

MIL-STD-299

17 January 1957

**SUPERSEDES
ORD-SIP-S321**

1 October 1945

MILITARY STANDARD

VISUAL INSPECTION STANDARDS

FOR

NAILED WOOD BOXES AND WIREBOUND

WOOD BOXES USED IN SMALL ARMS

AMMUNITION PACKING



OFFICE OF THE ASSISTANT SECRETARY OF DEFENSE
WASHINGTON 25, D. C.

Supply and Logistics

Visual Inspection Standards
for Nailed Wood Boxes and
Wirebound Wood Boxes Used in
Small Arms Ammunition Packing
MIL-STD-299

17 JANUARY 1957

1. This Standard has been approved by the Department of Defense and is mandatory for use by the Departments of the Army, the Navy, and the Air Force, effective 1 March 1957.
2. In accordance with established procedure the Standardization Division has designated the Ordnance Corps, Department of the Army as custodian of this Standard.
3. Recommended corrections, additions, or deletions should be addressed to the Standardization Division, Office of the Assistant Secretary of Defense (Supply and Logistics), Washington 25, D. C.

FOREWORD

This standard was prepared under the direction of the Office, Chief of Ordnance, to be used to supplement specifications for nailed wood boxes and wirebound wood boxes used in the packing of small arms ammunition. It replaces the following publications on the same subject: ORD-SIP-S321, 1 October 1945 and ORD-SIP-S321, Amendment 1, March 1954.

This publication serves to create a military standard which evaluates and illustrates a practical majority of defects and was assembled as a result of extensive surveys covering wood box and small arms ammunition manufacturing facilities.

The format used retains most of the features of the formats of the publications it replaces because experience has proved that the numbering of illustrations to conform to the numbering of visual defects in the applicable detailed specifications, special treatment of indexes and specialized grouping have served to facilitate inspection, training and general use.

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1. SCOPE AND PURPOSE

1.1 Scope. This standard provides illustrations and procedures for determining and evaluating defects normally found in nailed wood packing boxes and wirebound packing boxes used as shipping and storage containers for small arms ammunition and the standard shall be used as a supplement to pertinent specifications.

1.2 Purpose. The purpose of this standard is to:

(a) Provide a standard basis for the inspection of small arms ammunition nailed wood and wirebound packing boxes.

(b) Serve as an instruction manual for use in training personnel engaged in packing or in inspection of small arms ammunition boxes.

(c) Provide visual defect standards for use in connection with acceptance inspection of packed ammunition.

(d) Promote the standardization of manufacturing and inspection of small arms ammunition boxes.

2. REFERENCED DOCUMENTS

2.1 Standards.

MIL-STD-105—Sampling Procedures and Tables for Inspection by Attributes.

3. DEFINITIONS

3.1 General. Definitions of Standard MIL-STD-105 are applicable.

3.2 Specific. For the purpose of this standard the following definition applies:

3.2.1 Permissible defect. A condition which, though not desirable from an appearance standpoint, may be permitted for reasons of economy.

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4. GENERAL REQUIREMENTS

4.1 **General.** The descriptions and definitions of defects established in this standard are those commonly occurring. Any other defects not listed, present in the lot, shall be reported. If, in the opinion of the Government inspector, the other defects be serious, complete information, recommendations and request for disposition shall be submitted through proper channels.

5. DETAIL REQUIREMENTS

5.1 **Defect grouping.** For convenience in referencing, the defect lists and defect photographs are grouped as follows:

	Pages
Nailed Wood Boxes:	
List of Defects.....	3, 4
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Wirebound Wood Boxes:	
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LIST OF DEFECTS

NAILED WOOD BOXES

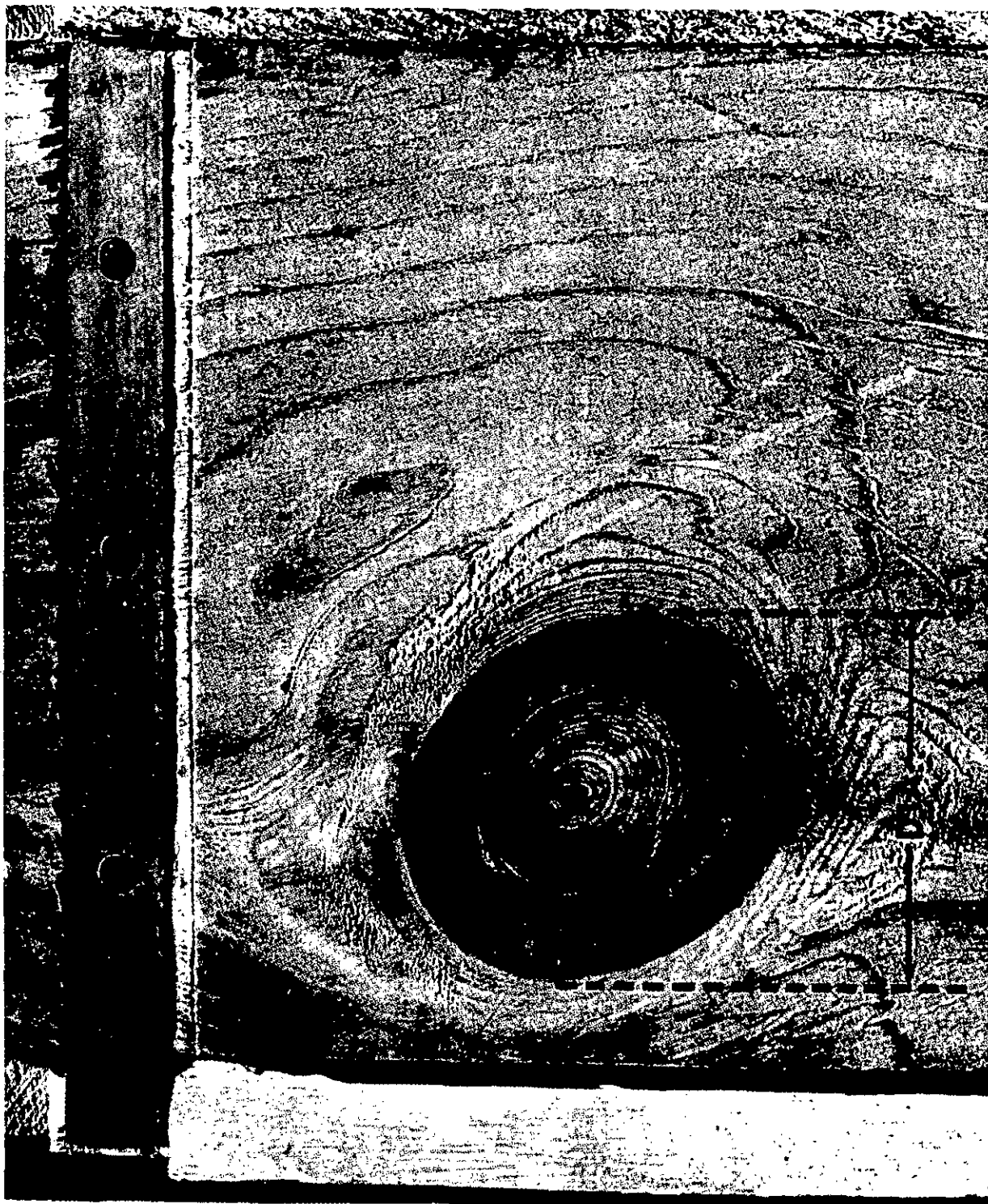
No.	Defect MATERIAL	Pages
Knots:		
1.	Single knot or cluster larger than 1/4 width of part or cleat.....	5-10
2.	Aggregate diameter greater than 1/2 width of part or cleat.....	11-14
3.	Loose or encased knot or knot hole larger than 1/2" diameter.....	15, 16
4.	Decay.....	17-19
5.	Worm holes over 1/8" diameter and over 1/2" in length (not illustrated).	
6.	Surface too rough for legible marking (not illustrated).	
7.	Cross grain having slope greater than 1 in 8.....	20, 21
Splits:		
8.	Forming a sliver at the outside edge of a board.....	22
9.	Full length—more than one unrepaired in a part.....	22, 23
10.	Full length—more than two repaired in a part.....	24
11.	Partial—more than two unrepaired in a part.....	25
12.	Partial or full length unrepaired in a cover.....	26, 27
13.	Shake exposing sharp edge or sliver.....	28, 29
14.	(Not illustrated.)	
Hardware:		
15.	Damaged, including corrosion.....	30, 31
16.	Untreated.....	32
17.	Strapping not according to specifications (not illustrated).	

WORKMANSHIP AND ASSEMBLY

Nailing:		
18.	Heads of more than 10% of all the nails in the box protruding.....	33
19.	Protruding nail point or corrugated fastener.....	33
20.	More than 10% of all the nails in the box overdriven over 1/2".....	34
21.	More than one missing nail per end.....	35
22.	More than one nail per end bent or driven through, or into a knot, split or crack (unless replaced by correctly driven nail).....	35, 36

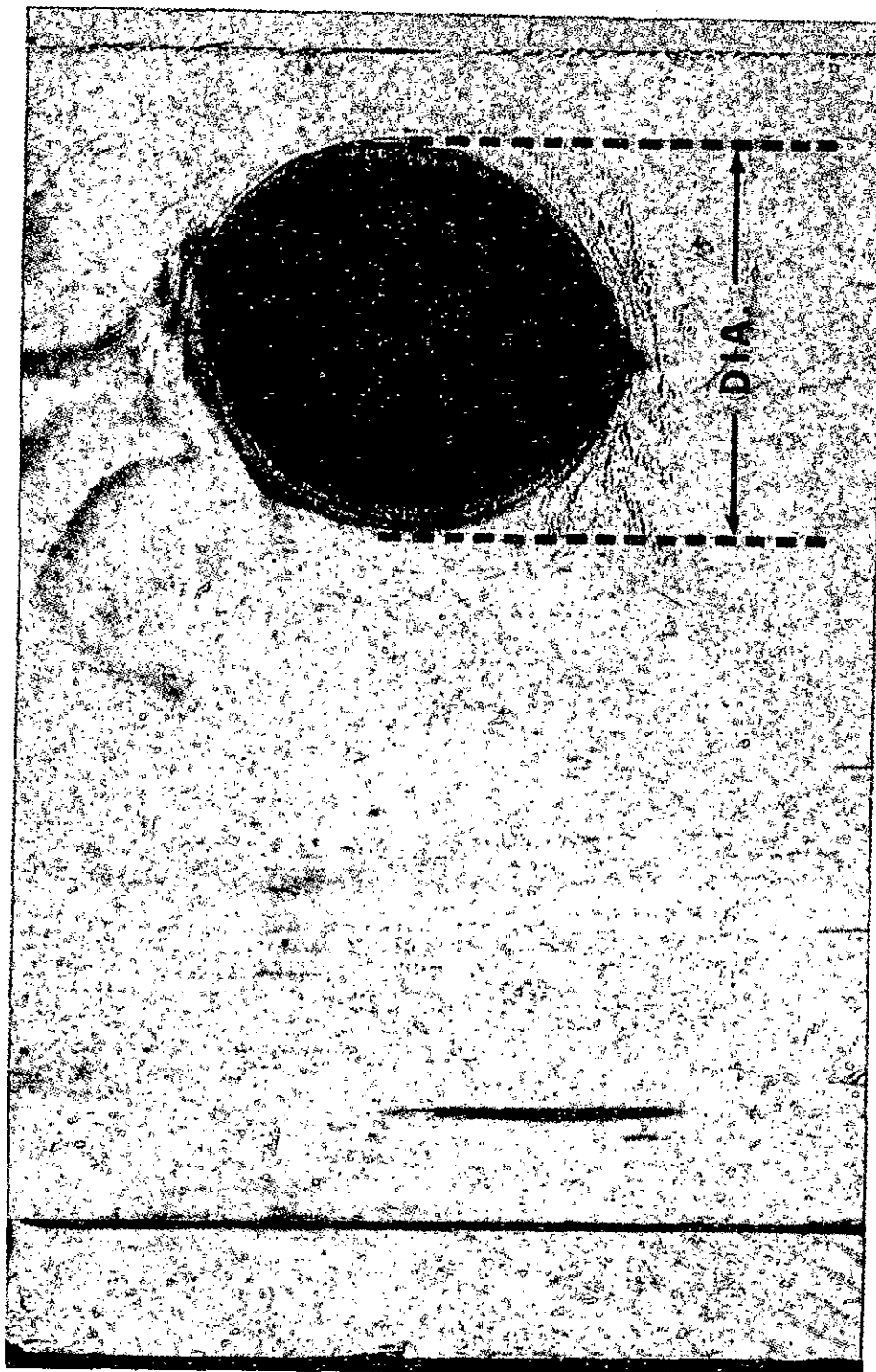
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No.	Defect	Pages
23.	Insufficient clinch (more than one nail per end or cover having less than 1/4" clinch) -----	37
24.	Combination of any two of defects 21, 22 or 23.-----	38
Strapping:		
25.	Missing strap -----	39
26.	Ends of strap not lapped -----	39
27.	Nail missing from lapped ends -----	39
28.	Strapping misaligned so as to affect utility of the box -----	40
Hardware:		
29.	Missing nut -----	41
30.	Insufficient or improper U bolt threads, or short bolt -----	41
31.	Long bolt (extending above top surface of cover cleat) -----	42
32.	Missing reinforcement -----	42
Wood parts:		
33.	Side extending beyond end cleat more than 1/4" -----	42
34.	Bottom or top extending beyond side more than 1/4" -----	42, 43
35.	Top more than 1/4" inside cleat -----	43
36.	Bottom or top more than 1/4" inside side -----	43
37.	Cleat end extending beyond bottom more than 1/4" -----	44
38.	Vertical cleat more than 1/4" from bottom surface -----	44
39.	Gap larger than 1/8" between vertical cleat and side -----	44
40.	Gap larger than 1/4" between horizontal and vertical cleat -----	44

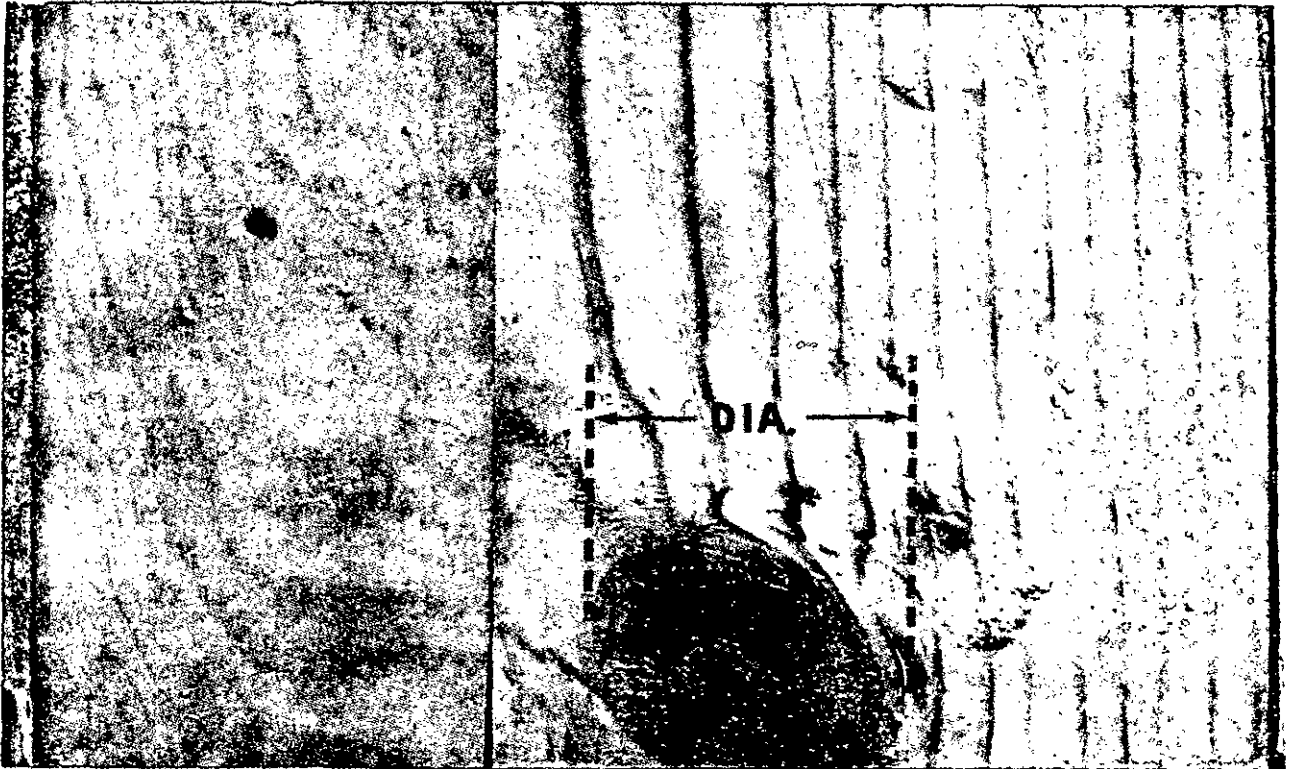


No. 1—TIGHT KNOT. Minor. (Diameter greater than $\frac{1}{2}$ width of part.)

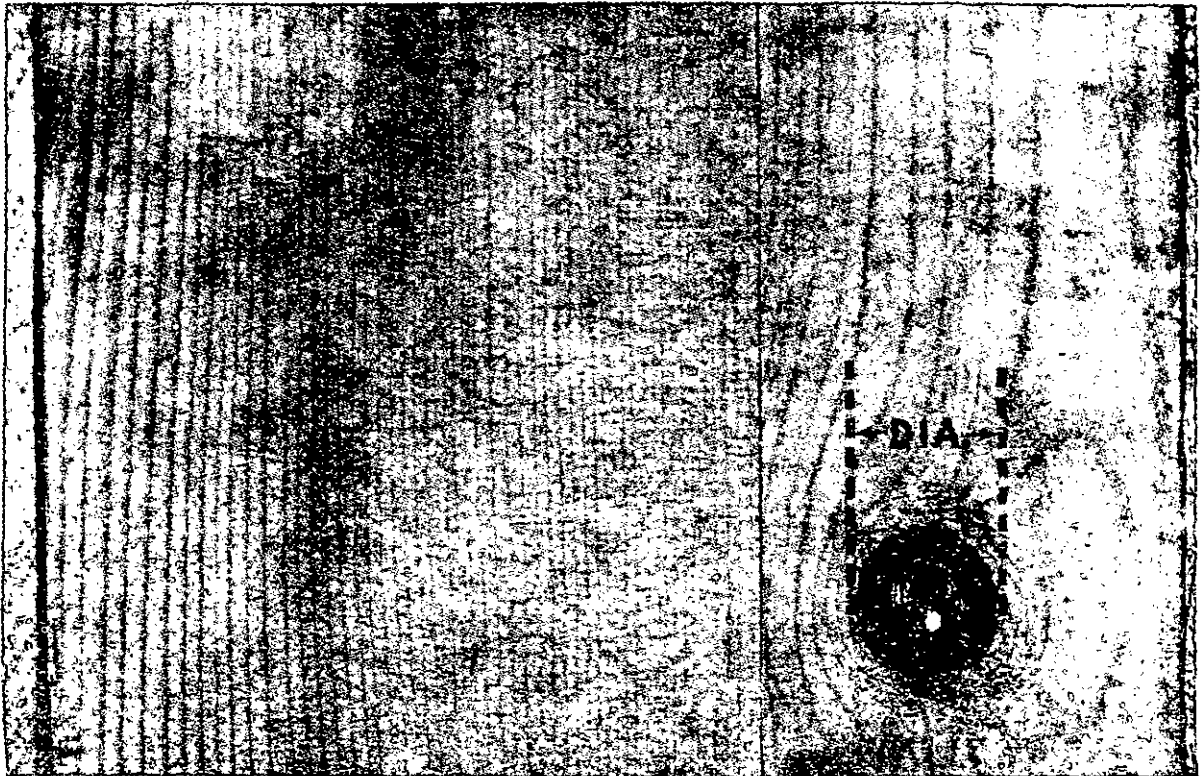
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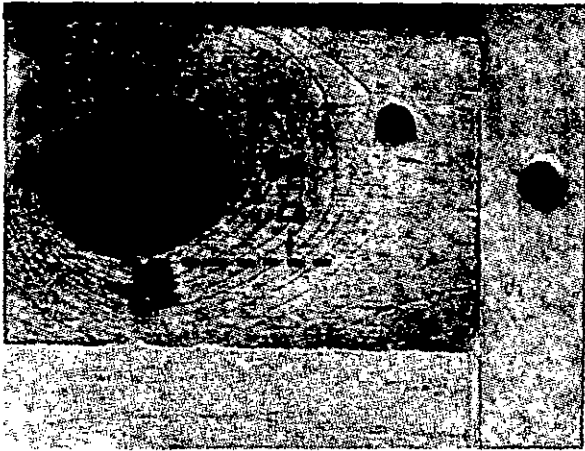
No. 1—TIGHT KNOT. Permissible. (Diameter less than $\frac{1}{8}$ width of part.)



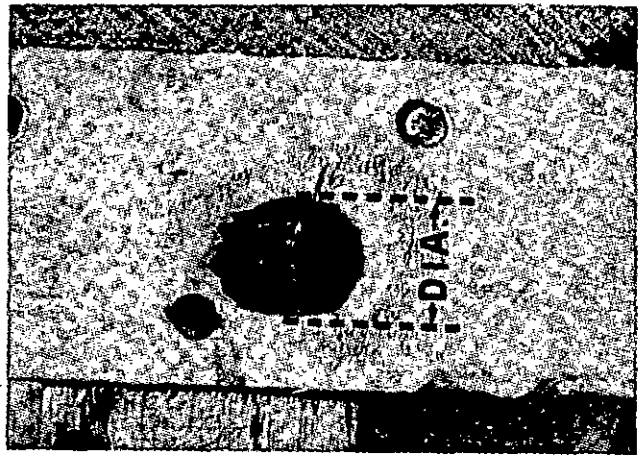
No. 1—TIGHT KNOT. Minor. (Diameter greater than $\frac{1}{2}$ width of part.)



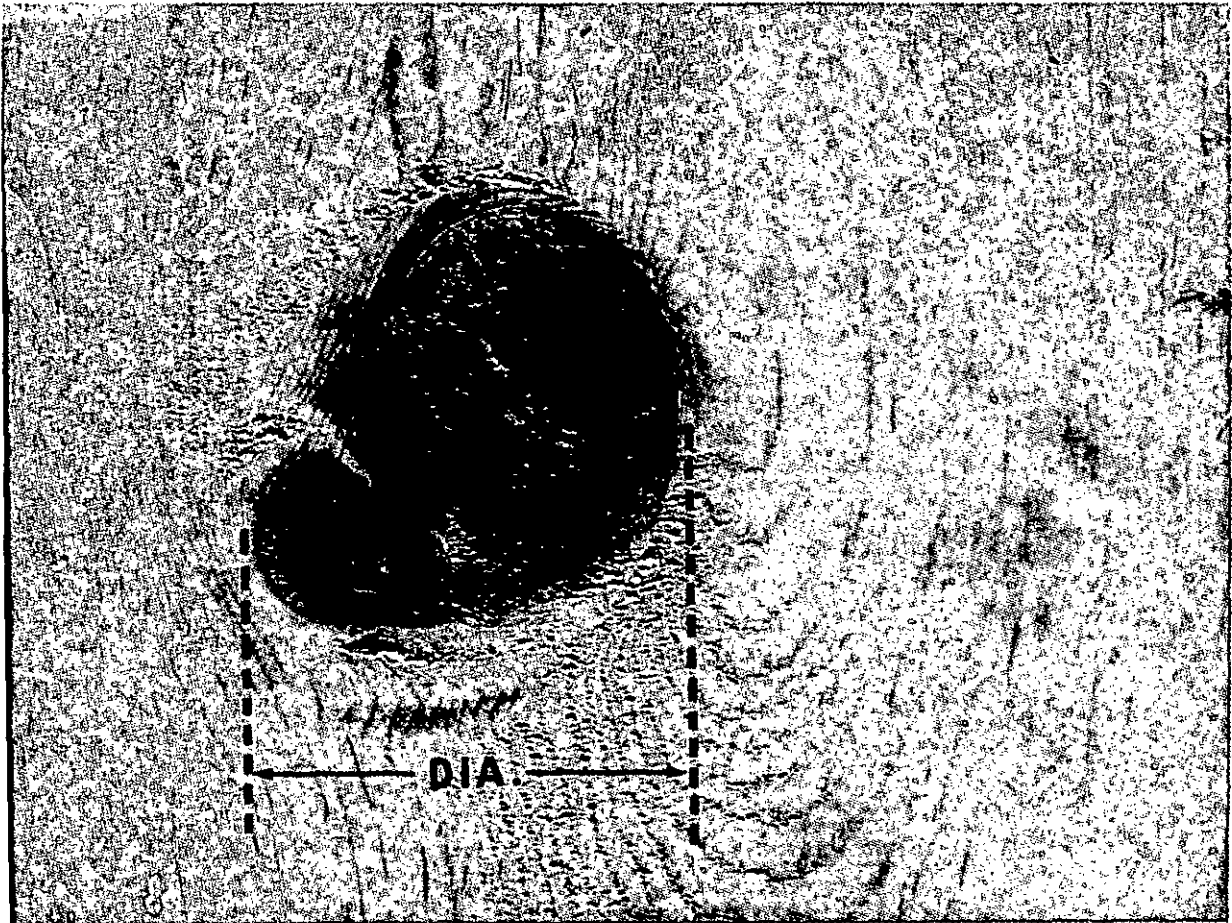
No. 1—TIGHT KNOT. Permissible. (Diameter less than $\frac{1}{2}$ width of part.)



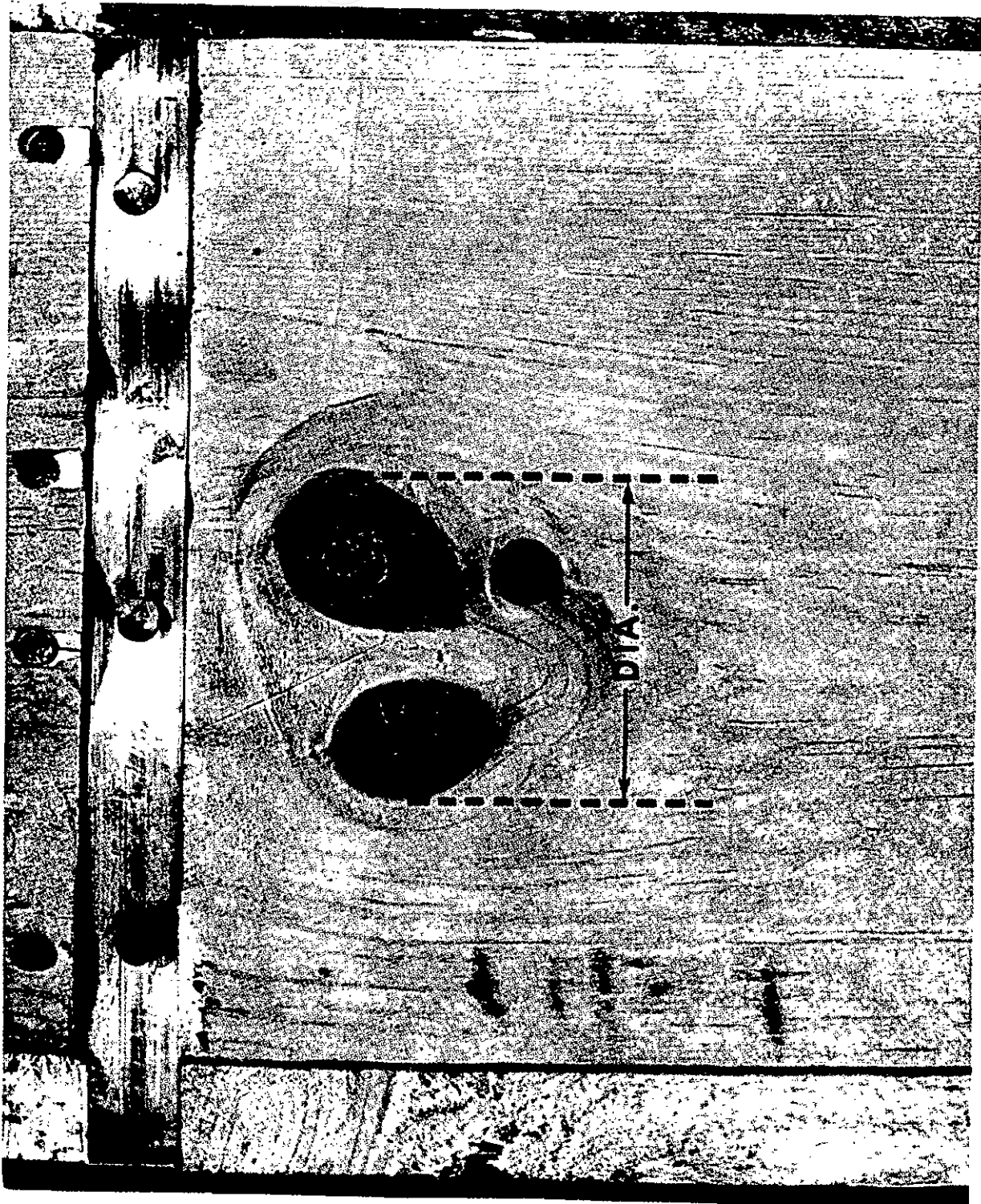
No. 1—TIGHT KNOT. Minor. (Diameter greater than $\frac{1}{4}$ width of cleat.)



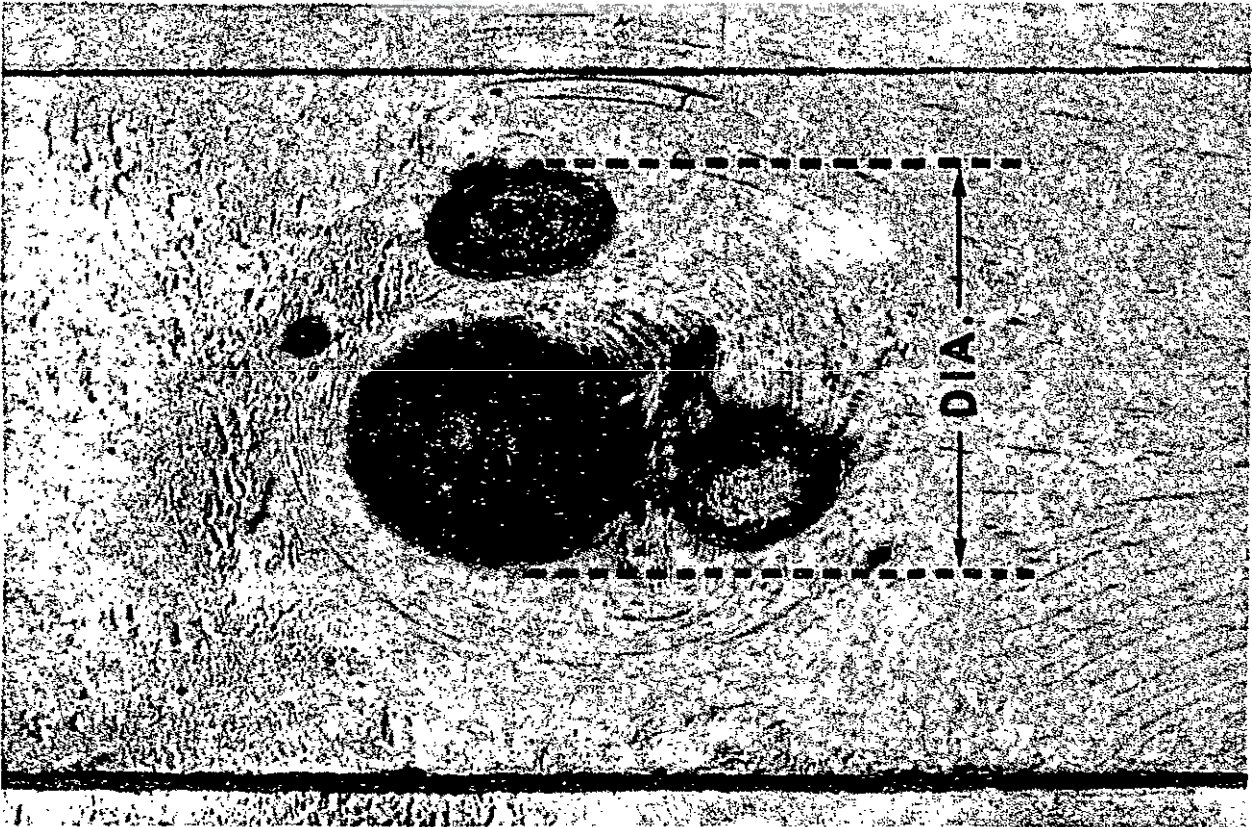
No. 1—TIGHT KNOT. Permissible. (Diameter less than $\frac{1}{4}$ width of cleat.)



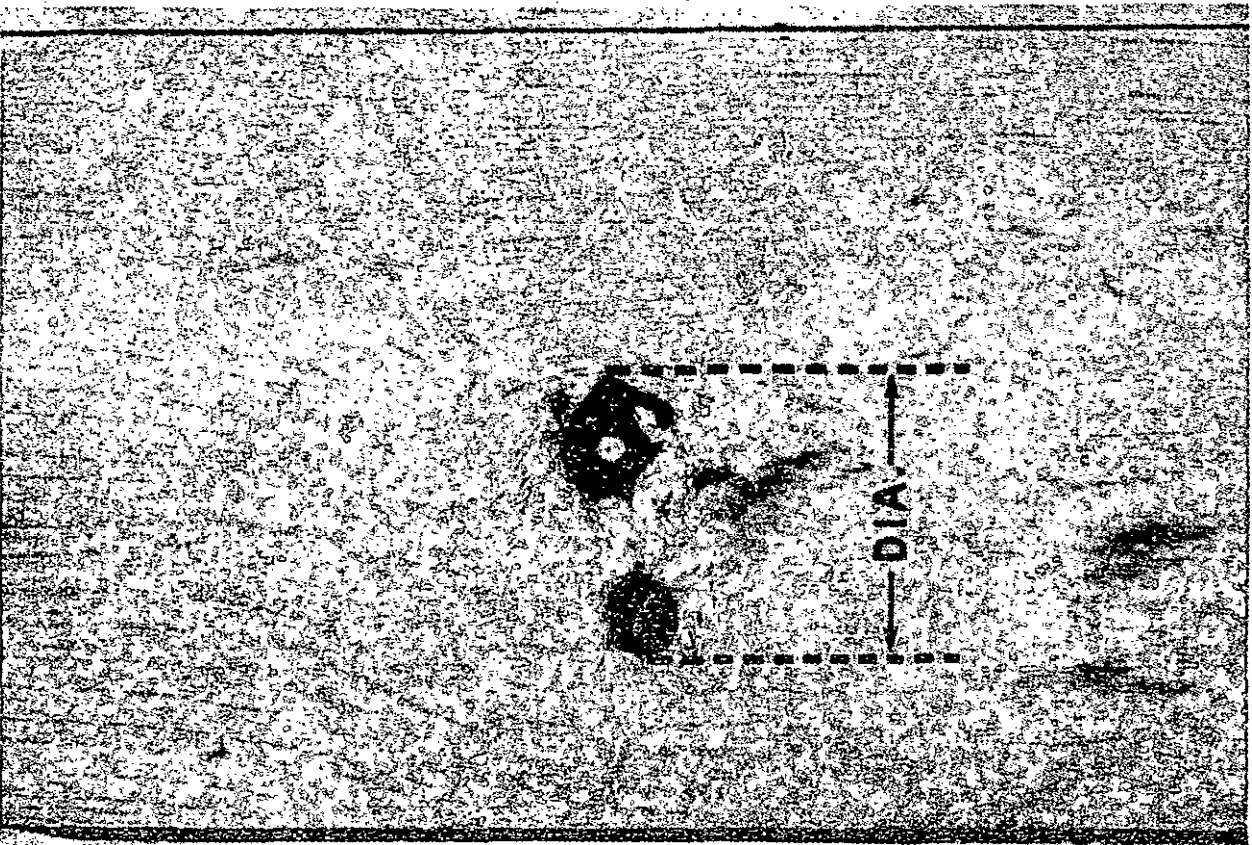
No. 1—KNOT CLUSTER. Minor. (Diameter greater than $\frac{1}{4}$ width of part.)



No. 1—KNOT CLUSTER. Permissible. (Diameter less than $\frac{1}{8}$ width of part.)



No. 1—KNOT CLUSTER. Minor. (Diameter greater than $\frac{1}{4}$ width of part.)

