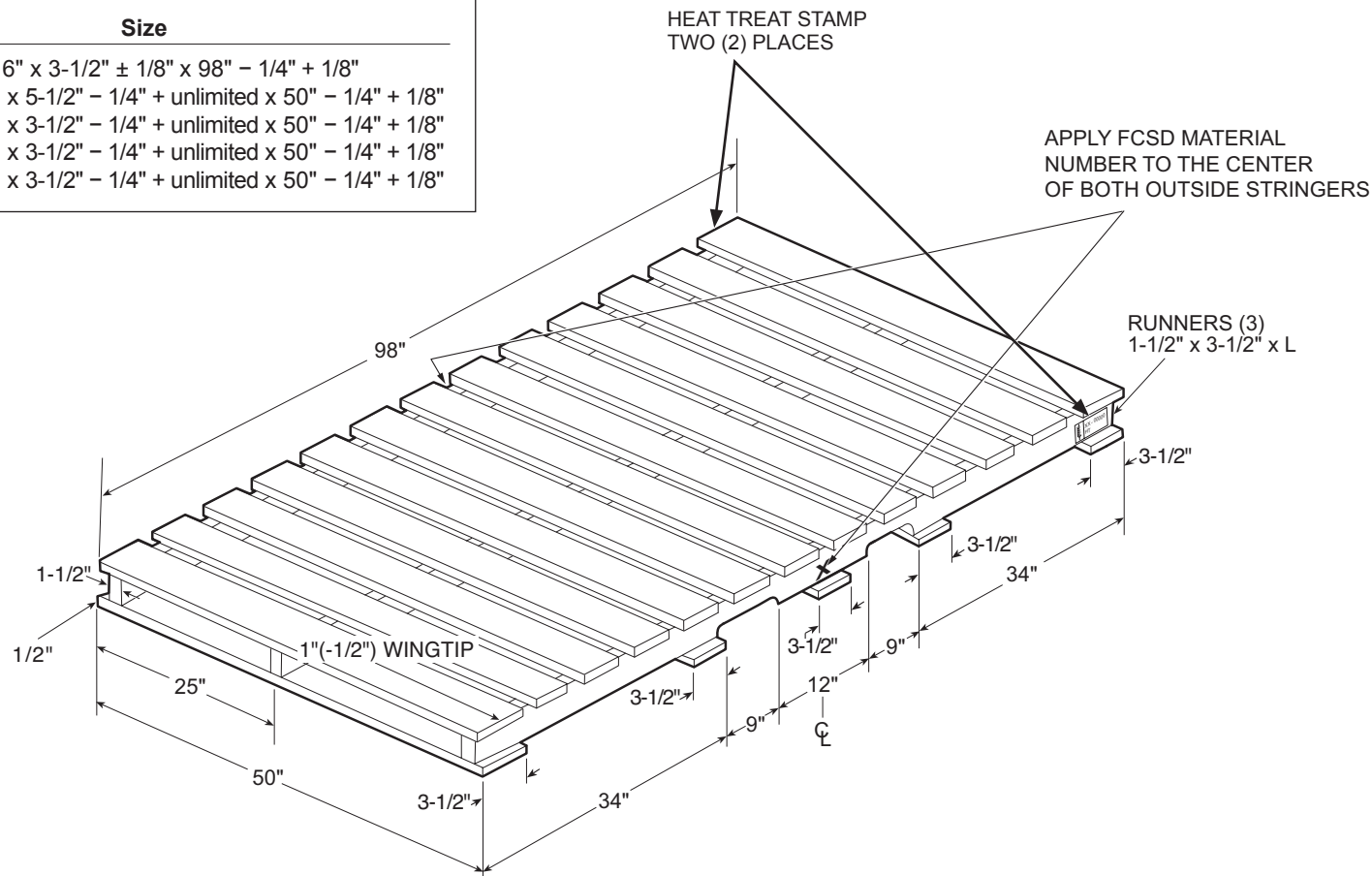
Designed DMD	Approved T.A. Kasper <i>[Signature]</i>	Date 8-1-81	Revised 3-15-22
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DETAIL Z - TYPICAL CONSTRUCTION STANDARDS

1660Z 98" x 50" BILL OF MATERIAL (Minimum specifications)

Description	Quantity	Size
Runners	3	1-1/2" ± 1/16" x 3-1/2" ± 1/8" x 98" - 1/4" + 1/8"
Top Lead	2	1/2" ± 1/16" x 5-1/2" - 1/4" + unlimited x 50" - 1/4" + 1/8"
Top Center	11	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 50" - 1/4" + 1/8"
Bottom Lead	2	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 50" - 1/4" + 1/8"
Bottom Center	3	1/2" ± 1/16" x 3-1/2" - 1/4" + unlimited x 50" - 1/4" + 1/8"



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Designed

DMD

Approved

T.A. Kasper

Date

8-1-81

Revised


3-15-22



Revisions:

