

8 MAY 1944

SUN DRIED AND BLANCHED DEHYDRATED
PEACHES
PEACHES
APRICOTS
RAISINS

H. RETAIL REQUIREMENTS.

H-1. Quality of Packaging and Packing Materials. All paperboard, waxes, adhesives and other materials used for the packaging and packing of this product shall not impart any objectionable odor or flavor to the product after storage.

(Note: This H Section is applicable to all the dried fruits.)

F. METHODS OF INSPECTION, SAMPLING, AND TEST.

(Include all other data applicable to the specific commodity for which the specification is written. The following applies to packaging and packing only.)

(Note: This F Section is applicable to all dried fruits.)

F-1. Physical tests on packaging and packing materials shall be made in accordance with the methods of the American Society for Testing Materials (ASTM) and the Technical Association of the Pulp and Paper Industry (TAPPI).

F-2. The sizing of the board in paragraph G-1c shall be determined as follows: Weigh a 6-inch square section of the board and hold horizontally under 2 inches of tap water at $75 \pm 5^{\circ}$ F. for 10 minutes. Remove the board, quickly wipe off the excess water with a dry, soft, absorbent cloth, using a minimum of pressure, and reweigh the board at once. To be sufficiently sized, the board shall not absorb more than 4.0 (3.5) grams of water under these conditions.

F-3. The water-resistance of the adhesives used for the fabrication and closures of cartons described in G-1b and G-1c shall be determined as follows: Cut two sections approximately 3 inches by 6 inches from the board to be used for the container. Apply adhesive evenly over the inner surface of one of these sections. Superimpose the outer surface of the other section on the first, maintain under a pressure of 5 pounds per square inch for one minute and allow to dry for twenty-four hours. Trim the combined sections into a two inch square piece cut from the interior. Immerse the square piece in tap water for twenty-four hours. Carefully pry the joint apart from all four edges. To be water-resistant, not less than 75 percent of the surfaces shall show a fiber separation.

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E-4. The double wax-dipped arsenal type carton described in G-1c shall be tested for waterproofness by submerging a completed carton under a two-inch head of water at room temperature for twenty-four hours, then wiping dry, opening and observing the inside surface of the carton for the pressure of moisture. Not less than two completed cartons, selected at random from those produced during a twenty-four hour period, shall be tested by the above procedure. Test cartons selected shall not be produced during the same hourly period. In the event that the water barrier fails, one carton from each two-hour production period shall be tested as described above until twenty-four hours satisfactory production is obtained. The packer shall comply with this requirement by maintaining a record of tests performed as outlined above. each(?)

E-5. The test for the bursting strength of the board shall consist of six punctures using a Mullen or Gady Tester; three from side of the sheet made at least two inches from the edge, and only one puncture shall be permitted below the minimum of 130 pounds.

G. PACKAGING, LABELING, PACKING AND MARKING FOR SHIPMENT.

(Note: This G Section applies to Peaches, Prunes and Apricots)

2x12 = 24

G-1. Packaging. The blanched dehydrated or sun-dried fruit shall be packaged in a folding carton, twelve of the folding cartons shall then be placed in a master carton of the double wax-dipped arsenal type and two of these master cartons shall be packed in a nailed wood box. Alternatively, not less than four nor more than six pounds of the product shall be packaged in a special number ten open top metal can and eight cans shall be packed in a V2s shipping container with a sleeve.

G-1a. Domestic. Not applicable to this specification.

G-1b. Overseas. (Use the sentence below appropriate for the specification).

Unless otherwise specified, not less than twenty-six ounces nor more than two pounds of dehydrated blanched or sun-dried prunes shall be packaged -----

Unless otherwise specified, twenty-four ounces of dehydrated blanched or sun-dried peaches shall be packaged -----

Unless otherwise specified twenty-four ounces of dehydrated blanched or sun-dried apricots shall be packaged-----

in a carton of the seal-end style with full overlapping outer flaps, preferably with tear slots and an extended glue-strip, or in a carton having a secure lock bottom construction and a notched tuck or suitable locking closure for the top.

G-1b(1). The carton described in G-1b shall have center of score to center of score measurements of approximately four and one-half inches in length by two and one-half inches in width by six inches in depth. Twelve cartons arranged as shown in Fig. 1 shall completely fill the double wax-dipped arsenal type master carton described in G-1c. The openings of the arsenal carton shall be in planes A B C D and A' B' C' D'.

