

**DESCRIPTION:** Full Overlap Slotted Container (FOL) or Overlap Slotted Container (OSC).

**MATERIAL:** 150# Test Singlewall corrugated, 26# ECT, 'B' Flute; 33# Kraft outer and inner facings.

**CONSTRUCTION:** Carton construction must be in compliance with applicable portions of the Uniform Freight Classification, Rule No. 41.

**NOTE: For manually packaged cartons, the following machine capable carton construction specifications do not apply, only dimensional and material information. This does not preclude the use of machine capable cartons for manual packaging. A standard FOL style carton is recommended for manual operations.**

The machine capable cartons will be either die-cut or press run, pending carton dimensions. The following information applies for both manufacturing methods:

- Manufacturer's joint is to be glued. Edge of adjacent panel must be parallel with female bead on manufacturer joint score panel with uniform opening at top and bottom of manufacturer's joint.
- To reduce score line energy, all vertical scores must be pre-broken a minimum of 125° after joint is glued.

For Die-Cut Cartons:

- Deep inside male vertical and horizontal scores are required, with deep double female counterscores outside. Female bead must be visible and not less than 5/16" in width.
- Glue tab must be crushed. Glue tab score must have deep male inside score and deep double female counterscore outside.
- See Page 6 for die-cut carton layout.


For Press Run Cartons:

- Slots will be offset in the direction of each width panel. Edge of slot must line up with vertical scores. Slot offset will result in narrower width panel flaps. Slot past corrugator scores.
- Corrugator scores must be deep offset point to point that fold easily in both directions.
- Overlap flaps are dimensioned to result in 1/8" distance between inside flaps, if possible.
- See Page 6 for press run carton layout.

Carton construction and dimension tolerances must be suitable for packaging on Superior semi-automatic equipment. Any manufacturing defect which causes difficulty in machine setup or closure shall result in rejection of the cartons.

**NOTE: Sample production run on Superior semi-automatic equipment is required by the Ford Customer Service Division Packaging Specifications Section prior to final sourcing of the cartons.**

FORD MOTOR COMPANY, PACKAGING ENGINEERING, FORD CUSTOMER SERVICE DIVISION, P.O. BOX 3000, LIVONIA, MICHIGAN 48151

Designed RDD	Approved D. C. Moyer 	Date 12-15-83	Revised 7-20-01
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**PRINTING:**

- 1/2" minimum printing is to be used for the carton detail number (outer flap of Panel #4), the words "Top Front" (outer flap of Panel #1), and the run number and date of manufacture (outer flap of Panel #3).
- See page 7 for the carton printing layout.

**Note:** Ford and Motorcraft brand graphics are not printed on these (plain) cartons. Part branding is achieved by affixing an appropriately sized part nomenclature brand label from the F-MFLSER Material Specification. Refer to the FCSD Packaging & Shipping Guide, Section 12 and Exhibit K, for labeling instructions.

**SHIPPING INSTRUCTIONS:**

The cartons are to be packed loosely in corrugated shipping tubes. If shipments are palletized, a 42" x 48" four-way entry wood pallet is required, with the overall pallet height not to exceed 42". All shipments are to be stretch wrapped, if applicable. Banding or strapping of a load is prohibited. All tubes or pallets are to be identified with the appropriate carton number. Mixed loads are prohibited.

**SPECIAL INSTRUCTIONS:** Packaging Engineering Information Only

- 1) Parts assigned to these cartons should not exceed 10 pounds in weight due to the overall carton strength. (This maximum concurs with the 10 pound weight limitation for bin zone parts).
- 2) Material numbers (F1000B series) have been assigned to the bundles for 4 unit cartons. The base number of the F1000B bundle detail corresponds to the appropriate F1000 unit carton. The F1000B material numbers have been incorporated into the Standard Material Report with pallet, pallet quantity and pattern included.
- 3) The Standard Material Report has been revised to show an FOL style code for all F1000 cartons. This change was made to accommodate the FOL style recommendation for all manually packaged cartons. The material specification will continue to reflect a partial overlap style versus full overlap for those cartons requiring this style for machine capability.
- 4) Unit carton detail numbers that qualify for bulk warehouse zones due to overall outside dimensions exceeding 25" per present Industrial Engineering standards will be highlighted with a pound "#" sign.
- 5) The Standard Material Report has been revised to show "Special Construction" rather than FOL style for the OSC cartons in this program. This was done to eliminate confusion when packagers order cartons for machine operation. (See item 4.)
- 6) Date of manufacture, factory run number and "top front" optional for manual packaging operations.