9-11-85	Front drop panel redesigned.	10-22-03	Removed mandatory inspection requirement. - DCM
5-1-89	Added corner post slots.	1-6-05	Revised all wood illustrations to show proper location of pallet notches. - DVB
5-1-89	Detail P added.	1-26-05	Removed banding graphics and banding notes on Details H, I, S and T. - DVB
5-1-89	Detail F added. - RGW	3-15-05	Revised weight restrictions on all wood and corrugated pallets. - DVB
6-1-89	Revised front flaps to 6".	3-24-06	Revised International Paper corrugated pallet drawing, added Pratt Industries corrugated pallet drawing, removed Classic Container and Laimbeer Packaging corrugated pallet drawings. Deleted BC (Corrugated) Pallet. Added Corrugated Pallet Requirements on page 1. - DVB
1-19-90	Detail G added. - RGW	3-5-07	Added blocks and adhesives to corrugated pallets. Removed obsolete corrugated carton suppliers, ARVCO Container Corporation, Genesee Packaging, Paper Plas Converting and Longview Fibre - Milwaukee. - GPL
1-22-90	Pallet fork openings re-dimensioned. - RGW	4-17-07	Added Details W, X and Y. - KLD
6-22-90	Revised corner post dimension.	9-25-07	Added Details WC, XC, YC and footnote. - KLD
12-18-90	Added Details H, I, Q, R, S, T and deleted Details E and N.	3-13-08	Added supplier/packager responsibility note regarding slip sheets. - GPL
3-8-91	Added Details U and V. - AWK & CAM	5-20-09	Added statement to item #6 on page 2 that mitered corners are not required. Removed mitered corners on all wood pallet illustrations. - KLD
1-20-95	Added 1660BC pallet. - AWK	4-28-10	Added detail BCAN. Added one top center board. Revised lengths of runners and deckboards. - KLD
3-2-95	Added 17-1/2" fork openings for all extended pallets. - AWK	6-18-10	Revised deckboard dimensions for details B and BCAN on pages 6 and 7. - KLD
11-15-95	Revised dimensions on side view (Page 8). - AWK	4-25-11	Added weight limit to all pallet details. - OVB
2-6-96	Added Piston Packaging, 4015 Michigan Ave., Detroit, Michigan, to approved supplier list. - RAB	7-1-12	Added 1660VC and corrected width dimension on 1660YC from 48" to 45". - OVB
11-25-96	Added World Corrugated Container, 930 Elliot Rd., Albion, Michigan, to approved supplier list, changed to 500 lbs. maximum capacity. - AWK	11-1-16	Added note on page 1 for heat treated stamp requirements with illustration on page 5 and international standards for Phytosanitary Measurement (ISPM NO. 15). Revised BOM tolerance range from (+ 1/4" - 3/8") to (+ 3/8"). - OVB
9-24-97	Added additional corrugated pallets for Laimbeer Packaging Corporation, Arvco Container Corporation, International Paper. - DMD	11-2-17	Added Detail Z on page 23. - OVB
11-13-97	Corrected page 6. Added Detail I and V to top of page and added Detail I to note "bands not required". - JWS	12-21-18	Revised construction standards on page 4. Revised dimensions on all pallets. - OVB
12-4-97	Added additional artwork (International Paper). - DMD	1-9-19	Revised bottom lead boards from 5-1/2" back to 3-1/2". - OVB
1-19-98	Added Windsor Pallet Limited. - DMD	3-5-19	Revised construction of 1660C - DVB
3-3-98	Added Tenneco Packaging. - DMD	3-15-22	Removed reference to corrugated pallets and details VC, WC, XC and YC from page 1. - DVB
6-3-98	Added Genesee Packaging. - DMD		
6-18-98	Revised Arvco drawing. - DMD		
10-9-98	Revised International Paper, Windsor and Bay Corrugated drawings. - DMD		
1-27-99	Revised Laimbeer Packaging Corporation drawing. - DMD		
3-17-99	Added additional artwork (Tenneco Packaging). - DMD		
11-3-99	Added additional artwork (Longview Fibre - Milwaukee) and revised Tenneco Packaging material description. - DMD		
2-14-00	Revised Bay Corrugated drawing. - DMD		
4-12-00	Revised Windsor Pallet drawing. - DMD		
5-17-00	Added Paper Plas Converting. - DMD		
1-15-01	Revised statement that the BC (corrugated) pallet should be used in place of the B (wood) pallet. - DVB		
1-9-02	Removed detail D (42" x 72") - Replaced by Detail F. - KLG		
3-6-03	Revised pallet structure on A, B, C, F, G, H, I, Q, R, S, T, U and V. - AAH		
7-31-03	Added maximum pallet weight to Details A and B. - DVB		
8-27-03	Revised maximum pallet weight to include all Details. - DVB		

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Designed	DMD	Approved	T.A. Kasper 	Date	8-1-81	Revised	3-15-22
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