G-1b(2). The boxboard used for the carton described in G-1b shall have a thickness of not less than 0.020 inch, shall weigh not less than 66 pounds per thousand square feet and have a bursting strength of not less than 60 pounds per square inch. It shall be composed entirely of new pulp, fifty percent of which shall be unbleached sulphite or it shall be of a grade not lower than solid manila. The board shall have a sufficient bending characteristic to withstand folding through 180° in the direction for which it is creased without visible cracks or fractures on the outer surface.

G-1b(3). When so specified, not less than four nor more than six pounds of the product shall be packaged in a round open top style metal can No. 10 size (603 x 700) with soldered side seams and with end can end compound-lined and double-seamed to the can body by the manufacturer of the package. The can cover shall be made without end lining compound and shall be seamed to the can body with a seam constructed to provide venting for gas pressures developed inside the can. The gas developed within the package shall be vented at a pressure below that which would bulge the can ends.

G-1b(4). Cans shall be made throughout from .50 electrolytic tinplate coated inside with an enamel suitable for the product and overall outside including the soldered side seam, with an olive drab corrosion-resistant enamel complying with specification QQD No. 201.

G-2. Labeling.

G-2a. Domestic. Not applicable to this specification.

G-2b. Overseas. One main panel of the individual carton shall be either printed in one-color with black ink or clearly embossed with the following information in Capital letters.

G-2b(1).

NET WEIGHT LBS. or GRS. (Letters not less than 1/8")
(SUN-DRIED) (Peaches, prunes, apricots) ()
Whichver is () (Letters not less than 1/2")
appropriate, but (or
not both. (DEHYDRATED) (Peaches, prunes, apricots)
(Letters not less than 1/2")

PACKED BY (Letters not less than 1/8")
NAME OF PACKER (Letters not less than 1/8")
ADDRESS (City & State) (Letters not less than 1/8")

G-2c. The above label data shall be lithographed one print black on the can cover when the number ten can is used as the package.

G-2d. One end or side panel of the double wax-dipped aerosol type carton described in G-1c shall be printed, stamped or stenciled with black ink as follows:

DEHYDRATED

(Letters not less than 1/2")

or

SUN-DRIED

PRODUCT (Peaches, prunes, apricots or raisins).

(Letters not less than 1/2")

(NOTE: This Section G applies to Raisins only)

RAISINS

G. PACKAGING, LABELING, PACKING AND MARKING FOR SHIPMENT.

G-1. Packaging. The sun-dried fruit shall be packaged in a folding carton. Three of the folding cartons shall then be placed in a master carton of the double wax-dipped arsenal type and two of these master cartons shall be packed in a nailed wood box. Alternatively, not less than four nor more than six pounds of the product shall be packaged in a special number ten open top metal can and eight cans shall be packed in a V2s shipping container with a sleeve.

G-1a. Domestic. Not applicable to this specification.

G-1b. Overseas. Unless otherwise specified, seven pounds of sun-dried raisins shall be packaged in a carton of the seal-end style with full overlapping outer flaps, preferably with tear slots and an extended glue-strip, or in a carton having a secure top and bottom locking construction wherein the two outer flaps are fully overlapping, such as the tuck and tongue construction. The top closure must be rigid enough to supply a firm sealing platform for the top and bottom flaps of the double wax-dipped arsenal carton which contains three of the seven pound raisin cartons.

G-1b(1). The carton described in G-1b shall have center of score to center of score measurements of approximately $7\frac{5}{8}$ inches in length, $4\frac{1}{16}$ inches in width and $8\frac{13}{16}$ inches in depth. Three cartons arranged as shown in Fig II shall completely fill the double wax-dipped arsenal type master carton described in G-1c. The openings of the arsenal carton shall be in planes A B C D and A' B' C' D'.

G-1b(2). The boxboard used for the carton described in G-1b shall have a thickness of not less than 0.035 inch, shall weigh not less than 110 pounds per thousand square feet and have a bursting strength of not less than 90 pounds per square inch. It shall be composed entirely of new pulp, fifty percent of which shall be unbleached sulphite, or it shall be of a grade not lower than solid manila. The board shall have a sufficient bending characteristic to withstand folding through 180° in the direction for which it is creased without visible cracks or fractures on the outer surface.