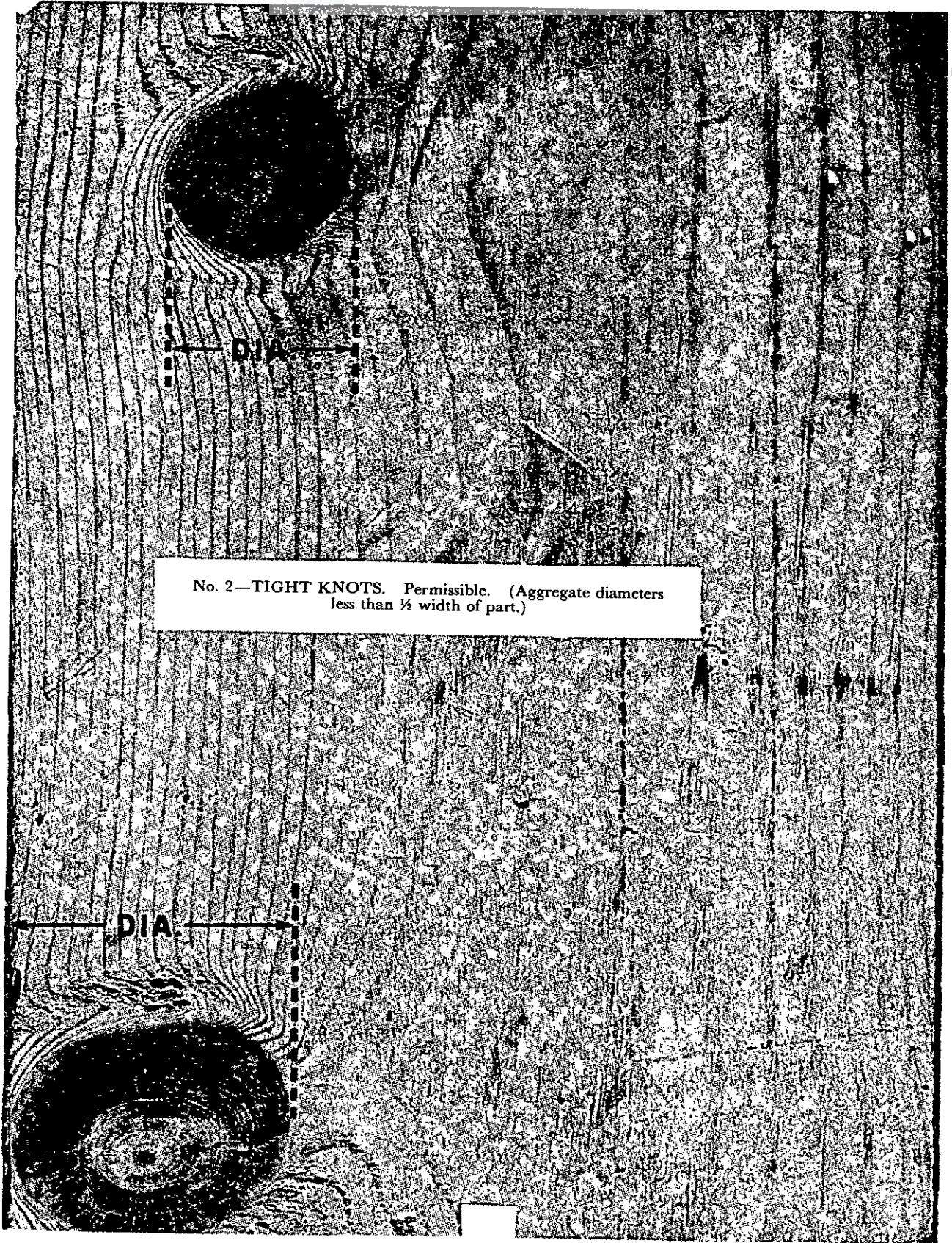


No. 1—KNOT CLUSTER. Permissible. (Diameter less than $\frac{1}{4}$ width of part.)

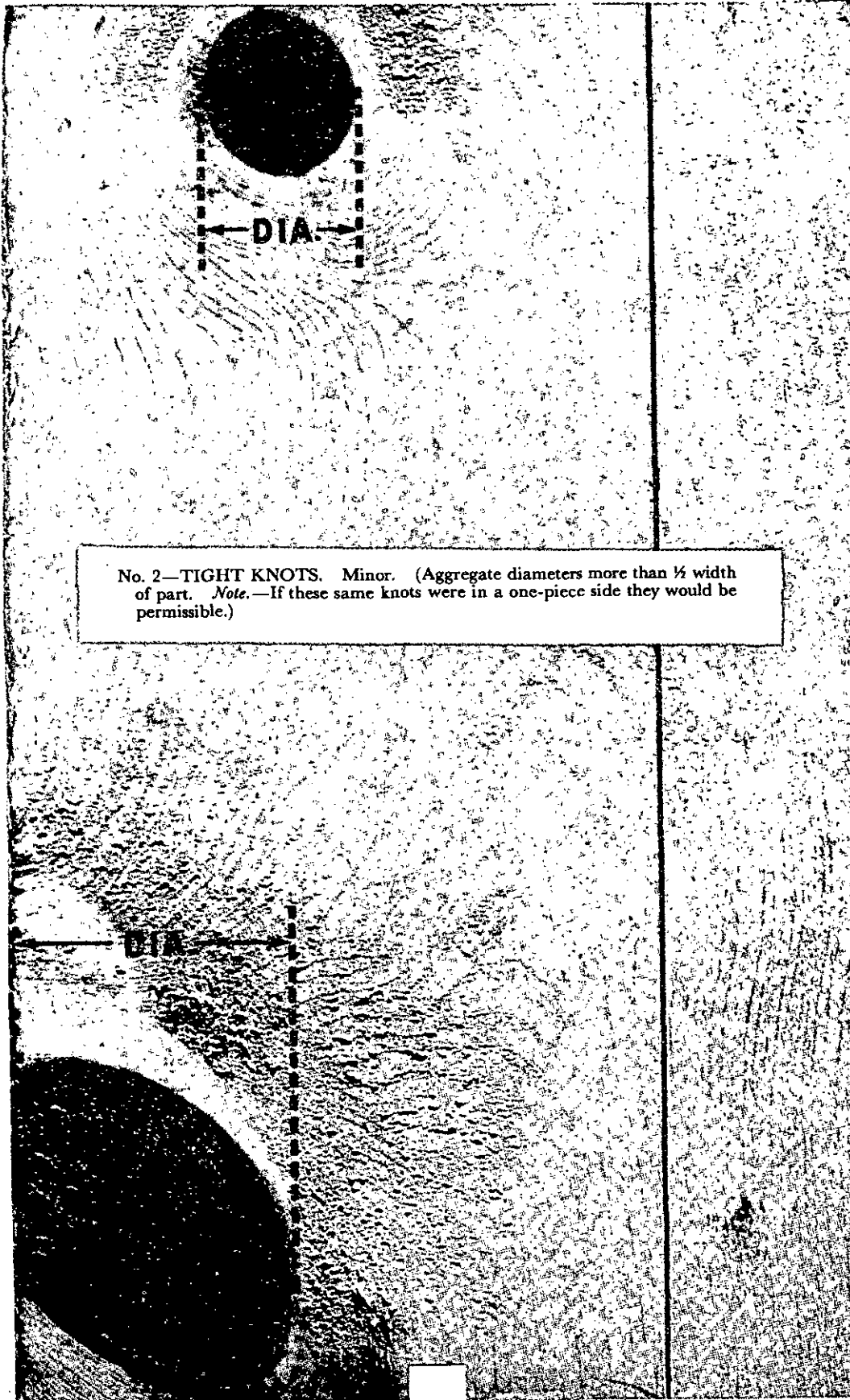


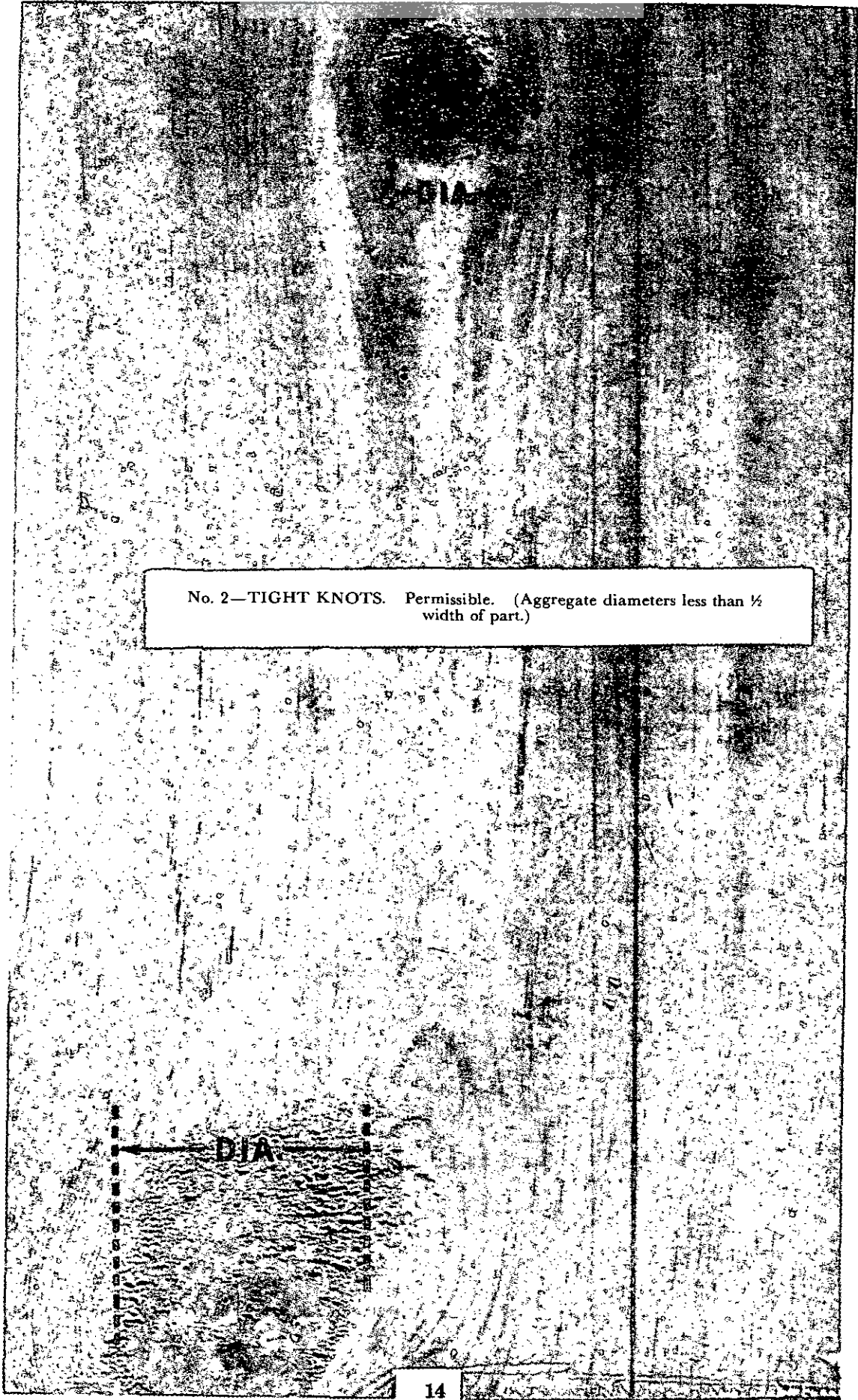
No. 2—TIGHT KNOTS. Minor. (Aggregate diameters greater than 1/2 width of part.)



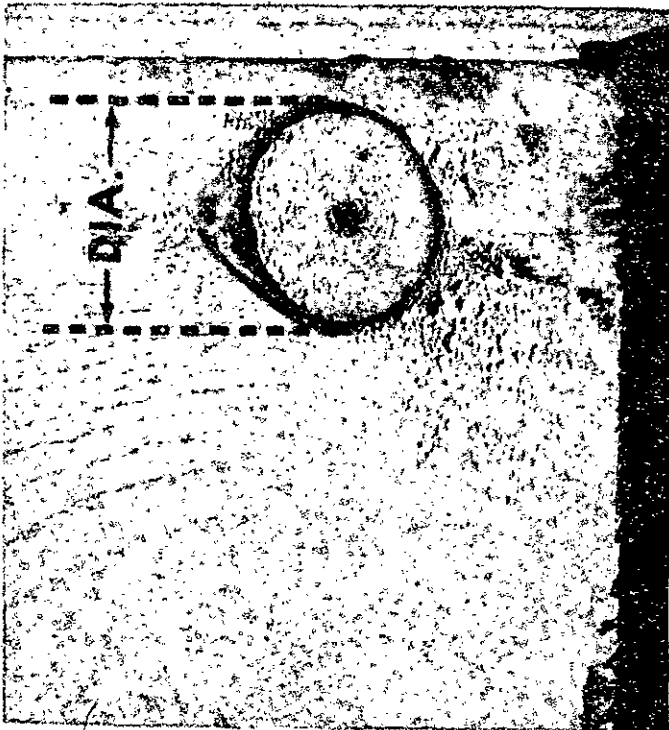


No. 2—TIGHT KNOTS. Permissible. (Aggregate diameters less than $\frac{1}{2}$ width of part.)

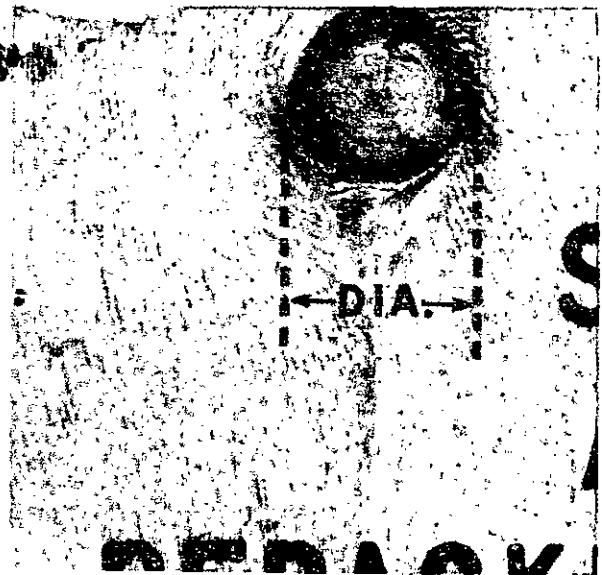




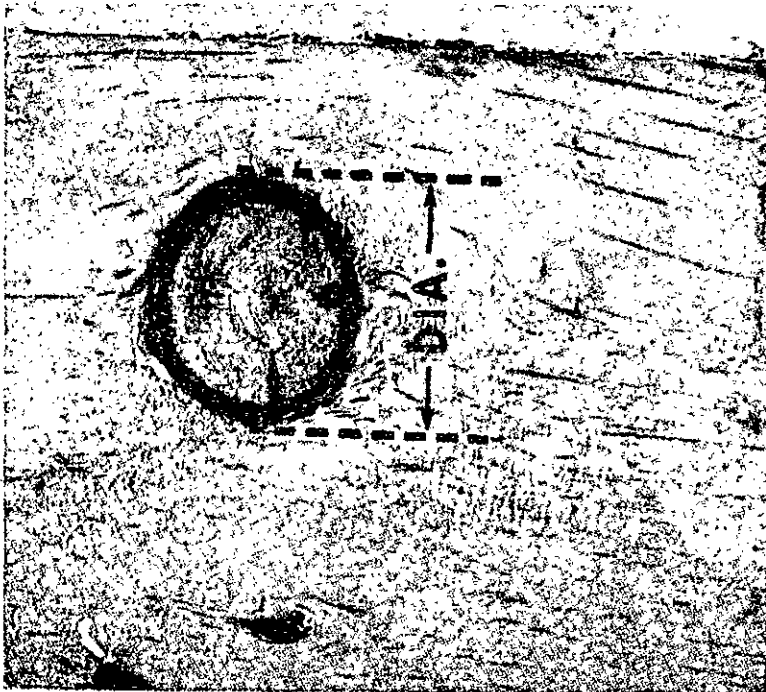
No. 2—TIGHT KNOTS. Permissible. (Aggregate diameters less than 1/2 width of part.)



No. 3—LOOSE KNOT. Minor. (Larger than $\frac{1}{2}$ " diameter.)



No. 3—LOOSE KNOT. Permissible. (Smaller than $\frac{1}{2}$ " diameter.)



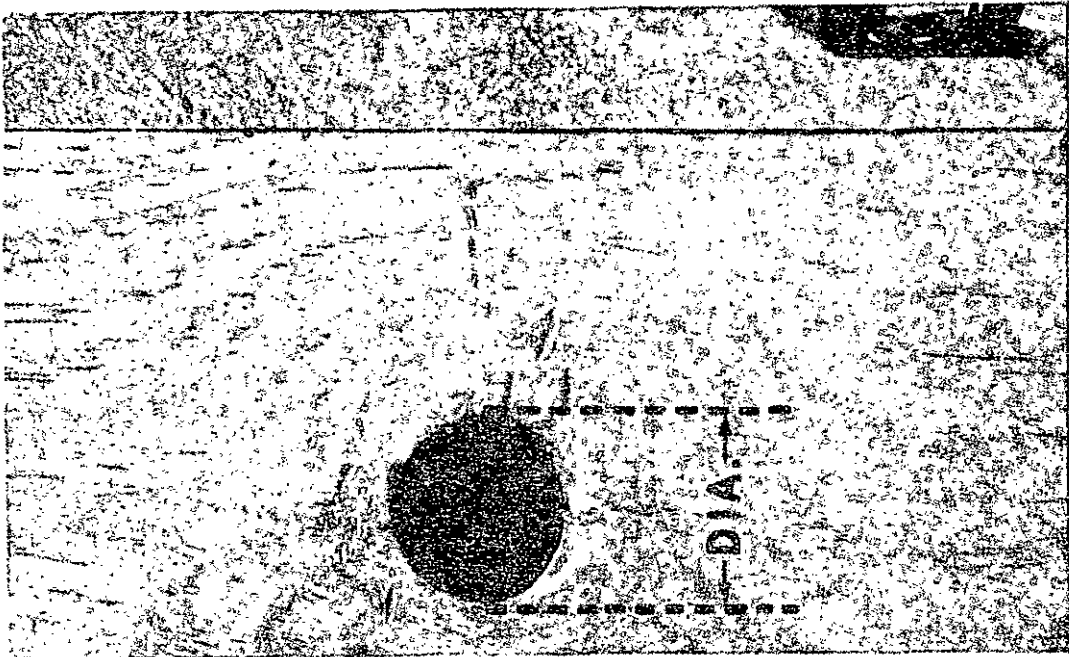
No. 3—ENCASED KNOT. Minor. (Larger than $\frac{1}{2}$ " diameter.)



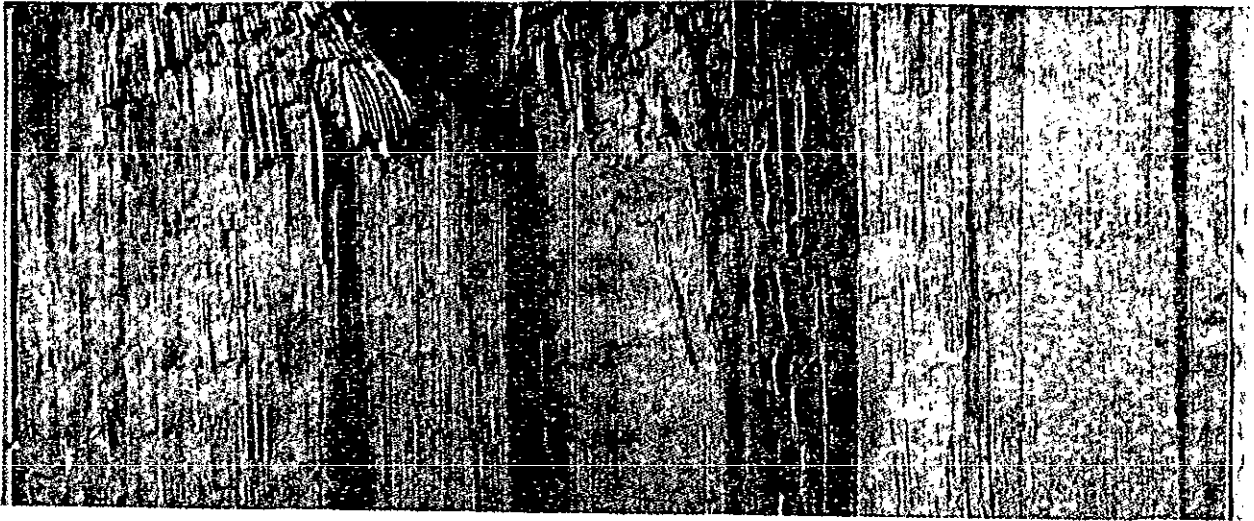
No. 3—ENCASED KNOT. Permissible. (Smaller than $\frac{1}{2}$ " diameter.)



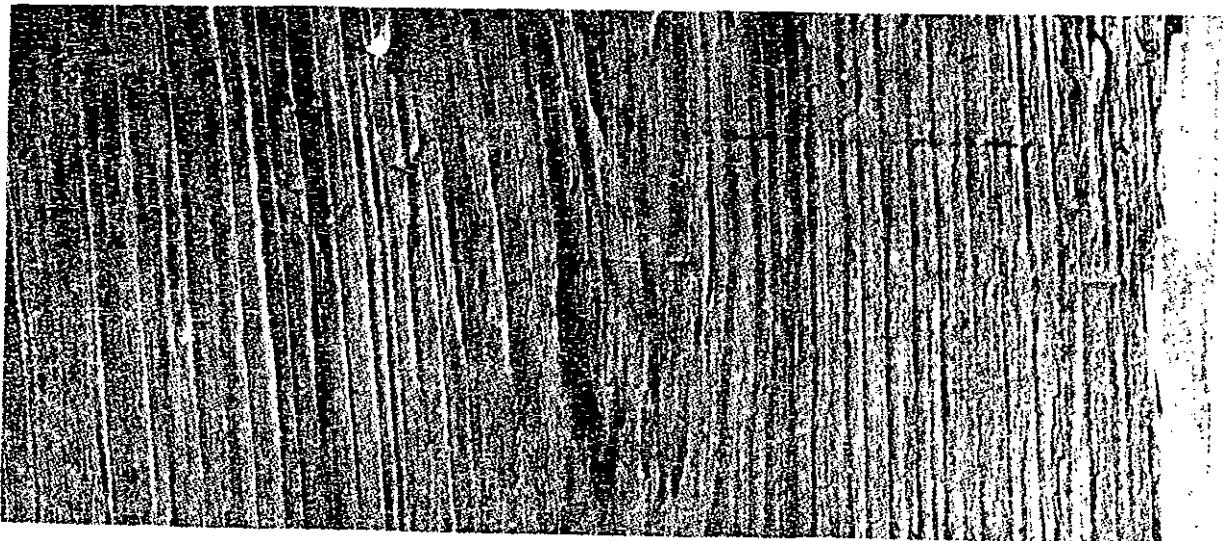
No. 3—KNOT HOLE. Minor. (Larger than $\frac{1}{2}$ " diameter.)



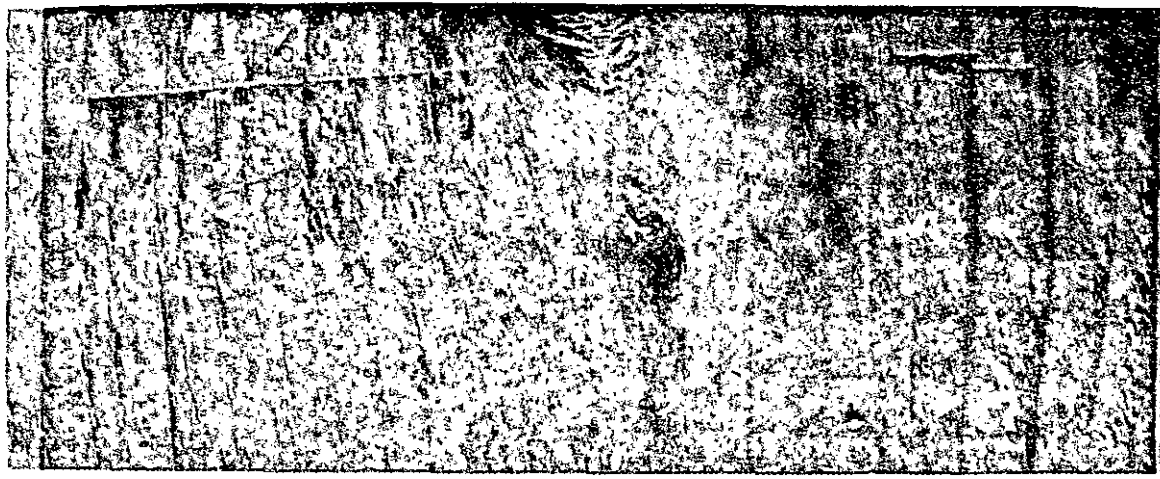
No. 3—KNOT HOLE. Permissible. (Smaller than $\frac{1}{2}$ " diameter.)



No. 4—DECAY. Major.



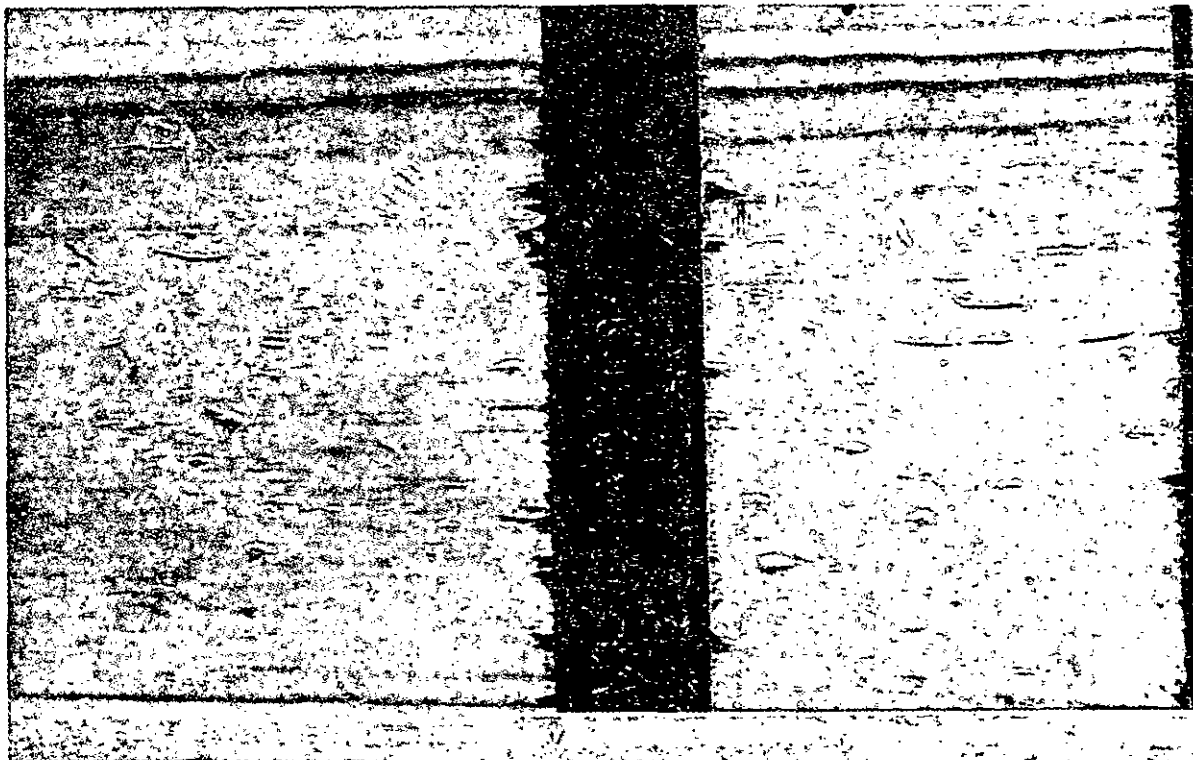
No. 4—DECAY. Major.



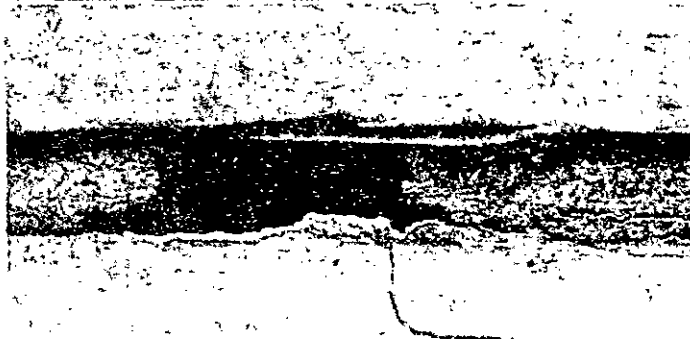
No. 4—DECAY. Major.



No. 4—DECAY. Major.

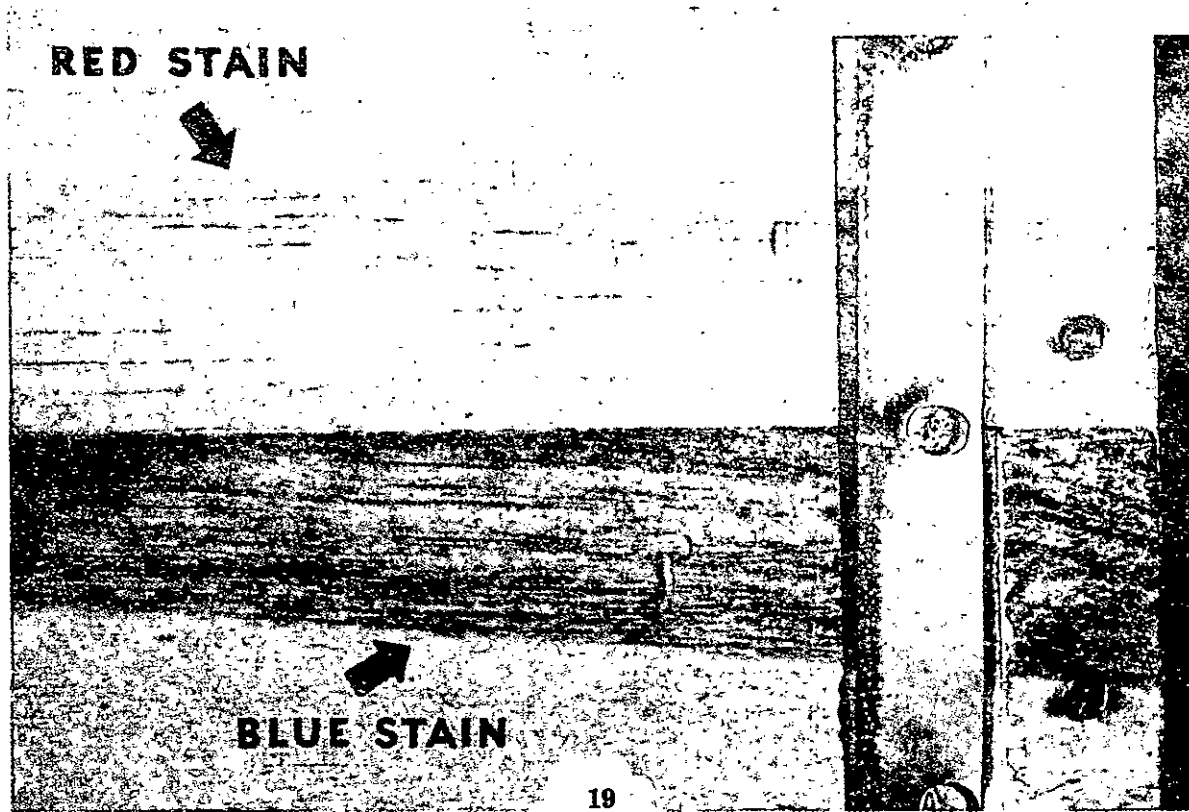


No. 4—DECAY. Major.



No. 4—DECAY. Major.

No. 4—SAP STAIN. Permissible.



RED STAIN

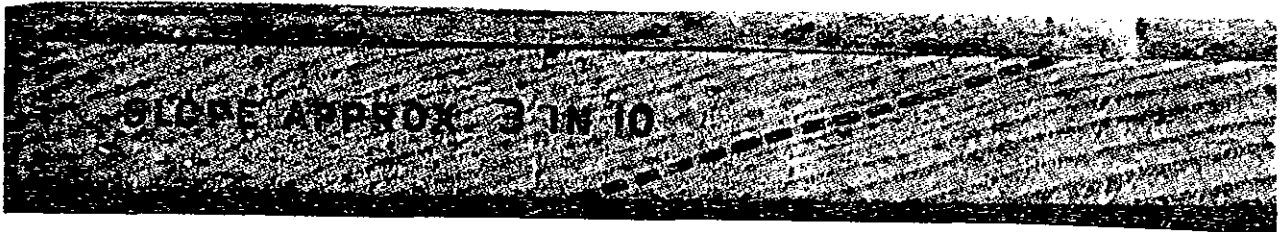


BLUE STAIN

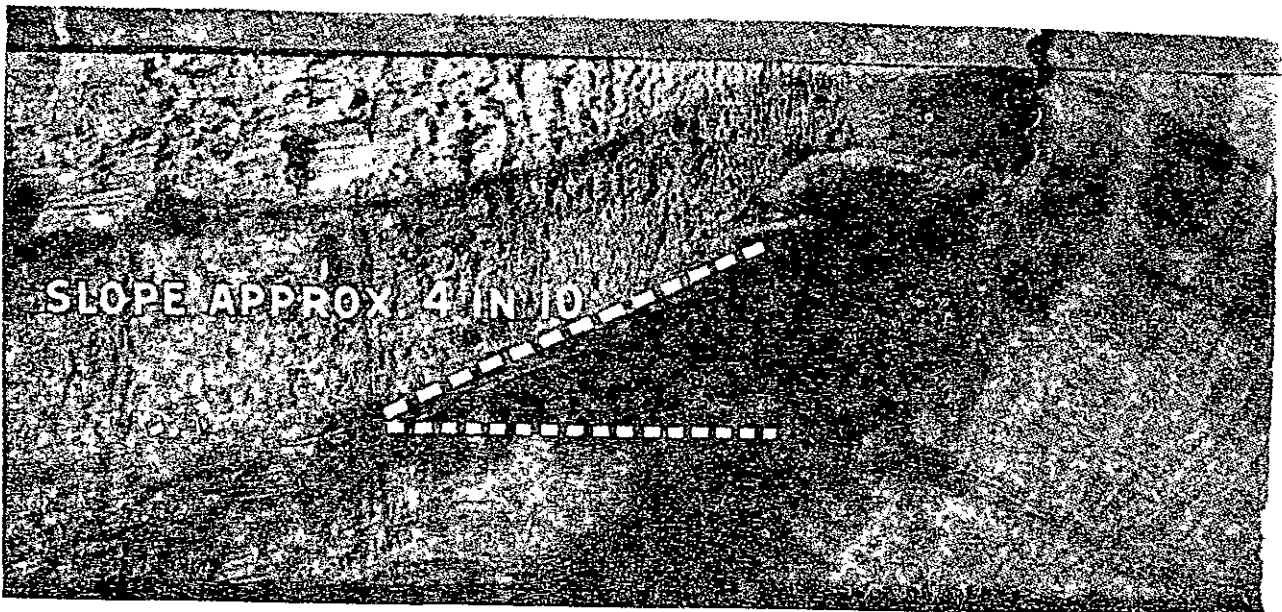




No. 7—CROSS GRAIN. Minor.



No. 7—CROSS GRAIN. Minor. (Slope greater than 1 in 8.)



No. 7—CROSS GRAIN. Minor. (Slope greater than 1 in 8.)



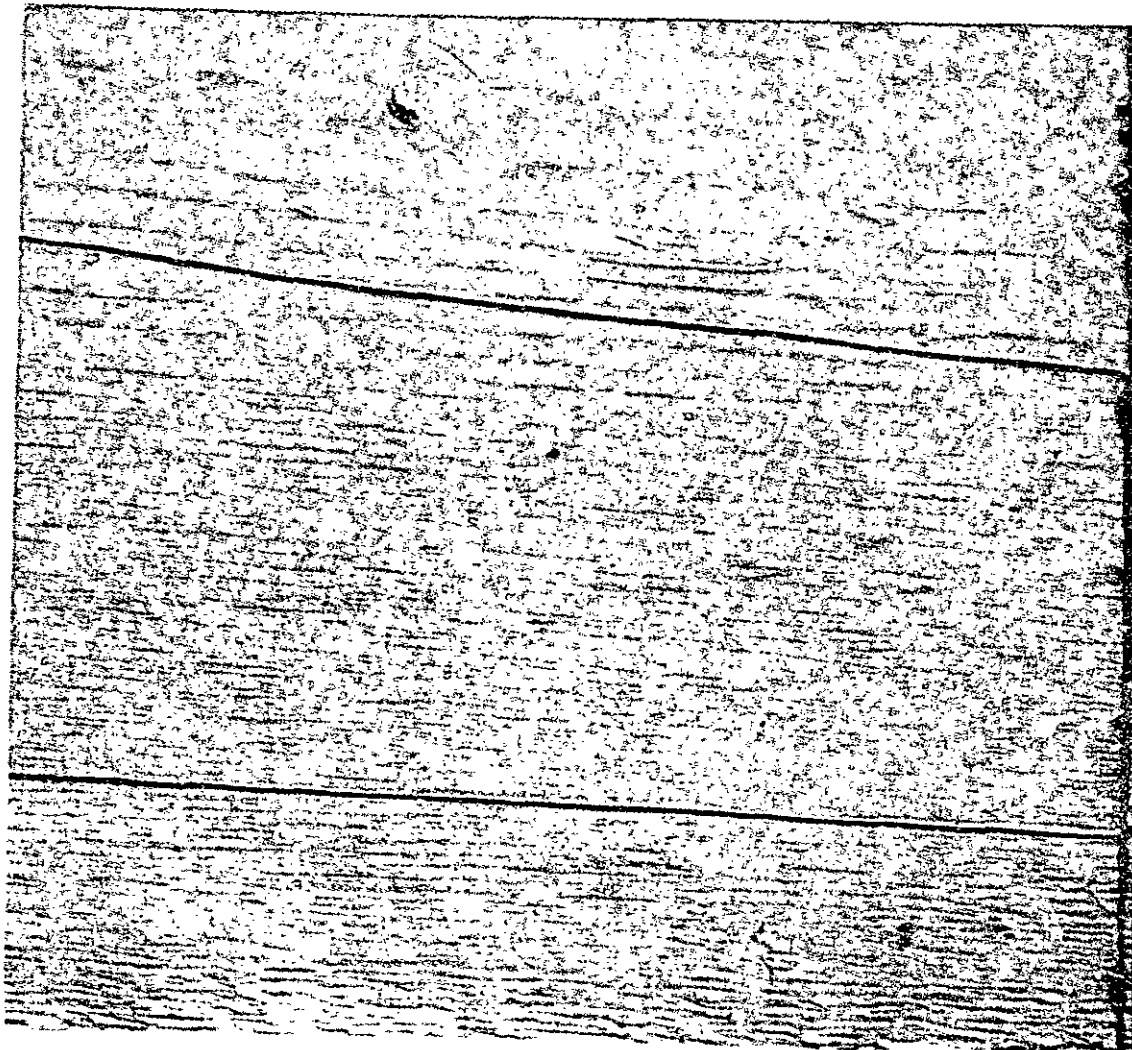
No. 7—CROSS GRAIN. Minor. (Slope greater than 1 in 8.)



No. 7—CROSS GRAIN. Permissible. (Slope 1 in 8 or less.) Slope illustrated approximately 1 in 8.



