




GENERAL INSTRUCTIONS APPLICABLE TO FORD POLY BAGS

A. Instructions to the Poly Bag or Film Purchaser and manufacturer:

1. The poly bags or film structure is multi-layer construction (LDPE) or single layer (LLDPE/LDPE) blend.
2. Unless otherwise stated, all mil thickness specified will be nominal thickness. A tolerance of plus 10% and minus 0 per mil thickness specified is acceptable. Any variance from this tolerance is subject to return to the manufacturer freight collect for full credit.
3. The poly bag or film must be anti-static and CORONA TREATED on printed side only.
4. Unless specified, the bags will be easy open (anti-static) tube style on rolls with a minimum 1/8" bar seal.
5. Poly bag or film must have exterior mat or non-glare finish and a low level no-slip additive.
6. The bag detail number with revision date, manufacturer or supplier code and recycled symbol are to be printed in blue ink on the left edge of each bag in a repeat pattern with font size and spacing sufficient to permit at least one complete imprint of all the data elements on each bag, and with a minimum of 10" between imprints. See illustration on page 5.
7. The length dimension for bags specified will not exceed a tolerance of plus or minus 1/2".
8. The width dimension for bags specified will not exceed a tolerance of plus or minus 1/2".
9. Poly film must perform satisfactorily on the machines for use intended and a representative must become familiar with this machinery.
10. Poly bags may be manufactured side or bottom seal for manufacturing efficiency.
12. To facilitate expedited packaging and shipment, FCSD packagers are authorized to cut down longer bags in order to meet requirements of present specification. For example, PB1DC (20" x 30") could be cut down to PB1DB (20" x 20"). It will be acceptable that the material number on the modified bag will not match the material number on the specification.
13. Periodic quality checks will be performed by FCSD Packaging Engineering department to assure conformance of the poly bag to this material specification. Noncompliant material which cannot be resolved to FCSD satisfaction will be returned freight collect for full credit.
14. Cut rolls of material to be shipped in corrugated cartons or stretch wrapped to pallet.
15. Shipping carton and pallets must be clearly marked with detail number and quantity.
16. Poly bags must have minimum 1/8" bar heat seal closure.
17. Poly bags should have a 3/8" diameter vent hole approximately 2" up and 2" in from the lower right hand corner.
18. Poly bags are not to contain BHT.

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Designed RGM	Approved T. A. Kasper 	Date 6-24-81	Revised 3-30-17
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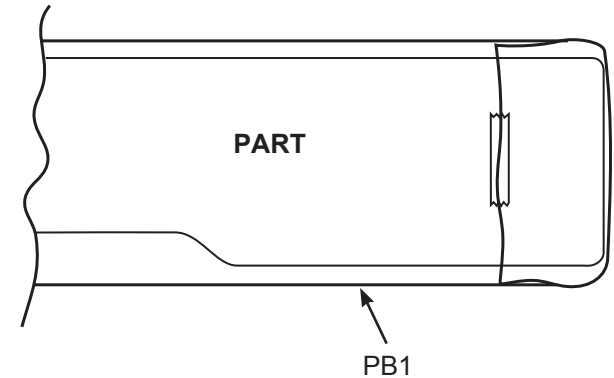
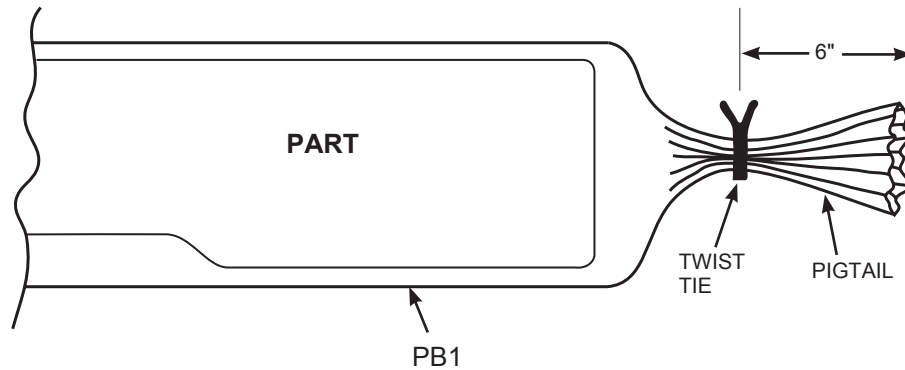
B. Unit Container Closure Instructions:

Poly bag must be closed by heat sealing, twist tie or tape. Heat sealing is the preferred method. Twist tie and tape closure must only be used if the part configuration requires it and prevents the part from falling out of the bag during normal handling.