G-1b(3). When so specified, not less than four nor more than six pounds of the product shall be packaged in a round open top style metal can No. 10 size (603 x 700) with soldered side seams and with one can end compound-lined and double-seamed to the can body by the manufacturer of the package. The can cover shall be made ~~without~~ end lining compound and shall be seamed to the can body with a seam constructed to provide venting for gas pressures developed inside the can. The gas developed within the package shall be vented at a pressure below that which would bulge the can ends.

6-1b(4). Cans shall be made throughout from .50 electrolytic tinplate coated inside with an enamel suitable for the product and overall outside, including the soldered side seam, with an olive drab corrosion resistant enamel complying with specification QQD No. 301.

6-2. Labeling.

6-2a. Domestic. Not applicable to this specification.

6-2b. Overseas. One main panel of the individual carton shall be either printed in one-color with black ink or clearly embossed with the following information in capital letters. If embossed, the copy shall be centered in the panel so as to be readily identified.

6-2b(1).

| | |
|--------------------------|---|
| NET WEIGHT | 7 LBS. (Letters not less than 1/8") |
| SEMI-NESS | (Solid or outline letters not less than 1/2") |
| RAISINS | (Solid or outline letters not less than 1/2") |
| PACKED BY | (Letters not less than 1/8") |
| NAME OF PACKER | (Letters not less than 1/8") |
| ADDRESS (City and State) | (Letters not less than 1/8") |

6-2c. The above label data shall be lithographed one print black on the can cover when the number ten can is used as the package.

(NOTE: The following sections apply to dehydrated or sun-dried peaches, prunes, apricots and raisins)

G-1c. Double Wax-Dipped Arsenal Carton. The arsenal type carton shall be manufactured of double kraft lined bending board between 0.040 and 0.045 inch in thickness. The kraft liners shall have a thickness of not less than 0.006 inch and the filler shall be of a furnish which will insure the finished board conforming with all requirements.

G-1c(1). The carton shall be of special slotted construction with all flaps meeting, as shown in Fig. II. Center of score to center of score dimensions shall be approximately $12\text{-}5/8$ inches in length, $7\text{-}13/16$ inches in width and 9 inches in depth. It shall contain the cartons as described in G-1b(1) so that the individual units are packed snugly and the arsenal carton is completely filled. No overlapping of the inner or outer flaps shall be permissible, nor shall they gap more than $1/16$ " when the flaps are glued into position to form the closure. Each side of the outer flaps shall be tapered inward at an angle of 7° from a point about $5/8$ inch from the hinge, and about $1/4$ inch from the side of the box. The corner portions of the outer flaps shall be offset $1/32$ inch from the center of the vertical score lines so as not to project over the edges of the closed carton. This will automatically increase the width of the inner flap by $1/16$ inch. The flaps shall be cut to $1/8$ inch plus or minus $1/32$ inch from the horizontal scores, except at the hinges all corners (including those situated $5/8$ inch from the hinges) of the shaped flaps shall be rounded with a $1/4$ inch to $5/16$ inch radius.

G-1c(2). The board shall be sized throughout to meet the requirements of F-1.

G-1c(3). The average bursting strength of the board shall be not less than 150 pounds. (See F-5).

G-1c(4). The direction of the grain of the boxboard shall be in the direction of the long dimension of the carton blank or around the finished carton at its maximum girth.

G-1c(5). The average tensile strength of the board (TAPPI T-404 m-41) shall be not less than 140 pounds per inch of width in the machine direction nor less than 55 pounds per inch of width cross direction.

G-1c(6). The board shall have a sufficient bending characteristic to withstand folding through 180° in the direction for which it is creased without visible cracks or fractures on the outer surface.

G-1c(7). The board shall permit penetration of the wax specified in G-1f. to a depth of not less than 35% of the thickness of the board when one side is held in contact with the wax, heated to $195^\circ \pm 5^\circ \text{ F}$ for 10 seconds.

G-1d. The glue flap of the manufacturer's joint shall be on the outside of the adjacent side panel of the carton and integral with one end of the carton. The outer corners of the glue flap shall be rounded with a 1/4 inch radius.

G-1d(1). The glue flap shall be tightly and adequately glued to the adjacent side wall of the carton over its entire area of contact with a water-resistant adhesive meeting the requirements of F-3, with no excess glue on the outside of the carton.