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D. C. Moyer



Date

12-15-83

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7-20-01

**CARTON SPECIFICS**

Detail Number	Dimensions			Style	Flap Lengths		Recommended Manufacture Method	Corr Direction	42" x 48" Pallet					
	(L)	(W)	(D)		Outer	Inner			Quantity	Pattern				
1001	4 1/8	x	1 7/8	x	4 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	***			
1002	4 1/8	x	1 7/8	x	5 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	***			
1003	4 1/8	x	1 7/8	x	7 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	864	54	x	16
1004	4 1/8	x	1 7/8	x	9 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	640	40	x	16
1005	4 1/8	x	1 7/8	x	11 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	576	36	x	16
1006	4 1/8	x	1 7/8	x	13 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	480	30	x	16
1007	4 1/8	x	1 7/8	x	15 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	432	27	x	16
1008	4 1/8	x	2 5/8	x	4 1/4	FOL	2 5/8	2	Die-Cut	Reverse	***			
1009	4 1/8	x	2 5/8	x	5 1/4	FOL	2 5/8	2	Die-Cut	Reverse	***			
1010	4 1/8	x	2 5/8	x	7 1/4	FOL	2 5/8	2	Die-Cut	Reverse	648	54	x	12
1011	4 1/8	x	2 5/8	x	9 1/4	FOL	2 5/8	2	Die-Cut	Reverse	480	40	x	12
1012	4 1/8	x	2 5/8	x	11 1/4	FOL	2 5/8	2	Die-Cut	Reverse	432	36	x	12
1013	4 1/8	x	2 5/8	x	13 1/4	FOL	2 5/8	2	Die-Cut	Reverse	360	30	x	12
1014	4 1/8	x	2 5/8	x	15 1/4	FOL	2 5/8	2	Die-Cut	Reverse	324	27	x	12
1015	4 1/8	x	4 1/8	x	4 1/4	FOL	4 1/8	2	Die-Cut	Reverse	648	81	x	8
1016	4 1/8	x	4 1/8	x	5 1/4	FOL	4 1/8	2	Die-Cut	Reverse	576	72	x	8
1017	4 1/8	x	4 1/8	x	7 1/4	FOL	4 1/8	2	Die-Cut	Reverse	432	54	x	8
1018	4 1/8	x	4 1/8	x	9 1/4	FOL	4 1/8	2	Die-Cut	Reverse	320	40	x	8
1019	4 1/8	x	4 1/8	x	11 1/4	FOL	4 1/8	2	Die-Cut	Reverse	288	36	x	8
1020	4 1/8	x	4 1/8	x	13 1/4	FOL	4 1/8	2	Die-Cut	Reverse	240	30	x	8
1021	4 1/8	x	4 1/8	x	15 1/4	FOL	4 1/8	2	Die-Cut	Reverse	216	27	x	8
1022	5 5/8	x	1 7/8	x	5 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	896	56	x	16
1023	5 5/8	x	1 7/8	x	7 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	672	42	x	16
1024	5 5/8	x	1 7/8	x	9 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	512	32	x	16
1025	5 5/8	x	1 7/8	x	11 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	448	28	x	16
1026	5 5/8	x	1 7/8	x	13 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	384	24	x	16
1027	5 5/8	x	1 7/8	x	15 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	336	21	x	16
1028	5 5/8	x	2 5/8	x	5 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	672	56	x	12
1029	5 5/8	x	2 5/8	x	7 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	504	42	x	12
1030	5 5/8	x	2 5/8	x	9 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	384	32	x	12
1031	5 5/8	x	2 5/8	x	11 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	336	28	x	12