Twist Tie and Tape Closure Illustrations:

1. Apply twist tie as close to part as possible without causing distortion to part, then cut pigtail no longer than six (6") from twist tie.

2. Apply 6" length of 2" or 3" wide clear poly tape to seal either open end.



C. Part Number Identification:

See page 5.

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D. Low Density or Linear Low Density Polyethylene Poly Bag or Film and Must Display the Following Characteristics:

<u>Characteristics</u>	<u>ASTM Test Number</u>	<u>Units</u>	<u>Value</u>
Impact — Dart	(Method A) D1709-67	Gram	328 or greater
Tensile Strength	D882-6T	PSI	
— Machine Direction (MD)			1,800 or greater
— Transverse Direction (TD)			1,500 or greater
Elongation	D882-67	%	
— Machine Direction (MD)			520 or greater
— Transverse Direction (TD)			600 or greater
Elmendorf Tear Strength	D1922	Gram	
— Machine Direction (MD)			500 or greater
— Transverse Direction (TD)			700 or greater
Dyne or Treat Level	PAL5505		40 or greater
Seal Strength	D882	PSI	60% of MD Tensile Strength or greater Minimum 1,080 PSI or greater

E. Approved Single Source Supplier: Advance Packaging Technologies
5720 Williams Lake Road
Waterford, MI 48329
Contact: Kathryn Fortineas, Customer Service
Phone: (800) 475-2247
Phone: (248) 674-3126
Fax: (248) 674-2630
E-mail: Kathryn@advancepac.com

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BAGS

Optics: Industrial Grade Clear low density or linear low density polyethylene with at least 25% post consumer recycled content, and mat or non-glare finish (low haze).

Detail Number	Size	Quantity Per Roll	Thickness
PB1AA	12-1/2" x 13-1/2"	500	Full 2.0 mil ventilated
AB	12-1/2" x 15"	450	Full 2.0 mil ventilated
AC	12-1/2" x 20"	350	Full 2.0 mil ventilated
AD	12-1/2" x 25"	275	Full 2.0 mil ventilated
AE	12-1/2" x 30"	225	Full 2.0 mil ventilated
AF	12-1/2" x 40"	175	Full 2.0 mil ventilated
AG	12-1/2" x 50"	125	Full 2.0 mil ventilated
AH	12-1/2" x 60"	100	Full 2.0 mil ventilated
AJ	12-1/2" x 80"	100	Full 2.0 mil ventilated
AK	12-1/2" x 158"	75	Full 2.0 mil ventilated
 			
PB1BA	15" x 15"	450	Full 2.0 mil ventilated
BB	15" x 20"	350	Full 2.0 mil ventilated
BC	15" x 25"	275	Full 2.0 mil ventilated
BD	15" x 30"	225	Full 2.0 mil ventilated
BE	15" x 40"	175	Full 2.0 mil ventilated
BF	15" x 50"	125	Full 2.0 mil ventilated
 			
PB1DA	20" x 20"	350	Full 2.25 mil ventilated
DB	20" x 25"	275	Full 2.25 mil ventilated
DC	20" x 30"	225	Full 2.25 mil ventilated
DD	20" x 40"	175	Full 2.25 mil ventilated
DE	20" x 50"	125	Full 2.25 mil ventilated
DF	20" x 60"	100	Full 2.25 mil ventilated
DG	20" x 90"	75	Full 2.0 mil ventilated
DH	20" x 140"	75	Full 2.25 mil ventilated
DJ	20" x 140"	200	Full 2.25 mil ventilated

Detail Number	Size	Quantity Per Roll	Thickness	Gussett
PB1EA	25" x 25"	275	Full 2.25 mil ventilated	
EB	25" x 30"	225	Full 2.25 mil ventilated	
EC	25" x 40"	175	Full 2.25 mil ventilated	
ED	25" x 50"	125	Full 2.25 mil ventilated	
EE	25" x 60"	100	Full 2.25 mil ventilated	
EF	25" x 140"	50	Full 2.25 mil ventilated	
EG	25" x 115"	60	Full 2.25 mil ventilated	
 				
PB1FA	30" x 30"	225	Full 2.25 mil ventilated	
FB	30" x 40"	175	Full 2.25 mil ventilated	
FC	30" x 50"	125	Full 2.25 mil ventilated	
FD	30" x 60"	100	Full 2.25 mil ventilated	
FE	30" x 75"	75	Full 2.25 mil ventilated	
 				
PB1GA	40" x 50"	125	Full 2.25 mil ventilated	
GB	40" x 60"	100	Full 2.25 mil ventilated	
GC	40" x 75"	75	Full 2.25 mil ventilated	
 				