G-1d(2). When the carton blank is folded and glued both horizontal and vertical score lines shall register within $\pm 1/16$ inch.

G-1e. The sealed carton shall be completely submerged in the wax described in G-1f, to obtain impregnation. After a cooling period, the carton shall be dipped a second time (completely submerged) in a bath of the same wax. The first dip shall cause the wax to impregnate the board to an average depth of approximately 35 percent of the thickness of the board, and the second dip shall build up a continuous film of wax on the outside of the board approximately 0.005 inch thick. The conditions of impregnation and coating shall be such that completely sealed carton shall meet the requirements of G-1.

G-1f. The wax for processing the carton as described in G-1e shall be of a micro-crystalline type or may be a mixture of waxes, with or without a crystalline inhibitor, which shall produce as a final product, an amorphous type of wax having the following characteristics:

The melting point (ASTM D 127-30) shall be not less than 140° F.

The wax shall not crack, chip or become separated from the surface to which it is applied when subjected to a temperature of -30°F for a period of 48 hours.

The product shall be odorless, tasteless and nontoxic.

A list of approved waxes may be obtained from the California Quartermaster Depot, Oakland, California, from the Chicago Quartermaster Depot, Subsistence Research and Development Laboratory, Chicago, Illinois, or from the Office of The Quartermaster General, Research and Development Branch, Washington, D. C.

G-3. Packing.

G-3a. Domestic. Not applicable to this specification.

G-3b. Overseas. Two of the wax-dipped cartons described in G-1e shall be packed in a snug-fitting nailed wood box, preferably tongue and groove, complying with Federal Specification MIL-B-621, either Style 1 or Style 4 except as follows:

G-3b(1). Style 1 Nailed Wood Box. The top, bottom, and sides shall be not less than 11/32 inch, and the ends shall be not less than 3/4 inch thick. Six-penny cement-coated nails shall be used throughout. If the ends are not in one piece or Linderman jointed, they shall be fastened securely together with corrugated fasteners.

G-3b(2). Style 4 Nailed Wood Box. The top, bottom, and sides shall be not less than 11/32 inch thick and the ends and cleats shall be not less than 5/8 inch thick. All nails shall be six-penny and if not clinched, shall be cement-coated.

G-3b(3). Over its entire outer surface, the nailed wood box shall be stained a light brown color which shall not obliterate the marking. In addition, the box may be stained inside at the option of the supplier. A water-soluble stain complying with Ordnance Department U. S. Army Tentative Specification AXS-843 shall be used.

G-3b(4). The inside dimensions of this box shall be approximately 16-3/8 inches in length, 12-7/8 inches in width and 9-1/4 inches in depth.

G-3c. Strapping. The boxes for overseas shipment shall be tightly strapped with steel straps protected with a rust-resistant coating. Flat strapping is preferred but round strapping is acceptable. The minimum gauge or size of the straps shall be as specified in the following table: Strapping shall be applied immediately prior to shipment to minimize loosening of straps due to shrinkage of the wood.

G-3c(1).

ROUND STRAPS

| Gauge | Minimum Ultimate Tensile Strength Lbs. per Square Inch |
|-------|---|
| 15 | 100,000 |
| 16 | 140,000 |

