

INCH-POUND
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MIL-B-117G  
18 August 1993  
 SUPERSEDING  
 MIL-B-117F  
 30 June 1988

## MILITARY SPECIFICATION

### BAGS, SLEEVES AND TUBING

This specification is approved for use by all Departments and Agencies of the Department of Defense.

#### 1. SCOPE

1.1 Scope. This document covers heat sealable, packaging bags, sleeves, and tubing required by the Military Services for the protection of supplies during transportation and storage under all climatic conditions.

\* 1.2 Classification. Bags, sleeves, and tubing shall be of the following types, classes, and styles.

- |          |   |  |
|----------|---|--|
| Type I   | - | Heavy duty   |
| Type II  | - | Medium duty  |
| Type III | - | Light duty   |
| Class A  | - | Waterproof, electrostatic protective, static dissipative                               |
| Class B  | - | Waterproof   |
| Class C  | - | Waterproof, electrostatic protective, static dissipative                               |
| Class E  | - | Watervaporproof, greaseproof   |
| Class F  | - | Watervaporproof, electrostatic protective, electrostatic and electromagnetic shielding |
| Class G  | - | Watervaporproof, greaseproof, flame resistant  |
| Class H  | - | Waterproof, electrostatic protective, electrostatic shielding                          |

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be used in improving this document should be addressed to: U.S. Army Natick Research, Development and Engineering Center, Natick, MA 01760-5019, by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.
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AMSC N/A

FSC 8105

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- Style 1 - Opaque
- Style 2 - Transparent
- Style 3 - One side opaque, other side transparent

1.2.1 Sizes. Bags, sleeves, and tubing shall be of the size specified in the contract or purchase order (see 6.2).

## 2. APPLICABLE DOCUMENTS

### 2.1 Government documents.

\* 2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

## SPECIFICATIONS

### FEDERAL

- L-P-378 - Plastic Sheet and Strip, Thin Gauge, Polyolefin
- PPP-B-601 - Boxes, Wood, Cleated-Plywood
- PPP-B-621 - Boxes, Wood, Nailed and Lock-Corner
- PPP-B-636 - Boxes, Shipping, Fiberboard
- PPP-B-1055 - Barrier Material, Waterproofed, Flexible
- PPP-T-60 - Tape, Packaging Waterproof

### MILITARY

- MIL-P-116 - Preservation, Methods Of
- MIL-B-121 - Barrier Material, Greaseproofed, Waterproofed, Flexible
- MIL-B-131 - Barrier Materials, Watervaporproof, Greaseproof, Flexible, Heat-Sealable
- MIL-B-22191 - Barrier Material, Transparent, Flexible, Heat-Sealable
- MIL-B-81705 - Barrier Material, Flexible, Electrostatic-Free, Heat-Sealable

## STANDARDS

### MILITARY

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes
- MIL-STD-129 - Marking for Shipment and Storage

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MIL-STD-147 - Palletized Unit Loads  
 MIL-STD-731 - Quality of Wood Members for Containers and Pallets

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

## AMERICAN SOCIETY FOR TESTING AND MATERIALS

D 3951 - Standard Practice for Commercial Packaging

(Copies should be obtained from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents may also be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

## 3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample shall be subjected to first article inspection (see 6.3) in accordance with 4.3.

\* 3.2 Material. Materials shall conform to the types, grades, and classes specified in table I.

TABLE I. Classification of materials

MIL-B-117			Material requirements document			
Type	Class	Style	Document	Type	Grade	Class
I	A	2	MIL-B-81705	II	-	1 or 2
I	B	1	MIL-B-121	I	A	1
II	B	1	MIL-B-121	II	A	1

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TABLE I. Classification of materials (cont'd)