No. 8—SPLIT. Major. (Forms sliver at outside edge.)

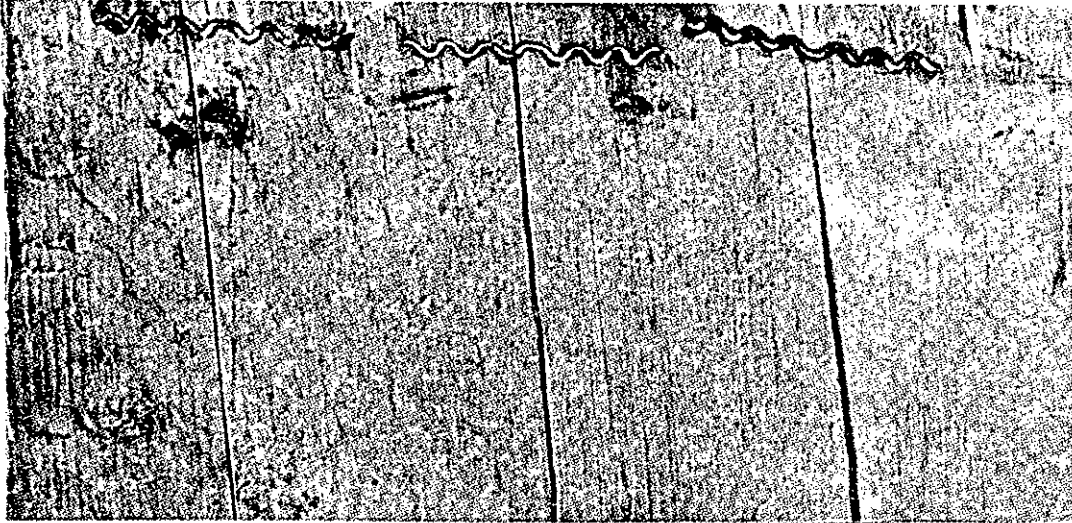


No. 9—FULL LENGTH SPLITS. Minor. (More than one unrepaired in a part. *Note.*—
This would be permissible if one or both of the splits were repaired with corrugated fasteners.)

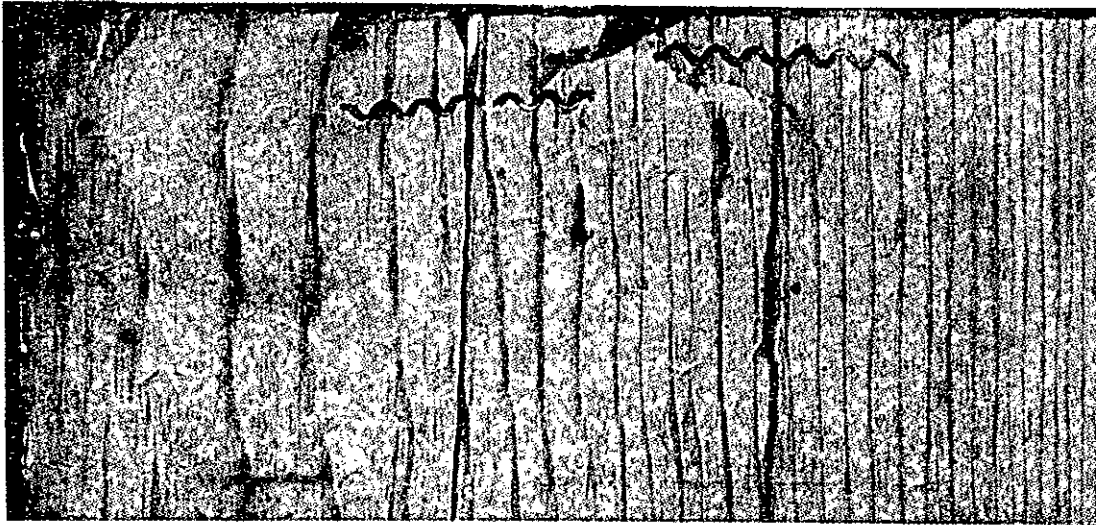


No. 9—FULL LENGTH SPLIT. Permissible. (Not more than one, unrepaired, in a part.)

8 -



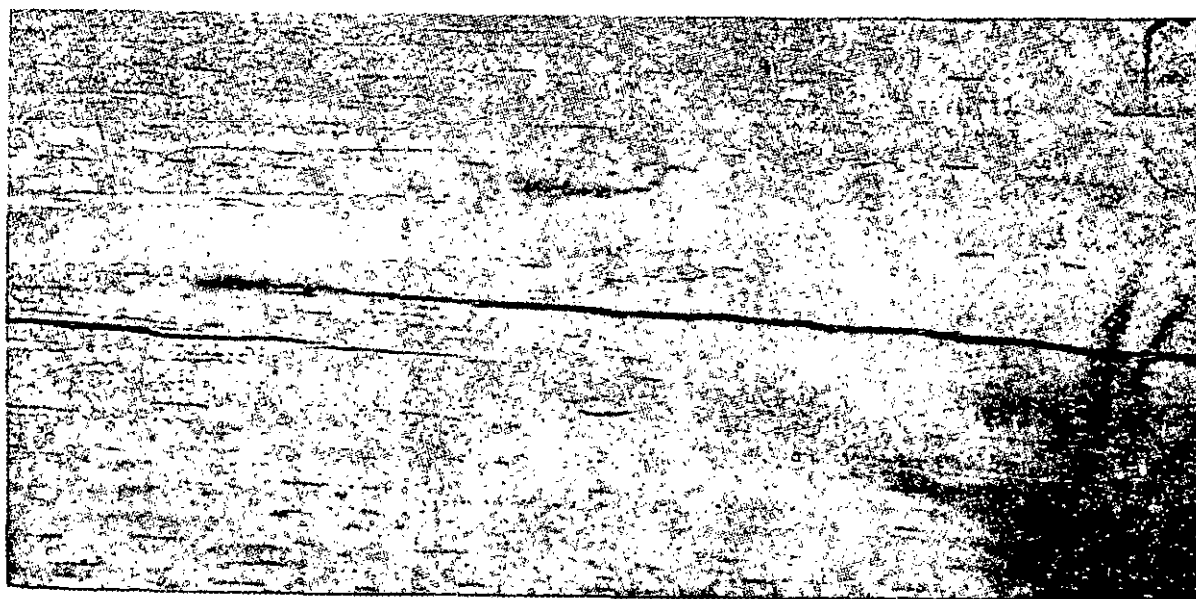
No. 10—FULL LENGTH SPLITS. Minor. (More than two, repaired, in a part.)



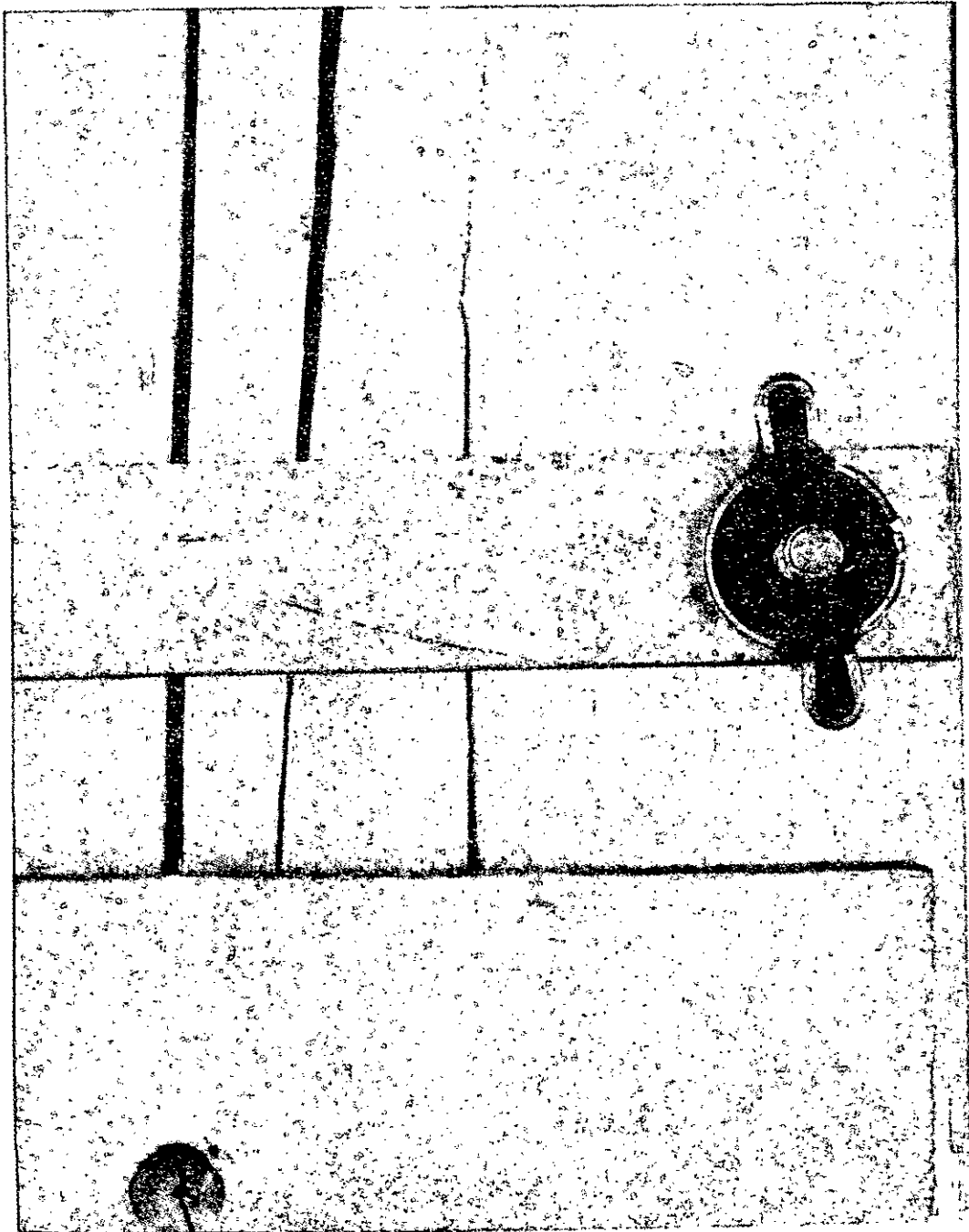
No. 10—FULL LENGTH SPLITS. Permissible. (Not more than two, repaired, in a part.)



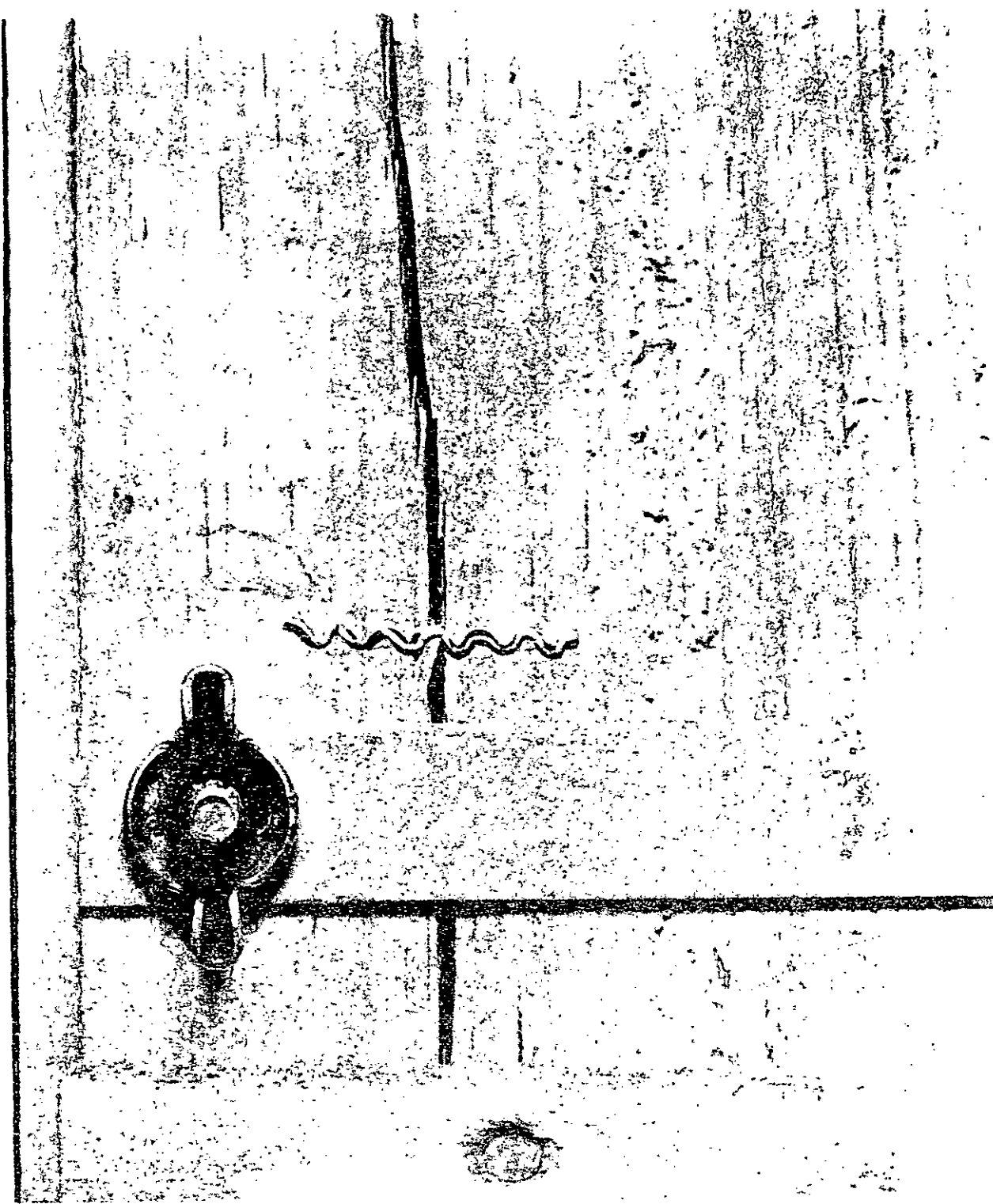
No. 11—PARTIAL SPLITS. Minor. (More than two, unrepaired, in a part. *Note.*—This would be permissible if one or more of the splits were repaired with corrugated fasteners.)



No. 11—PARTIAL SPLITS. Permissible. (Not more than two, unrepaired, in a part.)



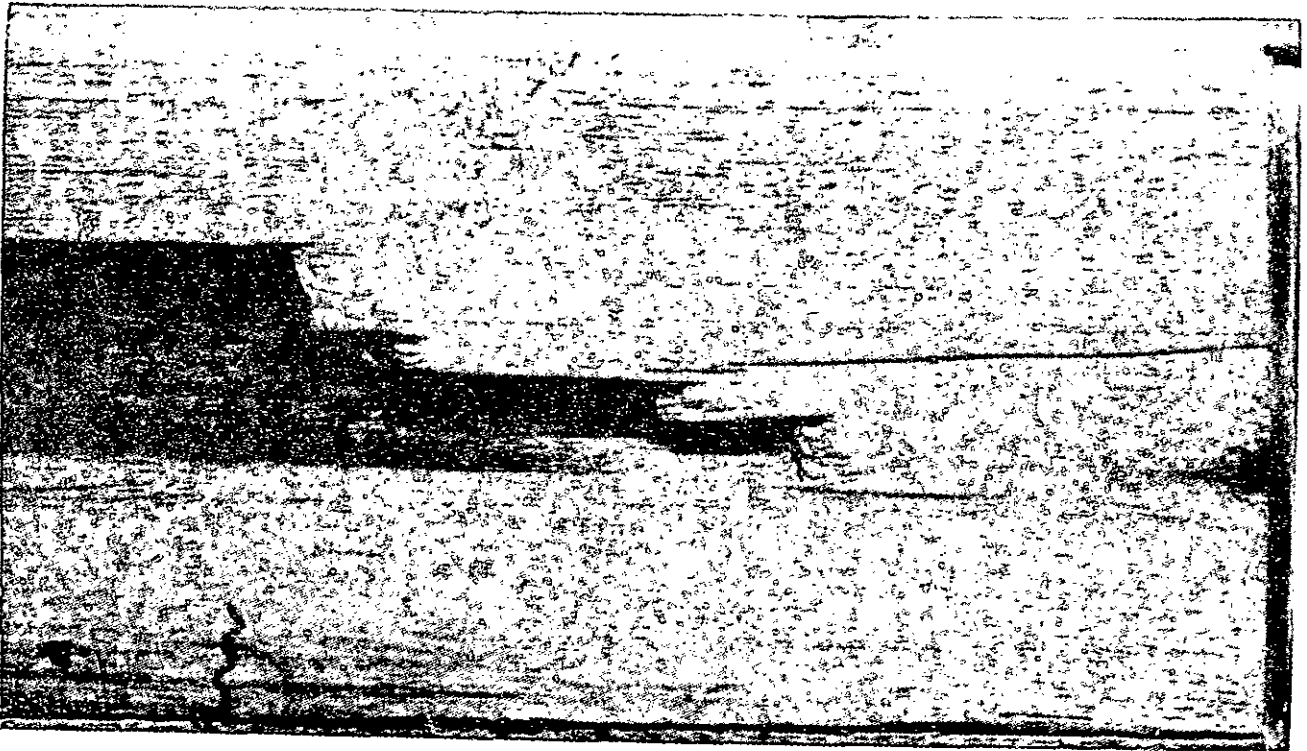
No. 12—SPLIT. Minor. (Either partial or full length in a cover.)



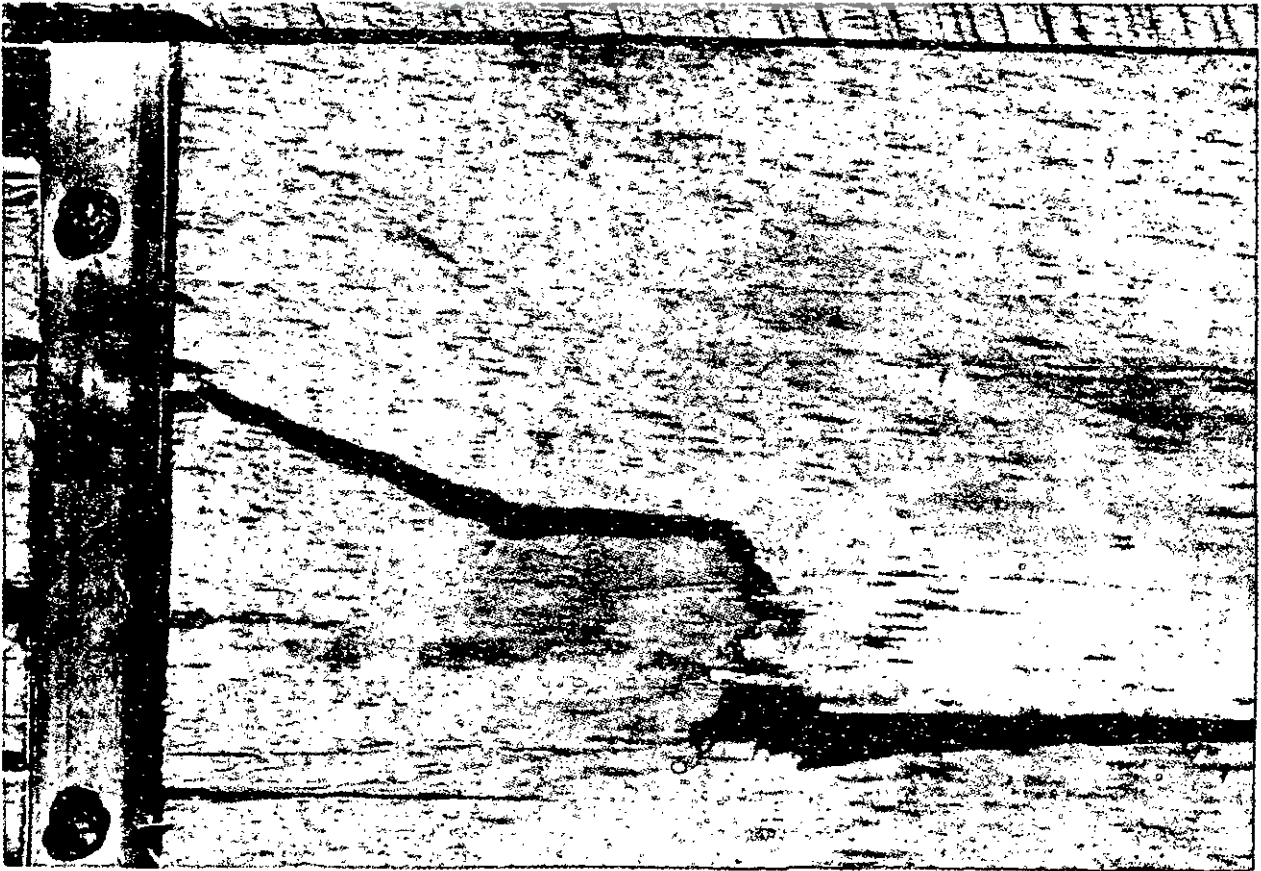
No. 12—SPLIT. Permissible. (In a cover, repaired.)



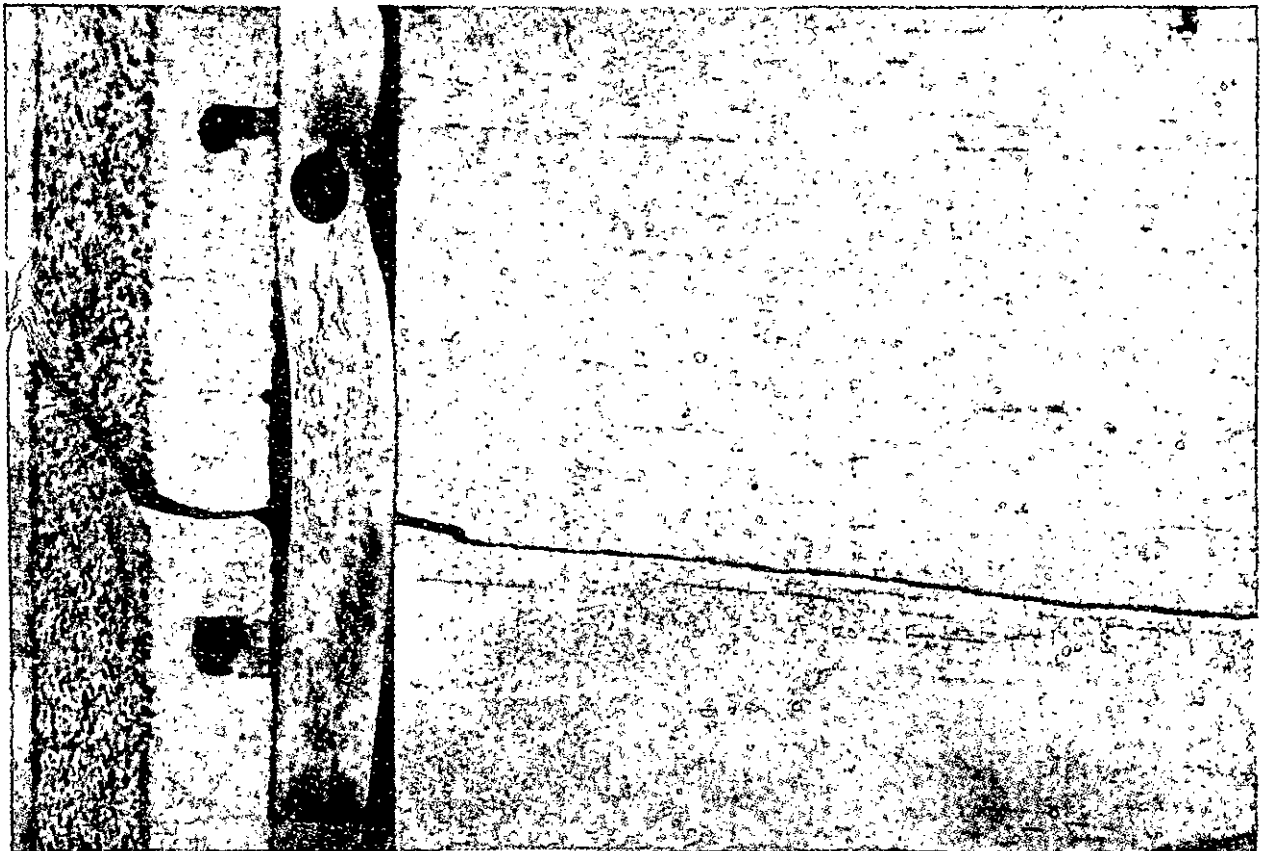
No. 13—SHAKE. Major.



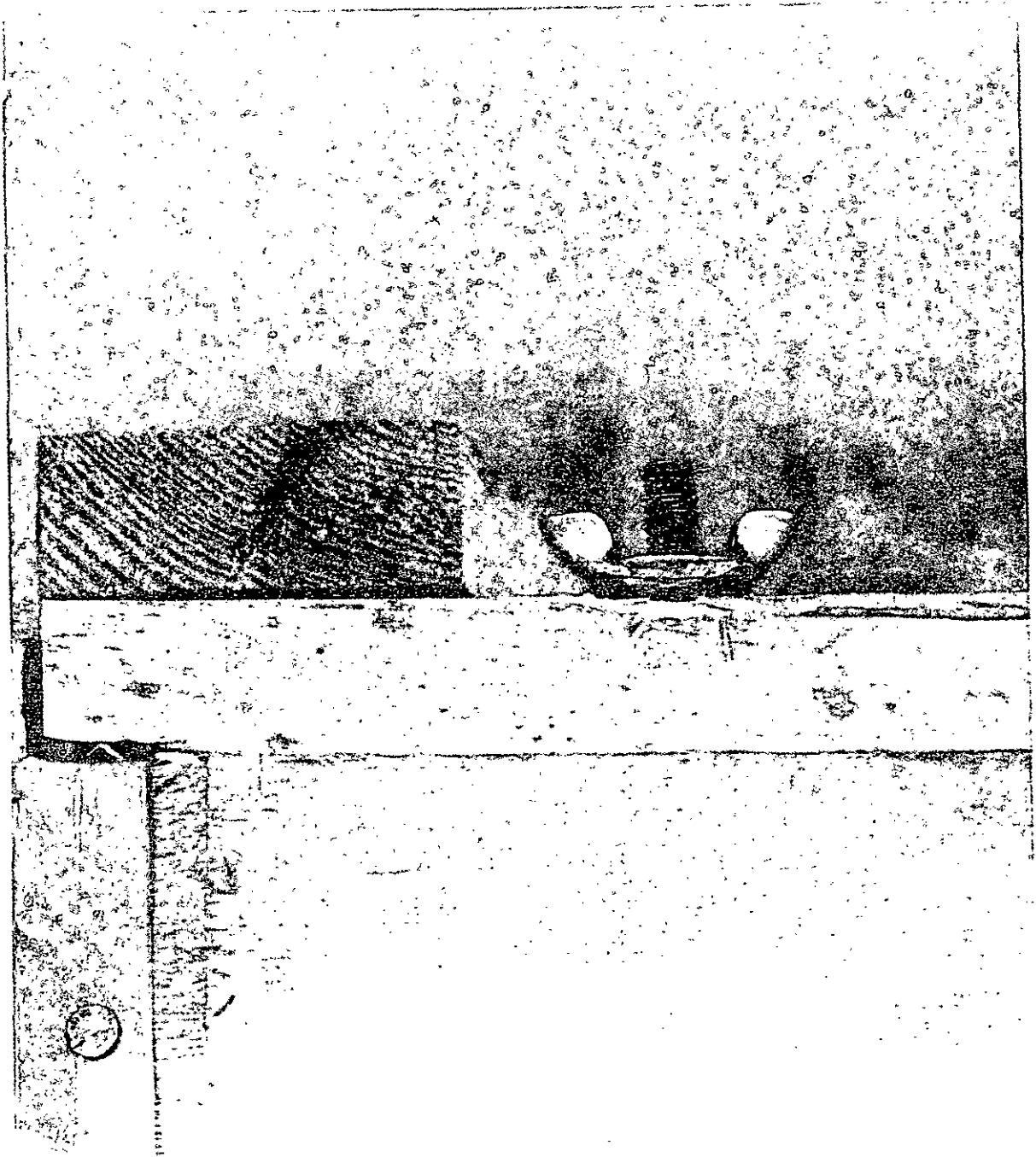
No. 13—SHAKE. Major.



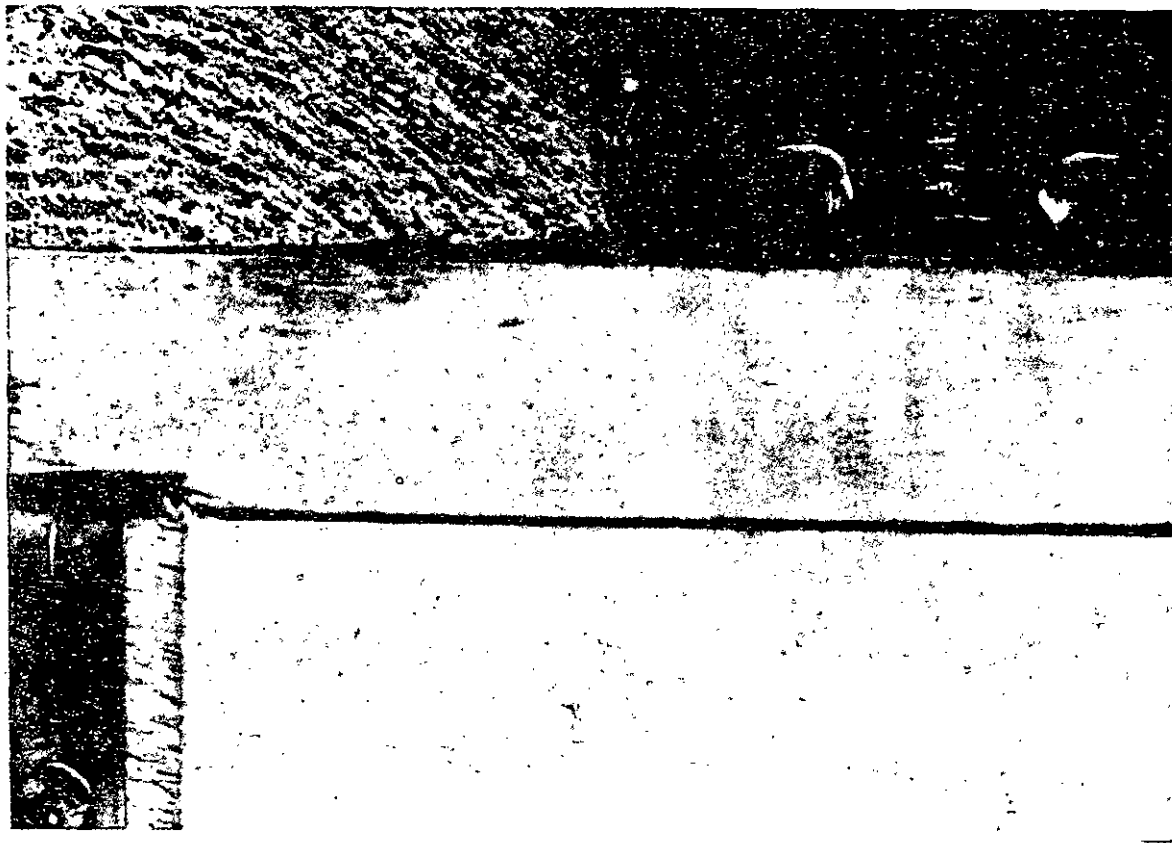
No. 13—SHAKE. Major.



No. 13—SHAKE. Permissible.



No. 15—DAMAGED HARDWARE. Minor. (Reinforcement burred.)

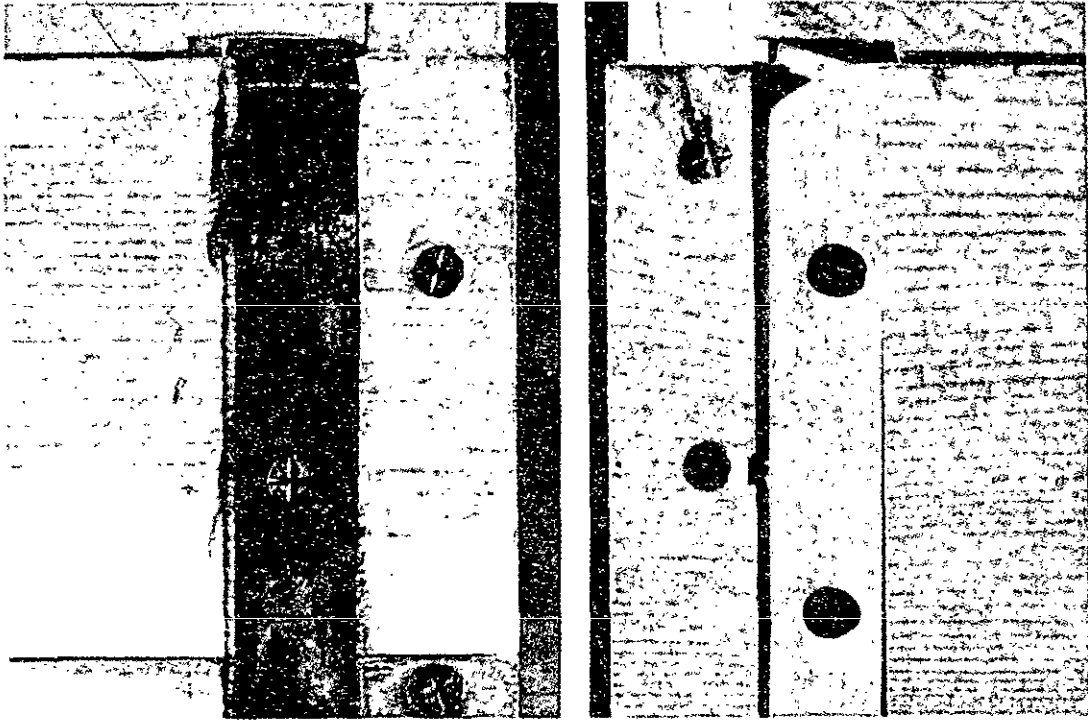


No. 15—DAMAGED HARDWARE. Minor. (Screw threads burred.)



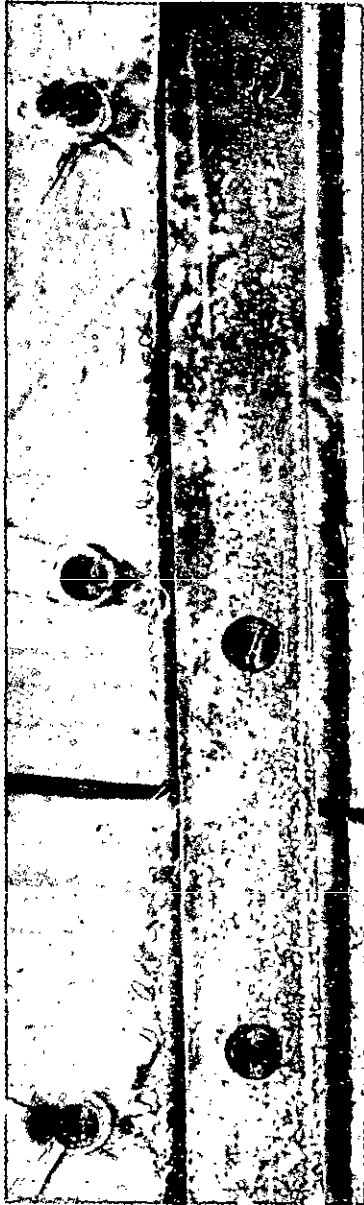
No. 15—DAMAGED HARDWARE. Minor. (Torn strap.)

No. 16—UNTREATED HARDWARE. Minor. (Reinforcements, wing-nuts, U-bolts, handles, ferrules and nails not illustrated. Treatment shall be in accordance with applicable drawings.)

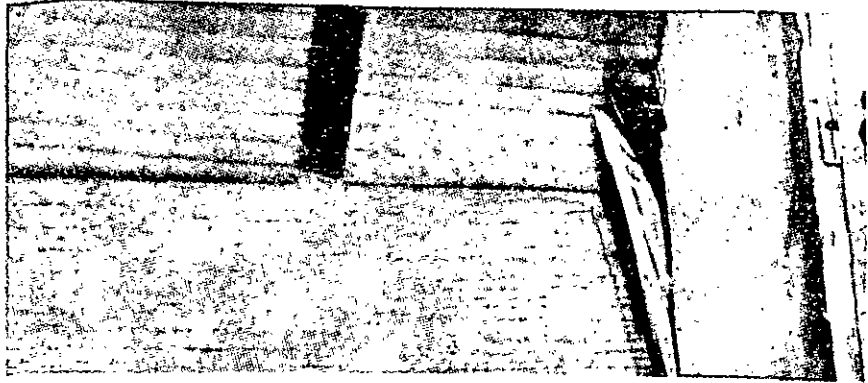


No. 16—UNTREATED HARDWARE. Minor.
(Strapping.)

No. 16—TREATED HARDWARE. (Strapping.
Galvanizing required.)



No. 18—PROTRUDING NAIL HEADS. Minor if more than 10% protrude. Permissible if 10% or less protrude.



No. 19—PROTRUDING NAIL POINT. Major.

