## CONTENTS III

PREFACE XI ACKNOWLEDGMENTS XIII

## 1 Introduction 1

Short History of Packaging in the USA 2 Functions and Goals of Transport Packaging 2 The Cost of Packaging 3 The Environmental Challenge to Packaging 4 Packaging's Placement in the Corporate Structure 5 Sources of Professional Information 6 Definitions 6

### 2 The Package Design Process 9

Taking a Total-System Approach to Package Design 9 The Protective Package Concept 11 The 10-Step Process of Transport Package Design 13 1. Identify the Physical Characteristics of the Product 13

- 2. Determine Marketing and Distribution Requirements 13
- 3. Learn about the Environmental Hazards Your Packages Will Encounter 13
- 4. Consider Packaging and Unitizing Alternatives 13
- 5. Design the Transport Package 14
- 6. Determine Quality of Protection Through Performance-Testing 14
- 7. Redesign Package (and Unit Load) Until it Successfully Passes All Tests 15
- 8. Redesign the Product if Indicated and Feasible 15
- 9. Develop the Packing Methods 15
- 10. Document All Work 15
- A Final Check 16

## 3 Rules and Regulations Governing Transport Packaging 17

Hazardous Materials (Hazmat) Regulations 18 Common Carrier Rules and Regulations 18 National Motor Freight Classification 19 Uniform Freight Classification 20 Small-Parcel Carrier Regulations 21 Air Cargo Regulations 21 Export 21

### 4 Hazards in the Distribution Environment 23

Environmental Hazards in Domestic Distribution 23 Shock Hazard in Handling and Transportation 24 Vibration hazard in Transportation 26 Static Compression Hazard in Warehousing 28 Dynamic Compression Hazards in Distribution 29 Concentrated Dynamic Pressure 29 Altitude-Extreme Variations 30 High-Humidity Hazard 30 Temperature Extremes in Distribution 30 Hazards in the Distribution Environment 31

### 5 Testing of Transport Packaging and Unit Loads 33

Sources of Testing Methods 34 Engineering Development Testing 34 Shock Hazard: Free Fall and Shock Machine Testing 35 Example 37 Shock Hazard: Incline Impact Testing 37 Shock Hazard: Horizontal Impact Testing 38 Vibration Hazard: Repetitive-Shock Testing 38 Vibration Hazard: Resonance by Sine Sweep and Dwell Testing 39 Vibration Hazard: Random Vibration Testing 40 Compression Hazard Testing 40 Tests for Other Physical Hazards 41 Natural Hazards: Temperature and Humidity Conditioning 42 Performance Testing of Shipping Containers and Systems 43 ASTM D4169 43 ISTA Procedures 44 Regulatory Use of Performance Testing 46 Example 47

## 6 Testing for Product Fragility 49

Shock Fragility Assessment 49 Vibration Fragility Assessment 52

Specialty Processes 64

# 7 Corrugated Boxes 55

Corrugated Packaging: Sustainable, Renewable and Recyclable 56 Recyclable 56 Containerboard Manufacturing 57 Raw Materials to the Paper Mill 57 At the Paper Mill 58 Corrugated Structure 59 Single Face 59 Single Wall 59 Double Wall 59 Triple Wall 59 Corrugated Box Manufacturing 61 At the Box Plant 61 Corrugator 61 Corrugated Adhesive System 62 Converting Operations 62 Printer-Slotter 62 Flexo Folder-Gluer 62 Die-Cutter 63 Graphics Press 63 Inks 64 Joining 64 Labeler 64