MIL-B-117			Material requirements document			
Type	Class	Style	Document	Type	Grade	Class
III	B	1	MIL-B-121	II	A	1
I	B	2	MIL-B-22191 L-P-378 <u>1/</u>	III I or II	- A	- 1 <u>2/</u>
I	B	3	MIL-B-121 MIL-B-22191	I III	A -	1 -
I	C	1	MIL-B-121	I	A	1
II	C	1	MIL-B-121	II	A	1
I	C	2	MIL-B-22191	II	-	-
I	C	3	MIL-B-121 MIL-B-22191	I II	A -	1 -
I	E	1	MIL-B-131	I	-	1
I	E	2	MIL-B-22191	I	-	-
II	E	1	MIL-B-131	I	-	3
III	E	1	MIL-B-131	I	-	2
I	E	3	MIL-B-131 MIL-B-22191	I I	- -	1 -
II	E	3	MIL-B-131 MIL-B-22191	I I	- -	3 -
I	F	1 or 2	MIL-B-81705	I	-	1 or 2
I	G	1	MIL-B-131	II	-	-
I	H	1 or 2	MIL-B-81705	III	-	1 or 2

1/ Unless otherwise specified (see 6.2), nominal thickness shall be 0.004 inch (see 6.1.8).

2/ Finish shall be No. 2 (treated).

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3.3 Construction.

\* 3.3.1 Bags. Class A, B, C, E, and G bags may be formed using two sheets or by folding one sheet of material. Class F and H bags shall be formed from one sheet of material and heat sealed on two sides (fold shall not heat sealed). Heat sealable surfaces of the specified material shall be placed face to face, heat sealing along both sides and the bottom edge. Transparent bags fabricated by the side weld process shall be folded and have two side seams. The side seams shall be parallel to each other and to the outer edge of the bag. The bottom fold shall be at right angle to the side seam. When specified (see 6.2), bags 12 inches or less in length, with a mouth opening of 10 inches or less, shall be provided with a lip by extending one edge of the mouth 1/4 inch (+ 1/16 inch) beyond and parallel to the outer edge. The length of the lip shall not be included in the dimensions of the bag. Bags fabricated from sleeves or tubing shall have a bottom seam and do not require a lip.

\* 3.3.1.1 Notched bags. When specified (see 6.2), bags shall have a tear, nick, or V-notch, 1/8 inch deep (+ 1/16 inch) in at least one edge 1 inch to 1-1/4 inches from the open (unsealed) end of the bag. The legend "TEAR HERE TO OPEN" with an arrow pointing to the tear, nick, or V-notch shall be printed on the bag with lettering a minimum of 1/8 inch in height.

3.3.2 Sleeves or tubing. Sleeves fabricated from either transparent plastic sheet, opaque materials, or a combination of both shall be formed by bonding two continuous sheets or folding one continuous sheet, placing the heat sealable surfaces of the specified material together, and heat sealing a seam along the entire length of both edges. The side seams shall be parallel to each other and the outer edge of the sleeve. Tubing fabricated from transparent plastic sheet by the extruding process requires no seams.

\* 3.4 Dimensions and tolerances. The length and width of bags, sleeves, and tubing shall be specified in the contract or purchase order (see 6.2). The width shall be measured from the inside edges of the side seams. The length shall be measured from the inside edge of the bottom seam to the edge of the opening (exclusive of lip). The tolerances for the length and widths shall be as indicated in table II. The maximum heat seal widths shall be as indicated in table II.

TABLE II. Dimensions and tolerances

Area (one side)	Length and width tolerances (inches)	Maximum heat seal width (inches) <u>1/</u>
25 sq. in. or less	-1/16, +1/8	3/8
26 thru 200 sq. in.	-1/8, +1/4	1/2
201 thru 500 sq. in.	-1/4, +3/8	5/8
501 sq. in. or over	-1/4, +1/2	5/8

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1/ Seams fabricated by the dielectric, impulse, or ultra-sonic process shall have a minimum 1/32-inch heat seal. Seams fabricated from unsupported plastic sheet (i.e., polyethylene or polyolefin) shall be required to meet the seam strength test specified in 3.5 with no minimum seam width required.

3.5 Seam requirements. All classes of bags and sleeves shall be capable of passing the vacuum chamber or submersion leakage tests and the heat sealed seam test of MIL-P-116.