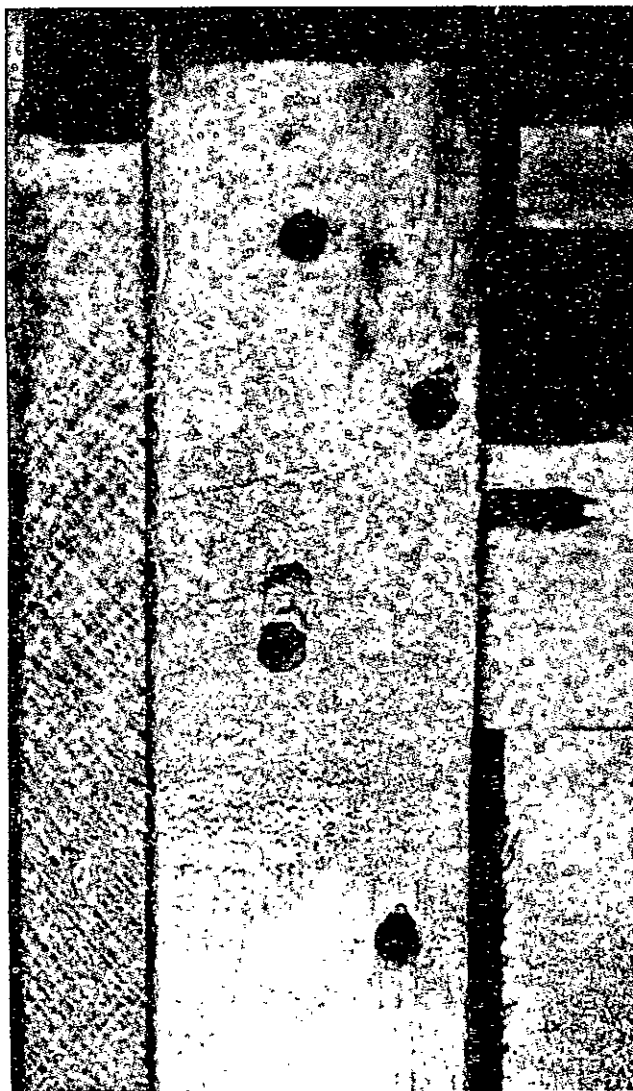


No. 19—PROTRUDING CORRUGATED FASTENER. Major.

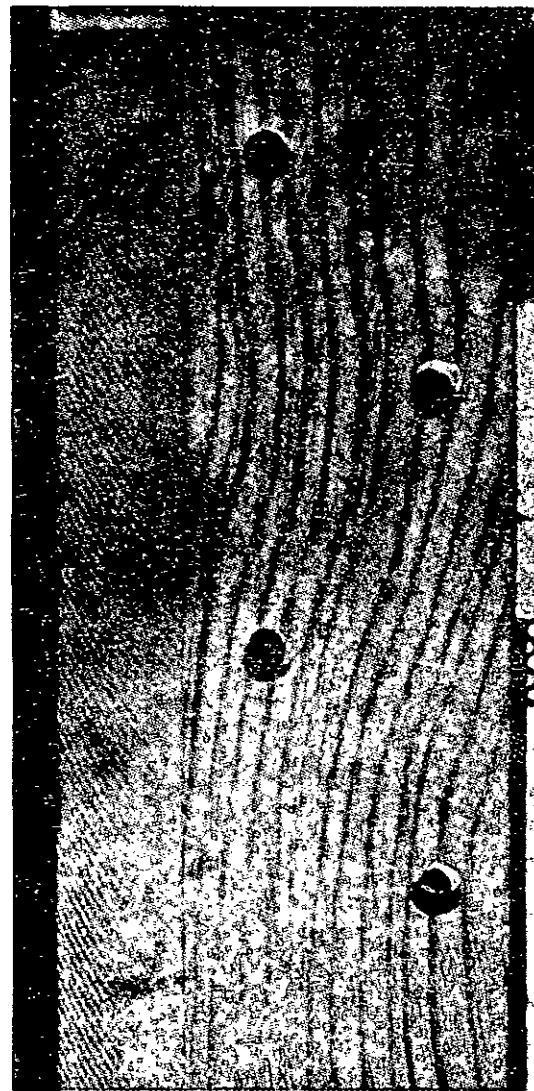


No. 19—PROTRUDING NAIL POINTS. Major.

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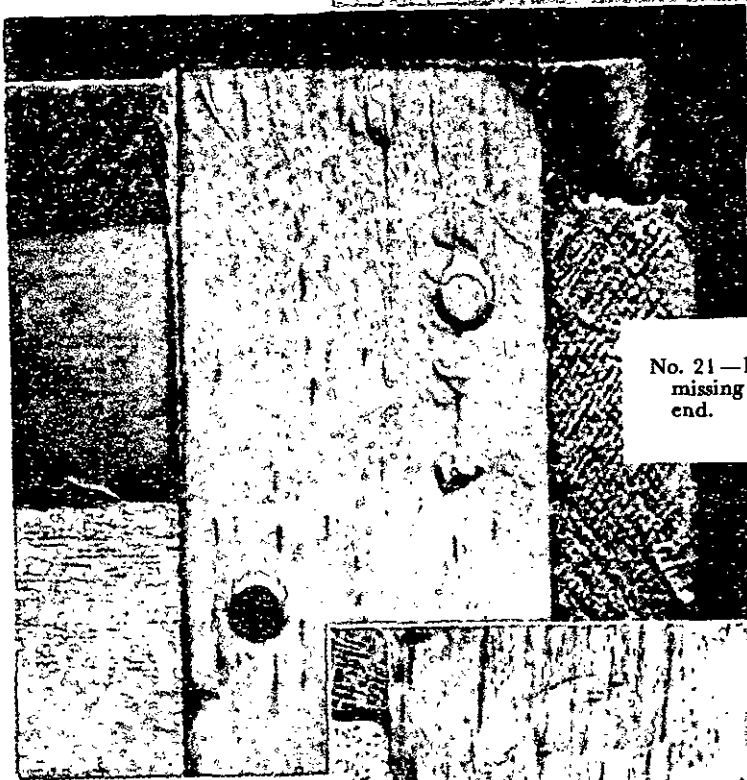
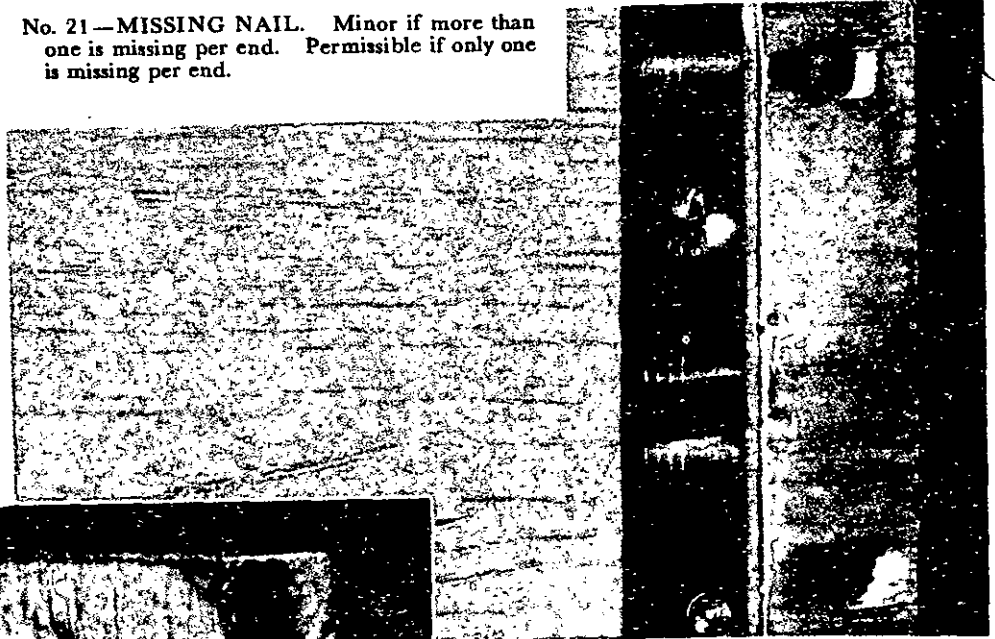


No. 20—OVERDRIVEN NAILS. (Driven more than $\frac{1}{2}$ " below surface.) Minor if more than 10% are overdriven. Permissible if less than 10% are overdriven.

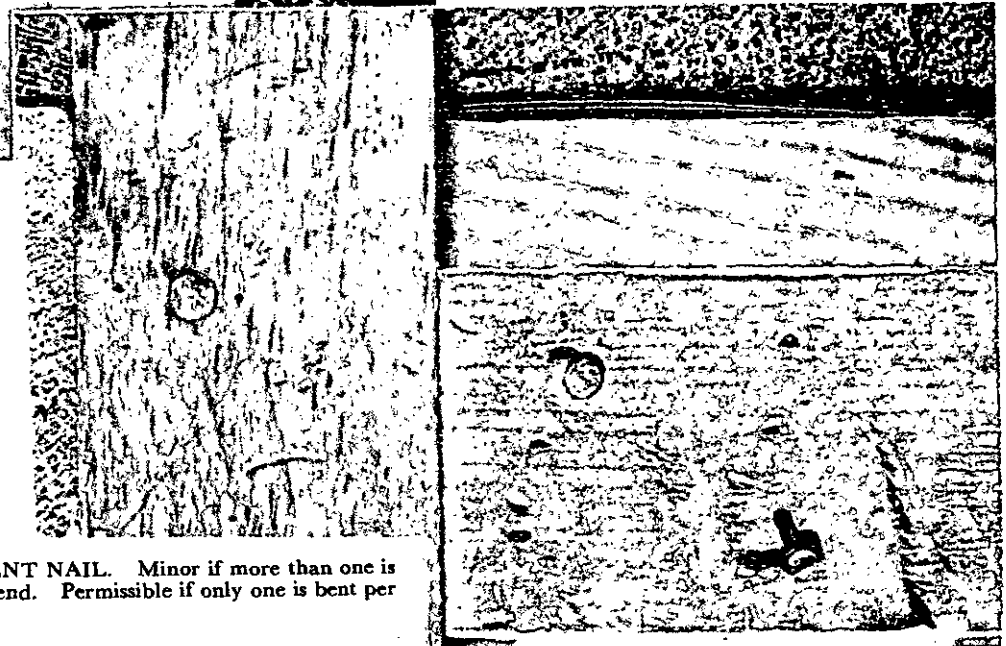


No. 20—OVERDRIVEN NAILS. Permissible. (Driven $\frac{1}{2}$ " or less below surface.)

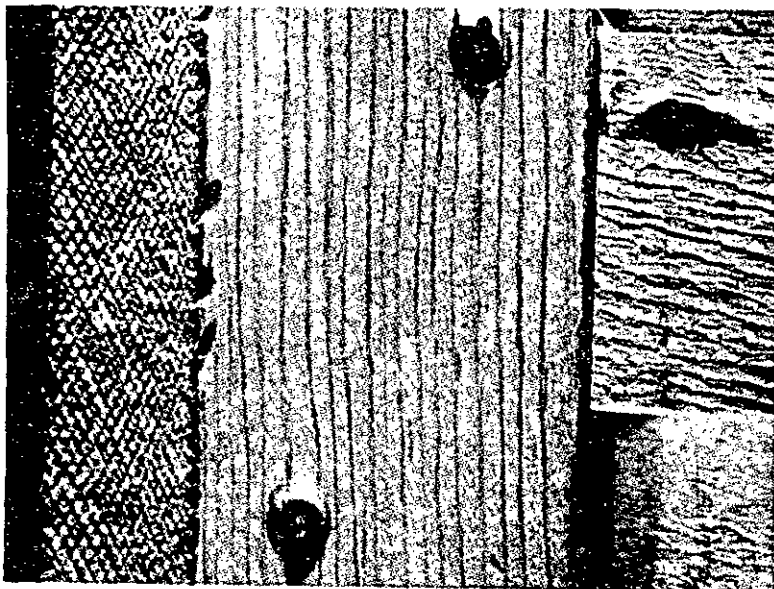
No. 21—MISSING NAIL. Minor if more than one is missing per end. Permissible if only one is missing per end.



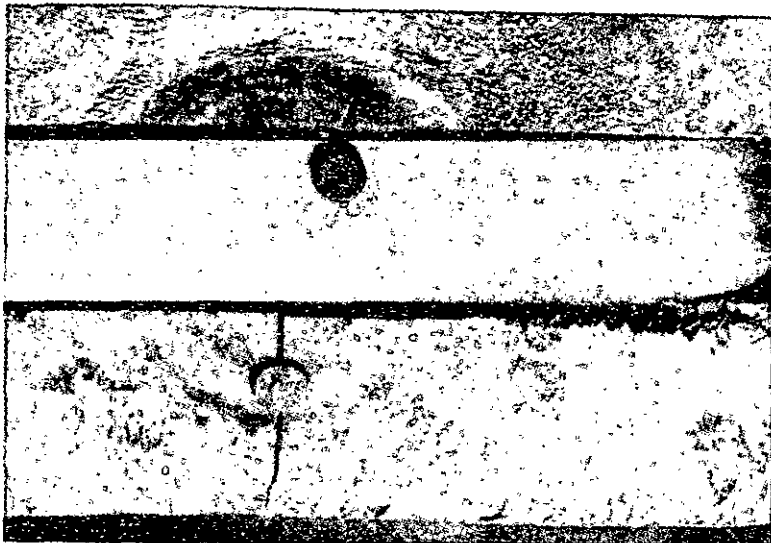
No. 21—MISSING NAIL. Minor if more than one is missing per end. Permissible if only one is missing per end.



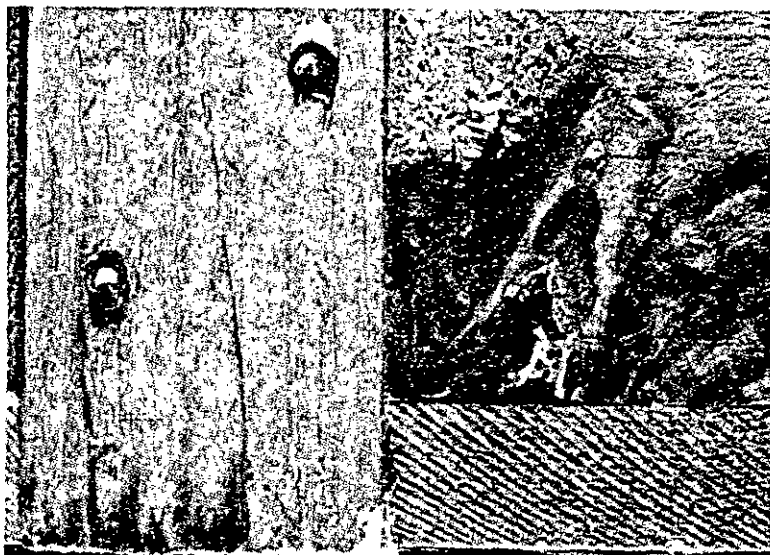
No. 22—BENT NAIL. Minor if more than one is bent per end. Permissible if only one is bent per end.



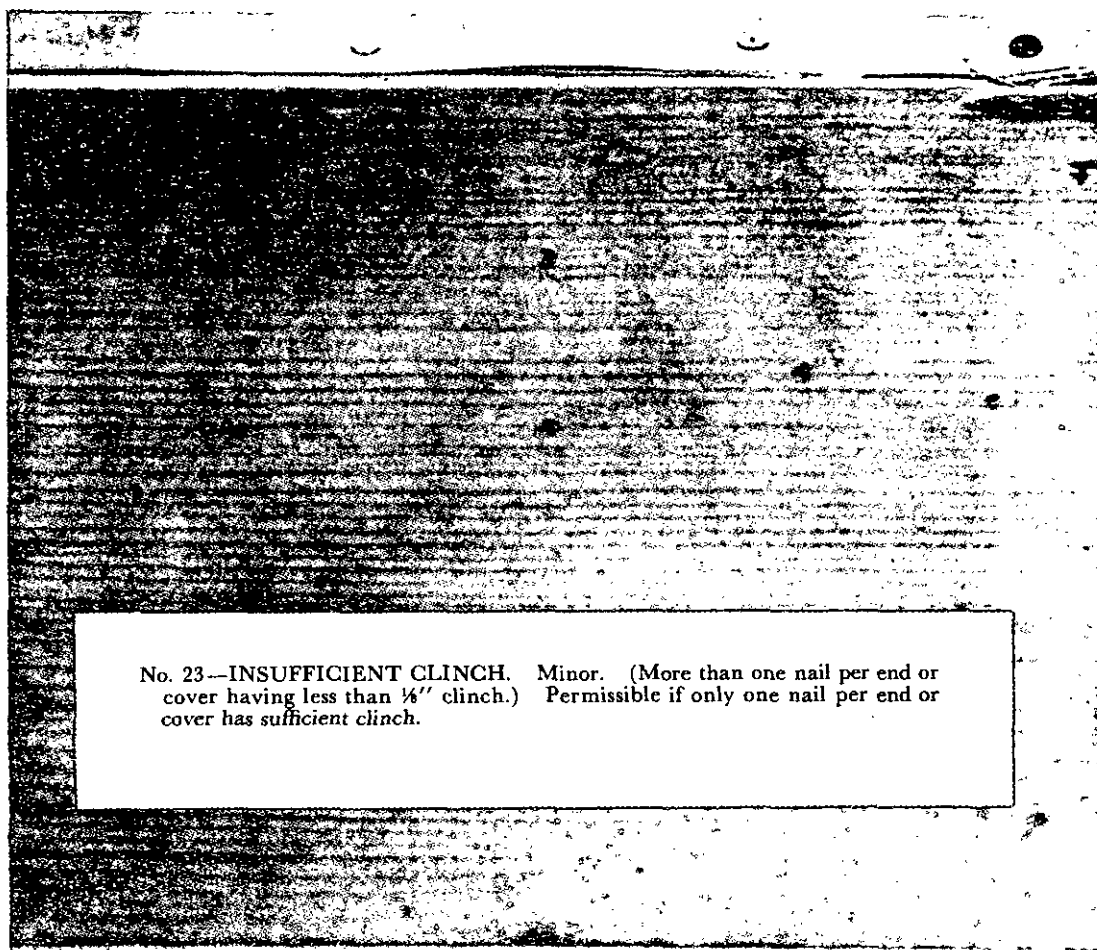
No. 22—BENT NAIL. Minor if more than one is bent per end. Permissible if only one is bent per end.



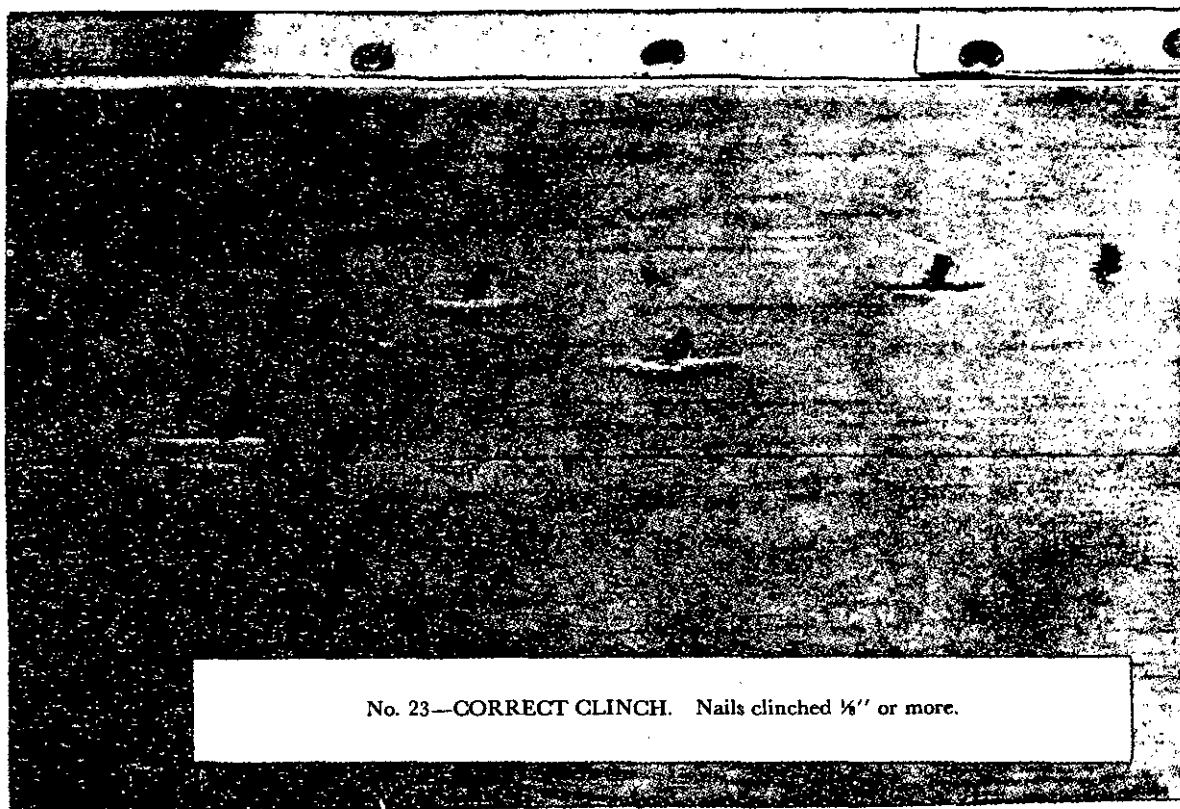
No. 22—NAILS DRIVEN THROUGH KNOT. Minor. Permissible if only one per end is driven through knot.



No. 22—NAILS DRIVEN INTO KNOT. Minor. Permissible if only one per end is driven into knot.

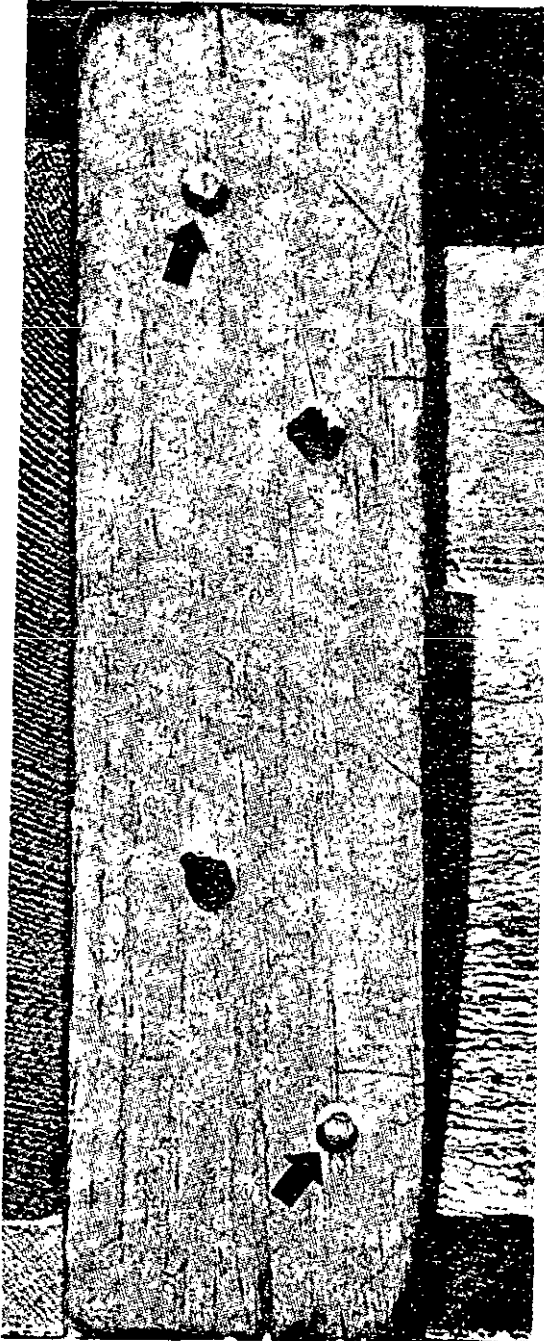


No. 23--INSUFFICIENT CLINCH. Minor. (More than one nail per end or cover having less than $\frac{1}{8}$ " clinch.) Permissible if only one nail per end or cover has sufficient clinch.

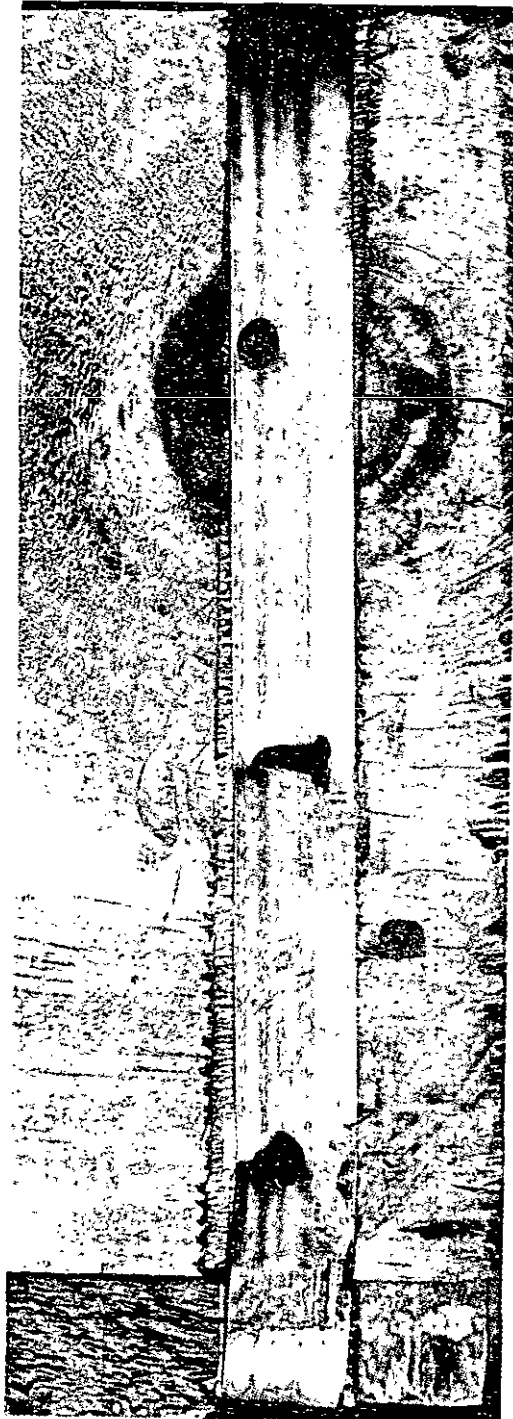


No. 23--CORRECT CLINCH. Nails clinched $\frac{1}{8}$ " or more.

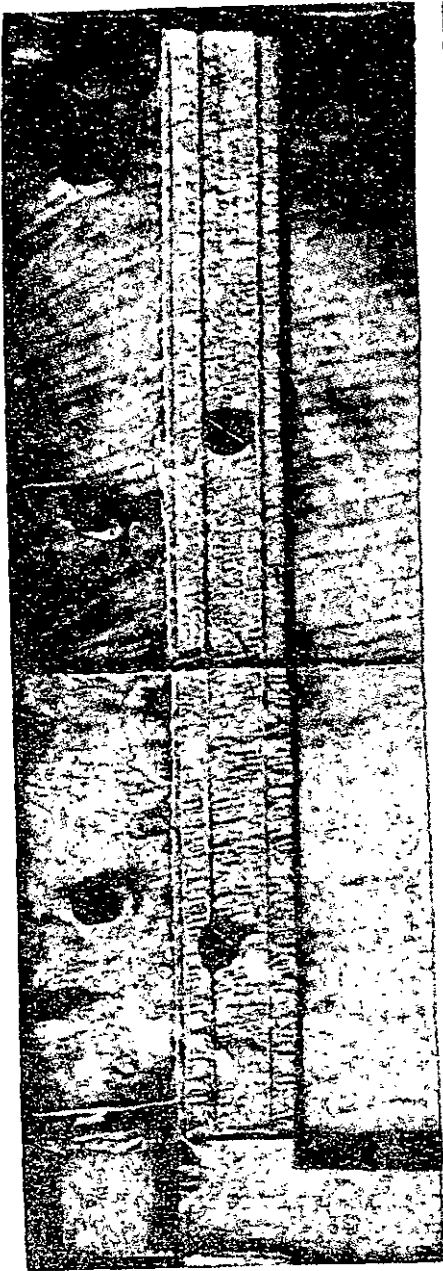
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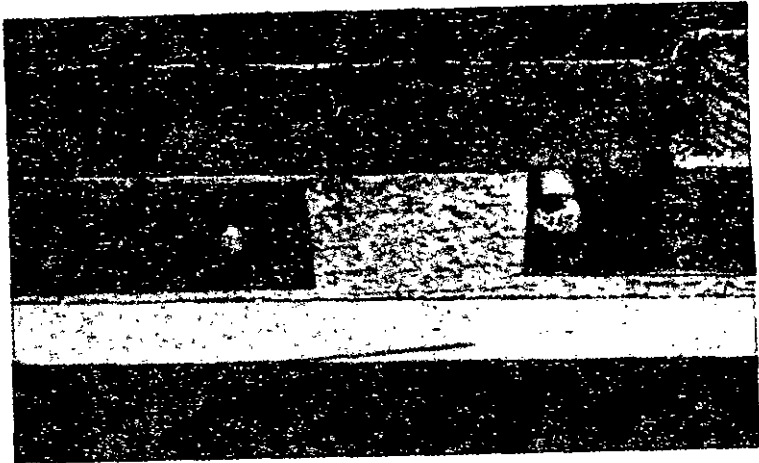
No. 24—COMBINED NAILING DEFECTS.
Major. (Two missing and two bent nails in one
cleat. Note.—Any other combination of defects
21, 22 and 23 also major.)



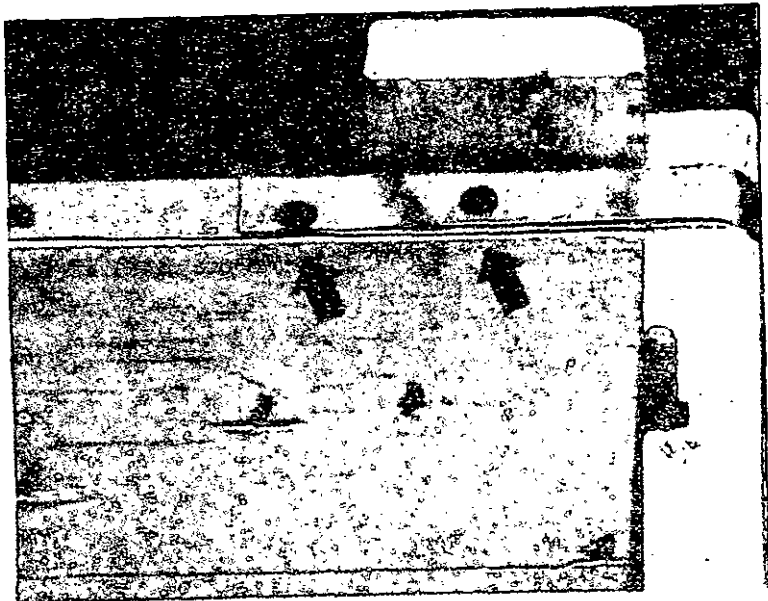
No. 24—COMBINED NAILING DEFECTS.
Major. (Two bent nails and two nails driven
through knot in same end of side.)



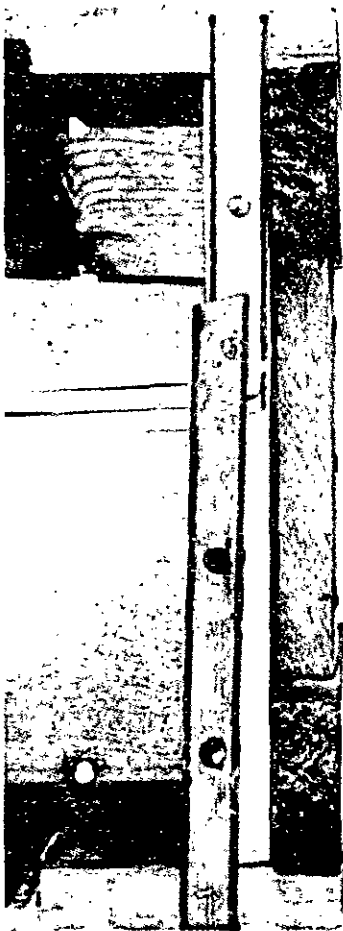
No. 25—MISSING STRAP. Major.



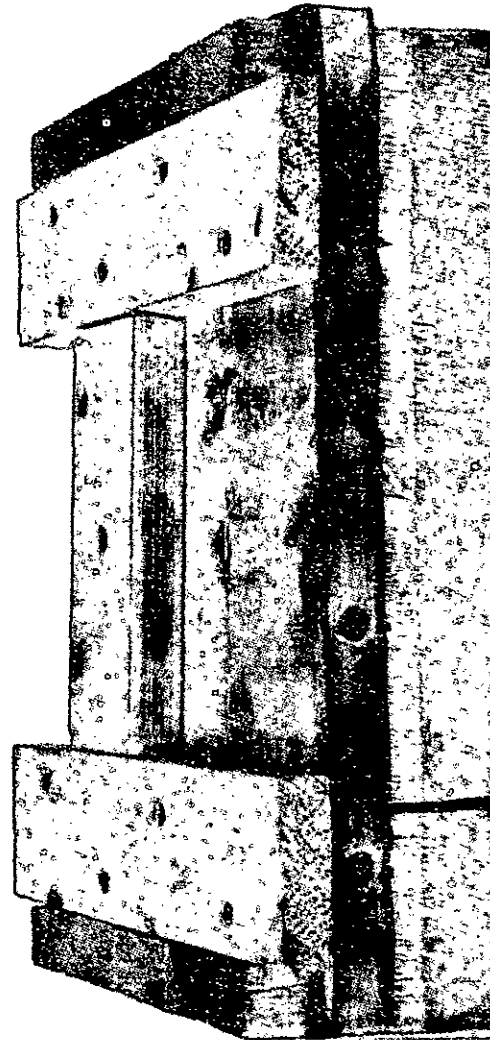
No. 26.—SHORT STRAP. Minor. (Ends not lapped.)



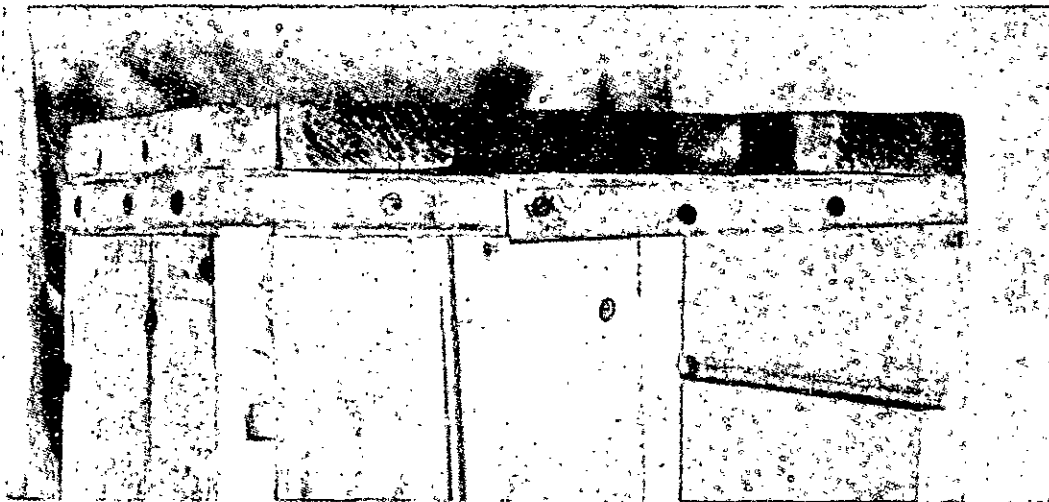
No. 27—LAPPED ENDS OF STRAP. Minor if one or both nails are missing from lapped ends. (Note—Both nails must pass through both ends of strap.)



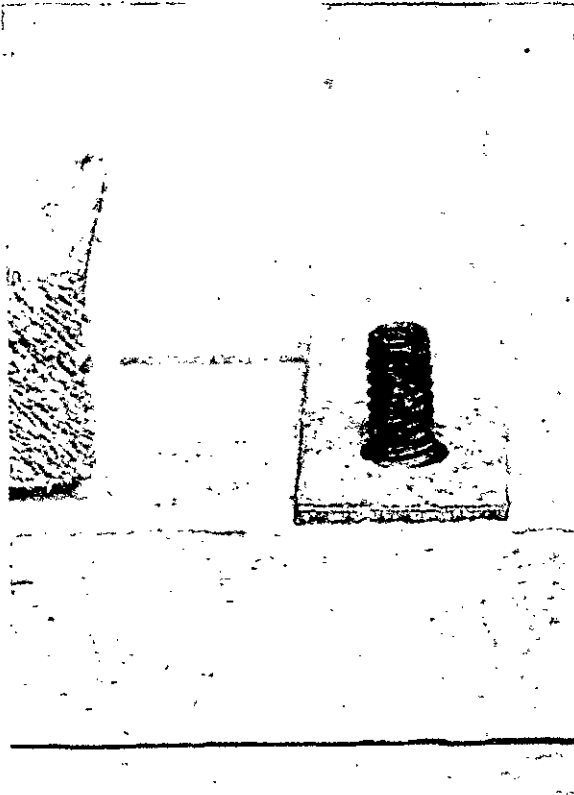
No. 28—STRAPPING MISALIGNED. Minor. (Edge of strap protruding beyond inside surface of box.) *Note*—U-bolt removed from subject illustrated.



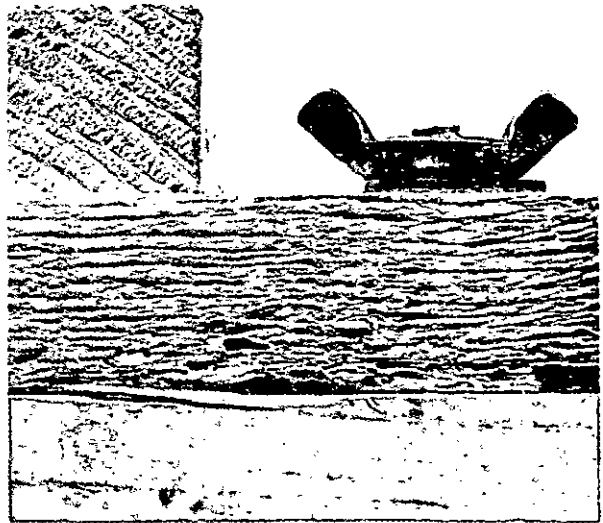
No. 28—STRAPPING MISALIGNED. Minor. (Strap out of rabbet, affecting strength of box.)