\*\*\* See Footnote on Page 5

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# - Bulk Zone Carton

**CARTON SPECIFICS**

Detail Number	Dimensions			Style	Flap Lengths		Recommended Manufacture Method	Corr Direction	42" x 48" Pallet					
	(L)	(W)	(D)		Outer	Inner			Quantity	Pattern				
1032	5 5/8	x	2 5/8	x	13 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	288	24	x	12
1033	5 5/8	x	2 5/8	x	15 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	252	21	x	12
1034	5 5/8	x	4 1/8	x	5 1/4	FOL	4 1/8	2 3/4	Die-Cut	Reverse	448	56	x	8
1035	5 5/8	x	4 1/8	x	7 1/4	FOL	4 1/8	2 3/4	Die-Cut	Reverse	336	42	x	8
1036	5 5/8	x	4 1/8	x	9 1/4	FOL	4 1/8	2 3/4	Die-Cut	Reverse	256	32	x	8
1037	5 5/8	x	4 1/8	x	11 1/4	FOL	4 1/8	2 3/4	Die-Cut	Reverse	224	28	x	8
1038	5 5/8	x	4 1/8	x	13 1/4	FOL	4 1/8	2 3/4	Die-Cut	Reverse	192	24	x	8
# 1039	5 5/8	x	4 1/8	x	15 1/4	FOL	4 1/8	2 3/4	Die-Cut	Reverse	168	21	x	8
1040	7 1/2	x	4 1/8	x	5 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	320	40	x	8
1041	7 1/2	x	4 1/8	x	7 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	240	30	x	8
1042	7 1/2	x	4 1/8	x	9 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	192	24	x	8
1043	7 1/2	x	4 1/8	x	11 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	160	20	x	8
# 1044	7 1/2	x	4 1/8	x	13 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	144	18	x	8
# 1045	7 1/2	x	4 1/8	x	15 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	120	15	x	8
1046	7 1/2	x	5 5/8	x	5 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	240	40	x	6
1047	7 1/2	x	5 5/8	x	7 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	180	30	x	6
1048	7 1/2	x	5 5/8	x	9 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	144	24	x	6
# 1049	7 1/2	x	5 5/8	x	11 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	120	20	x	6
# 1050	7 1/2	x	5 5/8	x	13 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	108	18	x	6
# 1051	7 1/2	x	5 5/8	x	15 1/4	OSC	3 5/8	3 5/8	Press Run	Vertical	90	15	x	6
1052	8 5/8	x	1 7/8	x	7 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	400	25	x	16
1053	8 5/8	x	1 7/8	x	9 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	320	20	x	16
1054	8 5/8	x	1 7/8	x	11 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	256	16	x	16
1055	8 5/8	x	1 7/8	x	13 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	240	15	x	16
# 1056	8 5/8	x	1 7/8	x	15 1/4	FOL	1 7/8	1 7/8	Die-Cut	Reverse	192	12	x	16
1057	8 5/8	x	2 5/8	x	7 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	300	25	x	12
1058	8 5/8	x	2 5/8	x	9 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	240	20	x	12
1059	8 5/8	x	2 5/8	x	11 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	192	16	x	12
# 1060	8 5/8	x	2 5/8	x	13 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	180	15	x	12
# 1061	8 5/8	x	2 5/8	x	15 1/4	FOL	2 5/8	2 5/8	Die-Cut	Reverse	144	12	x	12
1062	8 5/8	x	4 1/8	x	7 1/4	FOL	4 1/8	4 1/8	Press Run	Vertical	200	25	x	8

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**CARTON SPECIFICS**


# - Bulk Zone Carton

Detail Number	Dimensions			Style	Flap Lengths		Recommended Manufacture Method	Corr Direction	Quantity	42" x 48" Pallet Patter		
	(L)	(W)	(D)		Outer	Inner				x	x	x
1063	8 5/8	x 4 1/8	x 9 1/4	FOL	4 1/8	4 1/8	Press Run	Vertical	160	20	x	8
# 1064	8 5/8	x 4 1/8	x 11 1/4	FOL	4 1/8	4 1/8	Press Run	Vertical	128	16	x	8
# 1065	8 5/8	x 4 1/8	x 13 1/4	FOL	4 1/8	4 1/8	Press Run	Vertical	120	15	x	8
# 1066	8 5/8	x 4 1/8	x 15 1/4	FOL	4 1/8	4 1/8	Press Run	Vertical	96	12	x	8
1067	8 5/8	x 7 1/2	x 7 1/4	OSC	4 1/2	4 1/2	Press Run	Vertical	96	24	x	4
# 1068	8 5/8	x 7 1/2	x 9 1/4	OSC	4 1/2	4 1/2	Press Run	Vertical	80	20	x	4
# 1069	8 5/8	x 7 1/2	x 11 1/4	OSC	4 1/2	4 1/2	Press Run	Vertical	64	16	x	4
# 1070	8 5/8	x 7 1/2	x 13 1/4	OSC	4 1/2	4 1/2	Press Run	Vertical	60	15	x	4
# 1071	8 5/8	x 7 1/2	x 15 1/4	OSC	4 1/2	4 1/2	Press Run	Vertical	48	12	x	4