3.6 Identification.

\* 3.6.1 Bags, sleeves, and tubing. Each bag shall be marked or printed with an arrow pointing to the unsealed edge as an indication that the final closure is to be made at this edge. Sleeves shall be marked or printed in a manner to indicate the edges where final closures are to be made. In addition, each bag, sleeve, or roll of tubing shall be marked or printed in capital letters or numbers, approximately 10-point type, with the following information: bag document number and revision letter; type, class, and style; bag fabricator's name or trade mark; material designation; and month and year of fabrication. When the marking is interrupted or incomplete due to the size of the bags, the individual bag need not be marked as specified, but shall be accompanied within the shipping container by an identification sheet marked or printed with the following information: bag specification number and revision letter; type, class and style; bag fabricator's name or trade mark; material designation; and month and year of fabrication. For bags, sleeves, and tubing, the material designation shall consist of the barrier material manufacturer's code designation, as listed in the applicable Qualified Products Lists. The color and position of this printing shall be optional, except that it shall appear at least once on one surface only for bags and at least once every 12-inch length of sleeve or tubing material on one side only.

\* 3.6.1.1 Type I, class A, style 2 and type I, class H, style 2. Bags, sleeves, and tubing as specified in MIL-B-81705, type II and III, shall either be printed or have an identification sheet accompanying each unit package or roll of tubing or sleeve material. The identification sheet shall be marked or printed with the following information: bag document number and revision letter; type, class, and style; bag fabricator's name or trademark; material designation; month and year of fabrication. For bags, sleeves, and tubing, the material designation shall consist of the barrier material manufacturer's code identification, as listed in the applicable Qualified Products List. When specified (see 6.2), appropriate pressure sensitive labels may be applied to outer surfaces.

\* 3.6.2 Sealing recommendation. When specified (see 6.2), each unit package or individual roll of sleeve or tubing material (see 5.1.1.1 and 5.1.1.2) shall include a slip sheet with the following information legibly marked thereon:

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- a. Jaw type sealer (temperature, pressure, and dwell).
- b. Band type sealer (temperature, pressure, and dwell).
- c. Rotary type sealer (preheat, pressure, and speed).

3.7 Workmanship. Bags, sleeves, and tubing shall be uniformly constructed, free from pinholes, tears, cuts, splits, slits, creases, wrinkles, folds or other imperfections which might impair their usefulness. There shall be no blocking to the extent that will cause tearing of material or injury to the surface when opened.

#### 4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Responsibility for dimensional requirements. Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When dimensions cannot be examined on the end item, inspection shall be made at any point, or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.

4.1.3 Certificate of compliance. When certificates of compliance are submitted, the Government reserves the right to inspect such items to determine the validity of the certification.

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (see 4.4).

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4.3 First article inspection. When a first article is required (see 3.1 and 6.2), it shall be examined for the defects specified in table III for conformance to the dimensions in 3.3, and the sealed seams shall be tested as specified in 4.4.4. The presence of any defect or failure to pass any test shall be cause for rejection of the first article.

4.4 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.4.1 Component and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this specification or applicable purchase document.

4.4.1.1 Certification. The manufacturer shall submit a certificate of compliance that the materials used are as specified in table I.

\* 4.4.2 End item visual examination. The end items shall be examined for the defects listed in table III. The lot size shall be expressed in units of bags, sleeves, or tubing of one classification, as applicable. The sample unit shall be one bag, sleeve, or roll or tubing. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 4.0 for minor defects.