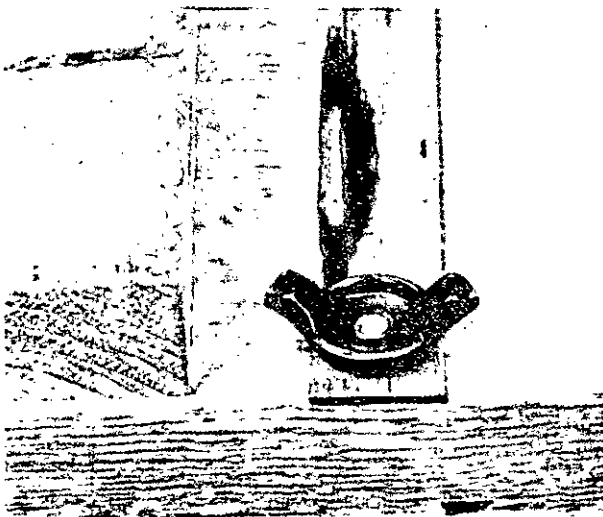
No. 28—STRAPPING MISALIGNED. Minor. (Point of strap protruding beyond inside surface of box.) *Note*—U-bolt removed from subject illustrated.



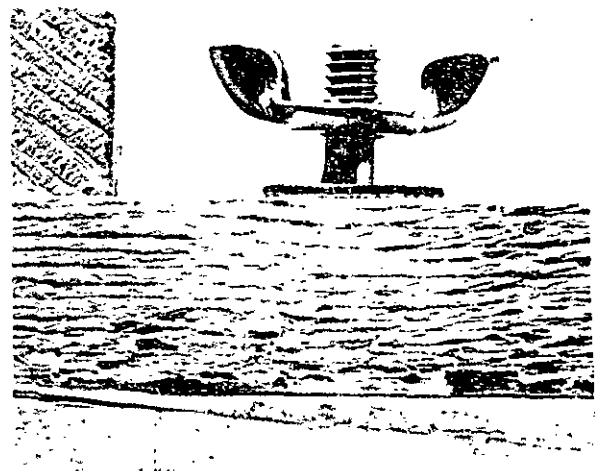
No. 29—MISSING NUT. Minor for box inspection.
Major for packed ammunition inspection.



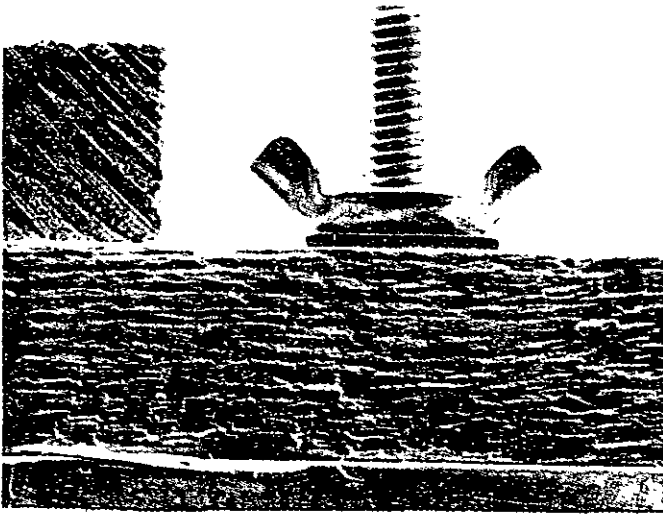
No. 30—SHORT BOLT. Permissible. (Bolt protrudes
above threaded portion of wing nut.)



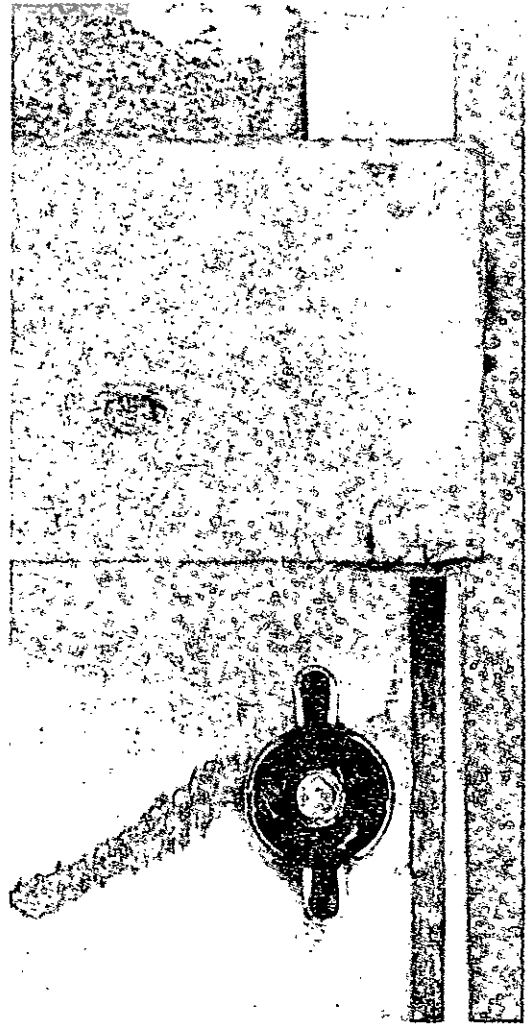
No. 30—SHORT BOLT. Major. (Bolt does not protrude
above threaded portion of wing nut.)



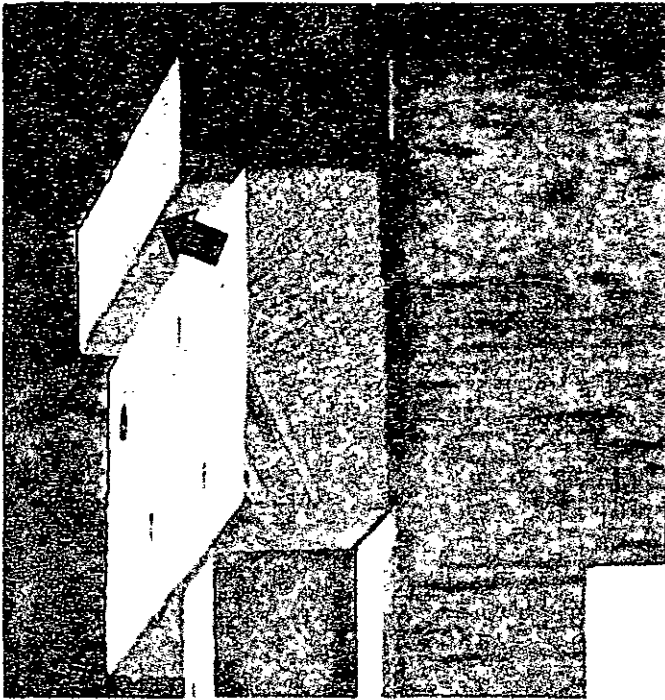
No. 30—INSUFFICIENT U-BOLT THREADS. Major.



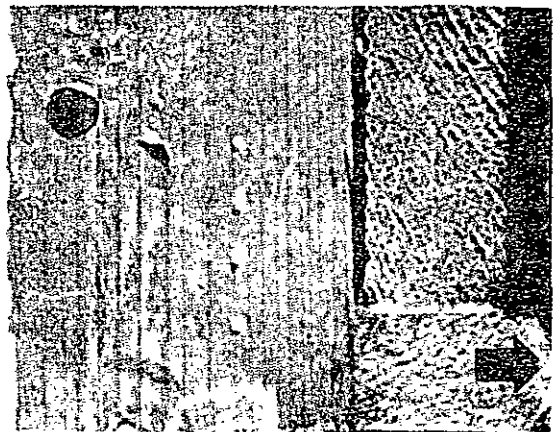
No. 31—LONG BOLT (Extending above top surface of cover cleat.)
Minor.



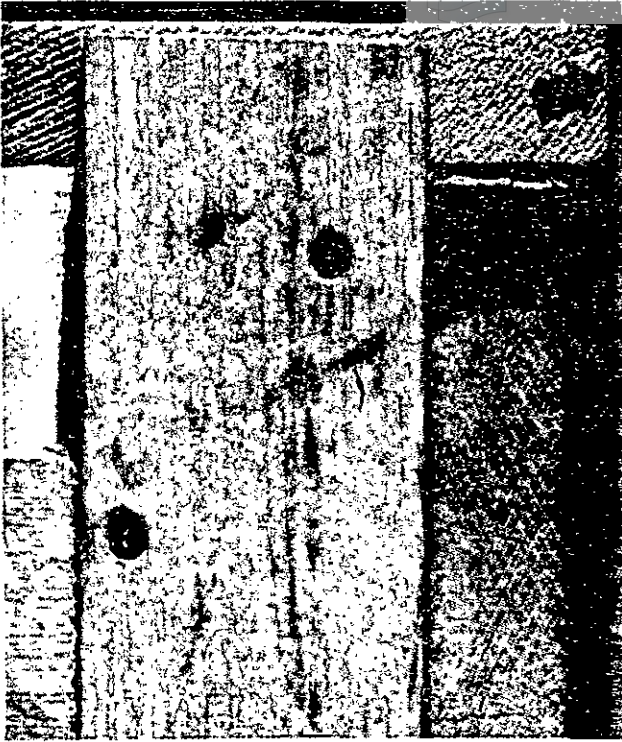
No. 32—MISSING REINFORCEMENT. Minor
for box inspection. Major for packed ammunition
inspection.



No. 33—LONG SIDE. Minor. (Extending beyond
end cleat more than $\frac{1}{4}$ ".)



No. 34—WIDE BOTTOM. Minor. (Extending
beyond side more than $\frac{1}{4}$ ".)



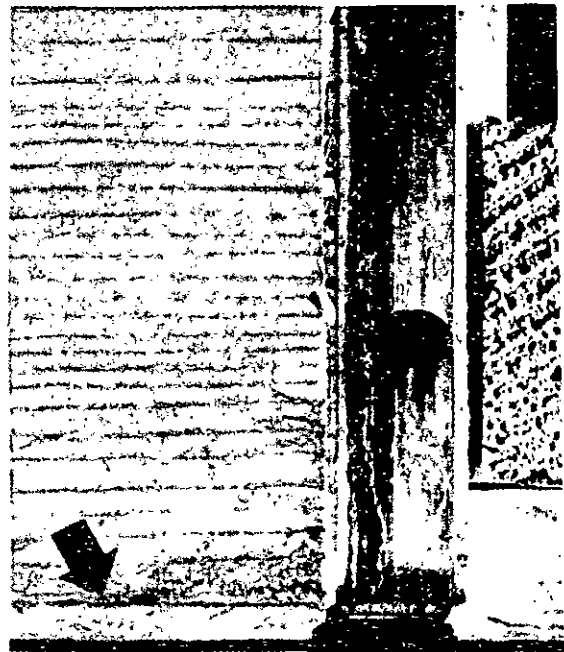
No. 34—WIDE TOP. Minor. (Extending beyond side more than $\frac{1}{8}$ ".)



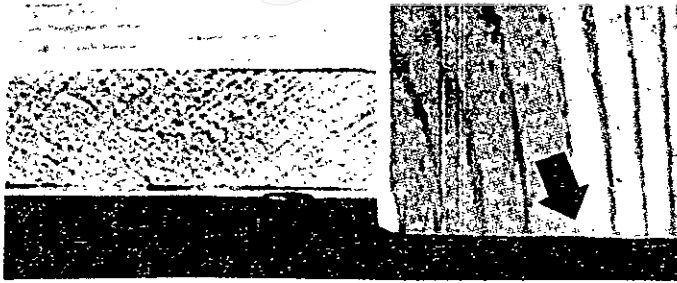
No. 35—SHORT TOP. Minor. (Extending more than $\frac{1}{8}$ " inside cleat at both ends.)



No. 36—NARROW TOP. Minor. (Extending more than $\frac{1}{8}$ " inside side at both sides. Note protruding end of reinforcement.)

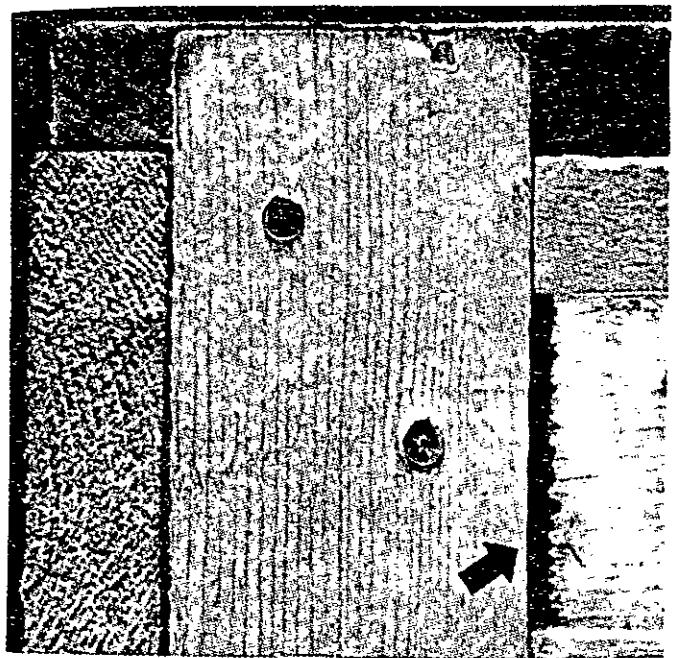
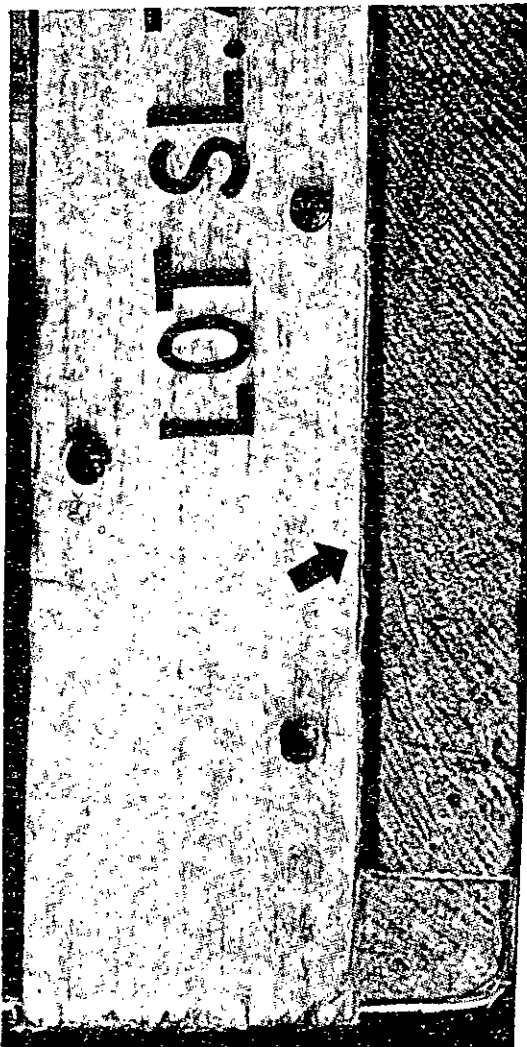
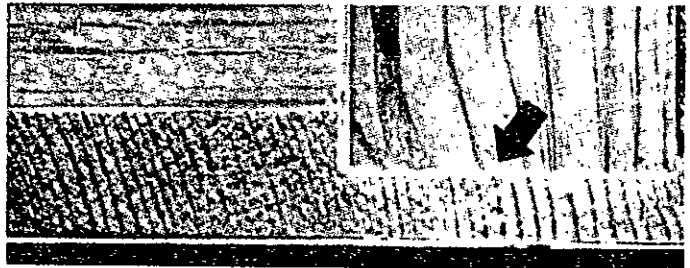


No. 36—NARROW BOTTOM. Minor. (Extending more than $\frac{1}{8}$ " inside side.)



No. 37—LONG VERTICAL CLEAT.
Minor. (Extending beyond bottom
more than $\frac{1}{4}$ ".)

No. 38—SHORT VERTICAL CLEAT
Minor. (Extending more than $\frac{1}{4}$ " in-
side bottom surface.)



No. 40—GAP. Minor. (Space between horizontal and vertical
cleat larger than $\frac{1}{4}$ ".)

No. 39—GAP. Minor. (Space between side and vertical cleat
larger than $\frac{1}{8}$ ".)

LIST OF DEFECTS

WIREBOUND WOOD BOXES

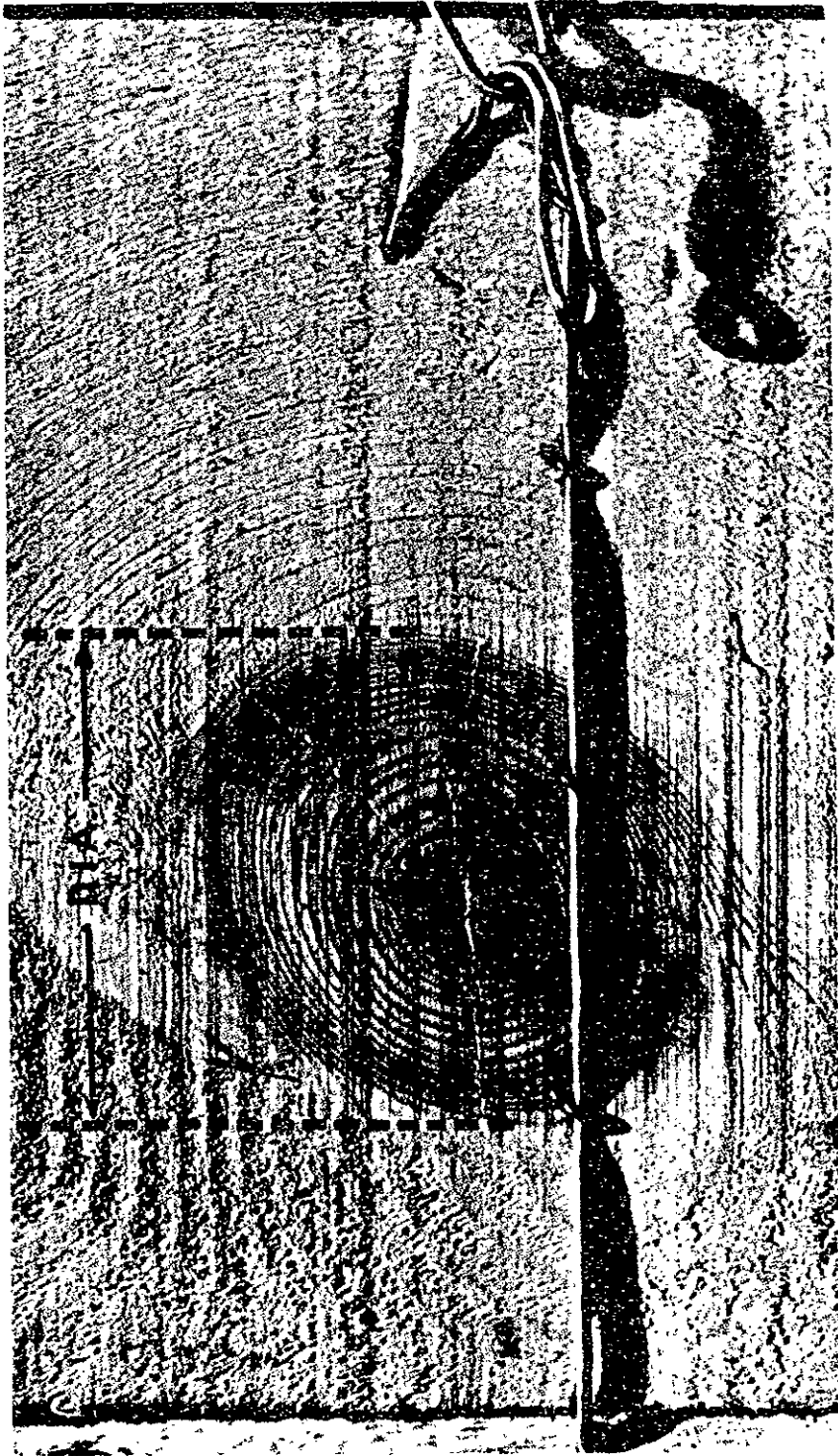
No.	MATERIAL Defect	Pages
Knots:		
1.	Tight knot larger than $\frac{1}{4}$ width of board or $2\frac{1}{2}$ " diameter, whichever is lesser.....	47-49
2.	Tight knot larger than $\frac{1}{2}$ width of cleat or batten.....	49, 50
3.	Loose knot or knot hole larger than 1" diameter in board.....	50, 51
4.	Loose knot or knot hole in cleat or batten.....	52
5.	Decay.....	53, 54
6.	(Not illustrated.)	
Cross grain:		
7.	In face boards having slope greater than 1 in 6 (except grain structure surrounding knots).....	55
8.	In cleats and battens having slope greater than 1 in 8 (except grain structure surrounding knots).....	56
Splits:		
9.	Forming a sliver at the outside edge of a board.....	57
10.	Forming a cross break at the outside edge of a board.....	57
11.	Full length—more than one per narrow piece (4" wide or less).....	57
12.	Full length—more than two in a part.....	58, 59
13.	Partial—over $\frac{1}{2}$ length but less than full length—more than three in a part.....	60
14.	Full length in cleat or batten.....	61
15.	Shake or soft spots.....	62
Broken board:		
16.	Broken or split off for full length or width of piece.....	63
17.	Broken or split off more than $\frac{1}{2}$ length or width of piece but less than full length or width.....	63
Wire:		
18.	Untreated binding or stapling.....	64
19.	Prong of loop fastener not driven through board and clinched.....	64
20.	Any broken, missing or unsatisfactorily spliced.....	65, 66
21.	Loose at corner of box.....	66
22.	Short loop preventing closing of box.....	66

WORKMANSHIP AND ASSEMBLY

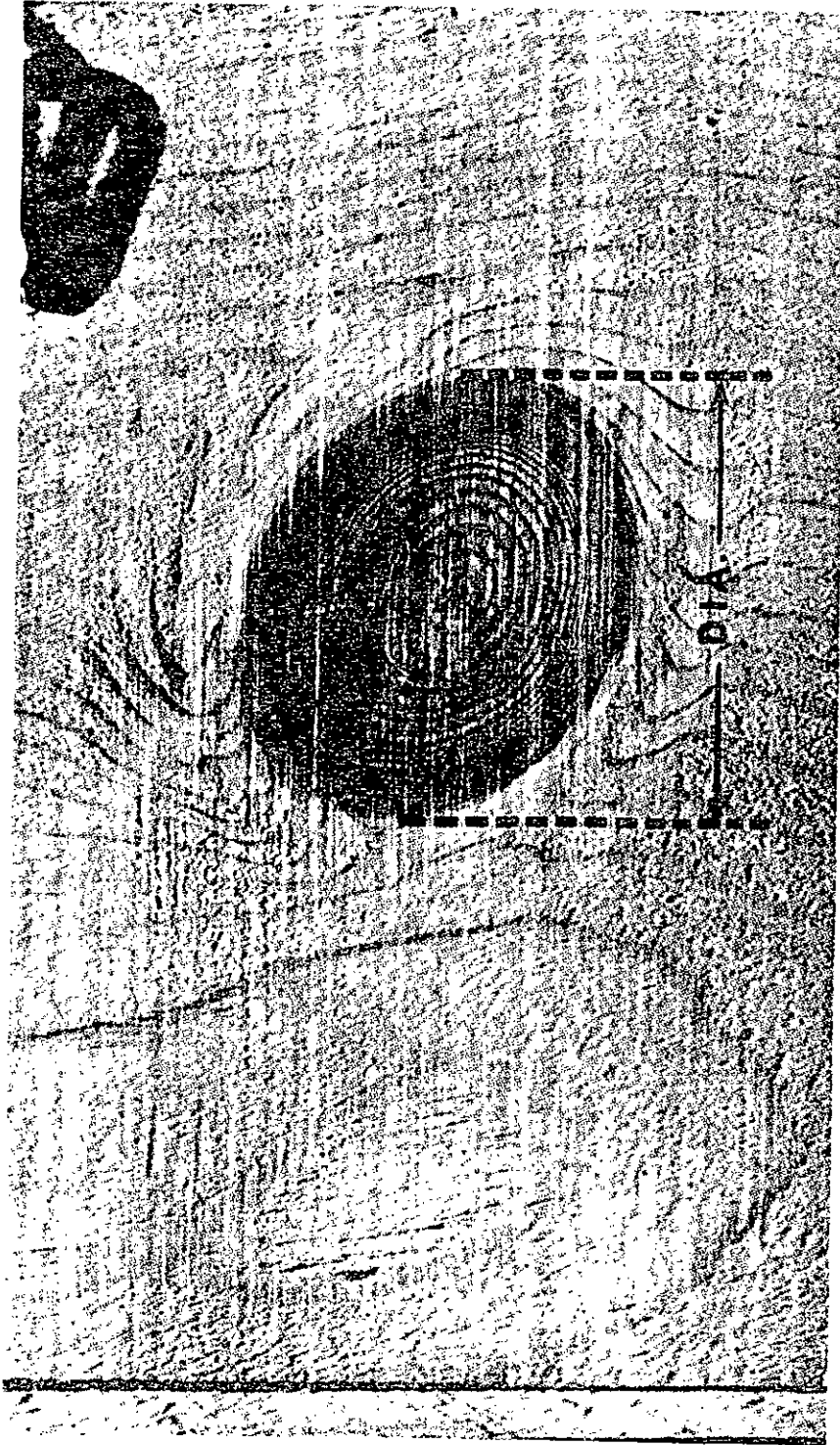
No.	Defect	Pages
	Stapling or nailing:	
23.	Protruding point.....	67, 68
24.	More than two binding wire staples missing, broken or poorly driven (one leg of staple not driven into board) per wire.....	69
25.	More than one batten staple missing or head protruding (per batten).....	70
26.	More than one batten nail missing or head protruding (per batten).....	71
	Wood parts:	
27.	Missing cleat or batten.....	72
28.	Overlapping boards.....	73

DEFECTS APPLICABLE TO PACKED AMMUNITION ONLY

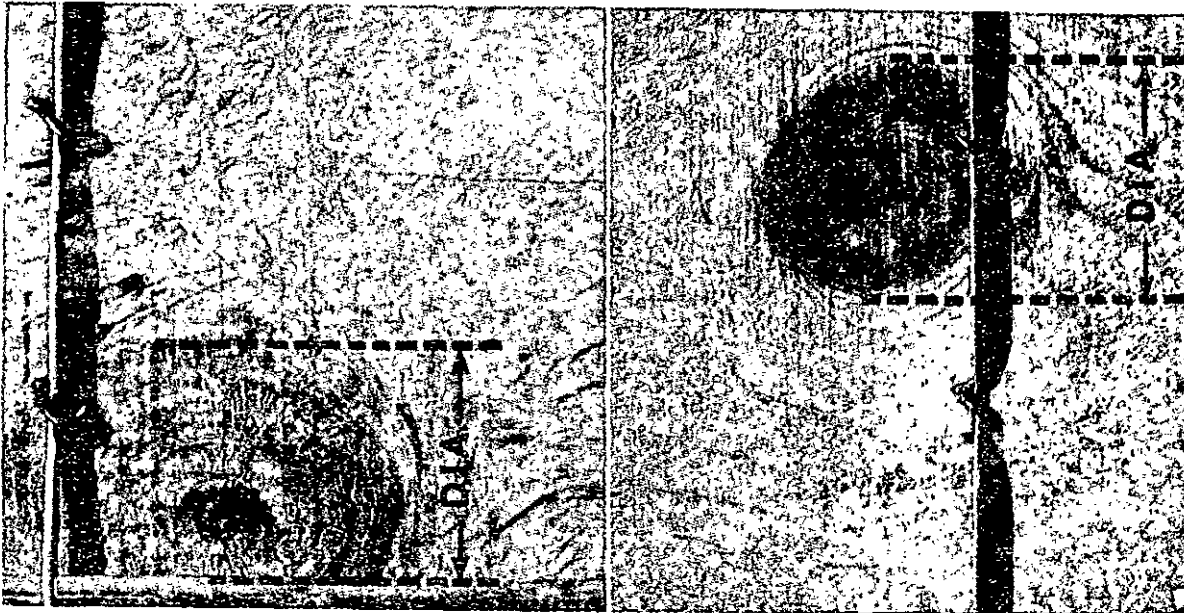
29.	Unfastened outside binding wire.....	74
30.	Unfastened inside binding wire.....	74
31.	Missing end.....	74
32.	Side, top or bottom extending beyond end cleat more than $\frac{1}{8}$ ".....	75
33.	End cleat extending beyond side, top or bottom more than $\frac{1}{8}$ ".....	75
34.	Gap larger than $\frac{1}{4}$ " between end of batten and cleat.....	76
35.	Gap larger than $\frac{1}{4}$ " between side of batten and cleat.....	76
36.	Gap larger than $\frac{1}{4}$ " between diagonal ends of more than one pair of cleats per box.....	77
37.	Reversed or inverted end.....	78
38.	Missing seal.....	78
39.	Incorrectly attached seal.....	78



No. 1—TIGHT KNOT. Minor. (Greater than $\frac{1}{8}$ width of board or $2\frac{1}{2}$ " diameter, whichever is lesser.)

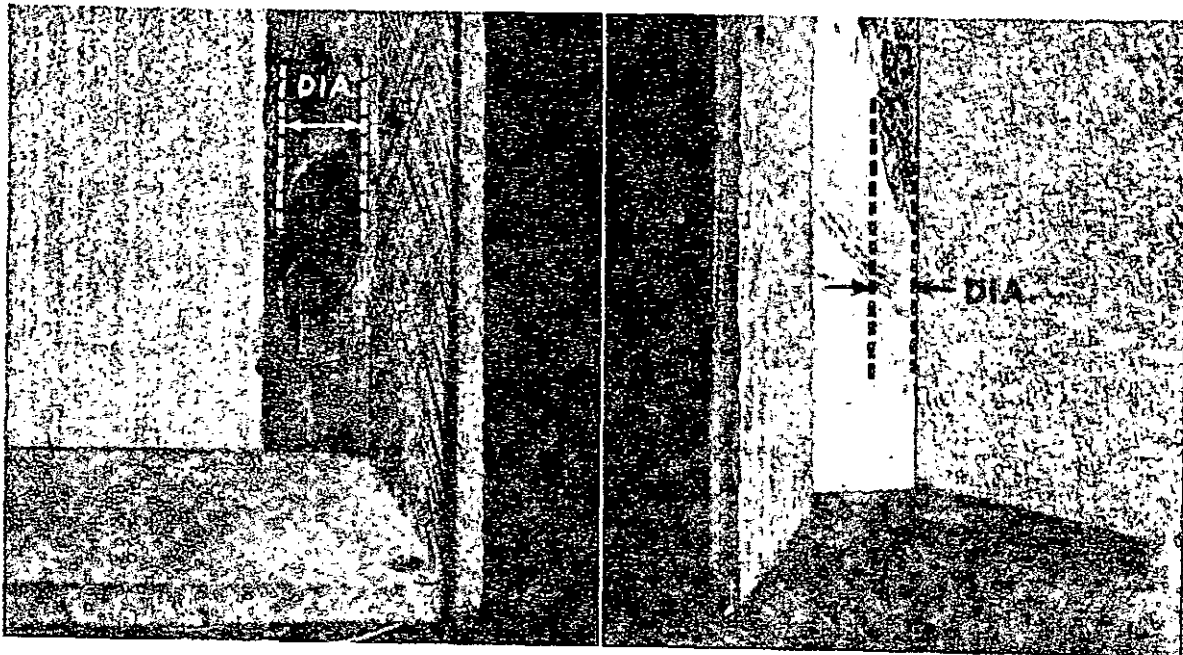


No. 1—TIGHT KNOT. Permissible. (Equal to or less than $\frac{1}{8}$ width of board or $2\frac{1}{4}$ " diameter, whichever is applicable.)



No. 1—TIGHT KNOT. Minor. (Greater than $\frac{1}{8}$ width of board or $2\frac{1}{2}$ " diameter, whichever is lesser.)

No. 1—TIGHT KNOT. Permissible. (Equal to or less than $\frac{1}{8}$ width of board or $2\frac{1}{2}$ " diameter, whichever is applicable.)



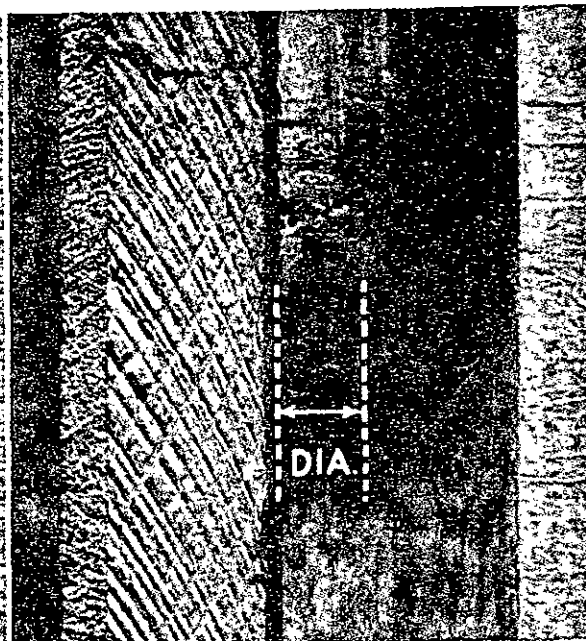
No. 2—TIGHT KNOT. Major. (Diameter greater than $\frac{1}{2}$ width of cleat.)

No. 2—TIGHT KNOT. Permissible. (Diameter less than $\frac{1}{2}$ width of cleat.)

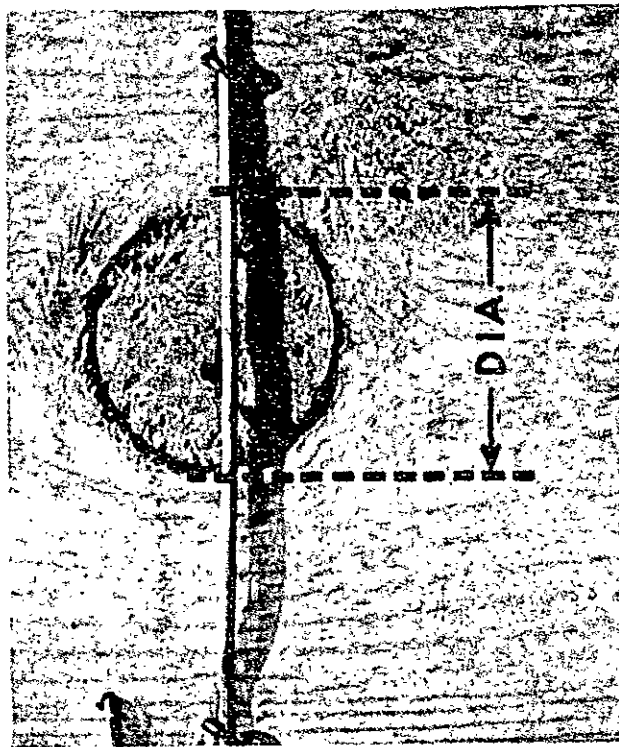
MIL-STD-299
17 January 1957



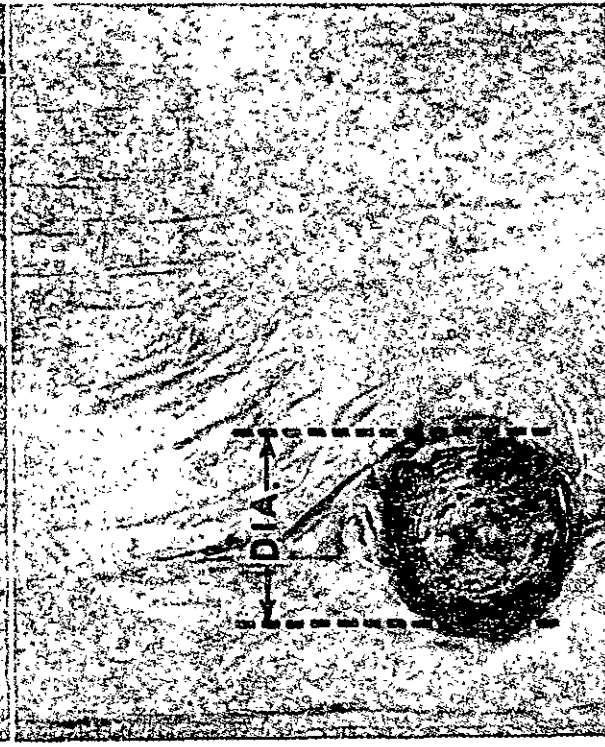
No. 2—TIGHT KNOT. Major. (Diameter greater than $\frac{1}{2}$ width of batten.)



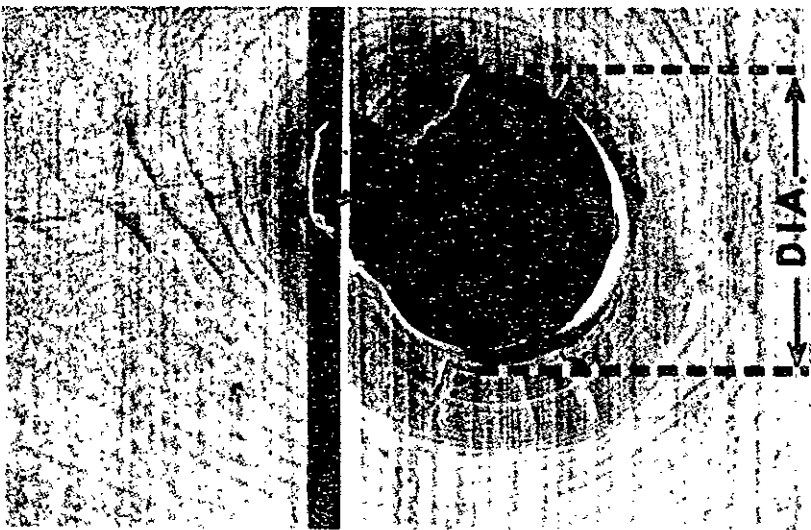
No. 2—TIGHT KNOT. Permissible. (Diameter less than $\frac{1}{2}$ width of batten.)



