



**PALLET STRETCH WRAP SYSTEM**

**STYLE:** Spiral Stretch Wrap.

**MATERIAL:** Acceptable Films:  
LLDPE Linear low-density polyethylene.  
LDPE Low-density polyethylene.  
EVA Ethyl vinyl acetate 12% minimum (copolymer).

**THICKNESS:** .80 mil (80 gauge) unless otherwise stated. All mil thickness specified is minimum thickness with a tolerance of plus or minus 3%.

**SIZE:** 20 inch (508mm) web width.

**HAZE:** Non-glare — low haze.

**OPTICS:** Industrial grade clear.

**CLING:** Film must contain appropriate properties to stick to itself. This allows film to be wipe-sealed as it is applied to load.

**APPLICATION INSTRUCTIONS:**

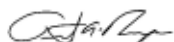
The film is started at the bottom of the pallet where film is wound onto the pallet before it starts to spiral, it then spirals (with a 50% minimum film overlap) up to the top of the load. At the top of the load additional wraps are applied, with a minimum of 3 inches (76.2mm) excess at the top, before spiraling down with a 50% film overlap to the pallet base where additional wraps are applied and sealed for completion. The wrap must extend at the base a minimum of 3 inches (76.2mm) below the top of the pallet deck to assure that the load is properly secured to the pallet.

Minimum wrap standards are shown in the table below:

**PALLET STRETCH WRAP TABLE**

Weight of Pallet Load	Bottom Wrap (Includes Pallet)	Top Wrap
0-500 Lbs. (0 - 226.79kg)	3	2
501-750 Lbs. (227.25 - 340.19kg)	4	3
751-1000 Lbs. (340.65 - 453.592kg)	5	4
1001-1500 Lbs. (454.05 - 680.39kg)	6	6
Over 1501 Lbs. (680.84kg)	8	8

**FORD MOTOR COMPANY, PACKAGING ENGINEERING, FORD CUSTOMER SERVICE DIVISION, 28301 SCHOOLCRAFT RD., BUILDING 300, LIVONIA, MICHIGAN 48150**

Designed RGW	Approved T. A. Kasper 	Date 10-31-07	Revised 10-1-21
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**STRETCH WRAP — HANDWRAPPING INSTRUCTIONS:**

FCSD recognizes the fact that supplier's will use handwrapping applications. The following methods should be adhered to when handwrapping.

1. **SPIRALING:** (Refer to Figure 1) - Tuck the lead wrap between the pallet and bottom box. Start spiraling around the boxes in an upward direction, overlapping the film by 50%. Once reaching the top, stretch film about 3 inches (76.2mm) over top corners for a "vertical hold-down", then spiral downward.\*
2. **ROPING:** (Refer to Figure 2) - Tie knot in film and secure under pallet. Unwrap one pallet width of film. Use your free hand to pull on the rope (film) to provide stretch. Now pull up and over top corner box. Pull down and stretch; secure to pallet. Follow procedure on remaining corners.\*

**NOTE: WHEN USING THE ROPING TECHNIQUE, YOU MUST ALSO SPIRAL STRETCH WRAP THE LOAD BY MANUAL OR AUTOMATIC MEANS.**

\* Refer to the pallet stretch wrap table for the minimum wrap standards.

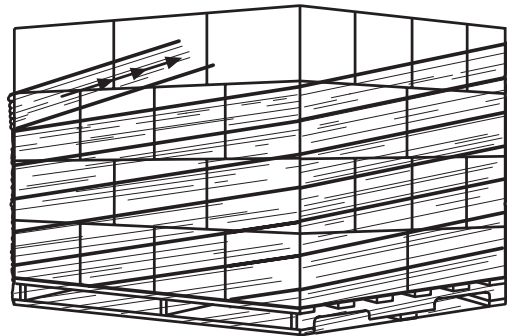
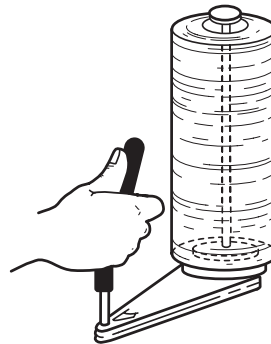


FIGURE 1



STRETCH WRAP DISPENSER

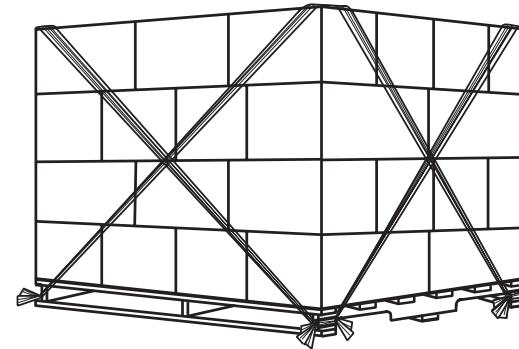



FIGURE 2

10-1-21 On page 1 changed thickness says .80 mil gauge to 80 mil (80 gauge). (KLD)  
2-19-19 Added KG and mm. (GPL)  
9-30-90 Revised film gauge and table (CM)

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