TABLE III. End item visual defects

Examine	Defect	Classification	
		Major	Minor
Material	Not as specified	101	
Construction	Class F and H not formed by folding one sheet of material	102	
	Heat sealing not as specified	103	
	Lip not provided, when applicable	104	
	Tear, nick, or V-notch not provided when specified	105	
Identification marking	Not as specified (see 3.6.1)		201
Workmanship	Not uniformly constructed		202
	Pinholes, tears, cuts, splits, creases, wrinkles, folds, or other imperfections that impair usefulness		203
	Blocking that causes tearing of material or injury to surface when opened		204

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4.4.3 End item dimensional examination. The end items shall be examined for the dimensions specified in table II. Any dimension not within the specified tolerance shall be classified as a defect. The lot size shall be expressed in units of bags, sleeves, or tubing of one classification, as applicable. The sample unit shall be one bag, sleeve, or roll of tubing, as applicable. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

4.4.4 End item testing. The seams of bags and sleeves shall be tested as specified in 4.5.1. The lot size shall be expressed in units of bags or sleeves of one classification, as applicable. The sample unit shall be one bag or sleeve, as applicable. The inspection level shall be S-4 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

4.4.5 Packaging examination. The end items shall be examined for the defects listed below. The sample unit shall be one shipping container, fully packaged. The lot size shall be the number of shipping containers in the inspection lot. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0.

<u>Examine</u>	<u>Defect</u>
Preservation	Preservation level not as specified (5.1) Not packed in units of multiples specified (5.1.1.1 or 5.1.1.2) Sleeve material not wound on substantial core (5.1.1.2) Unit packs not packed as specified (5.1.1.1 and 5.1.1.2) Mixed types, classes, styles, or sizes in same unit pack (5.1.1.1) Unit containers, when required, not snugly packed; contain fillers or waste space Packaging material not as specified; closures not accomplished by specified or required methods or materials (5.1.1.1 or 5.1.1.2)
Packing	Packing levels not as specified (5.2) Mixed types, classes, styles, or sizes packed in same container Container not as specified; closure not in accordance with the appendix to the applicable container document Tension too great (i.e., strapping tears or cuts through facing of containers)
Marking	Unit packs do not contain sealing recommendations (3.6.2) Unit and exterior container markings (as applicable) illegible, incorrect, incomplete, omitted, or not as specified (5.4)

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4.4.6 Palletization examination. The fully packaged and palletized end items shall be examined for the defects listed below. The lot size shall be expressed in units of palletized unit loads. The sample unit shall be one palletized unit load, fully packaged. The inspection level shall be S-1 and the AQL, expressed in terms of defects per hundred units, shall be 6.5.

<u>Examine</u>	<u>Defect</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirement
Palletization	Pallet pattern not as specified Load not bonded as specified
Weight	Exceeds maximum load limits
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application

4.5 Methods of inspection.

\* 4.5.1 Seam testing. Seams shall be tested in accordance with the seam test in MIL-P-116. When the material samples are of such size as to prohibit conducting the specified tests satisfactorily, the following procedures shall prevail. Cut a 6 by 8 inch section from the sample to be tested in such a manner that at least two of the fabricator's seals shall be included. Heat seal the remaining open unsealed edges in accordance with recommended procedures. The heat seal seam shall be uniform and continuous, of 3/8 inch width, and shall be free of pipes or channels. This procedure also applies to sleeves, in which case at least one of the fabricator's seals shall be included. An optional method for sleeves is by fabricating from the sleeve material a bag equal in length to the width of the sleeve. Sealed bags shall be tested in accordance with the vacuum chamber or submersion leakage tests of MIL-P-116.

## 5. PACKAGING

5.1 Preservation. Preservation shall be level A or Commercial, as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Bags. Bags of the same type, class, style, and size shall be unit packed by Method III of MIL-P-116, in increments of 50 not to exceed 500 (see 6.2) in a fiberboard box conforming to class WR of PPP-B-636. Unless otherwise specified (see 6.2), bags shall be packed flat. Bags of extra large size may be folded, provided dunnage material is placed at the line of folds to prevent damage. The sealing recommendations sheet (see 3.6.2) shall be inserted in each unit pack. Container closure shall be in accordance with the appendix of PPP-B-636.

