

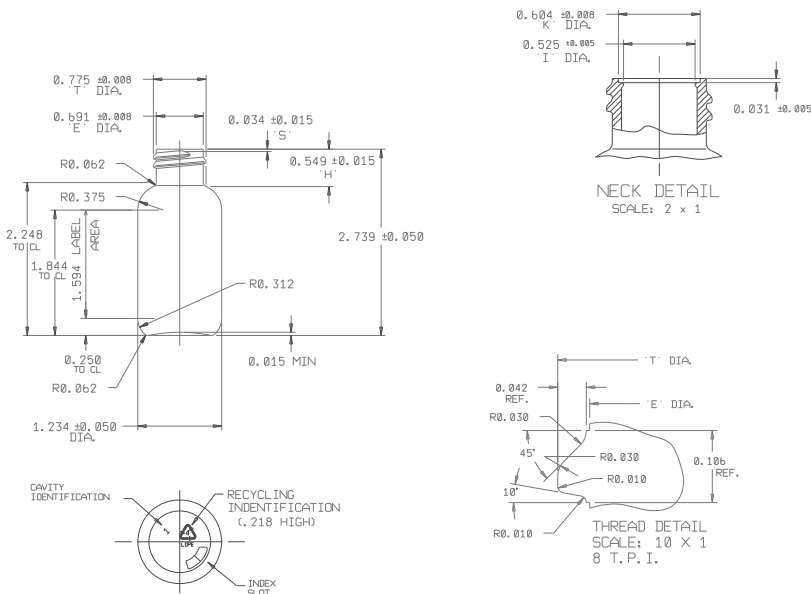


24-410 1OZ WHITE LDPE BOSTON ROUND FLAMED BOTTLE

Part #: 3587B

Size:	24-410 / 1 OZ
Color:	WHITE
Material:	LOW DENSITY POLYETHYLENE
Style:	BOSTON ROUND
Additional Info:	FLAMED BOTTLE
Case Pack:	1500/ EACH
Pallet Pack:	15000 / EACH

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2D CAD IS THE MASTER MODEL FOR THIS PRODUCT
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Rev	Description	By	Date	ECR
J	UPDATED TITLE BLOCK AND NOTES REPLACED TOLERANCE BOX WITH NOTE #3 ADD 1.594 LABEL AREA NO PHYSICAL CHANGE TO PART	JCG	21MAY12	416611912297-000
-	CORRECTED NOTE 5 (8 T.P.I. WAS 6 T.P.I.)	JCG	24NOV15	0000074110
K	S-dia tolerance from +0.013" to -0.012 to +/-0.015" H-dia tolerance from +0.007" to -0.017 to +/-0.015" Body Diameter tolerance from +/-0.031" to +/-0.050" SHE tolerance from +/-0.047" to +/-0.060" Base Push up from 0.047" +/-0.031" to MIN of 0.015" SPC tolerance from +/-11.8 to +/-2.661 K-dimension from 0.601" +/-0.005" to 0.604" +/-0.008" I-dimension from 0.520" +/-0.005" to 0.525" +/-0.005"	JCG	25MAR19	0000137620

- NOTES:
- (1) DIMENSIONS ARE IN INCHES.
 - (2) ALL DIMENSIONS APPLY AFTER FLAMING.
 - (3) ALL DIMENSIONS NOT TOLERANCE ARE FOR REFERENCE ONLY.
 - (4) TOLERANCES APPLY TO THE AVERAGE OF TWO MEASUREMENTS TAKEN 90° APART ON DIAMETERS. FIRST OF THESE MEASUREMENTS SHOULD BE TAKEN 15° OFF OF THE PARTING LINE.
 - (5) SPECIAL M20-SP410 NECK FINISH
1-1/2 TURNS OF THREAD - 8 T.P.I.
 - (6) MIN WALL THICKNESS: 0.015"

CONFIDENTIAL

Capacity Specification			
Overflow Capacity		37.5 ± 2.5	ml
Volume & Weight Information			
Calculated Overflow Capacity:		Calculated Fill Line Capacity:	
ml		ml	
Total Mat'l Vol.:	Material:	Container Target Weight:	
6.739 cc	LDPE	6.2 ± 0.5 gm	
Total Surface Area:	As Blown Density:	Avg. Wall Thickness:	
sq.cm	.92 gm/cc	.0XX" / .XX	
Drawing Information			
Process:	Finish Drawing:	Reference:	
IBM			
Date:	Drawn By:	Customer:	
05-07-96	GENE MAY	STOCK	
Title:			
10Z BOSTON ROUND			



Drawing Type:	
PRODUCT DRAWING	
Drawing Number:	Rev.
C 20863	K

Amcor Rigid
Plastics USA, LLC
10521 S. Hwy M-52
Manchester, MI 48158

PLANT:	4631	Millville
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Material Number	Old Part Number	Description
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20028579	20863-035	F,BTL,1 OZ,BR 1BF 20863-035,WHT,5104,6.2
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00 - SALEABLE PART	P0 - PCUS Active
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Sales Organization: P000

Drawing	Pcs/Carton	Pcs/Pallet	Cartons/Pallet	Batch	Surface Treatment
20863	1,500	15,000	10.00	NO	STD./ BODY ONLY

WEIGHT	23.06 LB	230.63 LB
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GROSS WEIGHT	G/EA:	6.974	NET WEIGHT	G/EA:	6.170
VOLUME		CCM/EA:		84.523	

