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Changes

- References to Continental Automotive Technical Standard Norms (TST):
  TST N 098 00.01 000 Packaging - Definition, Process, Requirements
  TST N 098 02.01 001 Container Optimized Wood Pallet L1108 and L1110
- Reference to INCOTERMS 2010
- New: Chapter 4.1 GLT Slip lid

Previous Editions

- Former specification called „Guideline for Expendable Packaging” and SML “Appendix A04” update January 2010, Vers. 3
- This TST replaces all other existing guidelines and procedures.

1 SCOPE

Due to growing globalization, it is necessary to use expendable packaging with standardized specification (dimension, quality, design), optimized regarding the whole material flow within the complete supply chain, e.g. dimension of the overseas container.

This TST is an extract of a specification we worked out together with the VDA (German association of automotive industry), with car manufacturers and worldwide 1Tier suppliers.

2 REFERENCES

- TST N 098 02.01 001 Container Optimized Wood Pallet L1108 and L1110 (1140 x 790/980x140 mm)
- TST N 098 00.01 000 Packaging - Definition, Process, Requirements
- SML Supplier Manual Logistics
- VDA 4525 Standardized expendable packaging for sea container applications
- VDA 4525, App. 1 and 2 Standardized expendable packaging for sea container applications - Annex_A1-4-system-elements
- EN ISO 8611-1 Pallets for materials handling - Flat pallets / Paletten für den Gütertransport – Flachpaletten
- FEFCO Codes International fibreboard case code
- ISPM No. 15 / IPPC International Standard for Phytosanitary Measures - Regulation of wood packaging material in international trade / International Plant Protection Convention (official web-side: IPPC)

All TSTs are downloadable at the Continental Automotive Homepage for Suppliers:
http://www.conti-online.com/www/automotive_de_en/general/contact_services/suppliers_logistics_en.html
3 LOADING UNIT

Loading units that are presently used often cause additional costs, e.g.
- Increased transport costs due to bad utilization of the container
- Excessive load securing and therefore needed material
- Higher risks for damaged or not available parts
- Additional workload for handling of claims
- Additional work of replacement to avoid capacity bottleneck

due to

- Unsuitable dimensions of Loading Unit (LU)
- Non stackable LU
- Unsufficient quality of packaging material
- Pallets with point load during stacking (missing skids, e.g. presswood pallets)
- Inadequate load securing
- Missing or incorrect labelling

For these reasons (to avoid damages and additional costs) the LU have to fulfil following characteristics:
- LU have to be stackable (static: min. 1+2, dynamic: min. 1+1)
- An outer cardboard box has to be used (three flutes, outer and inner layer kraft liner, water-resistant glue)
- secured with PET- or PP-straps (see chapter load securing)
- Dimensions of the LU adapted to 20’ and 40’ container: 1140mm x790mm or 1140mm x 980mm

We refer to these dimensions for all kind of transport modes (sea, air, land) to achieve one standard packaging mode with a minimized variance of packaging materials. Also for returnable loops these dimensions are suitable as alternative packaging.
3.1 Outer corrugated cardboard box (GLT)

Design of the outer corrugated cardboard boxes (GLT):

![Diagram of GLT boxes]

- System: FEFCO 0312
  - GLT slip lid
  - GLT folding box
  - Expendable block-pallet

- System: FEFCO 0310/0314
  - GLT slip lid
  - GLT shell
  - GLT slip bottom
  - Expendable block-pallet

- System: FEFCO 0312 + 0501
  - GLT slip lid
  - Inner shell
  - GLT folding box
  - Expendable block-pallet

3.2 Pallets

In this TST you will find two specified pallets with the dimensions 1140mm x 790mm or 1140mm x 980mm. The minimum requirements are:

Material:

- Solid wood, mono-material plastic (only after agreement).
- Required max. loading capacity has to be achieved.
- By using solid wood, the import- and export-regulations of the involved countries have to be considered (IPPC, ISPM No. 15).

Design:

- Four-way-free-entry block-pallet, with three skids, min. width of skids 90mm
- Usage of a „Full Perimeter Pallet“ has to be agreed by the receiving plant, because
- These pallets cannot be handled with a manual pallet jack.
- Usage of moulded presswood pallets is not acceptable.