\*\*\* - Bundle Required

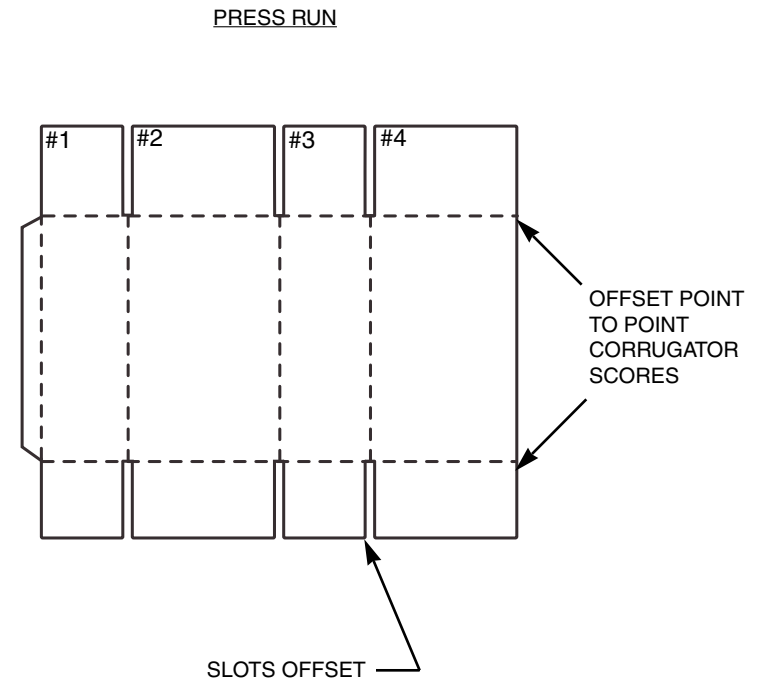
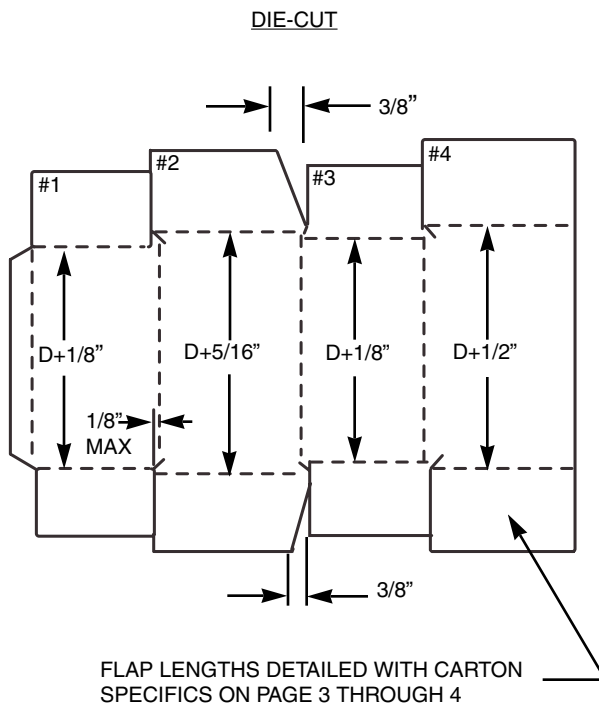
F1001 - 5 pcs.	(1 x 5)	1200	80 x 3
F1002 - 5 pcs.	(1 x 5)	1050	70 x 3
F1008 - 4 pcs.	(1 x 4)	960	80 x 3
F1009 - 4 pcs.	(1 x 4)	840	70 x 3

