

SPECIFICATIONS:

A - CONSTRUCTION

- A1. **STYLE:** A Nominal Grade (Grade N per ISO/TR 10233) 4-way notched stringer design, non-reversible double-faced pallet with flush stringers.
- A2. **SIZE** (Over-all deck foot print)
 - Length: 1,219 mm (48.00 in) (#01)
 - Width: 1,016 mm (40.00 in) (#02)
- A3. **OPENING SPACE:** > 88.5 mm (3.48 in) necessary to accommodate mechanical lifting equipment.
- A4. **DECK BOARDS:** Nominal 1x4 minimum spaced as noted on drawing.
- A5. **QUALITY EXPECTATIONS:** This is a performance based specification. For standard industry accepted general minimum quality expectations, reference "Uniform Standard for Wood Pallets" by NWPCA, 329 South Park Street, Alexandria, VA 22314.

B - PERFORMANCE REQUIREMENTS

- B1. **WORKING LOAD:** This pallet shall have a working load capacity of **1,273 Kg (2,800 lbs)**. This value shall be verified by METHOD 1 (testing) or METHOD 2 (analysis) (#03).
- B2. **METHOD 1 (TESTING):** Tests performed in accordance with ISO 8611 based on the required working load identified in B1 with the results evaluated per ISO/TR 10233 criteria.

Calculations:
 R = Designated Load Rating = W/SF
 = 3,629 Kg (8,000 lbs)
 W = Maximum weight on pallet in a 4,572 mm (180 in) static stacking height = B1 above.
 SF = 0.35 safety factor derived from historical testing of pallet durability variations. (ASTM D 1185).

STATIC TESTING: (minimum weights)

STACKING: 4,000 kg (8,800 lbs) minimum.
 BENDING: 4,550 kg (10,000 lbs) minimum.
 BOTTOM DECK: 4,100 kg (9,200 lbs) minimum.

IMPACT TESTING: (minimum weights)

INCLINED PLANE SHEAR: 273 kg (600 lbs)
 INCLINED PLANE TOP DECK: 273 kg (600 lbs)
 INCLINED PLANE BLOCK: 273 kg (600 lbs)
 CORNER DROP: (Weight of Pallet)

- B3. **METHOD 2 (ANALYSIS):** Analysis is performed using the "Pallet Design System" developed by:

Virginia Poly Technic Institute
 123 Oak Road
 Beachwood, VA, 01198

RACKED ACROSS LENGTH: > 1,273 kg (2,800 lbs)
 LATERAL COLLAPSE RESISTANCE: Medium or better

C - MATERIAL QUALITIES

- C1. **GRADE:** Standard warehouse or limited-use grade materials that meet the quality requirements per ISO 11444. Note that solid wood (hardwood or softwood) and manufactured wood (press wood) are allowed.
- C2. **MOISTURE CONTENT:** Deck Boards (top & bottom) to be less than 20% when tested per ASTM D4442. (#04)
- C3. **FINISH:** All lumber to be free of bark and wane.
- C4. **PHYTOSANITARY REQUIREMENTS:** All natural wood must meet the requirements of ISPM 15. (#05)

D - MARKINGS

- D1. **GENERAL:** Unless otherwise specified, each pallet shall be indelibly and legibly marked (method vendor option) with the following information:
 1. The HP Part Number (min height text of 9mm)
 2. The Part's Revision level
 3. The Phytosanitary heat-treated symbol in compliance with the "International Standards for Phytosanitary Measures", bulletin No. 15, 2002.
 4. Date of manufacture "week#/year"
 5. Supplier ID (no company advertising).

E - GENERAL REQUIREMENTS

- E1. **DELIVERY REQUIREMENTS:** Delivery quantities, schedules and special delivery preparations shall be determined by the ordering entity. Materials identified here-in shall be supplied using appropriate packing material that provides protection from damage and degradation while augmenting stable stacking practices for storage and handling.
- E2. **COMPLIANCE:** To the Hewlett-Packard General Specification for the Environment, GSE A-5951-1745-1, is required.
- E3. **CRITICAL DIMENSIONS & PROPERTIES:** Failure to meet these requirements or properties specified in this drawing shall be cause for rejection.