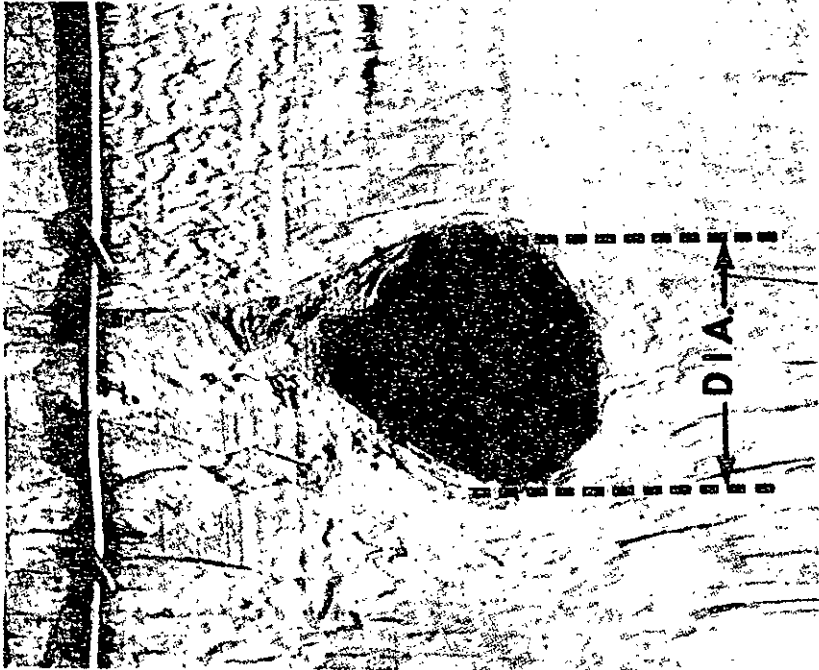
No. 3—LOOSE KNOT. Minor. (Larger than 1" diameter in board.)



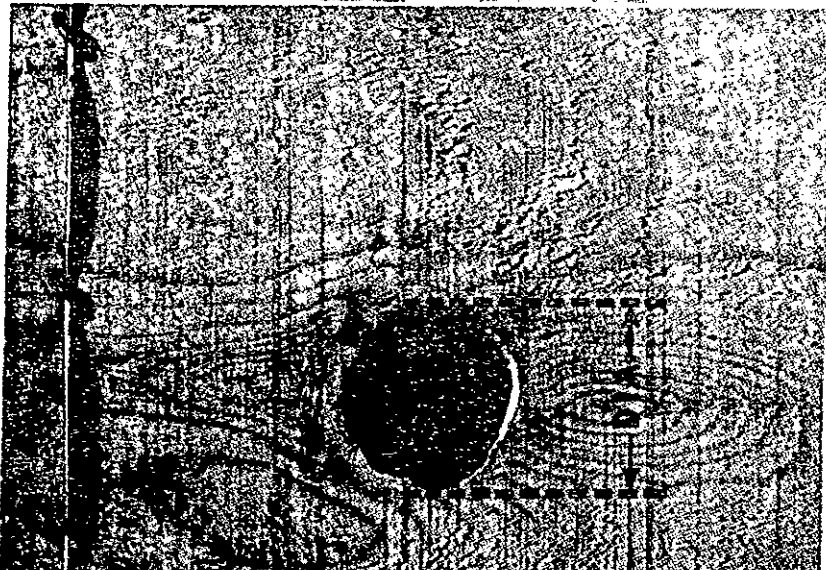
No. 3—LOOSE KNOT. Permissible. (Smaller than 1" diameter in board.)



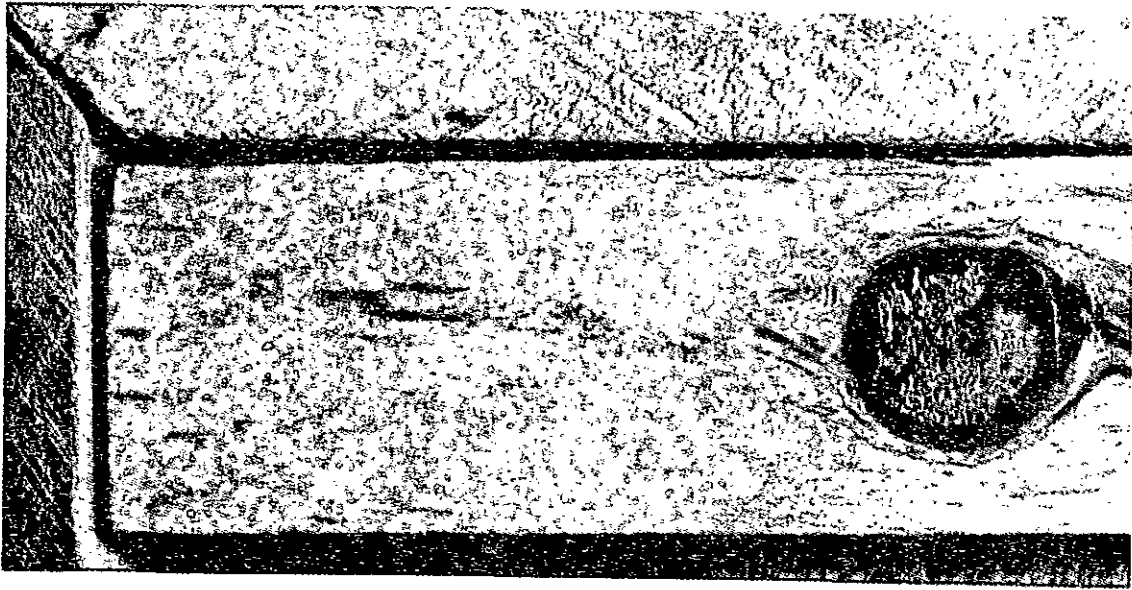
No. 3—KNOT HOLE. Minor. (Larger than 1" diameter in board.)



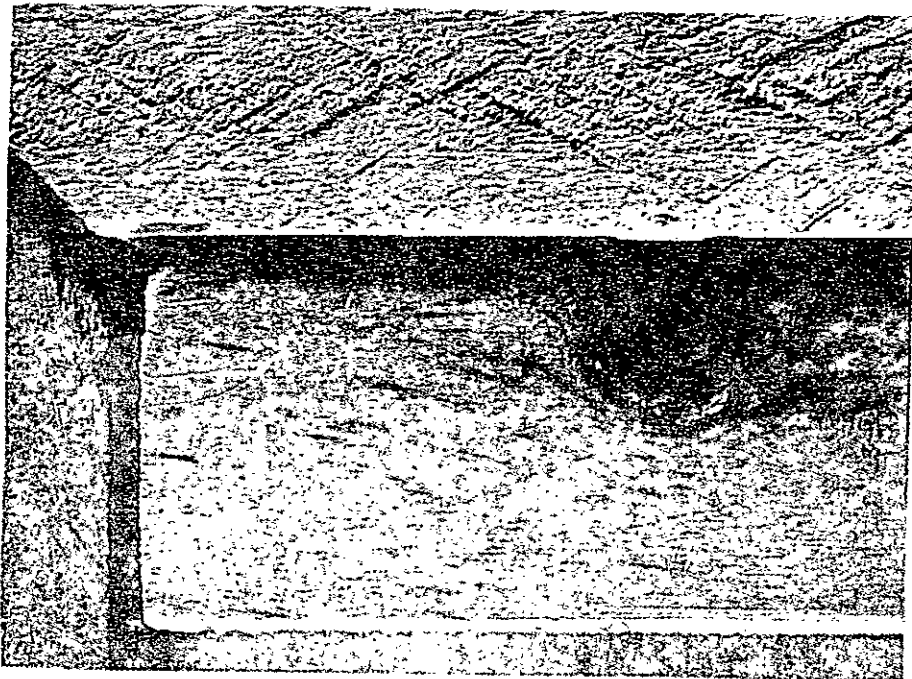
No. 3—KNOT HOLE. Minor. (Larger than 1" diameter in board.)



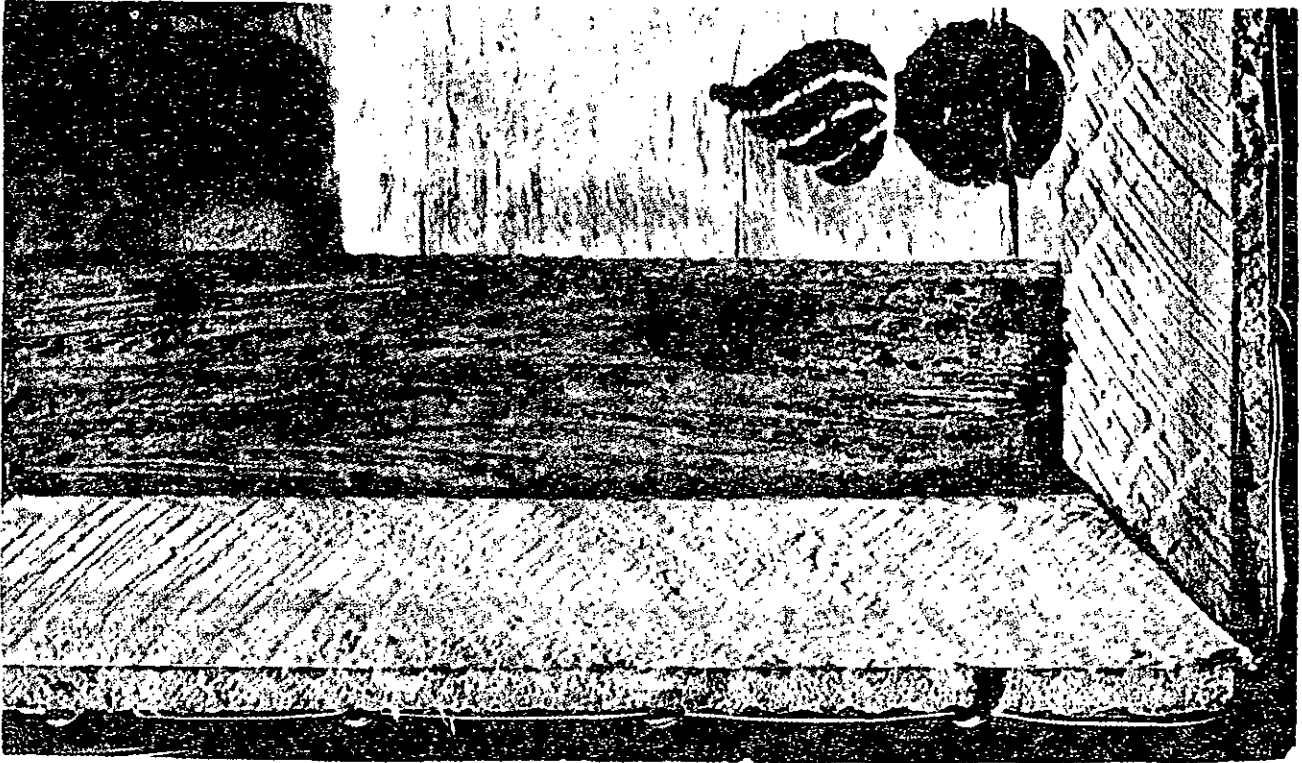
No. 3—KNOT HOLE. Permissible. (Smaller than 1" diameter in board.)



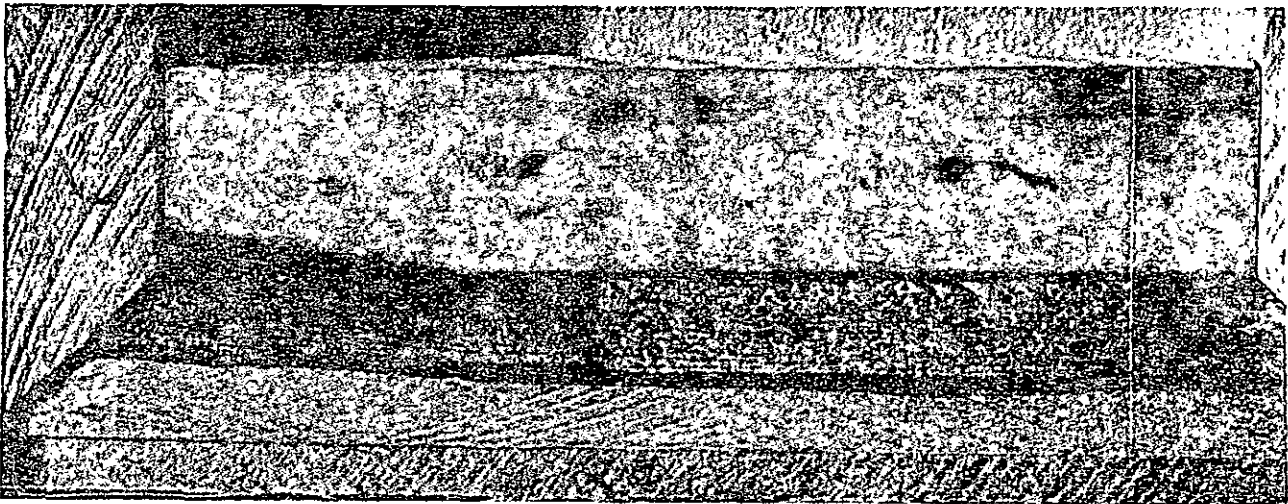
No. 4—LOOSE KNOT IN CLEAT OR BATTEN. Major.



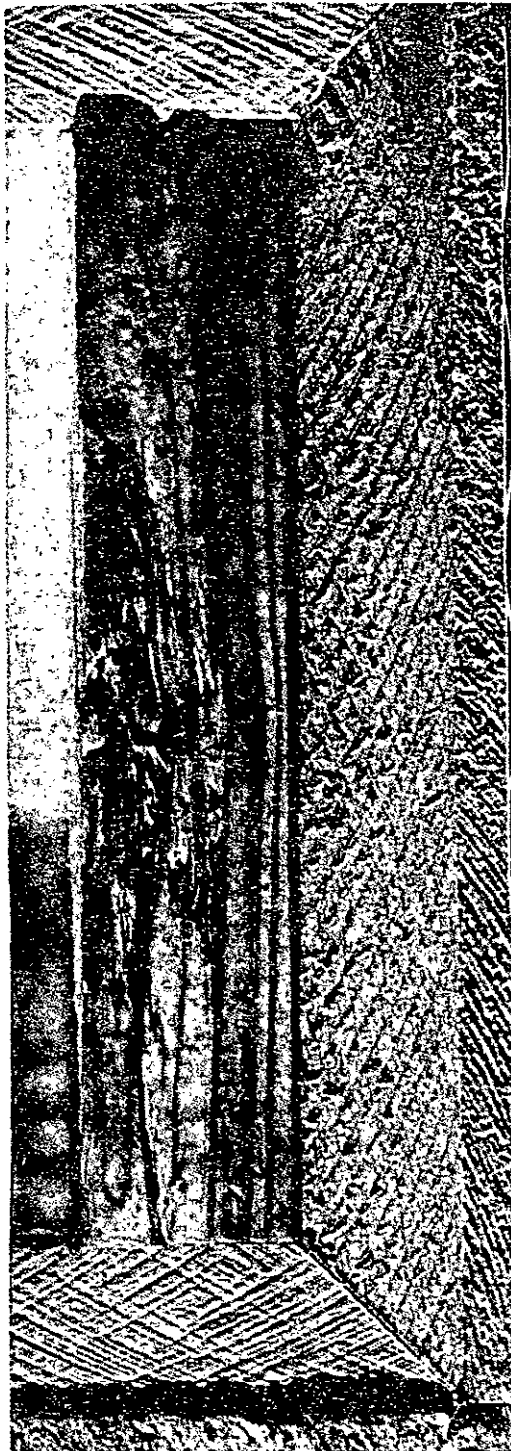
No. 4—KNOT HOLE IN CLEAT OR BATTEN. Major.



No. 5—DECAY. Major.



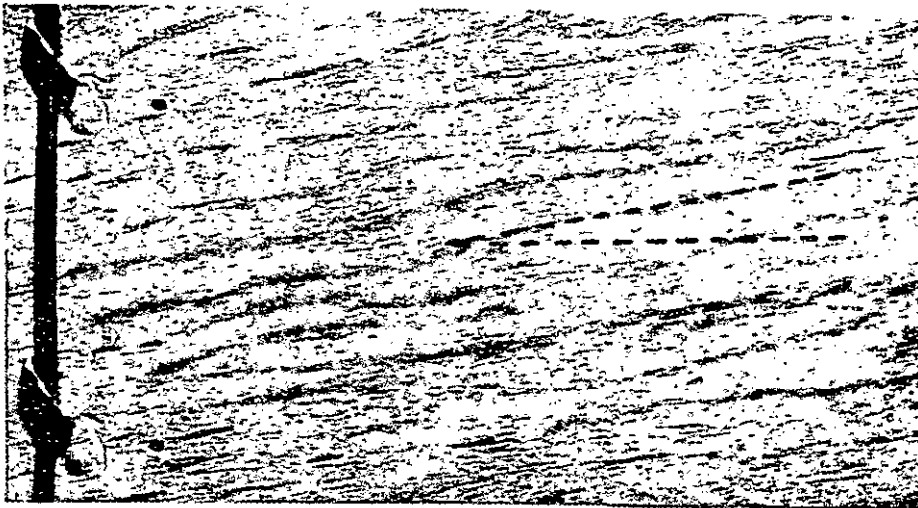
No. 5—DECAY. Major.



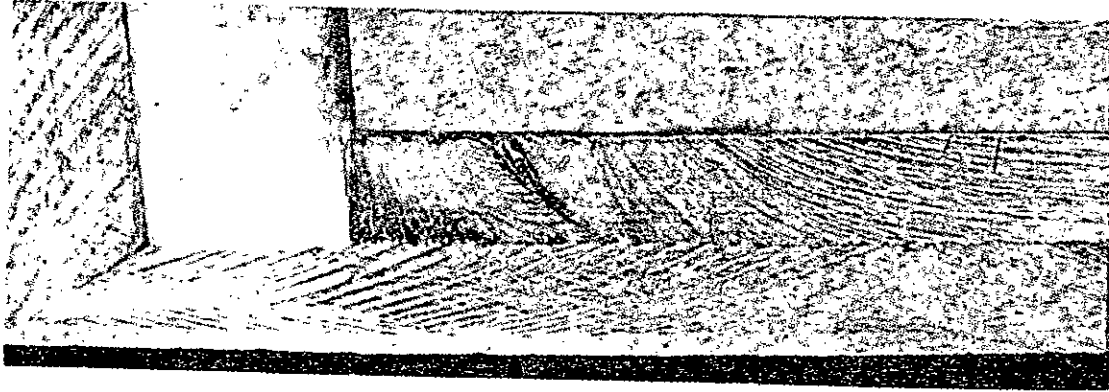
No. 5—DECAY. Major.



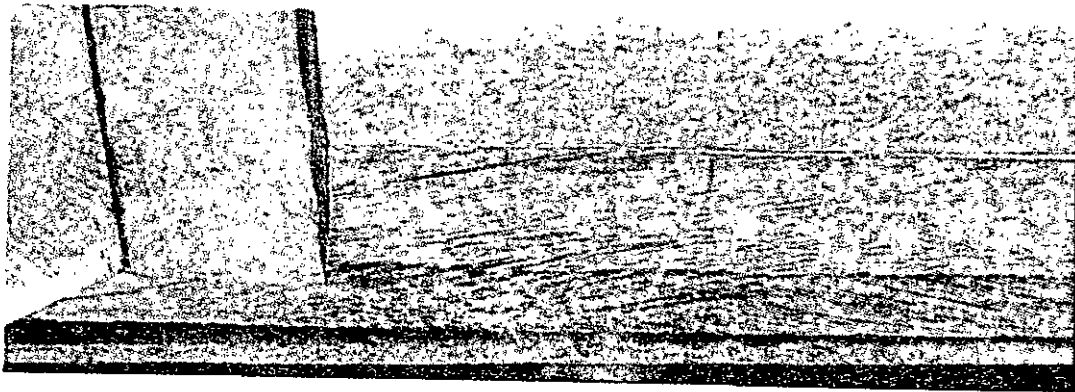
No. 7—CROSS GRAIN. Minor. (Slope greater than 1 in 6.)



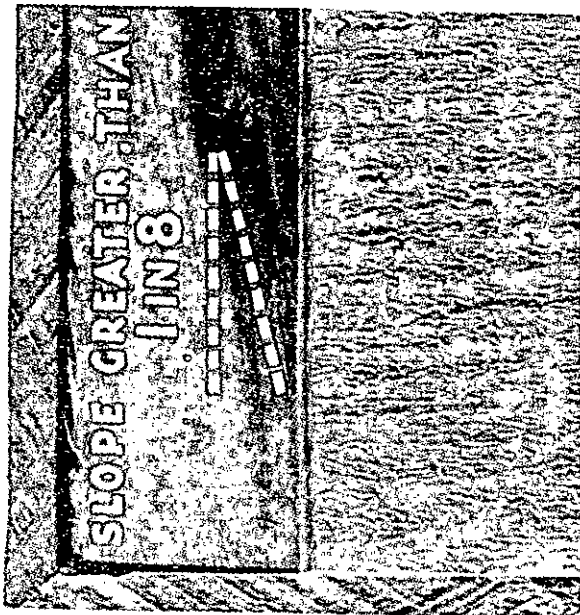
No. 7—CROSS GRAIN. Permissible. (Slope 1 in 6 or less.) Slope illustrated approximately 1 in 6.



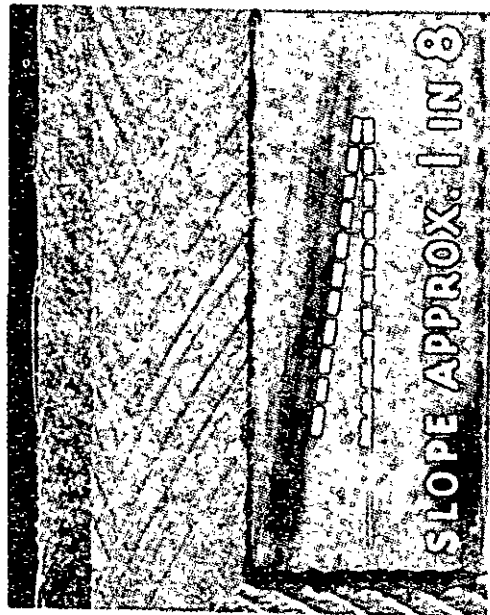
No. 8—CROSS GRAIN. Permissible. (Slope greater than 1 in 8 surrounding knot.)



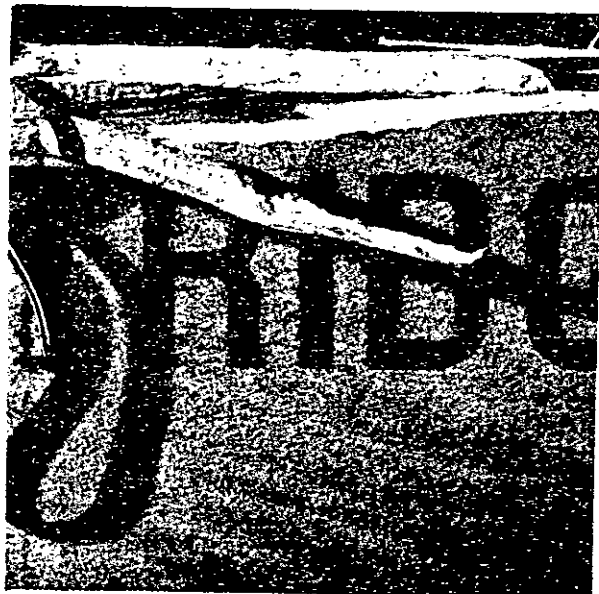
No. 8—CROSS GRAIN. Permissible. (Slope 1 in 8, or less.)



No. 8—CROSS GRAIN. Minor. (Slope greater than 1 in 8.)



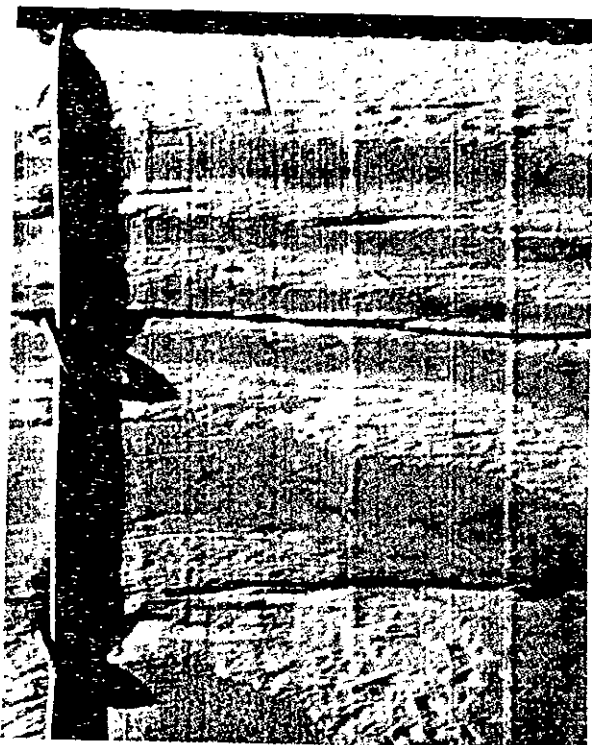
No. 8—CROSS GRAIN. Permissible. (Slope 1 in 8, or less.)



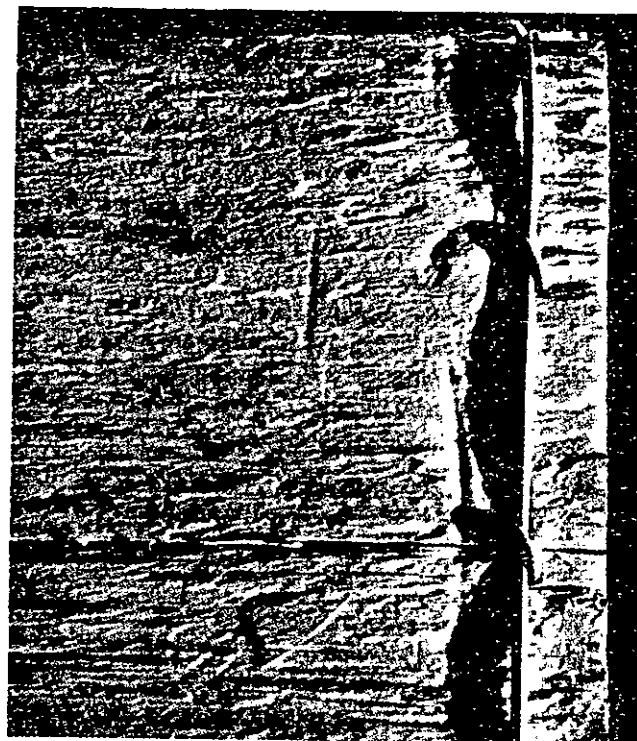
No. 9—SPLIT. Major. (Forms sliver at outside edge.)



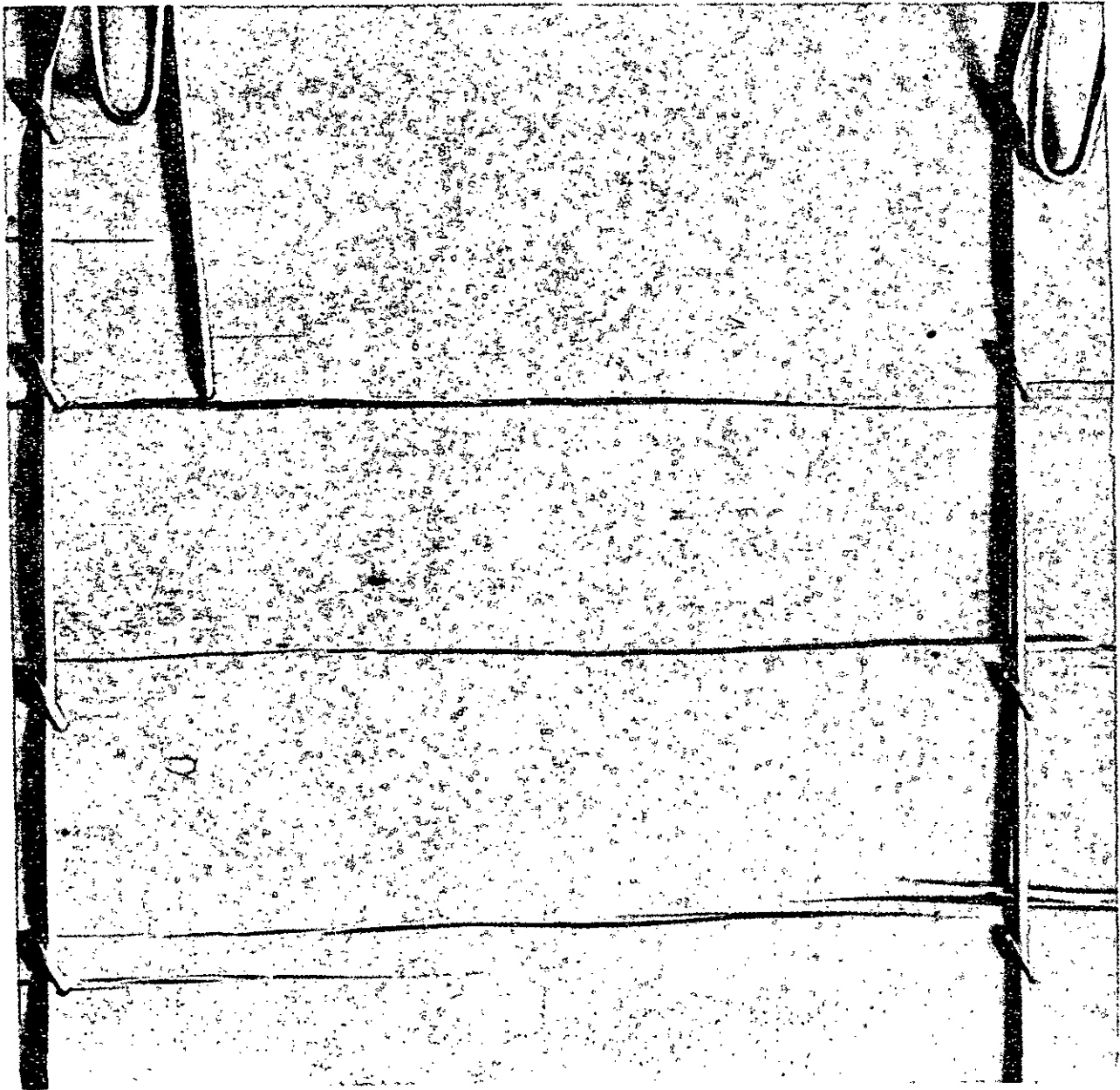
No. 10—SPLIT. Minor. (Forms a cross break at outside edge.)



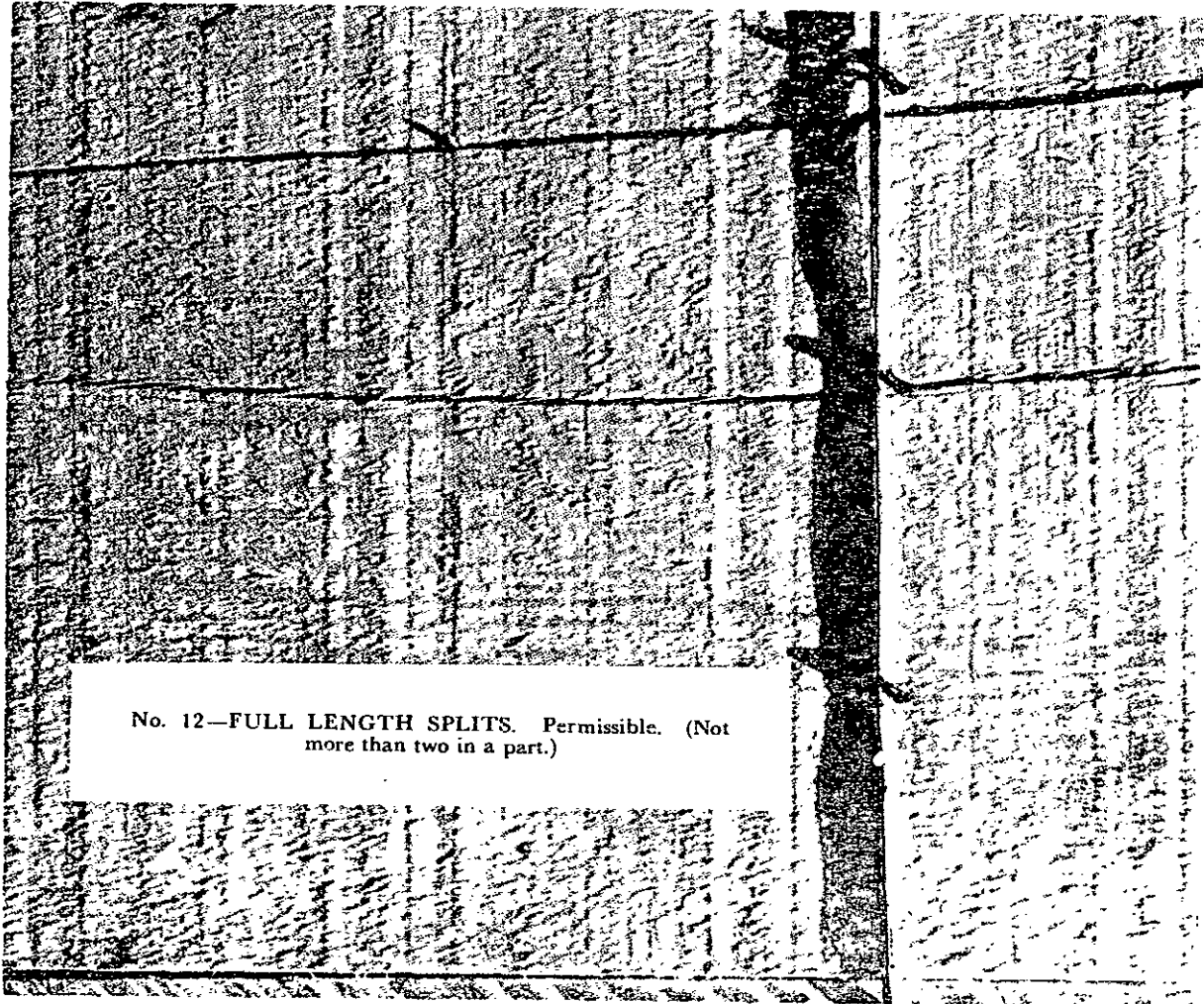
No. 11—FULL LENGTH SPLITS. Minor. (More than one in a narrow piece 4" wide or less.)



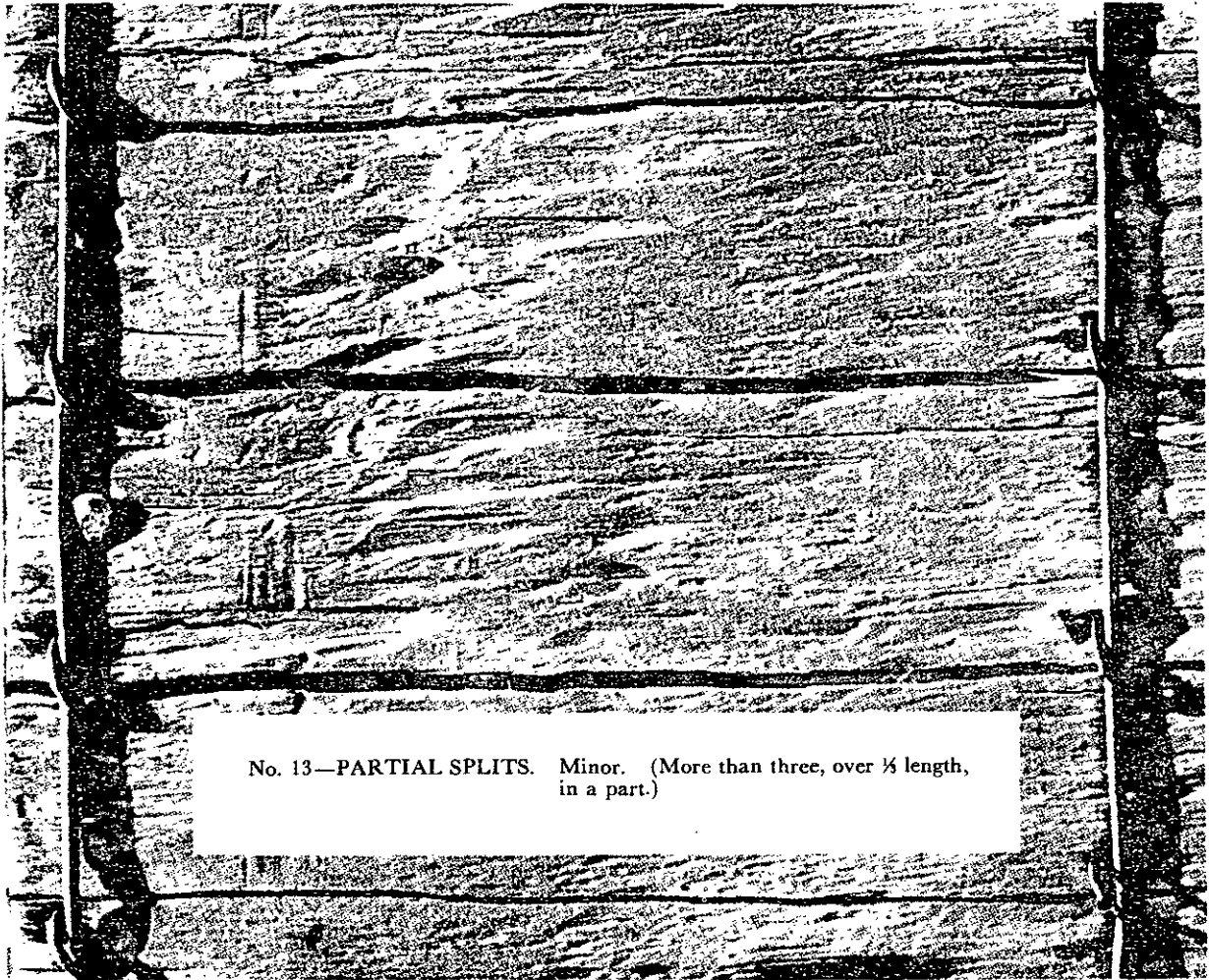
No. 11—FULL LENGTH SPLIT. Permissible. (Only one in a narrow piece 4" wide or less.)