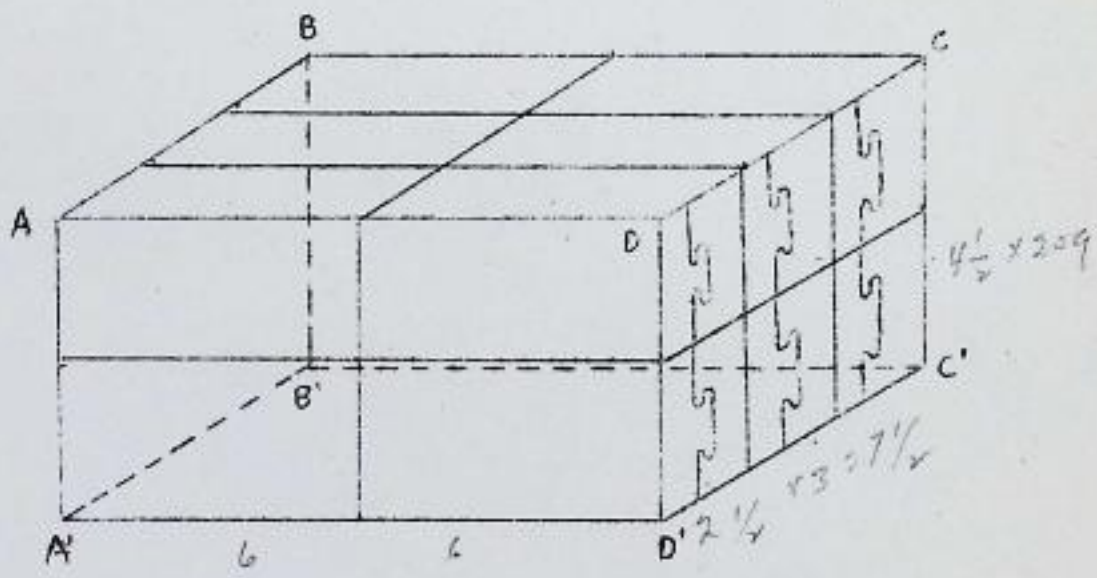
FLAT STRAPS

| Size | Minimum Ultimate Tensile Strength Lbs. per Square Inch |
|---------------|---|
| 3/8" x 0.015" | 80,000 |

Seals shall provide a joint strength of not less than 75 percent of the strap breaking strength.

G-3c(2). Style 1 Box - 3 Straps: Two straps shall be applied around the top, sides, and bottom with one strap located approximately 1/6 the length of the box from each end, and one strap shall be centered around the top, ends, and bottom, at right angles to the other two straps. The longest strap shall be applied first.

6-3c(3). Single A Box - 2 Straps: Two straps shall be applied around the top, sides and bottom with a strap located approximately $1/6$ the length of the box from each end.



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Fig. I

12 x 9 x 7 1/2

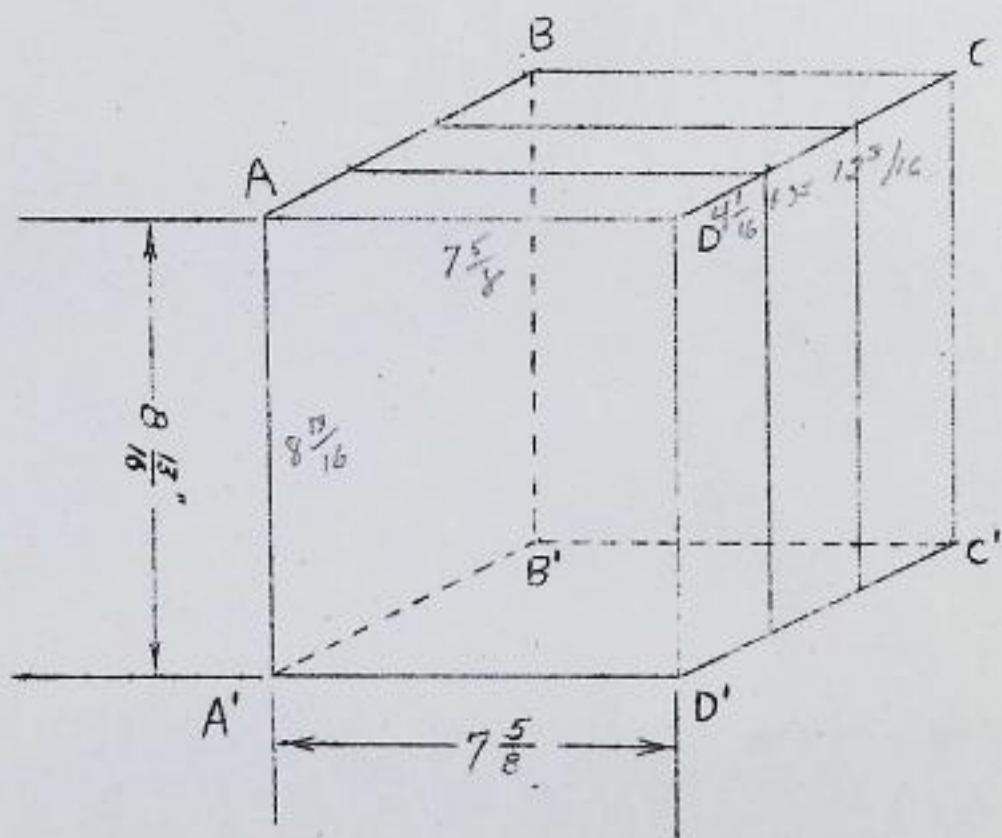


Fig. II

Detail of Double Wax Dipped Carton Construction.