Box Styles 64 Box Dimensions 65 **Designing Transport Packaging 65** The Development Process 66 Identify the Requirements 66 Design and Engineer 66 Qualify 66 Redesign and Optimize 66 Finalize the Process 66 Checklists for Efficient Acquisition of Corrugated Products 66 The Product Itself 67 Set-Up and Packing 67 Distribution and Storage 67 Marketing Considerations 68 Regulatory and Other Issues 68 How Carrier Regulations Fit In 68 The Boxmaker's Certificate 68 Understanding the BMC 69 Package Engineering with Example 70 Stacking and Compression 72 Distribution Environment and Container Performance 72 Example 74 **Compression Solutions 75** Cost Effectiveness 75 Containment 75 Bulge Resistance 76 Unitizing 76 Testing of Containerboard, Combined Board and Corrugated Products 77 Conditioning 78 Transport Packaging Test Methods 78 Compression Strength 78 Drop and Incline Impact 81 Vibration 82 Preshipment Evaluations 82 Compliance with Carrier Regulations 82 Edge Crush (ECT) 82 Burst/Puncture 83 One Additional Test Method: Caliper/Thickness 84 **Testing Facilities 84** 8 Unitizing: Pallets, Slip Sheets and Load Stabilizers 87

Unit Load Components 87 Pros and Cons of Unitizing 88 Costing a Unit Load System 88 Costs 88 Savings 89 Sizing the Unit Load 89 Load Bases 90 Pallets 90 Slip Sheets 95 Pallet Patterns 95 Load Stabilizers 95 Stretch-Wrapping 96 Strapping 98 Adhesives 98 Shrink-wrapping 98 Palletizing Equipment 99

#### 9 Returnable Containers and Dunnage 101

Advantages and Disadvantages of Returnables 102 System Features for Success with Returnables 103 Types of Returnables 103 Design Criteria for Returnables 105 Importance of a Tracking System 106 Cost Analysis 106

### 10 Cushioning Systems: Interior Packaging for Shock and Vibration Protection 109

How Cushioning Works 110 Cushioning Materials and Systems 111 Types 111 Properties 111 Measuring Cushioning Performance 114 Shock from Impact 114 Vibration Performance 115 Compressive Creep 117 Temperature Extremes 117 High Humidity 117 Cushioned-Package Design 118 Example 118 Cushioning-System Design 122 *Example 122* 

# 11 Dunnage: Interior Packaging for Blocking & Bracing/Spacing, Void Fill and Abrasion Protection 123

Functions of Dunnage 124 Blocking & Bracing/Spacing 124 Void Fill 124 Abrasion Prevention 124 Add Stacking Strength 125 Materials and Forms 125 Corrugated Fiberboard 125 Expanded Polystyrene 125 Foam-in-Place 126 Molded Pulp 127 Honeycomb 127 Retention Packaging 128 Skin Packaging 128 Vacuum Forms 129 Loose Fill 129 Paper Varieties 129

Air Bubble 130 Foam Sheeting 130 Inflatable Void Fill 130 Miscellaneous Dunnage Materials 130 Suspension Packaging 131 Checking Performance of Dunnage Packs 131

### 12 Corrosion- and ESD-Protective Packaging 133

Corrosion Control 133 Condensation 134 Preventive Measures 134 Preservatives 134 Volatile Corrosion Inhibitors 135 Desiccants 135 Electrostatic Damage Control 137 Protective Materials 137 Electrostatic Moisture Barriers 137 Static-shielding Materials 138 Conductive Bags 139 Static-dissipative Materials 139 13 Other Shipping Containers 141 Wood Containers 141 Container-Load Descriptions 141 Common Wood Container Types 142 Wood Boxes 142 Wood Crates 143 Wirebound Crates and Boxes 145 Drums and Pails 147 Steel Drums and Pails 147 Plastic Drums and Pails 149 Fiber Drums 150 Shipping Sacks 151 Paper Shipping Sacks 151 Plastic Shipping Sacks 152 Flexible Intermediate Bulk Containers 152 Applicable Regulations 152

#### 14 Marking and Coding of Transport Packages 153

Pictorial Markings for Handling of Goods 153 Hazardous Materials/Dangerous Goods Warning Labels 155 Package Certification 156 Bar Coding of Transport Packages and Unit Loads 158 Applying Markings to Transport Packages 159

### **APPENDIX: Sources of Transport Packaging Information 161**

Standards 161 Transportation Packaging Rules 162 Trade Associations 162 Professional Organizations 164