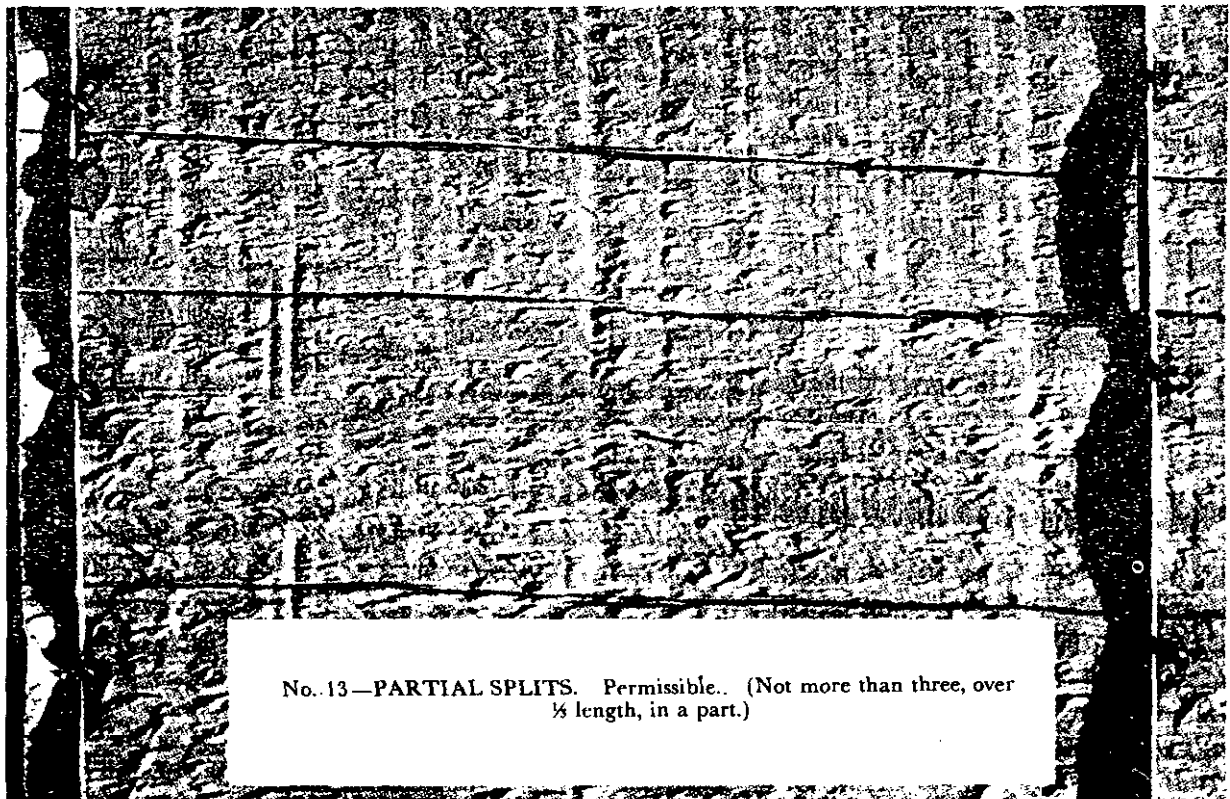
No. 12—FULL LENGTH SPLITS. Minor. (More than two in a part. *Note.*—A part assembled with narrow pieces having splits totalling more than two would also be defective.)



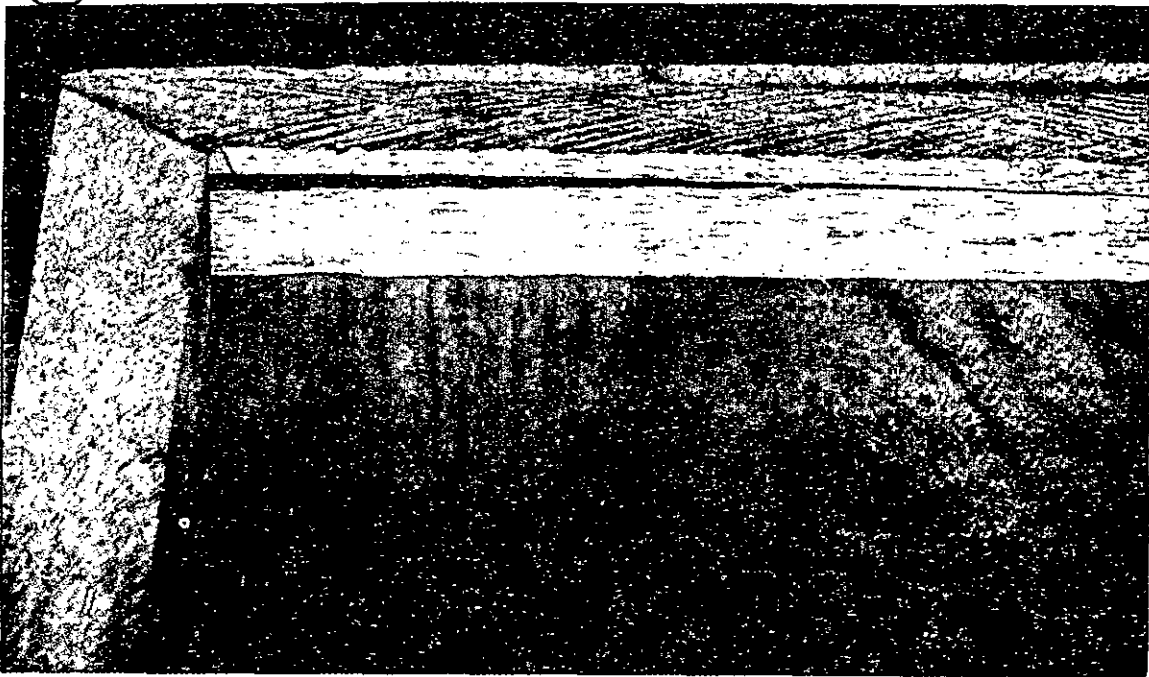
No. 12—FULL LENGTH SPLITS. Permissible. (Not
more than two in a part.)



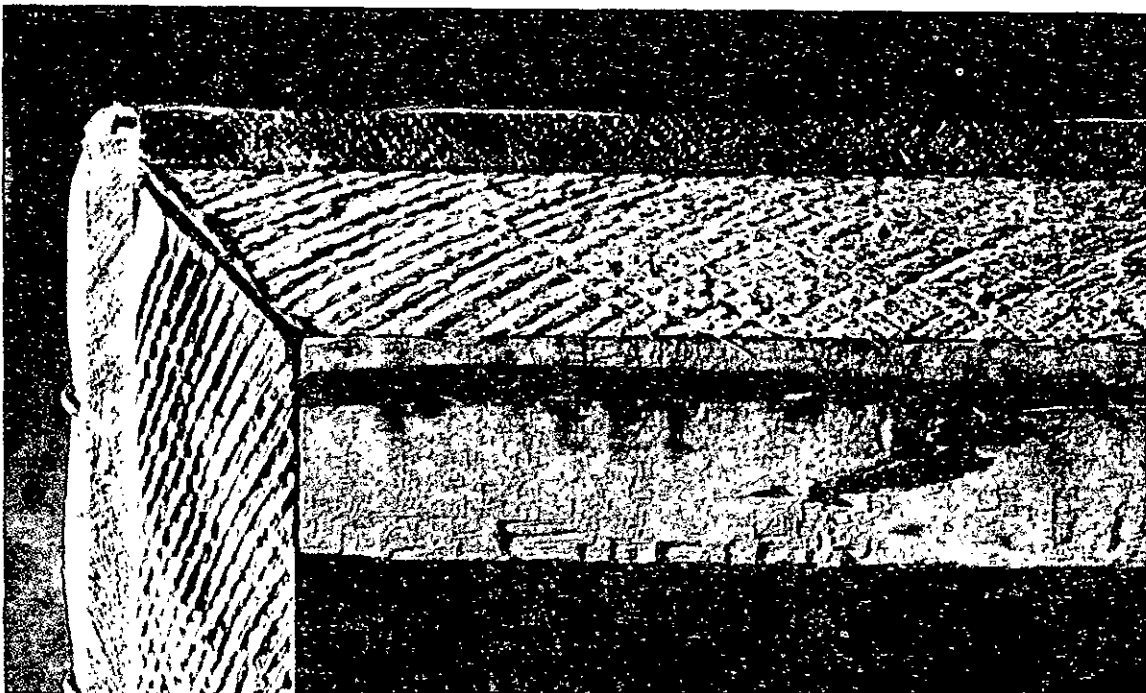
No. 13—PARTIAL SPLITS. Minor. (More than three, over $\frac{1}{2}$ length, in a part.)



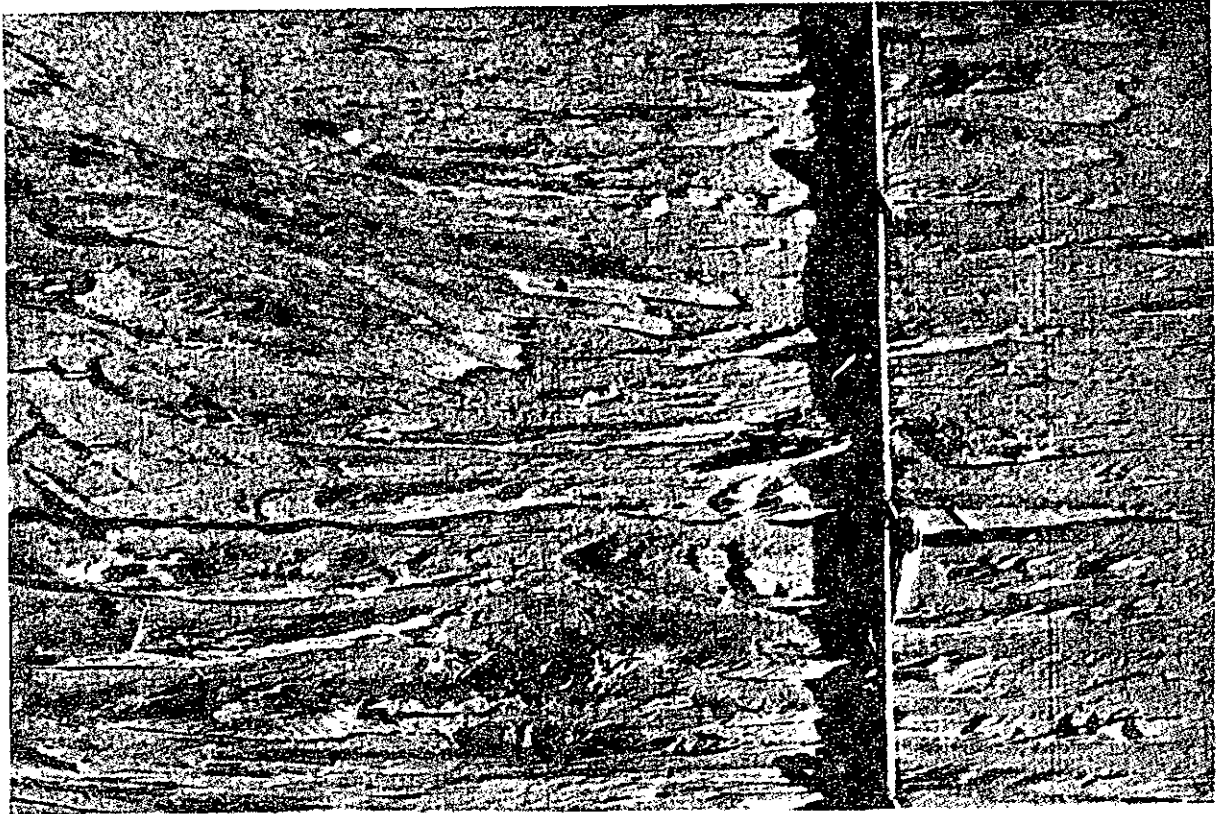
No. 13—PARTIAL SPLITS. Permissible. (Not more than three, over $\frac{1}{2}$ length, in a part.)



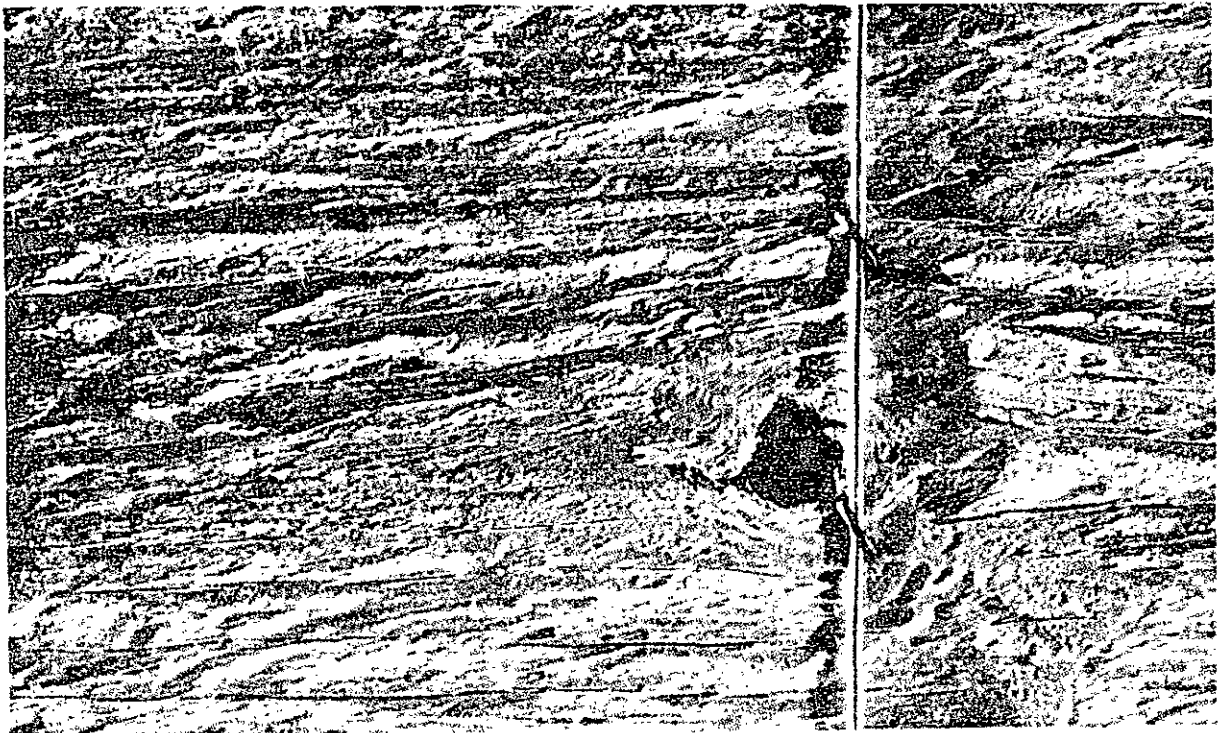
No. 14—SPLIT CLEAT. Major.



No. 14—SPLIT BATTEN. Major.



No. 15—SHAKE. Minor.



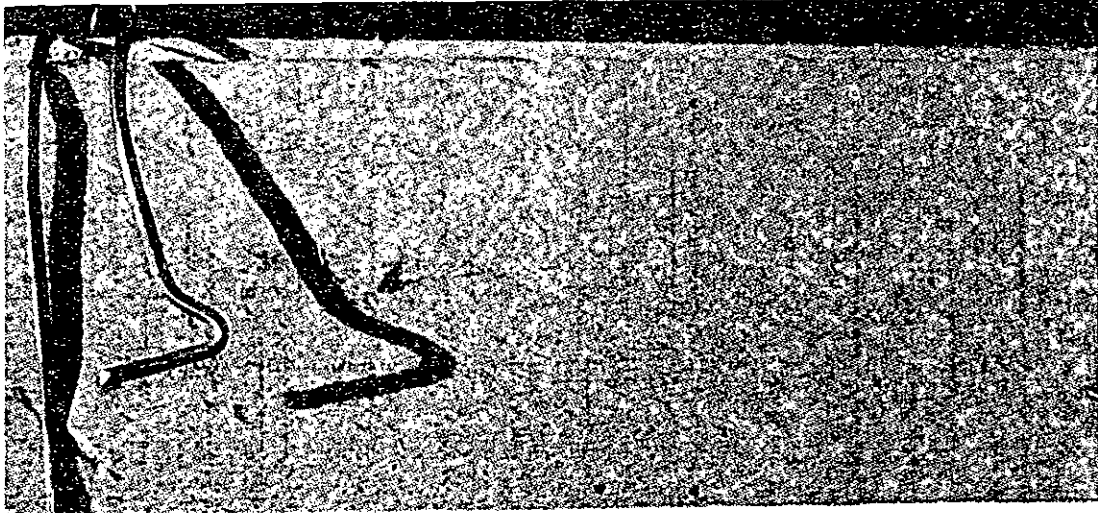
No. 15. SOFT SPOT. Minor.



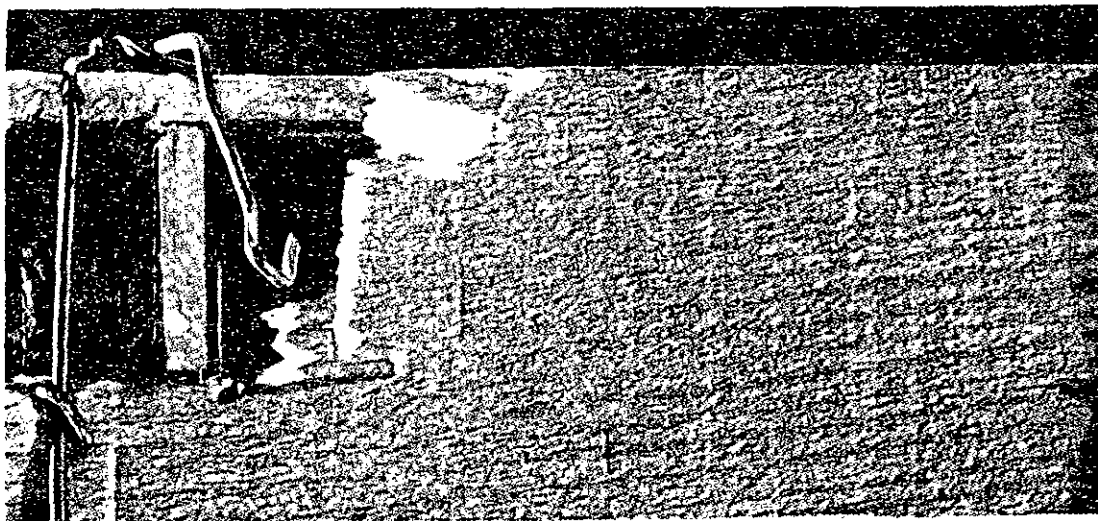
No. 16—BROKEN BOARD. Major. (Board is broken for full length of piece.)

No. 17—BROKEN BOARD. Minor. (Board is broken for more than $\frac{1}{2}$ length but less than full length of piece.)

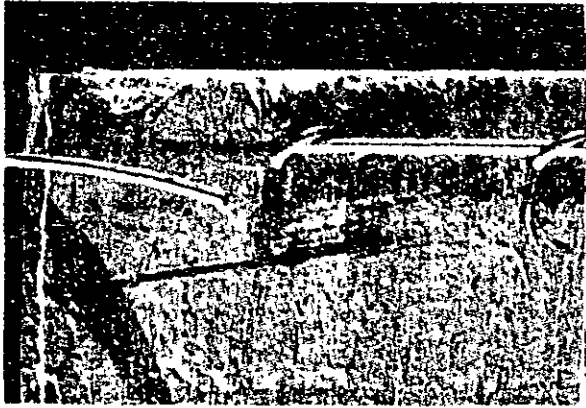
No. 18—UNTREATED BINDING WIRE OR STAPLES. Minor. (*Not illustrated.* Galvanizing required.)



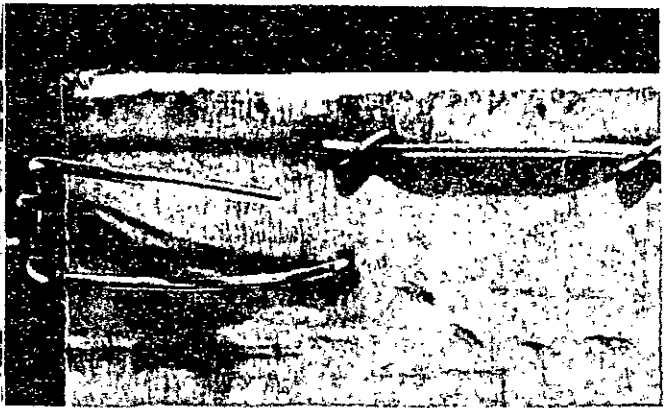
No. 19—PRONG OF LOOP FASTENER NOT DRIVEN THROUGH AND CLINCHED. Major.



No. 19—PRONG OF LOOP FASTENER NOT DRIVEN THROUGH BOARD AND CLINCHED. Major. (*Piece broken from board releases end of binding wire. This photograph applicable to packed ammunition inspection only.*)



No. 20—BROKEN BINDING WIRE. Major.



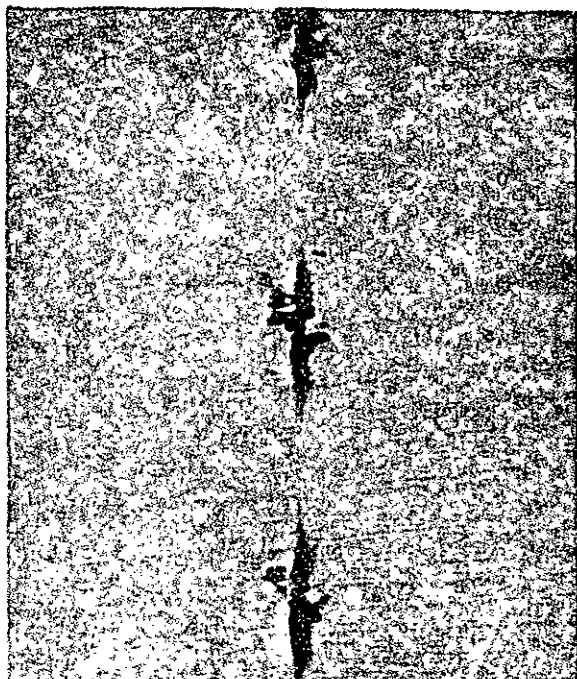
No. 20—BROKEN BINDING WIRE. Major.



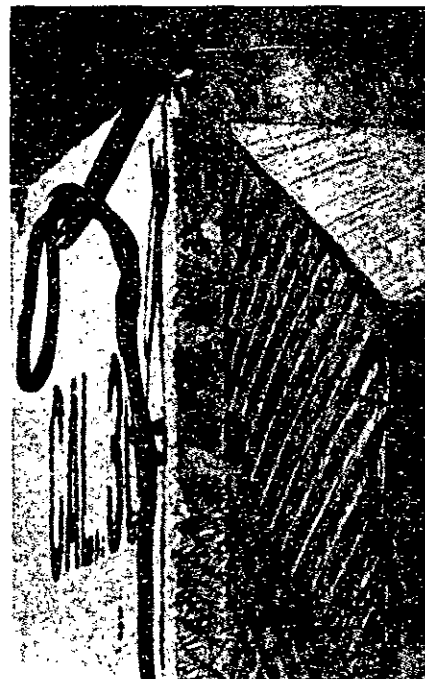
No. 20—SPLICED BINDING WIRE.
Permissible. (Satisfactorily repaired.)



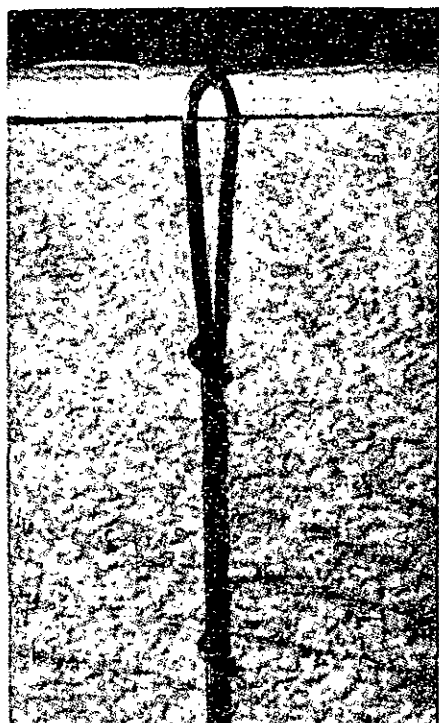
No. 20—SPLICED BINDING WIRE.
Major. (Repaired, but not satisfactorily.)



No. 20—MISSING BINDING WIRE.
Major.



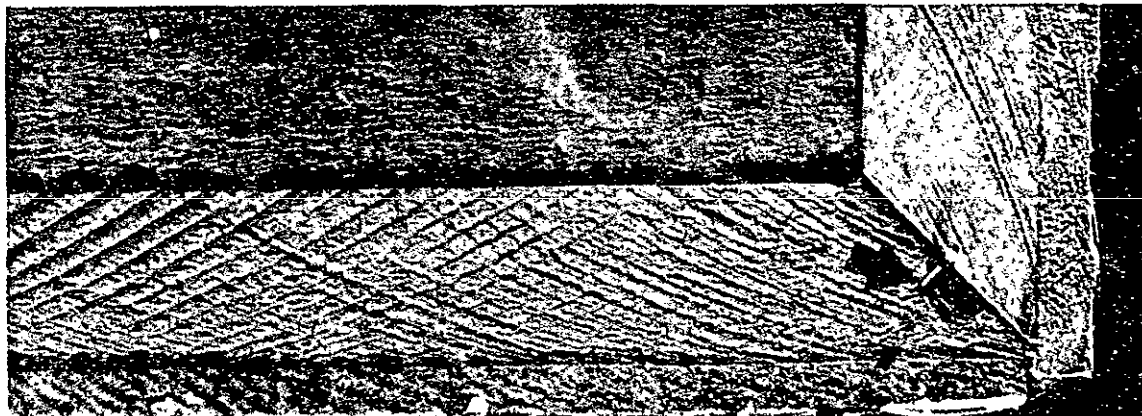
No. 21—LOOSE BINDING WIRE.
Minor. (Not fastened tightly.)



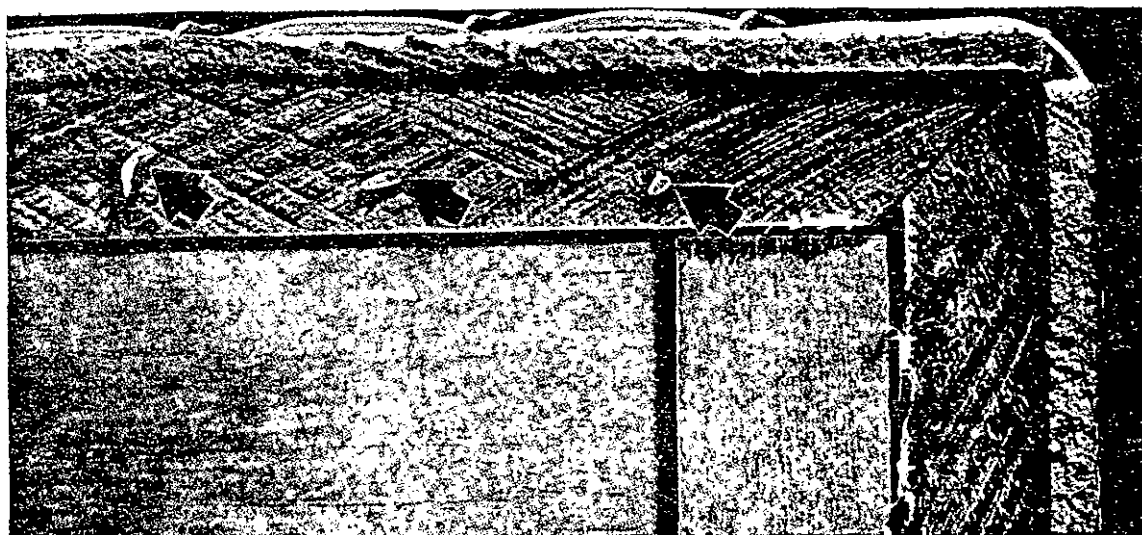
No. 21—LOOSE BINDING WIRE.
Minor. (Not drawn tightly.)



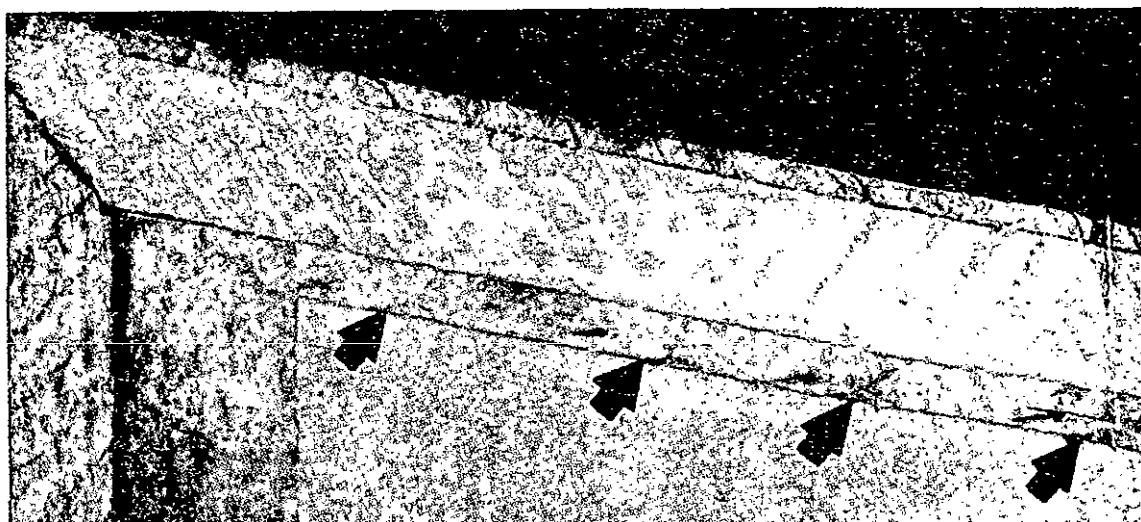
No. 22—SHORT LOOP. (Preventing
closing of box.) Major.



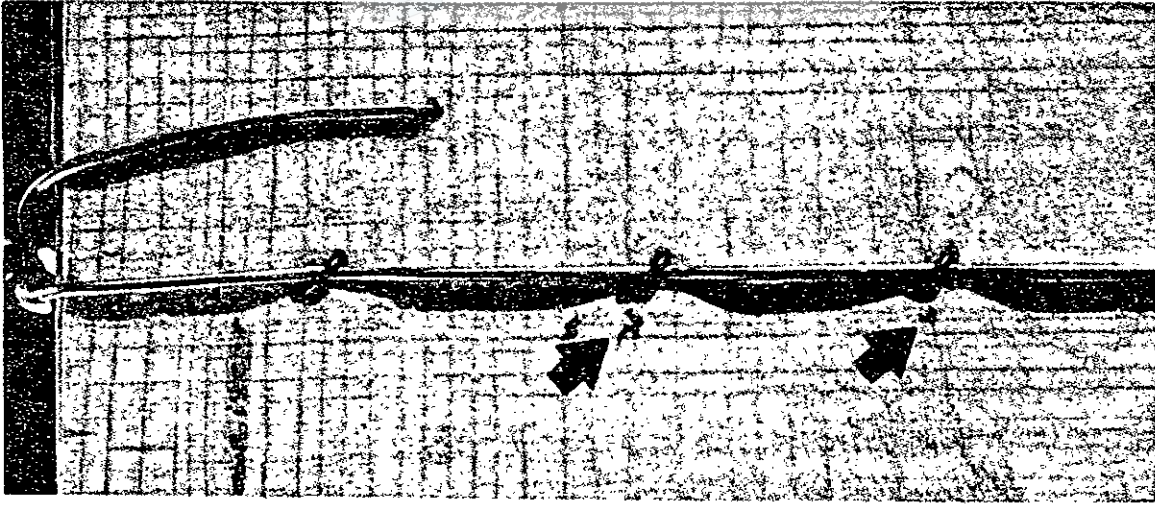
No. 23—PROTRUDING STAPLE POINT. Major.



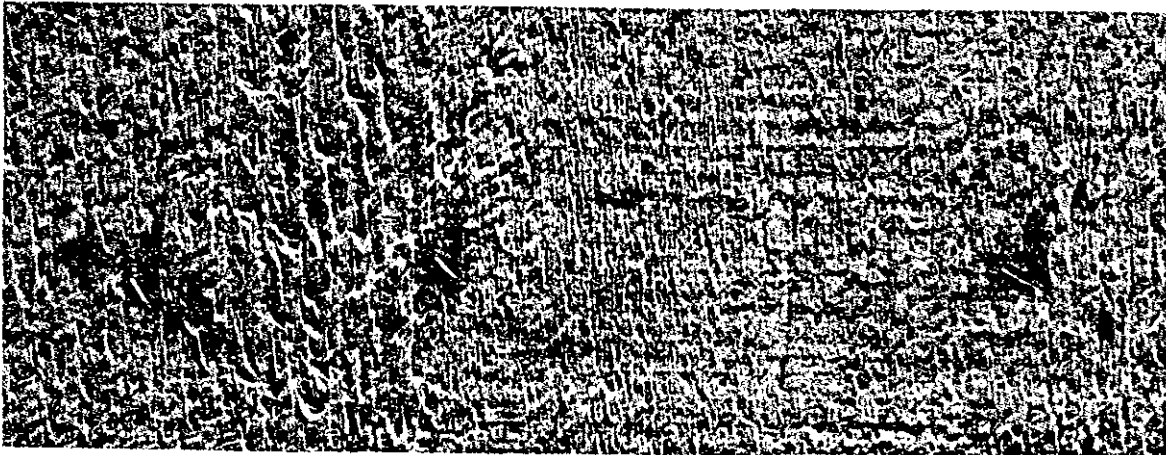
No. 23—PROTRUDING STAPLE POINTS. Major.



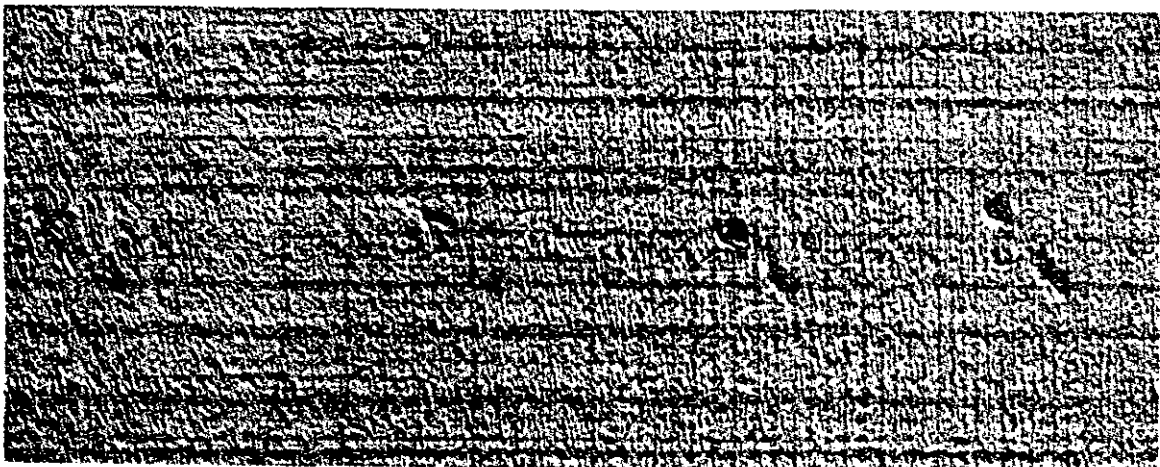
No. 23—PROTRUDING STAPLE POINTS. Major.



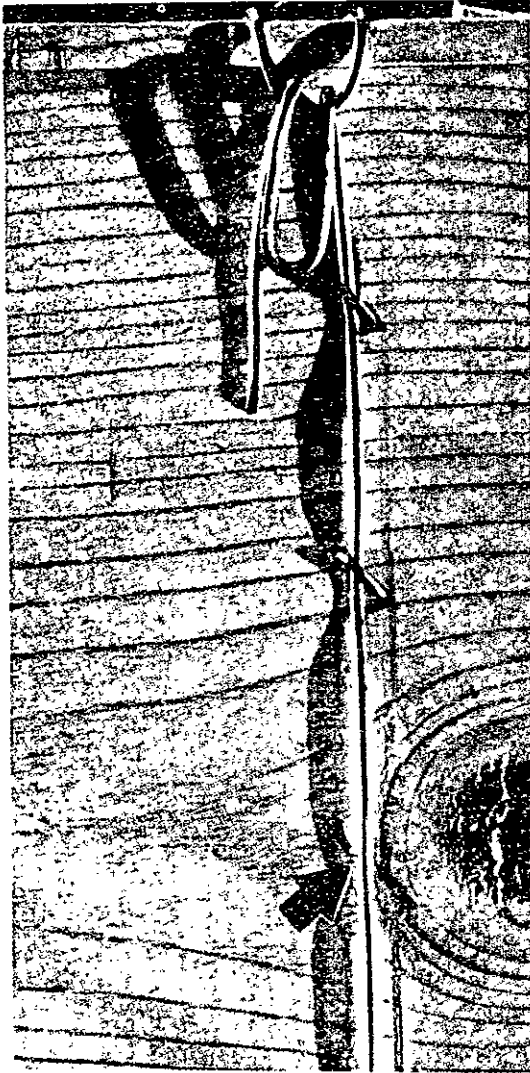
No. 23—PROTRUDING STAPLE POINTS. Major.