BACKFLUSH	:	
PRODUCTION STOR LOCATION	:	FP01 Finished Goods
BATCH	:	YES

Customer Information	Customer Item
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Bill of Material Information

Maximum Regrind %:	25.00%
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Material	Qty Required
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ALT 1	Production BOM
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O,MIX,PH,WX0200 WHITE 2/100 5104

R,PE,LDPE,NAT,CHEVRON PHILLIPS 5104
M,CONC,WHITE PCC/CCC PEC17030 (SEE MIX)
C,22.375" X 15.625" X 22.125",LARGE,RSC
Printing plate vendor is 90017322, reorder # is 5606-7
O,BAG,26 X 16 X 48 X 1.1MIL
O,PAL,48 X 40 4W CERTIFIED HEAT TREATED
O,TAPE, 3" POLY TAPE (P/S)

Routing Information

LAY DOWN FLAME TREATING - MUST PASS WATE Label pallets: DO NOT DOUBLE
STACK PALLETS.##.
BULK43
BULK PACK - FOLD BAG - "H" TAPE TOP AND BOTTOM WITH P/S TAPE
.
SKETCH #25 MUST RUN IN CLEAN ROOM/LOW
PARTICULATE ENVIRONMENT.##.

QUALITY ACCEPTANCE CRITERIA TABLE(S) :
Amcor acceptance criteria is based on ANSI/ASQ Z1.4-2003 Single Sampling
By Attributes, Level II

PLANT: 4631 Millville**Material Number Old Part Number Description**

20028579 20863-035 F,BTL,1 OZ,BR 1BF 20863-035,WHT,5104,6.2

CONTAINERS

NOTES: SOME DEFECTS MAY NOT APPLY TO ALL PRODUCT

ATTACH TABEL B IF ASSEMBLED PRODUCT

ATTACH TABLE E IF DECORATED PRODUCT

TABLE	LEVEL	AQL	CHARACTERISTIC
C	Critical A	0.0	Mislabeled/Incorrect Item Wrong Raw Material Hazardous contamination such as glass, metal, & insects
	Critical B	0.15	Defects That Prevett Normal Function: Holes in Bottle, Leakers Non-Filled, Non-Sealing Neck Finish, Neck Finish Mismatch Affecting Sealing Surface, Choked Neck/Push Down, Cocked Neck, Ovality, Not Functional on filling line, Non-Functional Rocker Bottom More than 3 folds within 6 inches along heat seal (if applicable) Mixed Foreign Components (more than 2 incorrect parts in a carton or cartons) Other non-functional defects as agreed to between Amcor and customer
	Major	1.0	Dimensional Nonconformance to Amcor Drawing Embedded Particles over .4 sq mm Tappi (.0312") more than 2 Particles (clustered) Color Beyond Customer Supplied Limit Standards Excessive Flash >0.010" Burns - Excessive Discoloration Capacity Under Minimum Specification Uneven Wall Distribution, Non-Functional Voids Exceeding Limit Standards (except PET) See Table D for PET criteria Dents affecting proper function Mismatch seam more than .010 along side/bottom Wall sinks preventing decoration Stray foreign items more than 1 or 2 (reject the effected carton only) Plastic chips or curls that exceed .125 that are not easily removed (extrusion only) Part-Line Mismatch that Adversely Affects Labeling Part-Line Mismatch that Adversely Affects Decorating Flaming (if required) Less than 38 Dyne within 90 days of shipping Contamination not easily blown off which exceed .4 sq mm Tappi (.0312") such as process related lubricants, dust, fibers that are not easily removed by on-line processing/cleaning Uncharacteristic Odor
	Minor	4.0	Embedded Particles Less than .4 sq mm Tappi (.0312") Clustered

PLANT:

4631

Millville

Material Number

Old Part Number

Description

20028579

20863-035

F,BTL,1 OZ,BR 1BF 20863-035,WHT,5104,6.2

Loose Particles Not Easily Removed or Visible at
3 feet
Excessive Pinch Off (Extrusion Only)
Incomplete Pinch off (Extrusion Only)
acceptable pinch is 0.020 thick or more
Open bubble or void in wall (Barrier Only)
Delamination (Barrier Only)
Surface Marks (cosmetic) visible at 3 feet
Color Dispersion Beyond Customer Supplied Limit
Standards
Contamination easily blown off which exceeds
.4 sq mm Tappi (.0312") such as dust or fibers
that are easily removed by on-line
processing/cleaning

NOTICES:

This document is prepared in lieu of a formal customer generated
specification document. Amcor will continue to accept and process any
new orders for the molded product shown above, to meet the requirements
listed in this document. However, if there is a formal customer
generated specification available, please forward it to Amcor Customer
Service for review and processing ASAP.

Any revision to this document must be negotiated and would only apply to
future orders, if revisions are approved by both parties.

Customer Signature

Date:

Please Sign and Fax to your Customer Service Representative. Thank you.

3587B

CUSTOMER SPECIFICATION 06/21/2021 MICKSEAN 1 / 3

PLANT: 4631 Millville

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VOLUME CCM/EA: 84.523

BACKFLUSH :
PRODUCTION STOR LOCATION : FP01 Finished Goods
BATCH : YES

Customer Information

Customer Item

Bill of Material Information

Maximum Regrind %: 25.00%

Material

Qty Required

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