



INSTRUCTIONS APPLICABLE TO CORRUGATED CARTONS

Instructions to the Carton Purchaser and Manufacturer:


1. FCSD's Contract Packagers are required to purchase all corrugated cartons from the FCSD designated single source, other suppliers can purchase cartons from any reliable source who can comply with the carton specifications and delivery service requirements.
2. Unless otherwise specified, corrugated cartons to be fabricated from either RECYCLED LINER BOARD AND/OR MEDIUM; OR VIRGIN CORRUGATED FIBERBOARD.
3. Where part nomenclature imprinting is required, the purchaser will indicate on the purchase order or release the EXACT NOMENCLATURE AS INDICATED ON THE SERVICE PARTS PACKAGE SPECIFICATION FORM.
4. Cartons are to be plain unless special printing requirements are included in the Package Material Specification, e.g. special graphics on sheet metal containers which are required to be printed in Ford Corporate Blue ink (Pantone 294).
5. The carton number is to be printed on each carton in the vicinity of the Box Maker's Stamp. Corrugated cartons must be constructed to conform with the I.C.C. Rule No. 41, LATEST FREIGHT CLASSIFICATION.
6. Unitization methods for PRC have been established and are published in the Packaging and Shipping Guide. Non-PRC receiving locations should be contacted prior to initial shipment to determine unique handling requirements.

SIZE: Refer to carton listing

MATERIAL: Double face, corrugated
B flute, Mullen test as indicated

STYLE : Refer to carton listing

FORD MOTOR COMPANY, PACKAGING ENGINEERING, FORD CUSTOMER SERVICE DIVISION, 29500 PLYMOUTH ROAD, LIVONIA, MICHIGAN 48150

Designed JS	Approved D. C. Moyer 	Date 1-25-82	Revised 4-16-07
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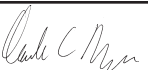
SPECIFICATIONS FOR MODULE STANDARD SHIPPING CONTAINERS

<u>DETAIL NUMBER</u>	<u>INSIDE DIMENSIONS</u>	<u>MANUFACTURING JOINT FOR CARTONS SHIPPED TO PRC</u>	<u>STYLE</u>	<u>MULLEN TEST</u>
A2000	6-5/8" x 3-1/2" x 6-1/4"	Outside glued joint	RSC	175 lbs.
A2030	13-1/4" x 7" x 6-3/8"	Outside glued joint	RSC	175 lbs.
A2040	13-1/4" x 7" x 3-1/4"	Inside extended or Outside glued joint	RSC	200 lbs.
A2060	13-1/4" x 7" x 9-5/8"	Outside glued joint	RSC	200 lbs.

TOLERANCES AND SPECIAL REQUIREMENTS FOR CARTONS ORDERED BY PARTS REDISTRIBUTION CENTER (PRC)