Load capacity:

- Capacity min. 500kg per pallet, if evenly loaded
- Capacity statically stacked min. 2000kg per pallet, if evenly loaded
- Suitable for storage in a high rack min. 500kg

Tests of pallets have to be done according to EN ISO 8611-1. For tests of stiffness a safety factor of 2 has to be met.
3.3 Carton (KLT)

Attached you will find also a proposal of inner packaging material, corrugated cardboard cartons with slip lids. It is also possible to use cartons according FEFCO code 0201 with flaps instead of slip lids, but than other dimension can be chosen than mentioned in the table of the KLT. But it is also possible to use the currently used inner packaging material inside the GLT. The height of the GLT could also be adapted to the height of your inner packaging material.

Design of the KLT:

With single slip lids in shell:

With layer slip lids in shell:

3.4 Load Securing (of the LU)

Following aspects have to be taken into consideration for securing the outer cardboard box on the pallet:

- The goods have to be secured against any movement on the transport
- The LU has to be strapped 4 times, 2 times lengthwise and 2 times crosswise.
- Wide plastic straps made of PET or PP have to be used to secure the goods (GLT) on the pallet. Min. breaking strength: 4200N and a maximum elongation at break of 12%. For a sufficient pretension (setting of cardboard material) cutting into the material by the straps has to be avoided!
- Therefore edge protection support has to be used.
- Loading flaps at the GLT have to be closed with filament-reinforced adhesive tape (min. 70mm, filament tape applied crossways in order to prevent splitting parallel with the loading flap).
- Using of additional stretch or shrink foil has to be agreed by the receiving plant.
This TST is based on the recommendation VDA (German association of automotive industry) 4525. Additional information you could also find in our “TST N 098 00.01 000 Packaging - Definition, Process, Requirements”, available on SupplyOn platform and our internet site “For Suppliers”:


The appliance of this TST doesn’t abdicate from suppliers’ responsibility for his action (choosing the right packaging, which is adequate for material flow, also written in INCOTERMS 2010). Every supplier act on at his own risk.
### GLT - SPECIFICATION

<table>
<thead>
<tr>
<th>Module</th>
<th>Code</th>
<th>System element</th>
<th>Nominal dimension [mm]</th>
<th>External dimension [mm]</th>
<th>Internal dimension [mm]</th>
<th>Design (options)</th>
<th>Quality**</th>
<th>LU - load scale</th>
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<td>1.140 x 700 x 800</td>
<td>FEFCO</td>
<td>0.057</td>
<td>7</td>
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</tbody>
</table>

1. Min. breaking strength that has to be achieved! Test has to be done with one pallet under the loading unit and one pallet on top! The values for breaking strength in the table have been achieved with the cardboard material with the stated data (ECT...).
2. Drop door at one long side, 750mm widthwise and a height of 440mm. Creasing station only 750mm widthwise, not over the complete length of the box! Cuttings of the drop door has to be glued with reinforced adhesive tape!
3. Loading units with this height can only be stacked 1x1 inside the container. Therefore only the superimposed load of one loading unit has to be guaranteed (at all times a safety factor 2.5 has to be guaranteed).
4. Cardboard material with three flutes has to be used for the GLT (GLT lids two flutes), which are wet strength glued. The external layers (inside and outside) has to consist of Kraftliner.
4.1 GLT Slip Lid

**Designation**
GLT cover LT 1108  98-4525-0108-1-00
GLT cover LT 1110  98-4525-0110-1-00

Following cover designs (FEFCO codes) are established at Continental Automotive:

- **FEFCO code 0310**

- **FEFCO code 0312**

- **FEFCO code 0314**
5 PALLET – SPECIFICATION

| Pallet LT 1108 | 98-4525-0108-0-00 |
| Pallet LT 1110 | 98-4525-0110-0-00 |

Designation: CA part-no

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<th>Module</th>
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<td></td>
<td>I w h</td>
<td>I w h</td>
<td>max. load per pallet</td>
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<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1.140</td>
<td>790</td>
<td>140</td>
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1) with surface loading (if evenly loaded) Suitable for high rack storage
2) with surface loading (if evenly loaded)!

