

TABLE III-A—SAMPLING PLANS FOR REDUCED CONDITION OF CONTAINER INSPECTION

| Code | Lot size ranges—No. of containers in lot | Type of plan | Sample size |     | Acceptable quality levels |    |     |    |     |    |
|------|--|--------------|-------------|-----|---------------------------|----|-----|----|-----|----|
|      |  |              |             |     | 0.25                      |    | 1.5 |    | 6.5 |    |
|      |  |              |             |     | Ac                        | Re | Ac  | Re | Ac  | Re |
| CAA  | 6,000 or less                            | Double       | 1st         | 18  | 0                         | 2  | 0   | 2  | 1   | 4  |
|      |  |              | 2d          | 18  |                           |    |     |    |     |    |
|      |  |              | Total       | 36  | 1                         | 2  | 1   | 2  | 5   | 6  |
| CA   | 6,001–36,000                             | Double       | 1st         | 36  | 0                         | 2  | 0   | 4  | 2   | 7  |
|      |  |              | 2d          | 60  |                           |    |     |    |     |    |
|      |  |              | Total       | 96  | 1                         | 2  | 3   | 4  | 10  | 11 |
| CB   | Over 36,000                              | Double       | 1st         | 120 | 0                         | 2  | 2   | 6  | 10  | 14 |
|      |  |              | 2d          | 60  |                           |    |     |    |     |    |
|      |  |              | Total       | 180 | 1                         | 2  | 5   | 6  | 17  | 18 |

TABLE III-B—LIMIT NUMBERS FOR REDUCED INSPECTION

| Number of sample units from last 10 lots inspected within 6 months | Acceptable quality level |      |     |     |     |     |     |     |       |  |
|--|--------------------------|------|-----|-----|-----|-----|-----|-----|-------|--|
|  | 0.15                     | 0.25 | 0.5 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10.0  |  |
| 320–499  | (*)                      | (*)  | (*) | 0   | 1   | 4   | 8   | 14  | 24    |  |
| 500–799  | (*)                      | (*)  | 0   | 2   | 3   | 7   | 14  | 25  | 40    |  |
| 800–1,249  | (*)                      | 0    | 1   | 4   | 7   | 14  | 24  | 42  | 68    |  |
| 1,250–1,999  | 0                        | 0    | 3   | 7   | 13  | 24  | 40  | 69  | 110   |  |
| 2,000–3,149  | 0                        | 2    | 6   | 14  | 22  | 40  | 68  | 115 | 181   |  |
| 3,150–4,999  | 1                        | 4    | 10  | 24  | 38  | 67  | 111 | 186 | 293   |  |
| 5,000–7,999  | 3                        | 7    | 18  | 40  | 63  | 110 | 181 | 302 | 472   |  |
| 8,000–12,499   | 7                        | 14   | 31  | 68  | 105 | 181 | 297 | 491 | 765   |  |
| 12,500–19,999  | 13                       | 24   | 52  | 110 | 169 | 290 | 471 | 777 | 1,207 |  |

\*Denotes that the number of sample units from the last 10 inspection lots is not sufficient for reduced inspection for this AQL. In this instance more than 10 inspection lots may be used for the calculations if the inspection lots used are the most recent ones in sequence within the last 6 months, they have all been on normal inspection, and none has been rejected on original inspection.

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§ 42.112 Defects of containers: Tables IV, V, VI, and VII.

TABLE IV—METAL CONTAINERS

| Defects   | Categories |       |       |
|---|------------|-------|-------|
|   | Critical   | Major | Minor |
| Type or size of container or component parts not as specified   | (1)        | (1)   | (1)   |
| Closure incomplete, not located correctly or not sealed, crimped, or fitted properly  |            | 101   |       |
| Dirty, stained or smeared container   |            |       | 201   |
| Key opening metal containers (when required):   |            |       |       |
| (a) Key missing   |            | 102   |       |
| (b) Key does not fit tab  |            | 103   |       |
| (c) Tab of opening band insufficient to provide accessibility to key  |            | 104   |       |
| (d) Improper scoring (band would not be removed in one continuous strip)  |            | 105   |       |
| Open top with plastic overcap (when required):  |            |       |       |
| (a) Plastic overcap missing   |            | 106   |       |
| (b) Plastic overcap warped (making opening or reapplication difficult)  |            | 107   |       |
| Outside tinplate or coating (when required):  |            |       |       |
| (a) Missing or incomplete   |            |       | 202   |
| (b) Blistered, flaked, sagged, or wrinkled  |            |       | 203   |
| (c) Scratched or scored   |            |       | 204   |
| (d) Fine cracks   |            |       | 205   |
| Rust (rust stain confined to the top or bottom double seam or rust that can be removed with a soft cloth is not scored a defect): |            |       |       |
| (a) Rust stain (nonmilitary purchases)  |            |       | 206   |
| (b) Rust stain (military purchases)   |            | 108   |       |
| (c) Pitted rust   |            | 109   |       |
| Wet cans (excluding refrigerated containers)  |            |       | 207   |

TABLE IV—METAL CONTAINERS—Continued

| Defects  | Categories |       |       |
|--|------------|-------|-------|
|  | Critical   | Major | Minor |
| Dent:  |            |       |       |
| (a) Materially affecting appearance but not usability .....  |            |       | 208   |
| (b) Materially affecting usability .....   |            | 110   |       |
| Buckle:  |            |       |       |
| (a) Not involving end seam .....   |            |       | 209   |
| (b) Extending into the end seam .....  |            | 111   |       |
| Collapsed container .....  |            | 112   |       |
| Paneled side materially affecting appearance but not usability .....                                     |            |       | 210   |
| Solder missing when required .....   |            | 113   |       |
| Cable cut exposing seam .....  |            | 114   |       |
| Improper side seam .....   |            | 115   |       |
| Swell, springer, or flipper (not applicable to gas or pressure packed product nor frozen products) ..... | 1          |       |       |
| Leaker or blown container .....  | 2          |       |       |
| Frozen products only:  |            |       |       |
| (a) Bulging ends $\frac{3}{16}$ " to $\frac{1}{4}$ " beyond lip .....                                    |            |       | 211   |
| (b) Bulging ends more than $\frac{1}{4}$ " beyond lip .....  |            | 116   |       |

<sup>1</sup> None permitted.

TABLE V—GLASS CONTAINERS

| Defects   | Categories       |                  |                  |
|---|------------------|------------------|------------------|
|   | Critical         | Major            | Minor            |
| Type or size of container or component parts not as specified ..... | ( <sup>1</sup> ) | ( <sup>1</sup> ) | ( <sup>1</sup> ) |
| Closure not sealed, crimped, or fitted properly .....               |                  | 101              |                  |
| Dirty, stained, or smeared container .....                          |                  |                  | 201              |
| Chip in glass .....   |                  |                  | 202              |
| Stone (unmelted material) in glass .....                            |                  |                  | 203              |
| Pits in surface of glass .....                                      |                  |                  | 204              |
| Sagging surface .....   |                  |                  | 205              |
| Bead (bubble within glass):   |                  |                  |                  |
| (a) $\frac{1}{8}$ " to $\frac{1}{16}$ " in diameter .....           |                  |                  | 206              |
| (b) Exceeding $\frac{1}{8}$ " in diameter .....                     |                  | 102              |                  |
| Checked .....   |                  | 103              |                  |
| Thin spot in glass .....  |                  | 104              |                  |
| Blister (structural defect) .....                                   |                  | 105              |                  |
| Bird swing (glass appendage inside container) .....                 | 1                |                  |                  |
| Broken or leaking container .....                                   | 2                |                  |                  |
| Cap (nonheat processed):  |                  |                  |                  |
| (a) Cross-threaded .....  |                  |                  | 207              |
| (b) Loose but not leaking .....                                     |                  |                  | 208              |
| (c) Pitted rust .....   |                  | 106              |                  |
| Cap (heat processed):   |                  |                  |                  |
| (a) Cross-threaded or loose .....                                   | 3                |                  |                  |
| (b) Pitted rust .....   |                  | 107              |                  |
| Sealing tape or cello band (when required):                         |                  |                  |                  |
| (a) Improperly placed .....   |                  |                  | 209              |
| (b) Not covering juncture of cap and glass .....                    |                  | 108              |                  |
| (c) Ends overlap by less than $\frac{1}{2}$ " .....                 |                  | 109              |                  |
| (d) Loose or deteriorating .....                                    |                  | 110              |                  |

<sup>1</sup> None permitted.

TABLE VI—RIGID AND SEMIRIGID CONTAINERS—CORRUGATED OR SOLID FIBERBOARD, CHIPBOARD, WOOD, ETC. (EXCLUDING GLASS AND METAL)

| Defects   | Categories       |                  |                  |
|---|------------------|------------------|------------------|
|   | Critical         | Major            | Minor            |
| Type or size of container or component parts not as specified ..... | ( <sup>1</sup> ) | ( <sup>1</sup> ) | ( <sup>1</sup> ) |
| Component part missing .....  |                  | 101              |                  |
| Closure not sealed, crimped, or fitted properly:                    |                  |                  |                  |
| (a) Primary container .....   |                  | 102              |                  |
| (b) Other than primary container .....                              |                  |                  | 201              |
| Dirty, stained, or smeared container .....                          |                  |                  | 202              |
| Wet or damp (excluding ice packs):                                  |                  |                  |                  |
| (a) Materially affecting appearance but not usability .....         |                  |                  | 203              |

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TABLE VI—RIGID AND SEMIRIGID CONTAINERS—CORRUGATED OR SOLID FIBERBOARD, CHIPBOARD, WOOD, ETC. (EXCLUDING GLASS AND METAL)—Continued

| Defects   | Categories |       |       |
|---|------------|-------|-------|
|   | Critical   | Major | Minor |
| (b) Materially affecting usability .....  |            | 103   |       |
| Moldy area .....  | 1          |       |       |
| Crushed or torn area:   |            |       |       |
| (a) Materially affecting appearance but not usability .....   |            |       | 204   |
| (b) Materially affecting usability .....  |            | 104   |       |
| Separation of lamination (corrugated fiberboard):   |            |       |       |
| (a) Materially affecting appearance but not usability .....   |            |       | 205   |
| (b) Materially affecting usability .....  |            | 105   |       |
| Product sifting or leaking .....  |            | 106   |       |
| Nails or staples (when required):   |            |       |       |
| (a) Not as required, insufficient number or improperly positioned .....   |            |       | 206   |
| (b) Nails or staples protruding .....   |            | 107   |       |
| Glue or adhesive (when required); not holding properly not covering area specified, or not covering sufficient area to hold property: |            |       |       |
| (a) Primary container .....   |            | 108   |       |
| (b) Other than primary container .....  |            |       | 207   |
| Flap:   |            |       |       |
| (a) Projects beyond edge of container more than ¼ inch .....  |            |       | 208   |
| (b) Does not meet properly, allowing space of more than ¼ inch .....  |            |       | 209   |
| Sealing tape or strapping (when required):  |            |       |       |
| (a) Missing .....   |            | 109   |       |
| (b) Improperly placed or applied .....  |            |       | 210   |

<sup>1</sup> None permitted.

TABLE VII—FLEXIBLE CONTAINERS (PLASTIC, CELLO, PAPER, TEXTILE, ETC.)

| Defects   | Categories       |                  |                  |
|---|------------------|------------------|------------------|
|   | Critical         | Major            | Minor            |
| Type or size of container or component parts not as specified .....                   | ( <sup>1</sup> ) | ( <sup>1</sup> ) | ( <sup>1</sup> ) |
| Closure not sealed, crimped, stitched, or fitted properly:                            |                  |                  |                  |
| (a) Primary container .....   |                  | 101              |                  |
| (b) Other than primary container .....  |                  |                  | 201              |
| Dirty, stained, or smeared container .....  |                  |                  | 202              |
| Unmelted gels in plastic .....  |                  |                  | 203              |
| Torn container:   |                  |                  |                  |
| (a) Materially affecting appearance but not usability .....                           |                  |                  | 204              |
| (b) Materially affecting usability .....  |                  | 102              |                  |
| Product sifting or leaking .....  |                  | 103              |                  |
| Moldy area .....  | 1                |                  |                  |
| Individual packages sticking together or to shipping case (tear when separated) ..... |                  | 104              |                  |
| Not fully covering product .....  |                  | 105              |                  |
| Wet or damp (excluding ice packs):  |                  |                  |                  |
| (a) Materially affecting appearance but not usability .....                           |                  |                  | 205              |
| (b) Materially affecting usability .....  |                  | 106              |                  |
| Overwrap (when required):   |                  |                  |                  |
| (a) Missing .....   |                  | 107              |                  |
| (b) Loose, not sealed or closed .....   |                  |                  | 206              |
| (c) Improperly applied .....  |                  |                  | 207              |
| Sealing tape, strapping or adhesives (when required):                                 |                  |                  |                  |
| (a) Missing .....   |                  | 108              |                  |
| (b) Improperly placed, applied, torn, or wrinkled .....                               |                  |                  | 208              |
| Tape over bottom and top closures (when required):                                    |                  |                  |                  |
| (a) Not covering stitching .....  |                  | 109              |                  |
| (b) Torn (exposing stitching) .....   |                  | 110              |                  |
| (c) Wrinkled (exposing stitching) .....   |                  | 111              |                  |
| (d) Not adhering to bag:  |                  |                  |                  |
| 1. Exposing stitching .....   |                  | 112              |                  |
| 2. Not exposing stitching .....   |                  |                  | 209              |
| (e) Improper placement .....  |                  |                  | 210              |

<sup>1</sup> None permitted.

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