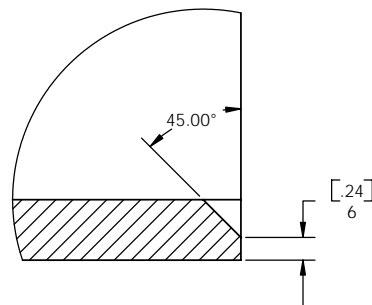
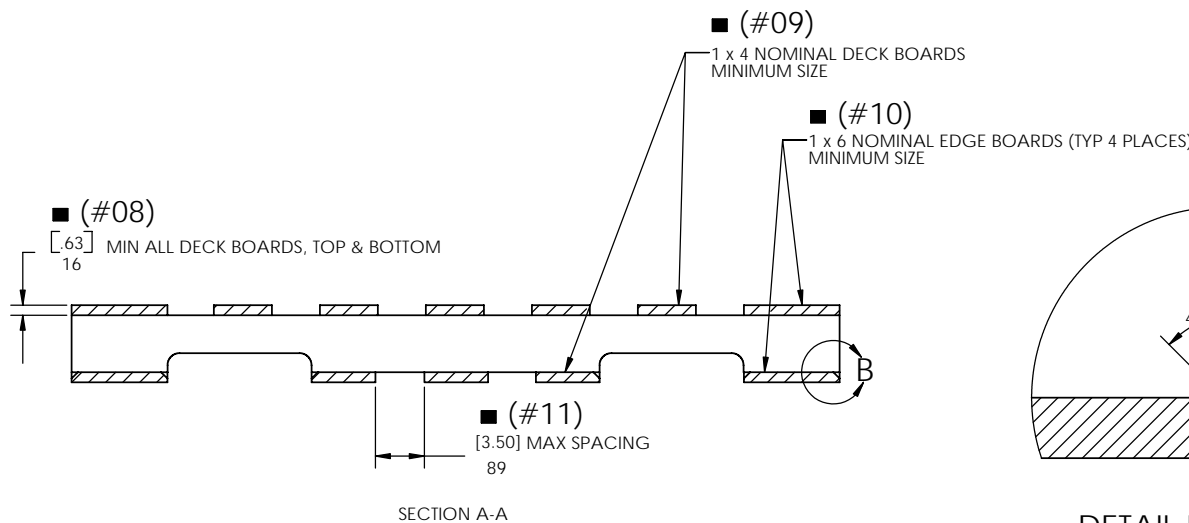
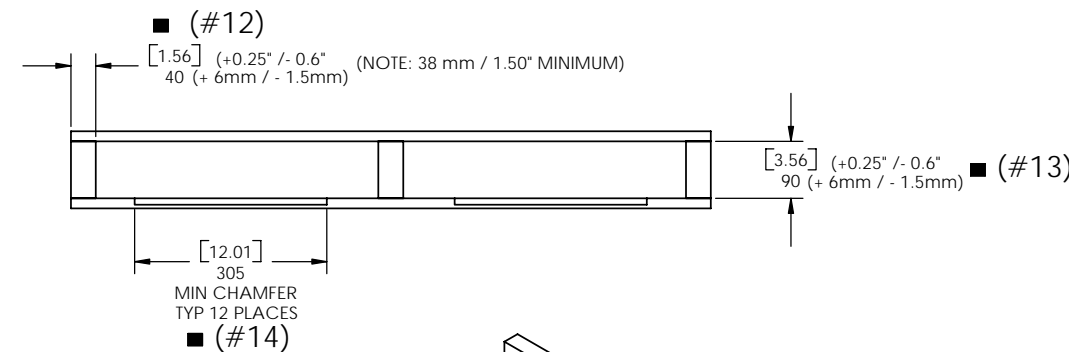
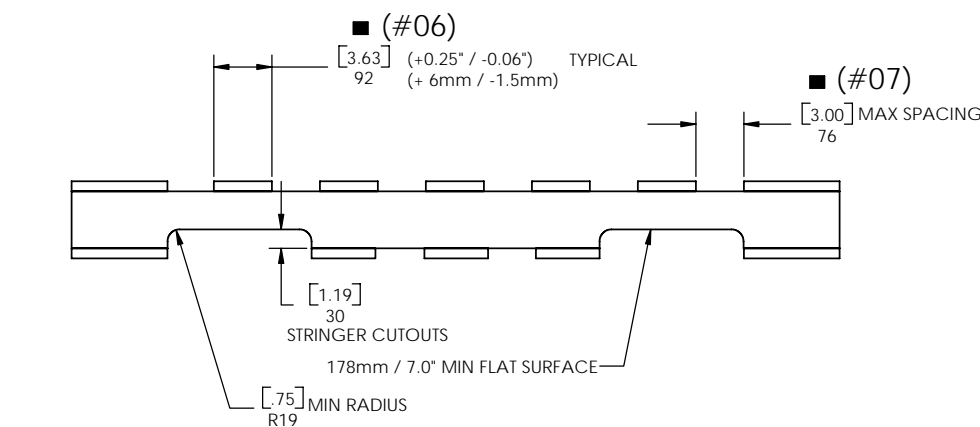