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CARTON LAYOUT

INSIDE VIEW



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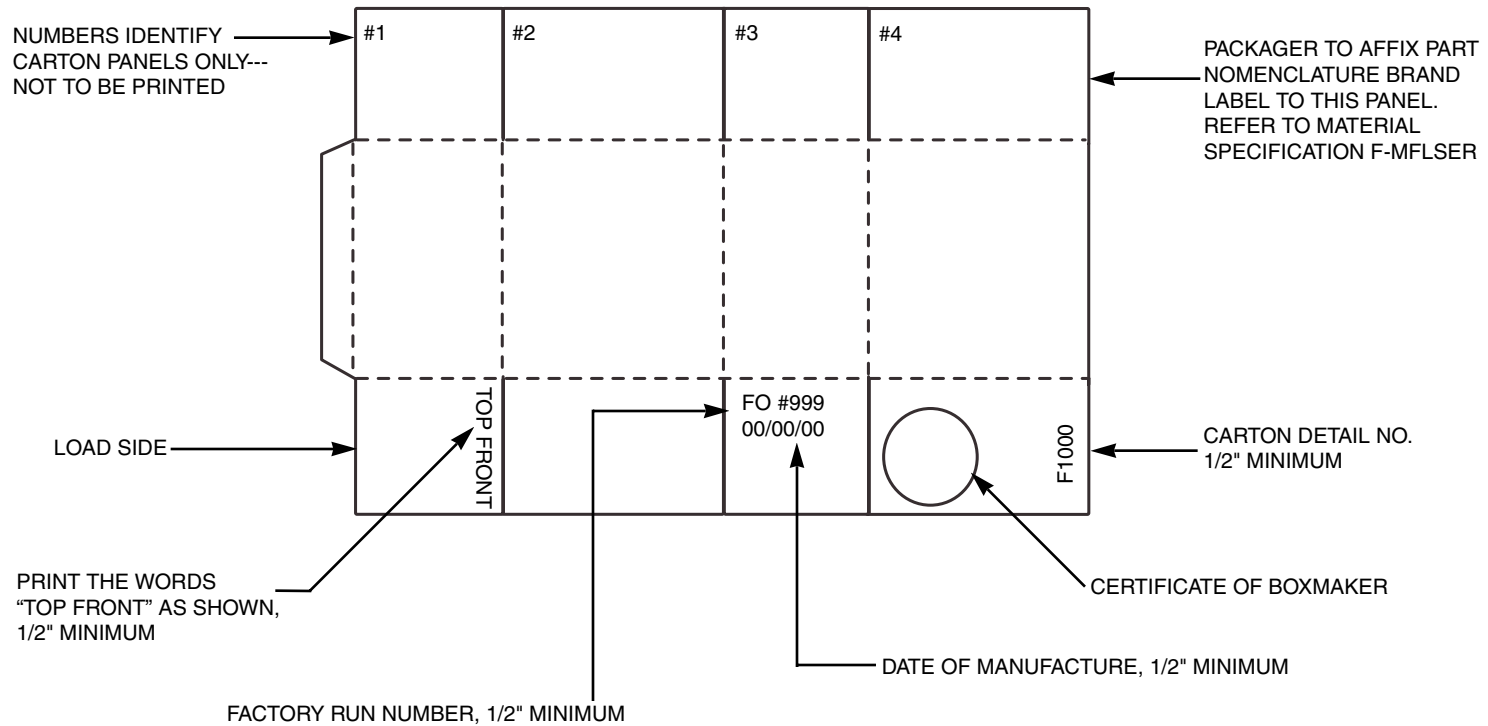
Date

12-15-83

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7-20-01

1/ PRINTING LAYOUT  
OUTSIDE VIEW




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- Revised 7-20-01: Changed title from F1000/FM1000 Series to F1000. Added part nomenclature label note on page 7. Deleted page 8 label illustrations. Added label requirement note to "printing" section on page 2. (DVB)
- Revised 2-28-01: Delete graphic requirements, revised outer and inner flap lengths F1067-F1071, added page 8 (JWS)
- Revised 12-1-97: Delete bundle requirements except F and FM 1001, 1002, 1008, and 1009. Reformat specification. Remove old pages 4, 5 and 6 (JWS)
- Revised 6-16-95: Legal Phrases II and III interchangeable on Panels 2 and 4 and replaced baskets with corrugated shipping tubes in the shipping instructions (DMD)
- Revised 8-15-94: Pallet quantity for F and FM 1001, 1002, 1003, 1004, 1006, 1008, 1009, 1011, 1013 (JWS)
- Revised 1-22-90: Deleted Legal Phrase I on page 11. Should be Legal Phrase II. Added Item 8 Special Instructions
- Revised 3-20-88: Pallet quantity for F1001-07; 1022-27; 1052-56; to 35" height. Delete Bundle 1062-63
- Revised 2-10-86: Added item 7 special instruction
- Revised 8-1-84: Special instruction added
- Revised 2-1-84: Major panel graphics revised for details 1022, 1028, 1034, 1040-1, 1046-7, 1052, 1057, 1062, 1067

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