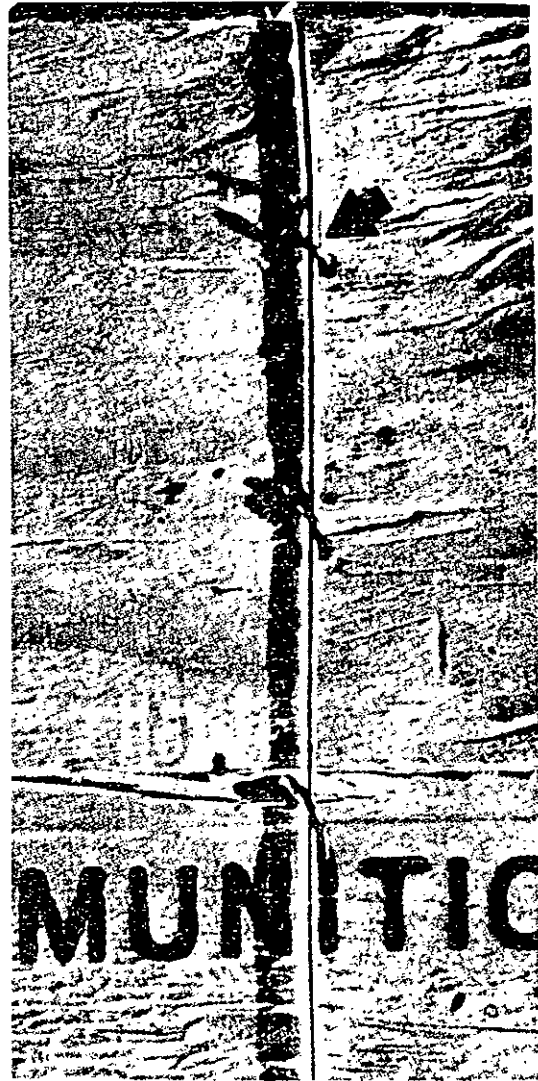
NO. 23—PROTRUDING STAPLE POINTS. Major.



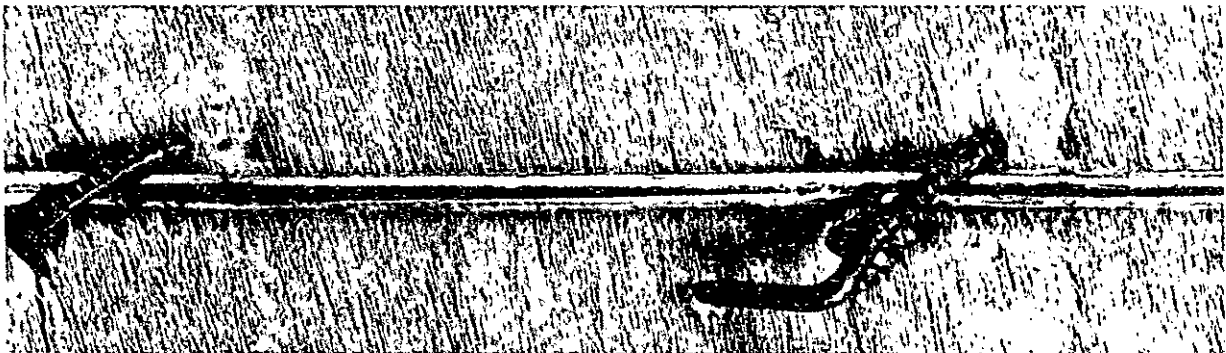
No. 23—CORRECTLY CLINCHED STAPLES. Required.



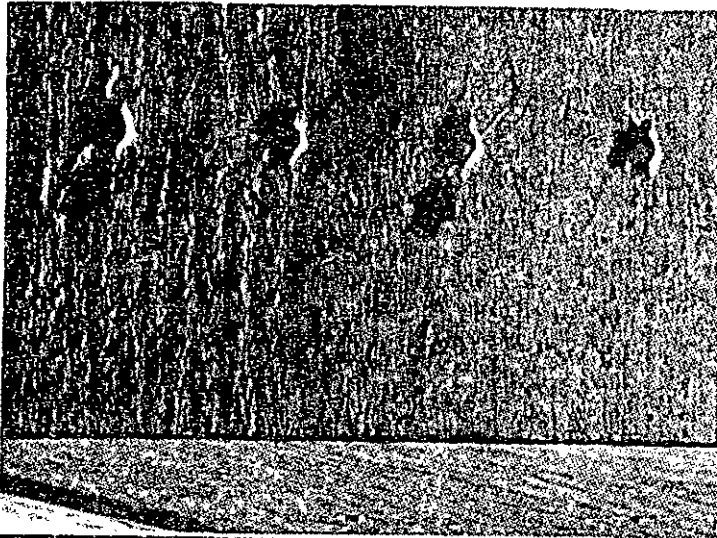
No. 24—MISSING STAPLE. Minor if more than two are missing per wire. Permissible if only two are missing per wire.



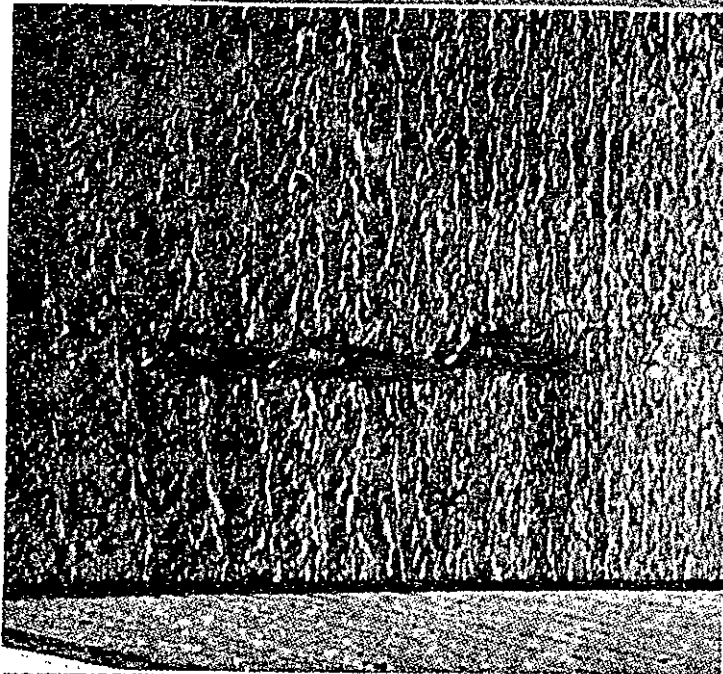
No. 24—BROKEN STAPLE. Minor if more than two are broken per wire. Permissible if only two are broken per wire.



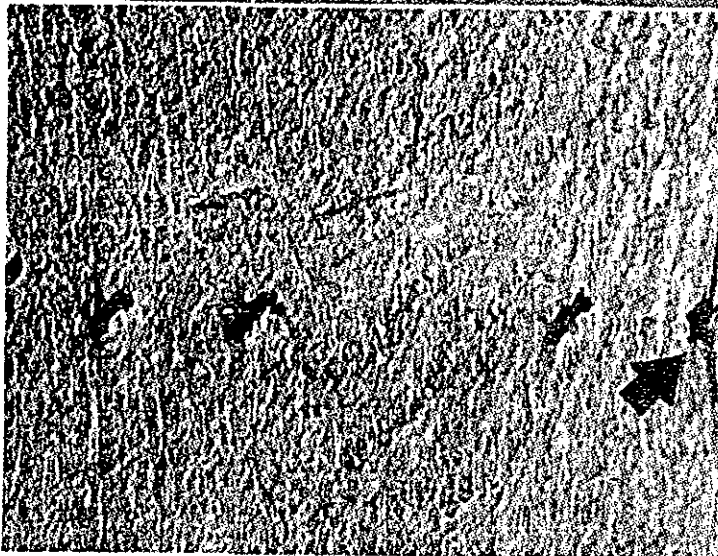
No. 24—POORLY DRIVEN STAPLE. Minor if more than two are poorly driven per wire. Permissible if only two are poorly driven per wire. (One leg of staple is not driven into wood.)



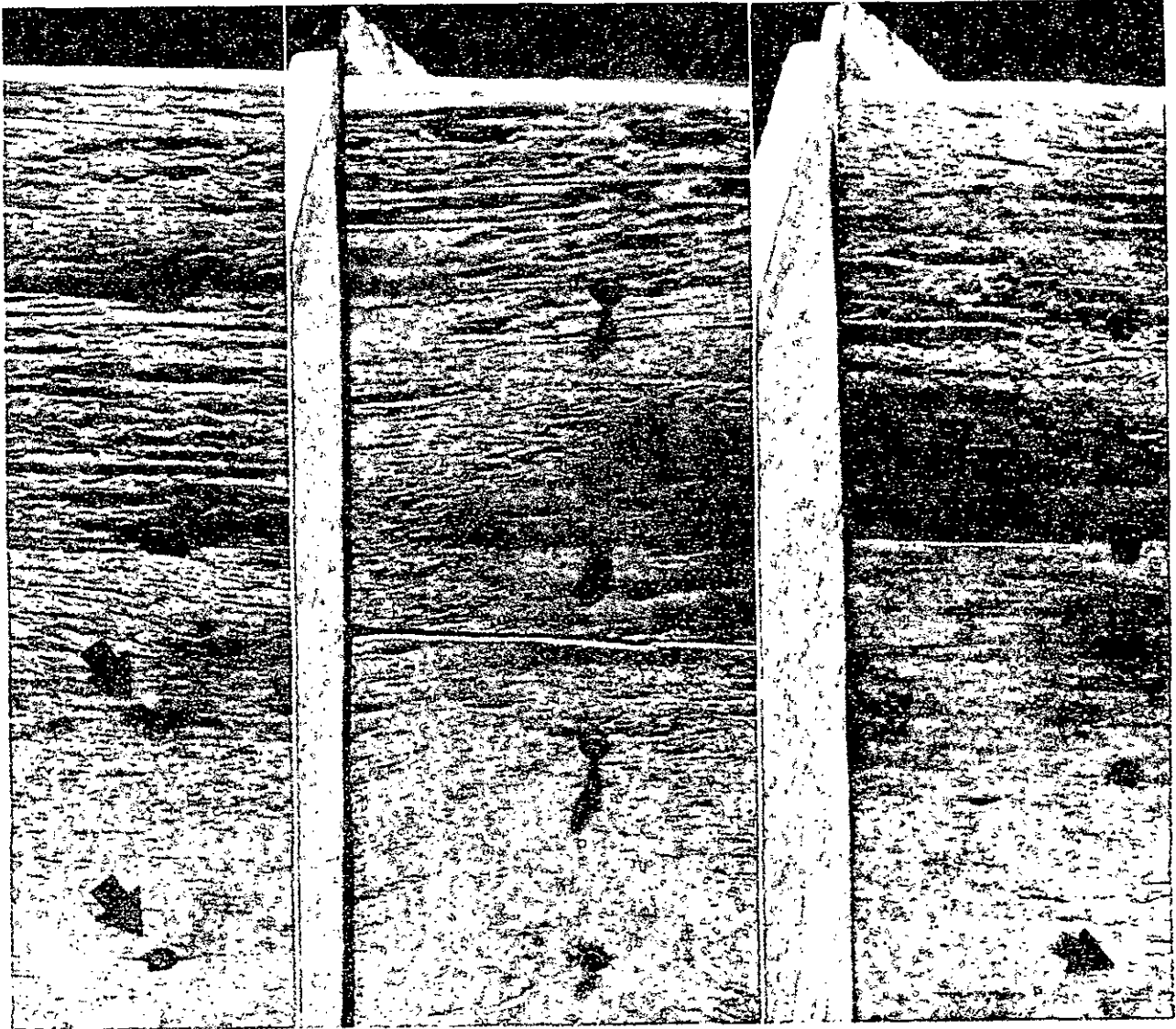
No. 25—MISSING BATTEN STAPLES.
Minor.



No. 25—PROTRUDING STAPLE LOOPS.
Minor if more than one protrudes per batten. Permissible if only one protrudes per batten.



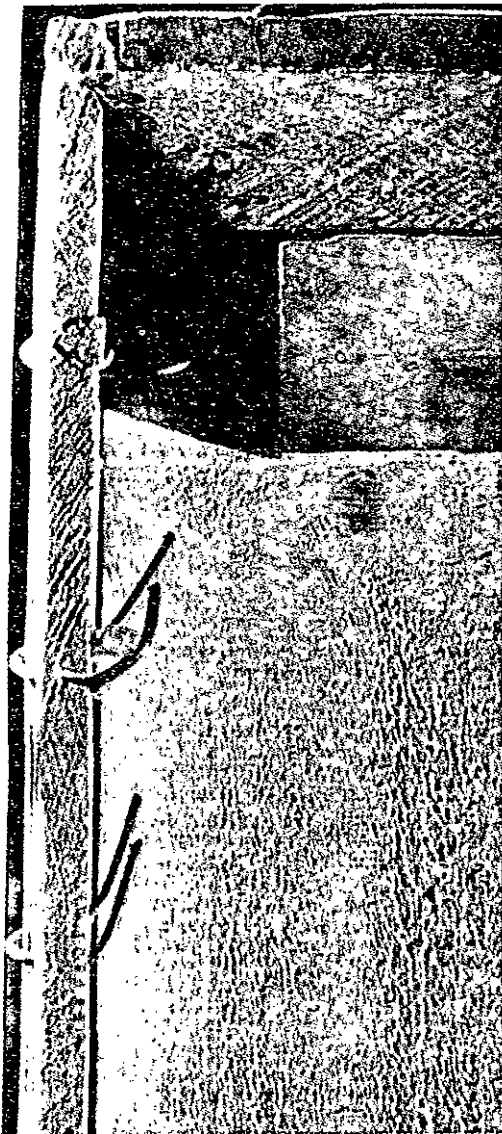
No. 25—MISSING BATTEN STAPLE.
Permissible. (Only one missing per batten.)



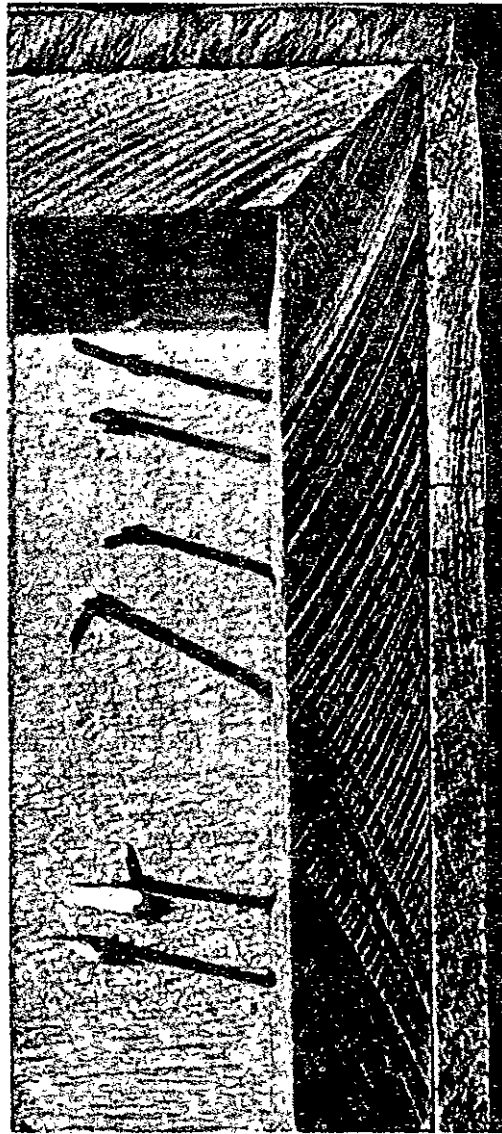
No. 26—MISSING BATTEN NAILS. Minor.

No. 26—PROTRUDING NAIL HEADS. Minor if more than one protrudes per batten. Permissible if only one protrudes per batten.

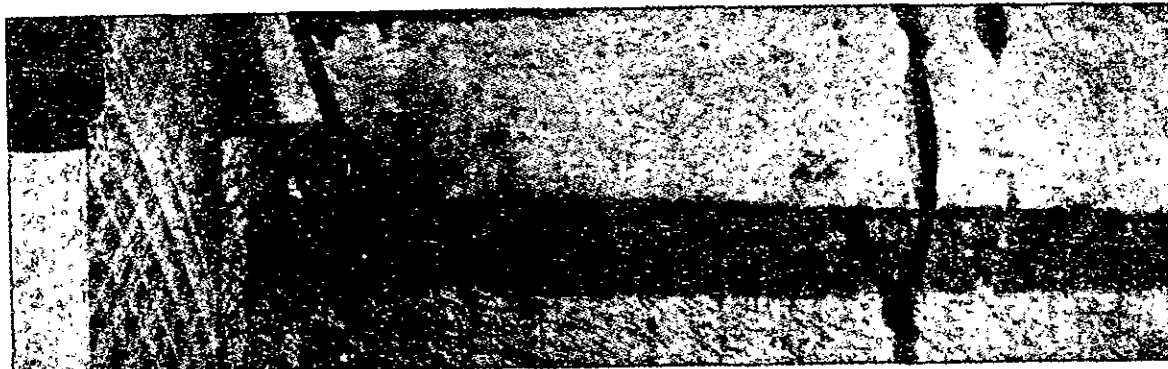
No. 26—MISSING BATTEN NAIL. Permissible. (Only one missing per batten.)



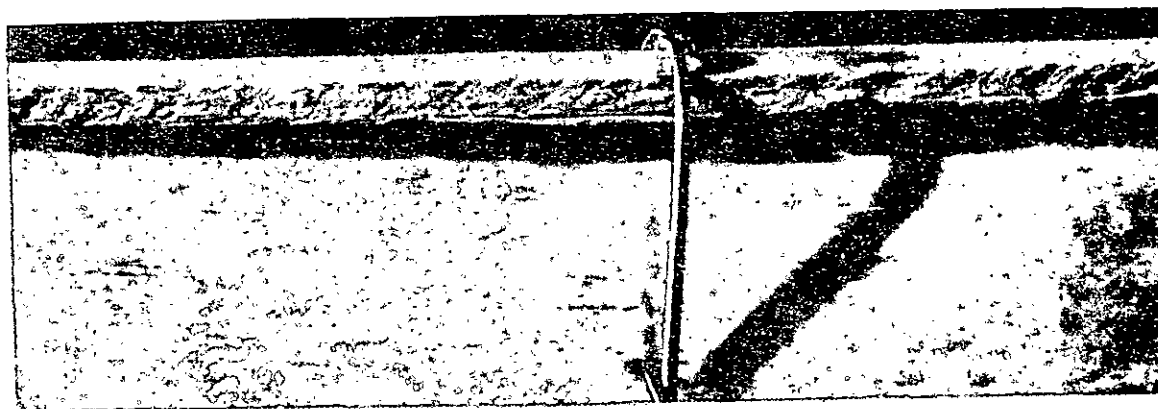
No. 27—MISSING CLEAT. Major.



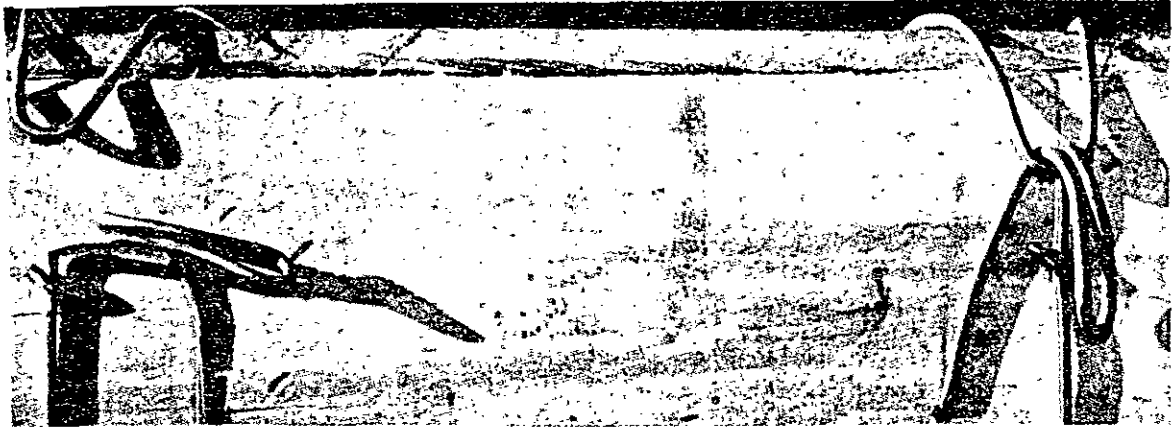
No. 27—MISSING BATTEN. Major.



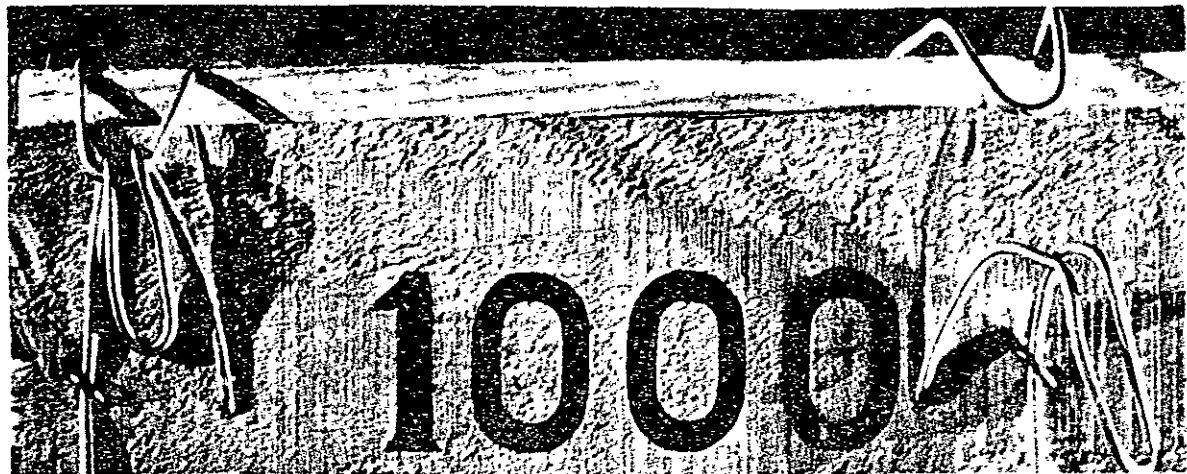
No. 28—OVERLAPPING BOARDS. Minor.



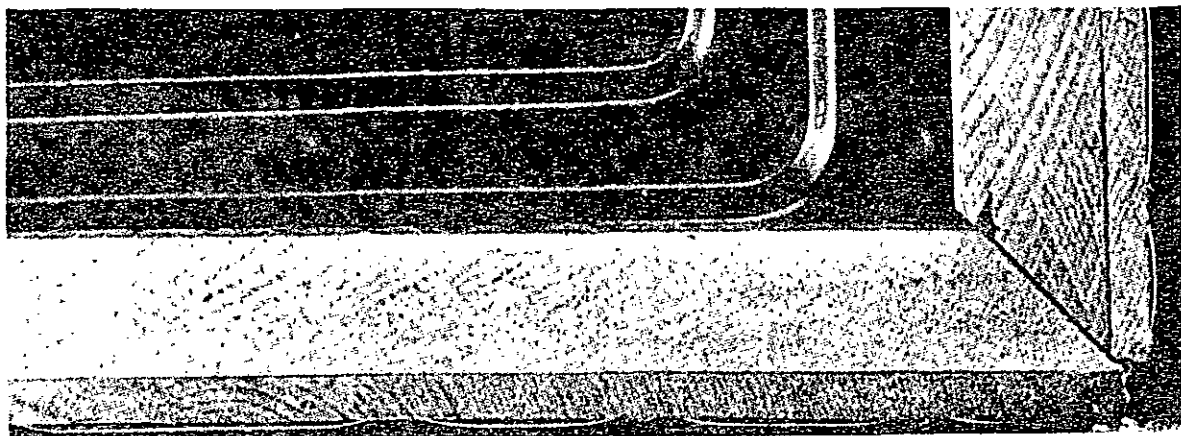
No. 28—OVERLAPPING BOARDS. Minor.



No. 29—UNFASTENED OUTSIDE BINDING WIRE. Major.



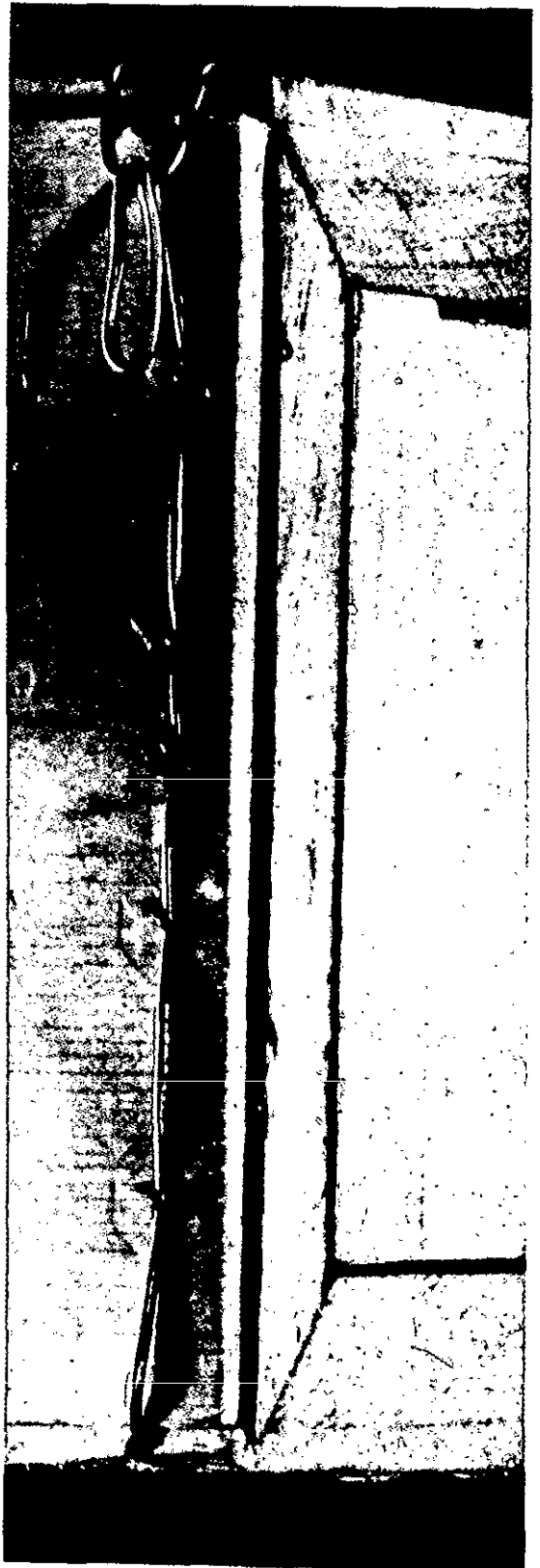
No. 30—UNFASTENED INSIDE BINDING WIRE. Minor.



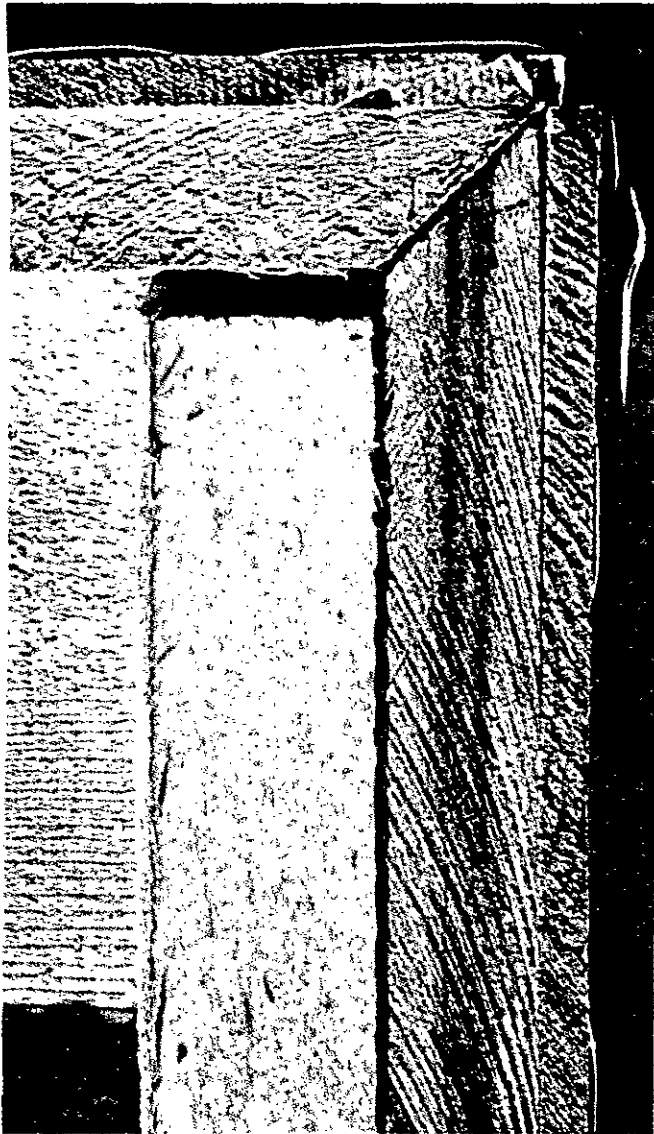
No. 31—MISSING END. Major.



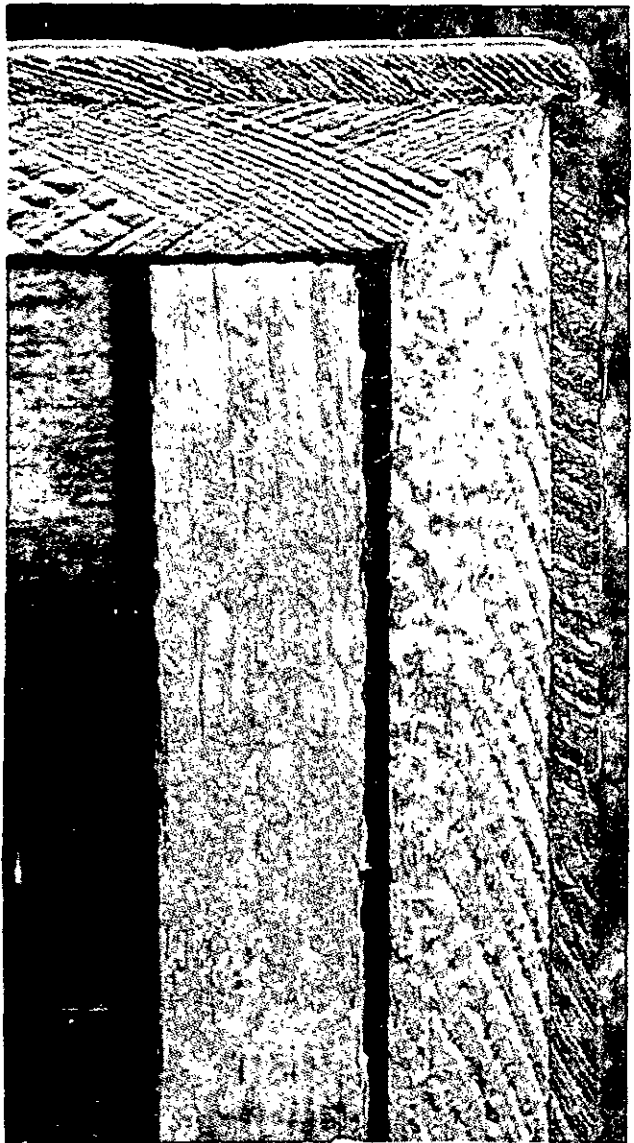
No. 32—Side, Top or Bottom Extending Beyond End Cleat More Than $\frac{1}{8}$ " Minor.



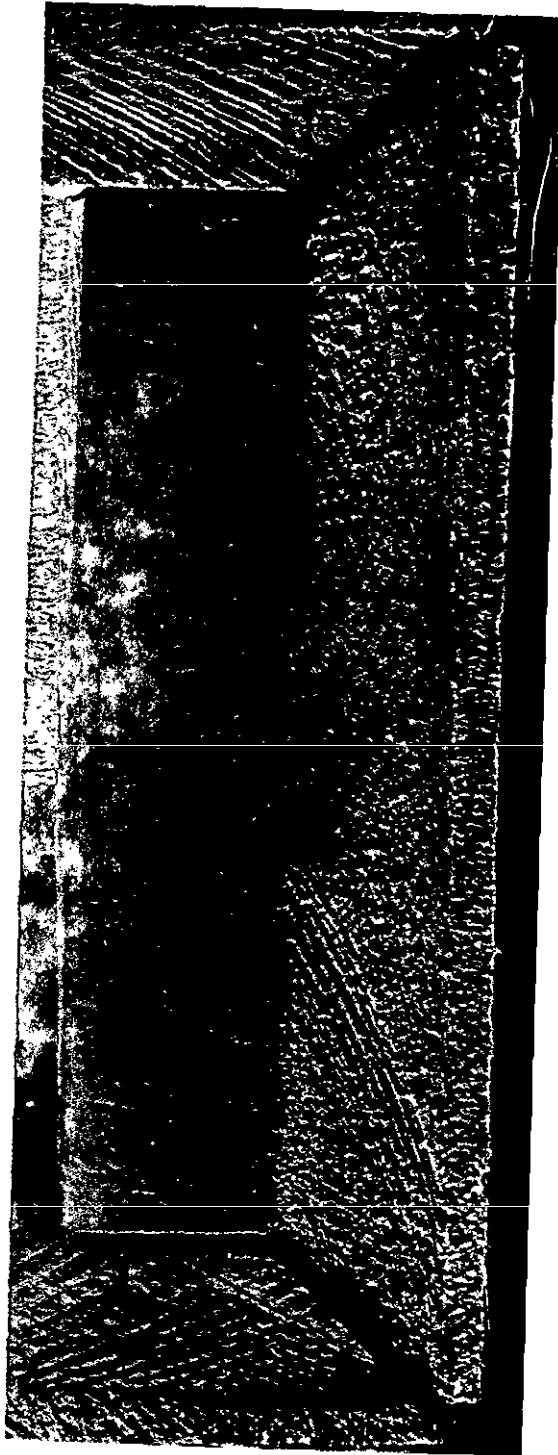
No. 33—End Cleat Extending Beyond Side, Top or Bottom More Than $\frac{1}{8}$ " Minor.



No. 34—GAP. Minor. (Space between end of batten and cleat greater than $\frac{1}{4}$ ".)

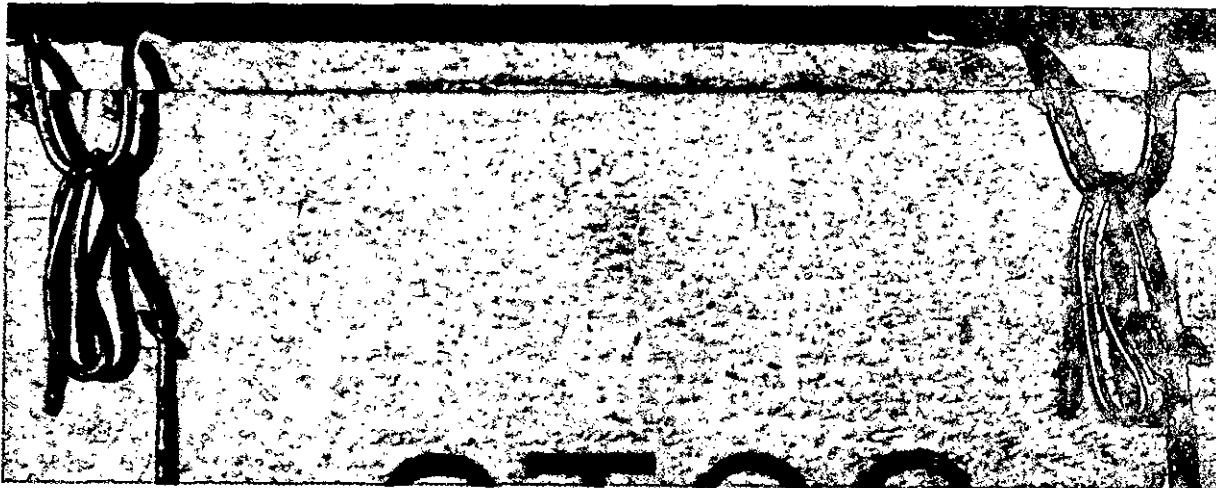


No. 35—GAP. Minor. (Space between side of batten and cleat greater than $\frac{1}{4}$ ".)

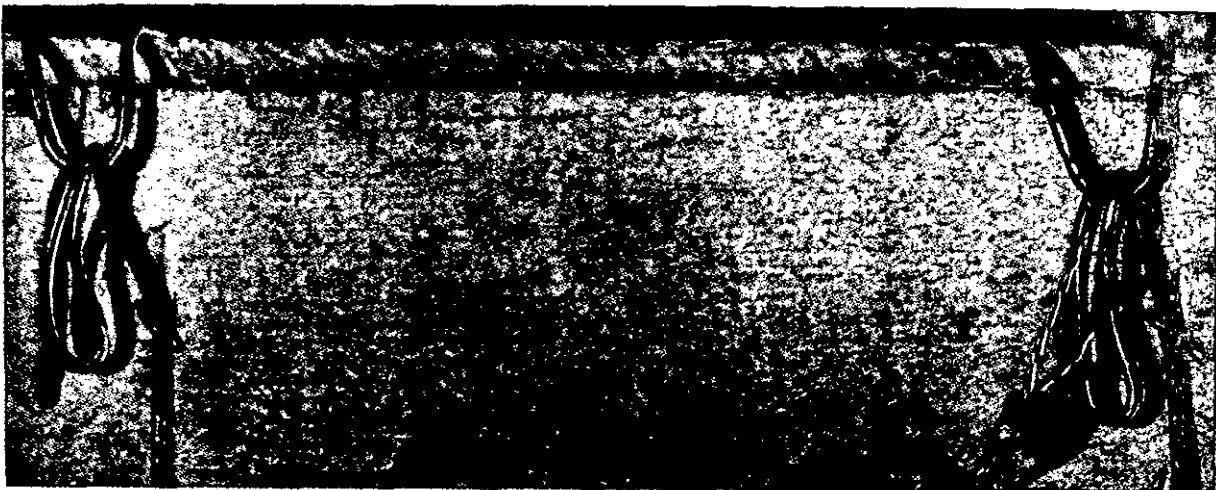


No. 36—GAP. Minor. (Space between diagonal ends of adjacent cleats greater than $\frac{1}{4}$ ".) Permissible if box has only one gap of this kind.

No. 37—Reversed or Inverted End. Minor. (*Not illustrated.* Printed end shall be on right end of box and shall not be inverted.)



No. 38—MISSING SEAL. Major.



No. 39—INCORRECTLY ATTACHED SEAL. Minor. (Top can be opened without breaking seal. *Note*—Other methods of attachment which have this fault are also defective.)

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