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5.1.1.2 Sleeves and tubing. Unless otherwise specified (see 6.2), sleeve or tubing material shall be unit packed as specified in 5.1.1.1 or wound on a substantial core, with a minimum inside diameter of 3 inches, into rolls of the length and width specified (see 6.2) but not exceeding 200 yards in length. The rolls may be packed singly or the smaller rolls in multiples of two, on edge, in a fiberboard box conforming to class WR of PPP-B-636. Closure shall be in accordance with the appendix of PPP-B-636. Rolls of sleeve or tubing material exceeding 40 pounds shall be wrapped in paper, conforming to class C-1 of PPP-B-1055 and all seams and joints shall be sealed with pressure-sensitive tape conforming to type III of PPP-T-60. The sealing recommendation sheet (see 3.6.2) shall be inserted in each unit pack.

5.1.2 Commercial. Bags, sleeves, and tubing shall be preserved in accordance with ASTM D 3951.

5.2 Packing. Packing shall be level A, B, or Commercial, as specified (see 6.2).

5.2.1 Level A packing. Bags, sleeves, and tubing of one type, class, style and size, preserved as specified in 5.1, shall be packed in containers conforming to PPP-B-601, overseas type or PPP-B-621, class 2. Closure shall be in accordance with the appendix of the applicable container document.

5.2.2 Level B packing. Bags, sleeves, and tubing of one type, class, style and size, preserved as specified in 5.1, shall be packed in containers conforming to PPP-B-636, class WR or PPP-B-621, class 1. Closure shall be in accordance with the appendix of the applicable container document.

5.2.3 Commercial packing. Bags, sleeves, and tubing, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

\* 5.3 Palletization. Bags, sleeves, and tubing, packed as specified in 5.2, shall be palletized on a 4-way entry pallet in accordance with load type Ia of MIL-STD-147. Each prepared load shall be bonded with straps in accordance with bonding means C and D or film bonding means F or G. Pallet pattern shall be in accordance with the appendix of MIL-STD-147.

\* 5.4 Marking. In addition to any special marking required by the contract or purchase order (see 6.2), unit packs, shipping containers, and palletized unit loads shall be marked in accordance with MIL-STD-129 as follows:

Specification MIL-B-117  
(including latest revision and amendment)

Type, class, and style (as applicable)

Size

Month and year of fabrication

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## 6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. The bags, sleeves, and tubing are intended for use as containers to provide various degrees of protection to the contents. Transparent bags are intended for use where transparency is desired to facilitate visual inspection of the enclosed product. For the purpose of permitting the maintenance of stocks of bags for quick shipment, common stock sizes are listed in table IV.

TABLE IV. Common stock sizes

Size designation	Inside dimension (inches) (W X L)
1	2-1/2 by 3
2	2-1/2 by 6
3	3 by 5
4	4 by 6
5	4 by 8
6	4 by 12
7	6 by 6
8	6 by 8
9	8 by 12
10	10 by 10
11	10 by 13
12	10 by 12
13	12 by 12

\* 6.1.1 Class A and H bags and sleeves. Class A and H and sleeves are designed for critical items that require protection against the buildup or retention of electrostatic potential in addition to protection against water penetration and are equivalent to the protection offered by submethod IC-3 of MIL-P-116.

6.1.2 Class B bags and sleeves. Class B bags and sleeves are designed as unit packages for items requiring waterproof protection and are equivalent to the protection offered by submethod IC-3 of MIL-P-116.

6.1.3 Class C bags and sleeves. Class C bags and sleeves are designed as unit packages for items that require greaseproof protection in addition to waterproof protection and are equivalent to the protection offered by submethod IC-3 of MIL-P-116.

6.1.4 Class E bags and sleeves. Class E bags and sleeves are designed as unit packages for critical items that require general protection against water vapor penetration in addition to waterproof and greaseproof protection and are equivalent to the protection offered by submethods IA-8 and IIC of MIL-P-116.

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6.1.5 Class F bags and sleeves. Class F bags and sleeves are designed for critical items that require protection against the buildup or retention of electrostatic potential in addition to protection against water and water vapor and are equivalent to the protection offered by submethods IA-8 and IIC of MIL-P-116.

6.1.6 Class G bags and sleeves. Class G bags and sleeves are designed for critical items that require flame resistance in addition to protection against water, water vapor, and grease penetration and are equivalent to the protection offered by submethods IA-8 and IIC of MIL-P-116.

