	Prepared By: Mirca Andrei	Revision #: 015	Document: TCPM-FRM-010
	Approved by: Ian Marsh	Rev. Date: March, 06 2024	Page 1 of 7
FORMS:	TIERCON CORP. PACKAGING STANDARDS		

Parts cannot be in any way damaged, marred, discoloured, distorted or altered by the packaging.
Update Packaging Matrix upon completion of order (Tiercon Internal)
Storage of packaging at point of use must be determined (indoor/outdoor) to ensure proper material specification/selection for optimal life expectancy of packaging as a whole due to environmental conditions.
All packaging must be designed in such a way as to be operator friendly and ergonomically correct.
Any and all packaging that requires special assembly techniques or methods must have an operator instruction submitted to Tiercon by the supplier for operator training purposes.
Wooden Pallets must meet International Standard for Phytosanitary Measures Article 15 (ISPM-15). See page 4 for details and weblink.

DUNNAGE / LAYER PADS / PART PROTECTION

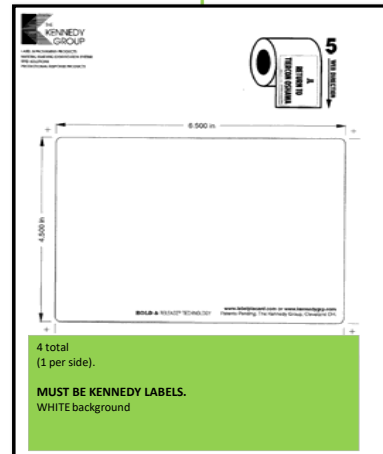
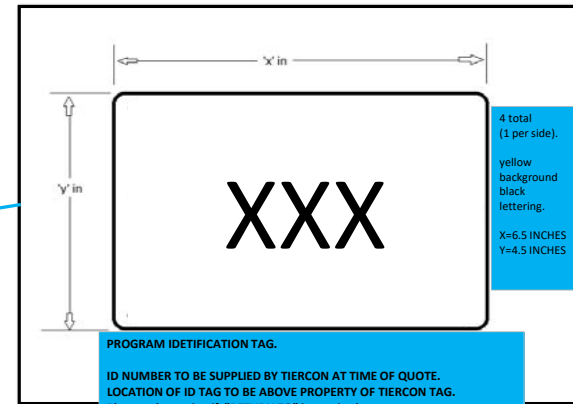
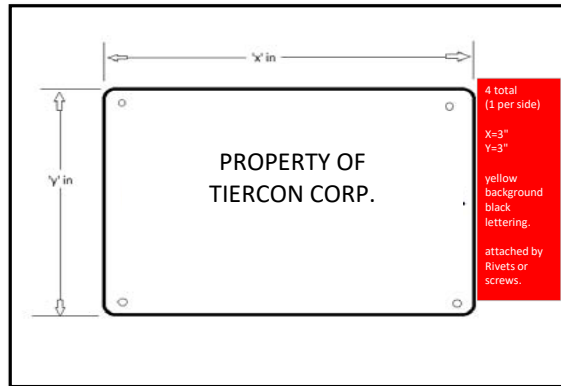
- 1.10 minimal contact on painted / chrome / other class A surface products (show surfaces)
- 1.10.1 must use X-Link Foam on painted / chrome / other class A surface products (show surfaces)
- 1.10.2 minimum 4 pound foam for multiuse purposes
- 1.10.3 all "loose log" style of foam must conform to the following.
 - 1.10.3.1 bottom support is required (plastic u-channel, wood, etc.)\
 - 1.10.3.2 ink stamp on side with program number and part description.
- 1.20 adequate clearance between parts to eliminate part damage
- 1.30 adequate clearance between parts and container to eliminate part damage
- 1.40 minimize part movement within/on the dunnage
- 1.50.1 layer pads must have holes for handling in and out of containers
- 1.50.2 layer pads must have "observation window" to allow visual verification of layers in the container
- 1.50.3 high volume parts (Annual Volume > 50,000) layer pads must be coroplast (4mm thick minimum)
- 1.50.4 layer pads with foam must have foam glued and tie wrapped/anchored to layer pad
- 1.50.5 single layered dunnage/layerpads must be velcroed to bottom of container
 - 1.50.5.1 multi layered dunnage layerpads must be encapsulated in enclosure. See FIG 1.1 below.
- 1.60 pigeon hole / partition style of container must have part protection on all interior sides for show surface products. 1.60.1 coroplast (4mm) to be reviewed if thicker material is required during prototype testing.
- 1.70 mutilation protection on metal containers:
 - 1.70.1 self adhesive felt (3M FT5477/9471LE.50.75 Description: 50MM X 75' FLOCK TAPE)
 - 1.70.2 plastisol dip
 - 1.70.3 pipe insulation foam
 - 1.70.4 When the only means of attaching foam dunnage to steel structures of a packaging rack is cable ties; the cable tie must have a min. 200lb tensile strength and be made of stainless steel.
- 1.80 Part clearance:
 - 1.80.1 - minimum when stacking totes, part to bottom of stacked tote 28.5mm
 - 1.80.2 - for all other containers supplier must meet a minimum clearance of 50.0mm.
 - 1.80.3 --- subject to further discussion during prototype phase.