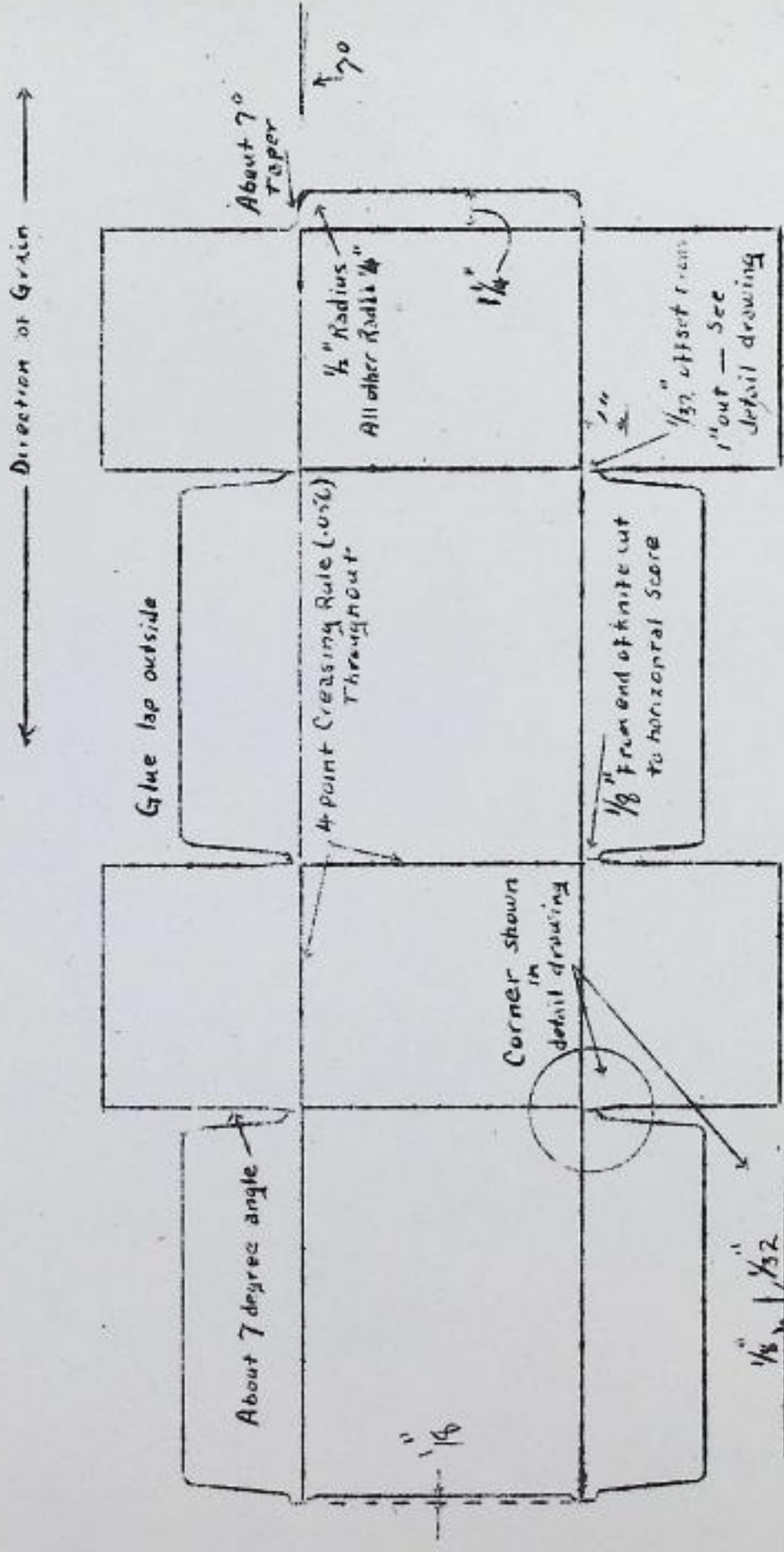


Fig. III