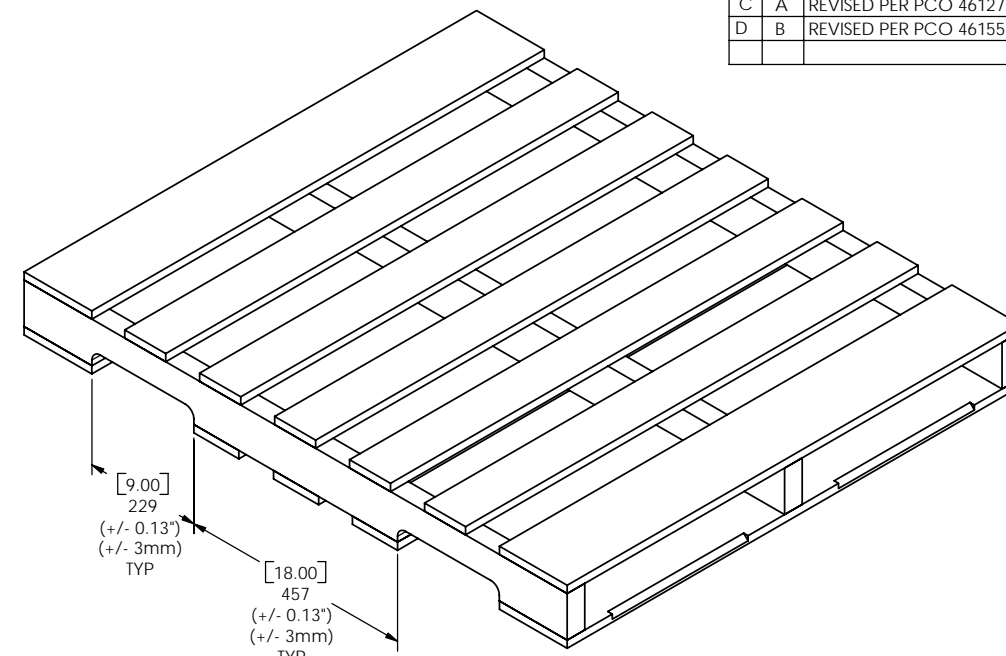
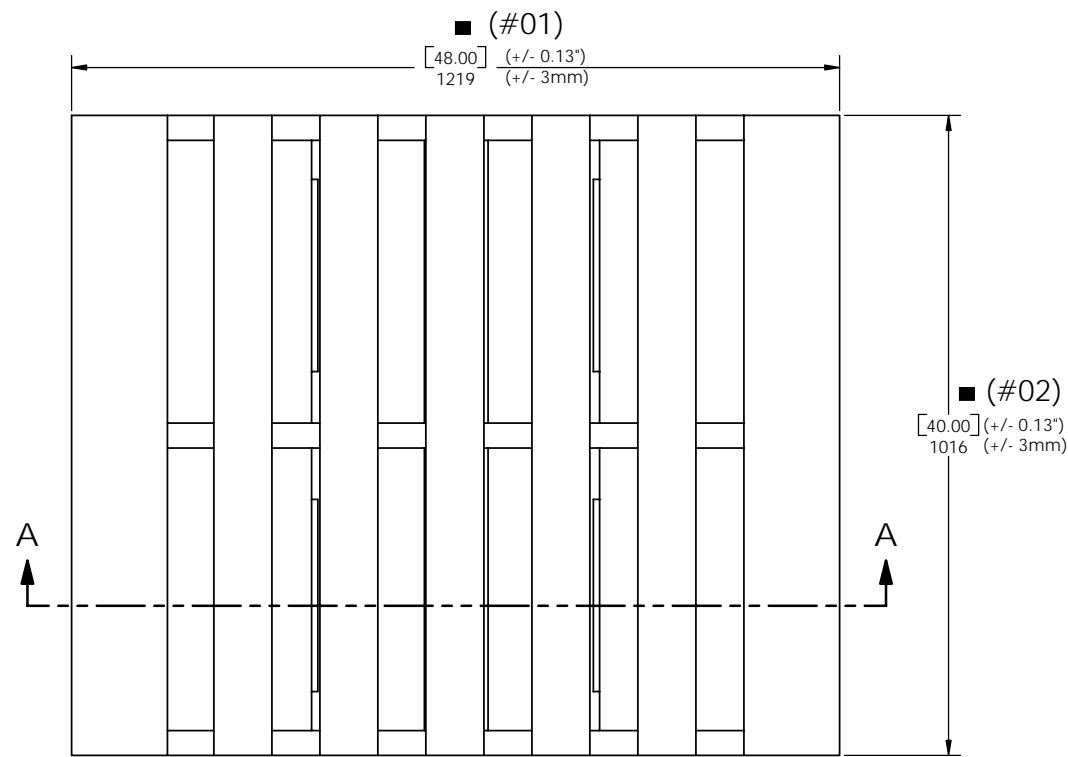
When SQC analysis is requested for critical parameters, the following notations will be on the drawing:

λ = Manufacturing Process Control Features (jointly established by HP and Supplier).

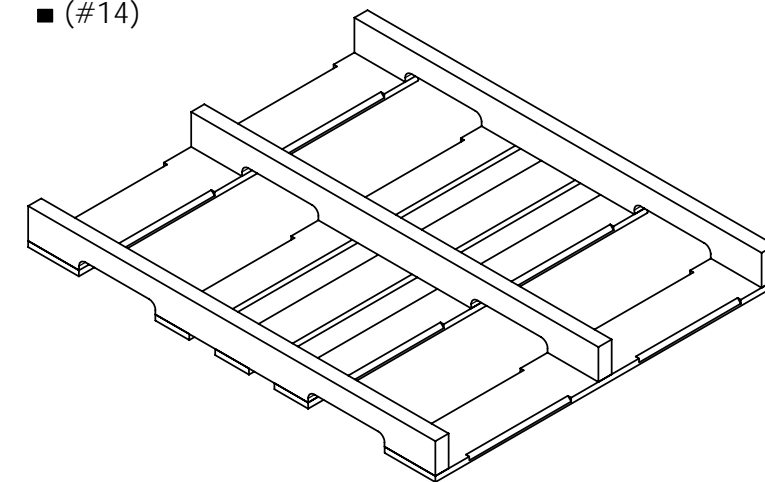
v = Critical to Function Feature (established by HP).

σ = Critical to Process/Tooling Setup Parameters (established by Supplier)

This category of dimensions and properties shall be inspected. A 3 Sigma or better process capability with reports (Mean, Sigma, Cp and a Cpk of 1.33) are required for part qualification. Inspection numbers are indicated by (#NN). The last number used in this drawing is (#14)



DETAIL B
SCALE 1 : 1



VIEW OF BOTTOM DECK BOARDS
(TOP DECK BOARDS NOT SHOWN FOR CLARITY)

HP RESTRICTED
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REVISIONS		DATE	APPROVED
A	A	05-08-01	P. BIANCAVILLA
B	A	10-31-02	J. WALDECK
C	A	01-29-03	J. WALDECK
D	B	05-06-05	P. BIANCAVILLA

ASSOCIATED 3D BODY		METRIC		ITEM	QTY	PART/MATERIAL DESCRIPTION	MAIL PART NO.	MAIL DWG NO.	MAIL SPEC
THIS ASSEMBLY WAS CREATED WITH 3D SOLID MODELING		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS THIRD ANGLE PROJECTION		P. BIANCAVILLA	12-23-00	DATE			
BLOCK STYLE	STRINGER STYLE	SEE TABLE 1		P. BIANCAVILLA	05-08-01	DATE			
N/A	AY8107B			P. BIANCAVILLA		ENGINEER/CHECKER			
				X	X	RELEASE TO PRODUCE			
				X	X				
				FILE NAME	185501A.SLPT	SolidWorks 2005 CAD application			
				PALLETT 48 x 40 4 WAY ENTRY					
				SCALE: 1:6 SHEET 1 OF 1					

NOTE: CHAMFERS SHOWN ARE MINIMUM REQUIRED