IDENTIFICATION AND LABELLING

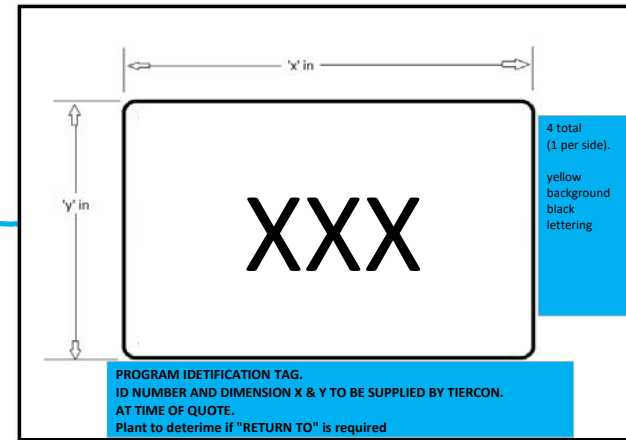
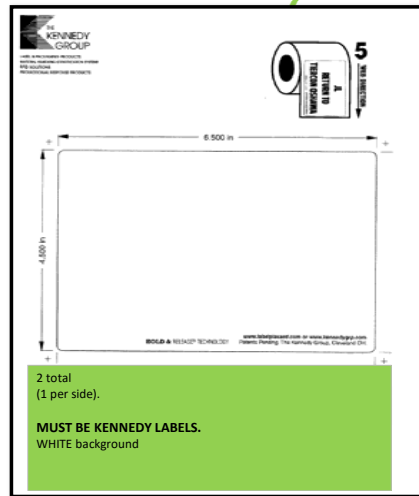
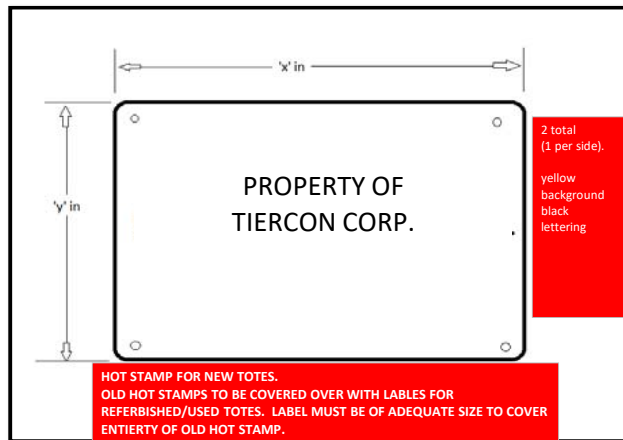
- 2.10 "property of Tiercon", "label plaquards", "program identification tags" must be present on all KD's, Totes, Metal Containers. 2.10.1 all metal containers to have "property of Tiercon Corp." stencilled on opposite posts and on outer sides.
- 2.10.2 "label plaquards" & "program identification tags" must be of correct mil thickness to not let the kd/bin/tote colour bleed through. 2.10.3 "program identification tags" must be present on all layer pads.
- 2.10.4 see tabs marked Label Standards for detailed information
- 2.10.5 used totes and non expendable containers must be clean prior to delivery