5.1 Pallet LT 1108

See also:
VDA 4525 and VDA Annex 1
CA Norm TST N 098 02.01 001 Container Optimized Wood Pallet L1108 and L1110
SAP CSE part-no.: 98-4525-0108-0-00

No IPPC-Standard
Verwendetes Holz muss völlig frei sein von Baumfraß und Bohrlöchern
Used wood must be free of bark and drillholes

Bei Bedarf technische Trocknung (18–22% Holzfeuchtigkeit)
technical drying, if required (18–22% moisture content)

An 2 gegenüberliegenden Kanten weiß gekennzeichnet
marked white on 2 opposite sides

Angegebene Maße sind Fertigmaße, und dürfen auch nach technischer
Trocknung nicht unterschritten werden, given dimensions are final dimensions and must not be below, even after technical

IPPC Kennzeichnung auf zwei gegenüberliegenden Seiten
IPPC marking on two opposite sides
5.2 Pallet LT 1110

See also:
VDA 4525 and VDA Annex 1
CA Norm TST N 098 02.01 001 Container Optimized Wood Pallet L1108 and L1110
SAP CSE part-no.: 98-4525-0110-0-00
## Expendable Packaging

### Module Code

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<th>Nominal dimension [mm]</th>
<th>External dimension [mm]</th>
<th>Internal dimension [mm]</th>
<th>Design (recommended variant)</th>
<th>Loading Unit (LU, load scale)</th>
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<tbody>
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<td>GLT 94</td>
<td>GLT-SD-1108</td>
<td>1.140 790 80</td>
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**GLT**

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<th>Internal dimension [mm]</th>
<th>Design (recommended variant)</th>
<th>Loading Unit (LU, load scale)</th>
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<td>Carton</td>
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<td>533 357 281</td>
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<td>7 5.5 7.5 1550</td>
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<td>Carton</td>
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<td>519 343 130</td>
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<td>7 5.5 7.5 1550</td>
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<td>K.T.-B2-1750</td>
<td>5ip lid, 1 flute</td>
<td>540 360 60</td>
<td>540 360 60</td>
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**KLT**

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<td>1.5 5.5 4.5 1350</td>
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</table>

* Depending on design of the bottom

1. For bulk goods a closed flat bottom similar to FEFCO 0701 or an additional inlay is advisable.

2. Every chosen design has to be checked regarding applicability for the chosen application. Recommended design variants should facilitate selection.
7 Optimization of Overseas – Packaging

Following you will find some examples for unacceptable and acceptable condition of overseas packaging / loading units.

7.1 Example 1: Pallets / Loading Unit

Unacceptable condition:

- No press wood-pallets anymore! Only 4-way-free-entry block-pallets!
- Using of outer cardboard box (loading unit) is necessary!
- Dimensions of the loading unit [LU] should be sea-container optimized!
- 2- till 3-times (dynamical) stackability of the LU ! (1+1 till 1+2 LU)
- Securing devices: No shrinking or stretching plastic sheets for the LU, only polypropylene or polyester (PP or PET) straps!

Acceptable condition:

- No press wood-pallets anymore! Only 4-way-free-entry block-pallets!
- Using of outer cardboard box (loading unit) is necessary!
- Dimensions of the loading unit [LU] should be sea-container optimized!
- 2- till 3-times (dynamical) stackability of the LU ! (1+1 till 1+2 LU)
- Securing devices: No shrinking or stretching plastic sheets for the LU, only polypropylene or polyester (PP or PET) straps!
7.2 Example 2: Plastic Foil Stretched Around The Box

Unacceptable condition:

☒ Not really better security during the transportation
☒ Often the foil closes the entrance-holes of the pallet
☒ More handling time to remove the foil
☒ More waste and waste-costs

Acceptable condition:

✓ The loading unit is not shrunk or stretched with foil and is secured only with PP- or PET- straps!
7.3 Example 3: Stackability of Loading Units

Unacceptable condition:

- 2-way pallets
- Presswood-pallets
- Stretched single cartons
- Single cartons with no outer cardboard box (LU)

Acceptable condition:

- 4-way-free-entry block-pallet
- The LU is strapped with PP- or PET- straps
- The LU is stackable
7.4 Example 4: Stackability of Loading Units and Inner Packing

Unacceptable condition:

- Small single carton at the top of the LU
- LU is not stackable
- Stretched single cartons on a pallet
- Single cartons with no outer cardboard box (LU)
- Single cartons into a LU, but too much free space inside the LU

Acceptable condition:

- Small cartons are into an outer cardboard box (LU)
- The small cartons fill out the LU from bottom to top
- Inner packaging support outside stacking
- The LU is stackable
- 4-way-free-entry block-pallet
- The LU is strapped with PP- or PET- straps
7.5 Example 5: Identification

Unacceptable condition:

- General: Symbol at the packaging with less than double stacking
- Symbol only on the top of the LU, no remarks at the sides
- No symbol and only text: That's not clear for all nations

Acceptable condition:

- Stackability, dynamical factor: 1+1 better 1+2!
- Clear symbol (comprehensible for all nations)!
- Place identifying symbol at each side!
- Clear identifying symbol: