


ISSUING AUTHORITY	ORIGINAL ISSUE DATE	REVISION LEVEL	REVISION ISSUE DATE	DOCUMENT CONTROL ID	PAGE
Manufacturing Engineering	05-02-2016	NC	-	MEI-PAC787	1 of 6

1 PURPOSE


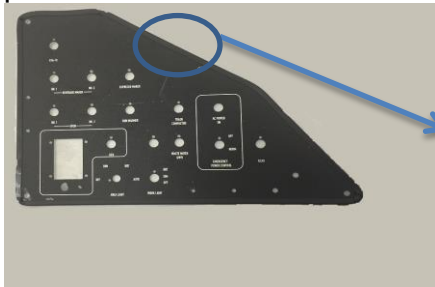


This document details the minimum packaging requirements from suppliers of various parts used in the production of 787 Galleys.

2 PROCEDURE



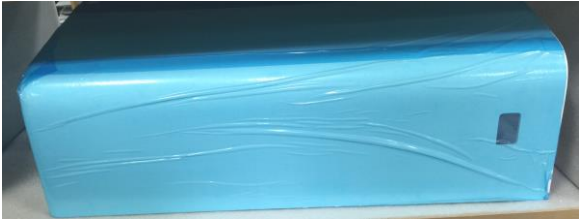
NOTE: ALL PARTS SHOULD BE INDIVIDUALLY PACKAGED.

WHO	PROCESS	TOOLS
Supplier	<p>A. <u>Packaging of Satin Anodized parts, painted parts, passivated parts and parts with primer paint</u></p> <p>All parts from vendors should be packaged with either of the two options as a minimum requirement:</p> <p>OPTION 1: Bubble wrap all parts individually. No area of the part should be left exposed without bubble wrap. All parts should be individually packaged this way. See FIG A.1.</p>  <p>FIG A.1</p> <p>OPTION 2: Cover the parts with at least 1/8" foam completely. No area of the part should be left exposed without foam. Wrap them in Poly tubing entirely. All parts should be individually packed this way. See FIG A.2.</p>	<p>Low Density Poly Tubing</p> <p>Tape</p> <p>Bubble wrap</p>



ISSUING AUTHORITY	ORIGINAL ISSUE DATE	REVISION LEVEL	REVISION ISSUE DATE	DOCUMENT CONTROL ID	PAGE
Manufacturing Engineering	05-02-2016	NC	-	MEI-PAC787	2 of 6

WHO	PROCESS	TOOLS
	 <p style="text-align: center;">FIG A.2</p>	
Supplier	<p>B. <u>Packaging of Electric Panels</u></p> <p>To ensure protection of the Electric Panels, please follow the steps below:</p> <ol style="list-style-type: none"> 1) Cover the edges of the Electric Panel with rubber edge protector as shown in FIG B.1 and FIG B.2. <div style="display: flex; justify-content: space-around;"> <div data-bbox="474 1045 906 1329">  <p style="text-align: center;">FIG B.1</p> </div> <div data-bbox="922 1157 1252 1329">  <p style="text-align: center;">FIG B.2</p> </div> </div> <ol style="list-style-type: none"> 2) All parts to be covered with the plastic cover provided by ZGUS to protect the front side of the electric panel as shown in FIG B.3. <div data-bbox="474 1476 922 1839">  <p style="text-align: center;">FIG B.3</p> </div>	<p>ZGUS provided plastic cover</p> <p>Styrofoam</p> <p>Edge protector</p>



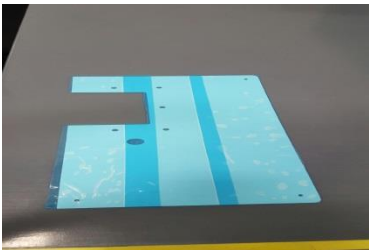

ISSUING AUTHORITY	ORIGINAL ISSUE DATE	REVISION LEVEL	REVISION ISSUE DATE	DOCUMENT CONTROL ID	PAGE
Manufacturing Engineering	05-02-2016	NC	-	MEI-PAC787	3 of 6

WHO	PROCESS	TOOLS
	<p>3) Then it should be secured in corrugated boxes with all sides protected by shadow boxed Styrofoam. See FIG B.4 and FIG B.5.</p>  <p style="text-align: center;">FIG B.4</p>  <p style="text-align: center;">FIG B.5</p>	
Supplier	<p>C. <u>Packaging of Headers</u></p> <p>To ensure protection of Headers, please follow the steps below:</p> <p>1) Cover the headers with tape on the outer section as shown in FIG C.1.</p>  <p style="text-align: center;">FIG C.1</p>	<p>Foam</p> <p>Bubble Wrap</p> <p>Corrugated Boxes</p> <p>Surface Armor tape- Part # 3-410-B</p>