PB1HA	55" x 75"	75	Full 2.25 mil ventilated	40" x 15"x 75"
HB	55" x 110"	50	Full 2.25 mil ventilated	40" x 15" x 110"
 				
PB1JA	8" x 20"	350	Full 2.0 mil ventilated	
JB	8" x 25"	275	Full 2.0 mil ventilated	
JC	8" x 30"	225	Full 2.0 mil ventilated	
 				
PB1KA	20" x 177"	50	Full 2.0 mil ventilated	
 				
BLN0001	20" x 200"	35	Full 2.25 mil ventilated	

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Approved Alternative: 2.6 (+10%) plain poly tube material numbers PTUBE05 (5" width), PTUBE12 (12" width) and PTUBE15 (15" width) are all approved alternative unit containers. Individual packaging specifications that specify a PB1 bag will not be changed to reflect this alternative container. These poly tube containers must be heat sealed on both ends. Unit container labeling requirements for the PTUBE poly tubes are the same as the PB1 bag.

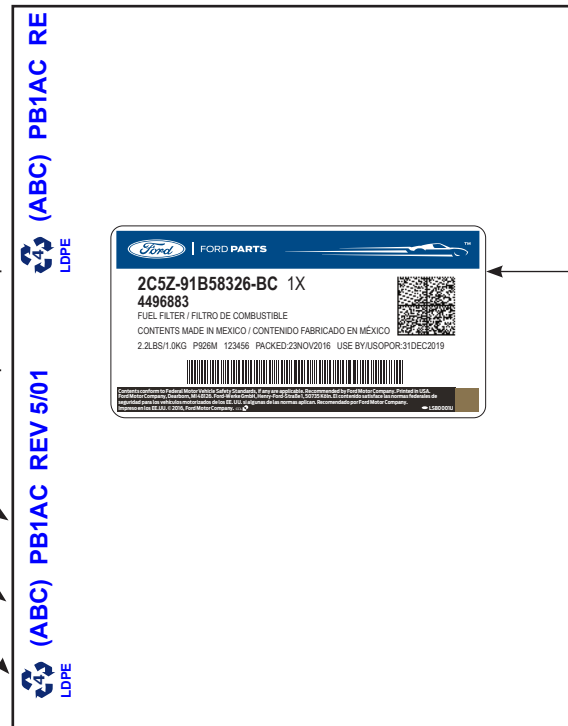
Phase Out Bags		
Detail Number	Size	Quantity Per Roll
PB1AA	18" x 19"	350

Print data elements on the left edge in a repeat pattern with a font size and spacing sufficient to permit at least one complete imprint on each bag, and with a minimum of 10" between imprints on the longer bags.



Detail Number
Manufacturer Code
Recycled Symbol

PB Bag Printing and Part Nomenclature Label Illustration



LSB0001U part nomenclature label centered on outside of the printed side of bag. Motorcraft branded parts must use LSB0001V. Refer to PRINT (NEW). Go to website <http://web.pkginfo.ford.com>

NOTE: It is unacceptable to imprint the part nomenclature on PB Series bags because they are plain. The LSB0001U Ford label (or LSB0001V Motorcraft label if part is Motorcraft branded) label (refer to F-MFLSER (NEW) Package Material Specification) is required on all PB Series bags to display the part nomenclature. Go to website <http://web.pkginfo.ford.com>


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- 3-30-17 Revised bag thicknesses. Update graphics on page 5. (OVB)
- 2-16-17 Added details AK, PB1KA and BLN0001 on page 4. (AJB)
- 6-5-13 Added alternate material options. (OVB)
- 3-20-13 Corrected mil descrepancy on page 4 from 3.0 to 2.6 mil and revised mil tolerance on page 1 to +10% - 0. (OVB)
- 7-25-07 Added note that poly bags are not to contain BHT. (GPL)
- 3-8-07 Removed 3-layer construction requirement and Post Consumer Recycled Content requirements. Revised performance characteristics, section D. (GPL/OVB)
- 11-27-06 Added ML1194 label as acceptable label. (KLD)
- 3-27-06 Revised section B; added section C; added note to page 5 illustration. (KLD)
- 12-6-01 Removed PB1CC closing requirements. (KLG)
- 9-10-01 Removed PB1CC detail. (DMD)
- 6-13-01 Moved location of data elements to left edge of bag in repeat pattern. (DVB)
- 10-17-00 Deleted graphics. Revised general instructions A3 and A8. Added illustration. (DVB)
- 4-24-98 Revised material, was 5 mil. Designated PB1CA a phase out bag. (DVB/JWS)
- 3-22-99 Added PB1CC unique characteristics. (DMD)
- 4-27-99 Added PB1CC closure method. (DMR)

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