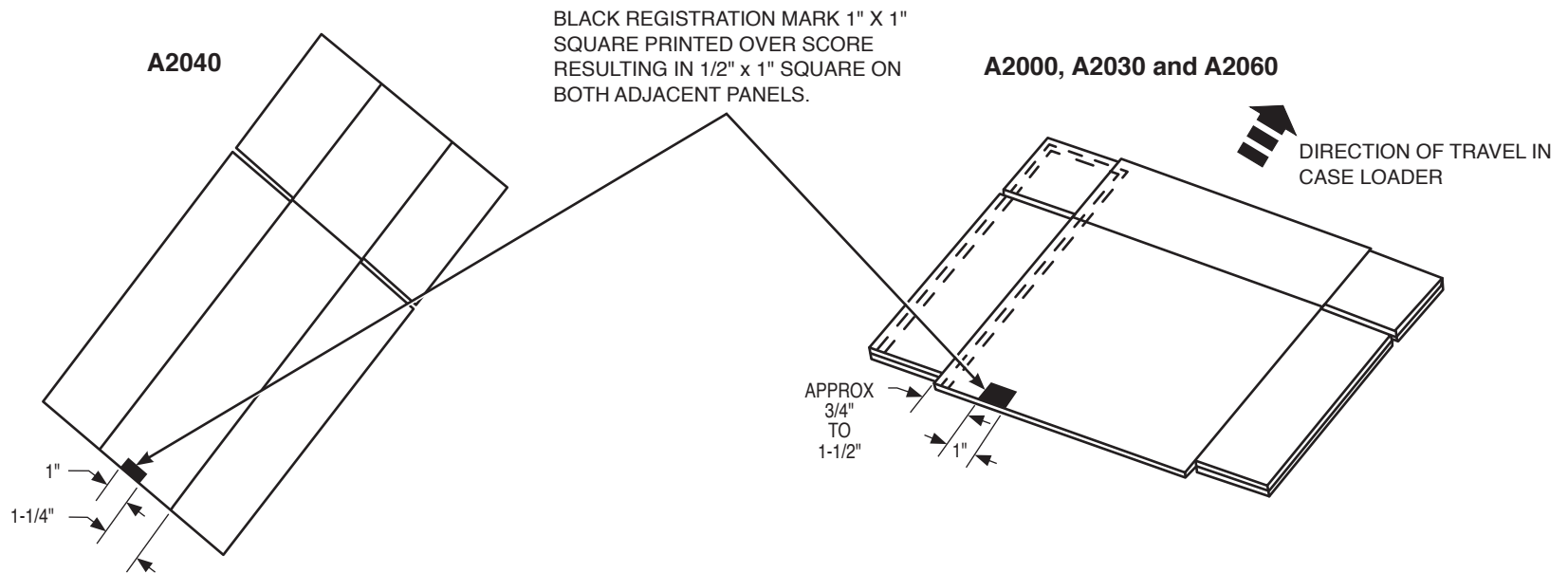
1. The amount of gap at the manufacturer's joint shall not vary more than plus or minus one board thickness for the lot average.
2. Variations in the width of gap at the manufacturer's joint on the same box (MISALIGNMENT) shall not exceed 1/8" when measured at the flap scorelines.
3. Top and bottom outer flaps are to have minimum 1/16" gap - maximum 3/16" gap.
4. An adequate, but not excessive amount of glue is to be used on manufacturer's joint. Excessive gluing which results in the inside (interior) surfaces of the boxes sticking together or the exterior (outside) surfaces sticking together is unacceptable.
5. All flap scores must be hinged scored (offset - point to point) to facilitate mechanical folding and closing. Body scored must be deep enough so that they produce well defined crisp score lines and smooth well formed corners.
6. All manufacturer's slots will be long enough that the end of the slot will overlap at least 1/2" of the scoreline. This assures a square folding box can be produced when sealing. Then slots for A2040 shall be offset into the width panel flaps.
7. Variations in the length and width dimension of the knock down boxes shall not exceed plus or minus 1/8" from the lot average. As used in this connection length shall mean the full dimension of the knock down form right-angled to the manufacturer's joint. Width shall mean the full dimension of the knock down form parallel to the manufacturer's joint.
8. The amount of warp upon arrival at a customer's plant shall not exceed 1/4" per foot and shall be measured by placing the box on a flat surface so that the bow rises in the middle. The distance from the middle to the flat surface shall then be measured.

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- 9. Manufacturer's joint when glued shall be flattened sufficiently to reduce rocking of containers when stacked on top of each other in a vertical magazine.
- 10. A 1" x 1" black registration mark to be printed along with Mororcraft logos, as illustrated below. This mark will assist the case load operator to assure that the cases are properly stacked in the machines vertical magazine.
- 11. Shipping containers are to be securely sealed (closed) by PRC with hot melt glue.
- 12. PRC is to establish adequate internal procedures to assure that hot melt glue system is shut-down, started up and maintained in accordance with manufacturer's recommendations.



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PACKAGED PARTS PALLETIZATION INDEX

<u>SHIPPING CONTAINER</u>	<u>PALLET</u>	<u>OVERPACKS PER PALLET</u>	<u>PATTERN</u>
A2000	1660B	378	(42" x 9")
A2030	1660B	90	(18" x 5")
A2040	1660B	162	(18" x 9")
A2060	1660B	56	(14" x 4")

Revisions:

- 4-16-07 Removed carton graphics, revised pallet patterns. (KLD)
- 4-3-96 Added optional Outside Glued Joint to A2040 and made top and bottom outer flaps 3/16" maximum, was 1/8" maximum. (JWS)
- 8-10-89 Revised pallet quantity A2000 and A2060. (JWS)
- 3-8-88 Revised pallet pattern and height, added page 7. (JWS)
- 7-6-87 Revised A2000 minor logo, was A - "A" logo acceptable. (JS)
- 11-14-83 Deleted A2010 and revised A2040 pallet pattern.
- 10-24-83 To improve PDC bin compatibility. Deleted A2050 and A2070 (A2050 - 13-1/4 x 6 x 15/16 x 12--7/8; A2070 - 13-1/4 x 10-1/2 x 15-3/4); Replaced A2050 with A2060 (30 - #402/MF402 and 60-#400/MF400 and #401/MF401).
- 6-15-83 Revised to add Outside Glue Joint and "point to point" hinge score for cartons shipped to PRC.
- 3-31-83 A2070 depth was 15-1/2"; A2050 depth was 12-5/8-extended; glue tab was 1" plus added palletization index.

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