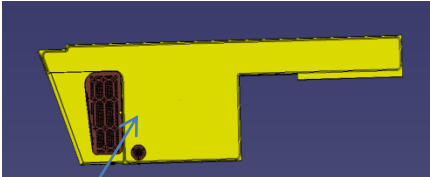
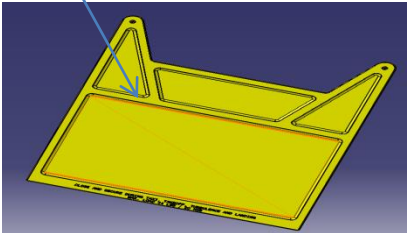
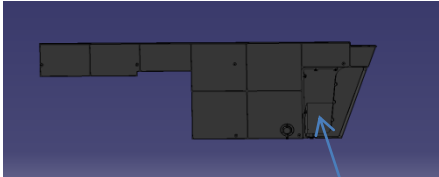
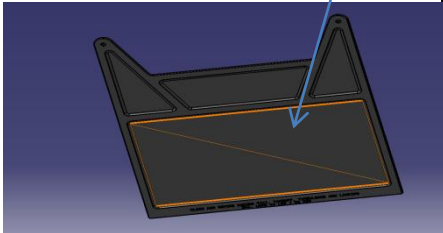
ISSUING AUTHORITY	ORIGINAL ISSUE DATE	REVISION LEVEL	REVISION ISSUE DATE	DOCUMENT CONTROL ID	PAGE
Manufacturing Engineering	05-02-2016	NC	-	MEI-PAC787	4 of 6

WHO	PROCESS	TOOLS
	<p>2) The Headers should be covered entirely by at least 1/8 inch foam OR use Bubble Wrap. See FIG C.2.</p>  <p>FIG C.2</p> <p>3) Then it should be secured in corrugated boxes which meet ASTM D5118 and D3951 standards. See FIG C.3.</p>  <p>FIG C.3</p>	

ISSUING AUTHORITY	ORIGINAL ISSUE DATE	REVISION LEVEL	REVISION ISSUE DATE	DOCUMENT CONTROL ID	PAGE
Manufacturing Engineering	05-02-2016	NC	-	MEI-PAC787	5 of 6

WHO	PROCESS	TOOLS
Supplier	<p><u>D. Packaging of Work Decks, Black Anodized parts, Waste Flaps, Doublers, Pull out tables</u></p> <p>1) Black Anodized Extrusions All extrusions should be taped in the outside only as shown in Figure D.1 and D.2. Then package it with either options in described in Section A.</p> <div style="display: flex; justify-content: space-around;">   </div> <p style="text-align: center;">FIG D.1 FIG D.2</p> <p>2) Doublers with two different finish should follow the following instructions :</p> <ol style="list-style-type: none"> a. If one face primer and the other face is black anodized tape the black anodized side. b. If one face is primer and the other face is painted, only painted face should be taped. c. Then package it with either options in described in Section A. <div style="display: flex; justify-content: space-around;">   </div> <p style="text-align: center;">FIG D.3 FIG D.4</p> <p>3) Word Decks, Waste Flaps, Pull out tables</p> <ol style="list-style-type: none"> a. For work Decks, waste flaps and pull out tables apply tape on the front face only (See FIG D.5, D.7). The back face can be kept empty (See FIG D.6, D.8). 	<p>Surface Armor tape- Part # 3-410-B</p> <p>Poly Tubing</p> <p>Bubble Wrap</p> <p>Corrugated boxes</p> <p>Foam</p>

ISSUING AUTHORITY	ORIGINAL ISSUE DATE	REVISION LEVEL	REVISION ISSUE DATE	DOCUMENT CONTROL ID	PAGE
Manufacturing Engineering	05-02-2016	NC	-	MEI-PAC787	6 of 6

WHO	PROCESS	TOOLS
	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>Front Face- FIG D.5</p> <p>Apply Tape</p>  <p>Front Face- FIG D.7</p> </div> <div style="text-align: center;">  <p>Back Face- FIG D.6</p> <p>Do not apply Tape</p>  <p>Back Face- FIG D.8</p> </div> </div> <p>b. Then they should be covered entirely by at least 1/8 inch foam OR Bubble Wrap individually. Secure it in Corrugated boxes before shipping.</p> <p>4) All other Black Anodized part</p> <p>a. They should be covered with blue tape on all the black anodized surfaces.</p> <p>b. Then package it with either options described in Section A.</p>	

REVISION HISTORY

Prepared by:	REV	DESCRIPTION	DATE
Ayan Mukherjee	NC	Initial Release	05/02/2016