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PRETORIA METAL PRESSINGS (PTY) LTD

SPECIFICATION FOR CARTONS AND INSERTS

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1. SCOPE

- 1.1 This specification establishes the requirements for the manufacture and acceptance of ammunition cartons and inserts.

2. APPLICABLE DOCUMENTS

- 2.1 SABS 0157: Part I - IV, 1987: Code of practice for Quality Management Systems.

3. REQUIREMENTS

3.1 Item definition

The cartons or inserts shall comply visually and dimensionally with the applicable drawings.

3.2 Product characteristics

3.2.1 Performance

3.2.1.1 Weight loss

The loss of weight of a carton or insert shall not exceed 9% when dried at 103 - 105°C for 2 hours. Testing shall be done in accordance with Lab method LM/0/12.

3.2.1.2 pH

The pH of a water extract shall range from 5,5 - 7,5. Testing shall be done in accordance with lab method LM/0/12.

3.2.1.3 Tarnishing

The carton or insert shall not tarnish the products packed therein. Testing shall be done in accordance with PMP lab method LM/0/12.

3.2.1.4 Sulphates

The water soluble sulphates, expressed as sodium sulphate shall not exceed 0,4%. Testing shall be done in accordance with LM/0/12.

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3.2.1.5 Chlorides

The water soluble chlorides, expressed as sodium chloride shall not exceed 0,08%. Testing shall be done in accordance with LM/0/12.

3.2.2 Physical characteristics3.2.2.1 Material

Pearlkote: Thickness 0,55mm ± 10%.

3.2.2.2 Colour and printing

In accordance with the applicable drawing.

3.2.2.3 Dimensions

In accordance with the applicable drawing.

3.3 Workmanship

The material must be free from surface, internal or any other defects that will be detrimental to the final product.

3.4 Qualification inspection and samples

Only applicable if specified on the contract or order.

4. QUALITY ASSURANCE PROVISIONS4.1 Responsibility for inspection

- 4.1.1 Unless otherwise specified in the contract or order, the supplier is responsible for the performance of all inspection requirements as specified herein.
- 4.1.2 Except as otherwise specified, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements.
- 4.1.3 The purchaser or his representative reserves the right of inspection of Laboratory Certificates of raw materials and components used for the manufacture of the cartons or inserts.

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4.1.4 The supplier shall be responsible for making available to the purchaser all facilities necessary if required, for inspection of the cartons or inserts.

4.1.5 The supplier will be responsible for the implementation of the applicable quality management systems according to SABS 0157 to assure the appropriate quality of the product. The purchaser reserves the right to audit the supplier's production facilities at all times to ascertain whether quality requirements are being met.

4.2 Quality conformance inspections

4.2.1 Lot information

A lot shall consist of one or more batches of cartons or inserts produced by one manufacturer in accordance with the same specifications under one continuous set of operating conditions. The supplier shall ensure that all deliveries to the end user are fully traceable by lot number and that identification records be supplied to the end user to match lot numbers with inspection records.

4.2.2 Examination of inspection sample

NO	DESCRIPTION OF DEFECT
1	Dimensions incorrect
2	Printing incorrect(where applicable)
3	Packaging incorrect
4	Material incorrect
5	Mixed lots
6	Excessive weight loss
7	pH incorrect
8	Tarnishing
9	Sulphates excessive
10	Chlorides excessive

Acceptance/Rejection

Any defect shall lead to rejection of the lot, subject to negotiations between the supplier and the acceptance authority.

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5. PREPARATION FOR DELIVERY5.1 Preservation and packaging

The products shall be supplied in sound, dry containers in quantities of 500.

5.2 Package marking

All containers to be legibly and durably marked with the following details on suitable labels:

- 5.2.1 Description as in the title of this specification.
- 5.2.2 Document and order number.
- 5.2.3 Tare and nett masses.
- 5.2.4 Contractor's initials or recognised trademark.
- 5.2.5 Additional markings called for in the contract or order.
- 5.2.6 Name of supplier.
- 5.2.7 Containers belonging to the same order must be numbered consecutively in a closed series.

5.3 Documentation for delivery

The following documents must be forwarded with each consignment of cartons or inserts.

- 5.3.1 The original specification which accompanied the order in the case of a single consignment or the final consignment of staggered deliveries.
- 5.3.2 A certificate of conformance/analysis stating all the results of the tests conducted by the supplier during manufacture and final acceptance.
- 5.3.3 The supplier's delivery note shall clearly state the relevant order and document number.

6. NOTES

- 6.1 If the supplier of the product is not the original manufacturer, the full name and address of the manufacturer must be supplied in writing prior to the despatch of the product.

6.2 Intended use

The products will be used for the storage and transport of small arms cartridges.

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AMENDMENT HISTORY SHEET

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