6.1.7 Size limitations. Size of bags is unrestricted with the following exceptions:

- a. Type III, class E, style 1-450 square inches; maximum product of inside width times inside depth.
- b. Type II, class C, style 1-50 square inches; maximum product of inside width times inside depth.

\* 6.1.8 Weight limitations. Net weight of contents shall not exceed 10 pounds when bag is used without additional packaging/packing. No weight restrictions are imposed if the filled bag is packed in a supporting container. There are no weight restrictions for the following bags:

<u>Type</u>	<u>Class</u>	<u>Style</u>
I	B	2 <u>1/</u>
I	C	2
I	E	1, 2, 3
I	F	1
I	G	1

1/ When using L-P-378, the following applies:

Nominal thickness (inches)	Weight limitation (pound)
0.004	up to 5
0.006	over 5

\* 6.2 Acquisition requirements. Acquisition documents must specify the following:

- a. Title, number, and date of this specification.
- b. Type, class, and style of bags, sleeves, or tubing, as applicable (see 1.2).
- c. Size of bags, sleeves, or tubing (inside dimensions) (see 1.2.1 and 3.4).

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- d. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- e. When a first article is required (see 3.1, 4.3 and 6.3).
- f. Nominal thickness of L-P-378, if different (see 3.2).
- g. Lip requirement, when required (see 3.3.1).
- h. Tear, nick, V-notch, when required (see 3.3.1.1).
- i. When pressure-sensitive labels may be applied (see 3.6.1.1).
- j. When sealing recommendations are required (see 3.6.2).
- k. Level of preservation and packing required (see 5.1 and 5.2).
- l. Quantity of bags, sleeves, and tubing per unit package (see 5.1.1.1 and 5.1.1.2).
- m. Preservation of bags, if different (see 5.1.1.1).
- n. Preservation of sleeves and tubing, if different (see 5.1.1.2).
- o. When palletization is required (see 5.3).
- p. Special marking, as applicable (see 5.4).

6.3 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of Federal Acquisition Regulation (FAR) 52.209-4. The first article should be a preproduction sample. The contracting officer should specify the appropriate type of first article and the number of units to be furnished. The contracting officer should also include specific instructions in all acquisition instruments regarding arrangements for selection, inspection, and approval of the first article.

\* 6.4 Subject term (key word) listing.

Barrier material  
Containers, protective  
Packaging  
Plastic  
Waterproof

6.5 Changes from previous issue. The margins of this document are marked with an asterisk (\*) to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only, and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content, as written, irrespective of the marginal notations and relationship to the last previous issue.

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Custodians:

Army - GL  
Navy - SA  
Air Force - 69

Preparing activity:

Army - GL  
(Project 8105-0357)

Review activities:

Army - AR, AT, MI, SM, EA, AV  
Navy - OS, SH, YD  
DLA - DH

User activity:

Navy - MC

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

**NOTE:** This form may not be used to request copies of documents, nor to request waivers, or clarification of requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

<b>I RECOMMEND A CHANGE:</b>	1. DOCUMENT NUMBER MIL-B-117G	2. DOCUMENT DATE (YYMMDD) 1993 August 18
3. DOCUMENT TITLE BAGS, SLEEVES AND TUBING		
4. NATURE OF CHANGE (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)		
5. REASON FOR RECOMMENDATION		
6. SUBMITTER		
a. NAME (Last, First, Middle Initial)	b. ORGANIZATION	
c. ADDRESS (Include Zip Code)	d. TELEPHONE (Include Area Code) (1) Commercial (2) AUTOVON (if applicable)	7. DATE SUBMITTED (YYMMDD)
8. PREPARING ACTIVITY		
a. NAME U.S. Army Natick RD&E Center	b. TELEPHONE (Include Area Code) (1) Commercial 508-651-4532	(2) AUTOVON/DSN 256-4532
c. ADDRESS (Include Zip Code) Commander, U.S. Army Natick RD&E Center ATTN: SATNC-IRS Natick, MA 01760-5019	IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT: Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	