OPTIONS

- 3.00 reinforce bottom on totes, smooth bottom preferred
- 3.01 all exposed/cut surfaces on coroplast (pcore) dunnage must be covered with mutilation protection on metal containers, all exposed surfaces which may be in contact with parts must be covered with mutilation protection note - if stitched material is to be used as mutilation protection, must be verified to not mar parts.
- 3.02 metal containers that are enclosed on 3 sides must have curtain on open side - curtain must be on inside of frame and Velcro on 3 sides
- 3.03 if using wood, must be weather resistant. Please see page 4 for Heat Treat requirements for pallets.



Due to potential issues with drop down doors on the "Long Side" of containers (knock downs), any container larger than 48x45 with "Long Side" doors must be approved by the plant.



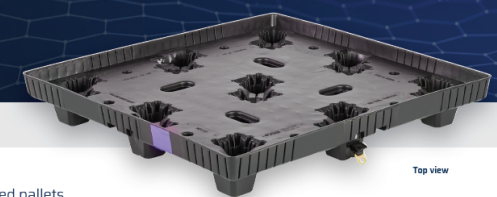
TriEnda
Upgrading the Experience

PRODUCT DETAILS AND SPECIFICATIONS

T45x48 I.D. Pallet

Heavy Duty
Thermoformed HDPE
Twin Sheet Construction

01 / Details

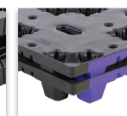


FEATURES

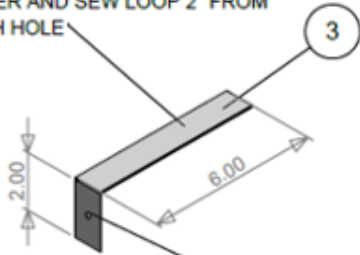
- Anti-jam design keeps nested pallets from resting on retractors during return shipments
- Mirror image design
- Conveyable

OPTIONS

- Cargo belt & buckle
- Stripe identification
- Identification labels (4) locations with top pallet deck
- Drain holes
- Hand holes

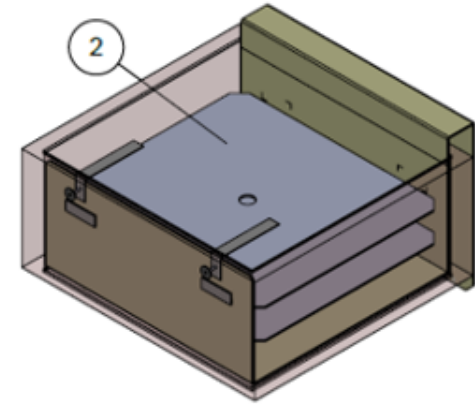
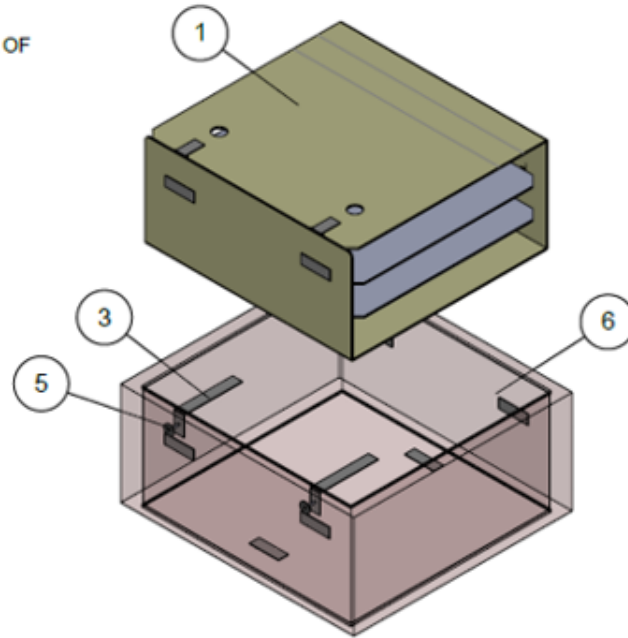


FOLD OVER AND SEW LOOP 2" FROM
END WITH HOLE



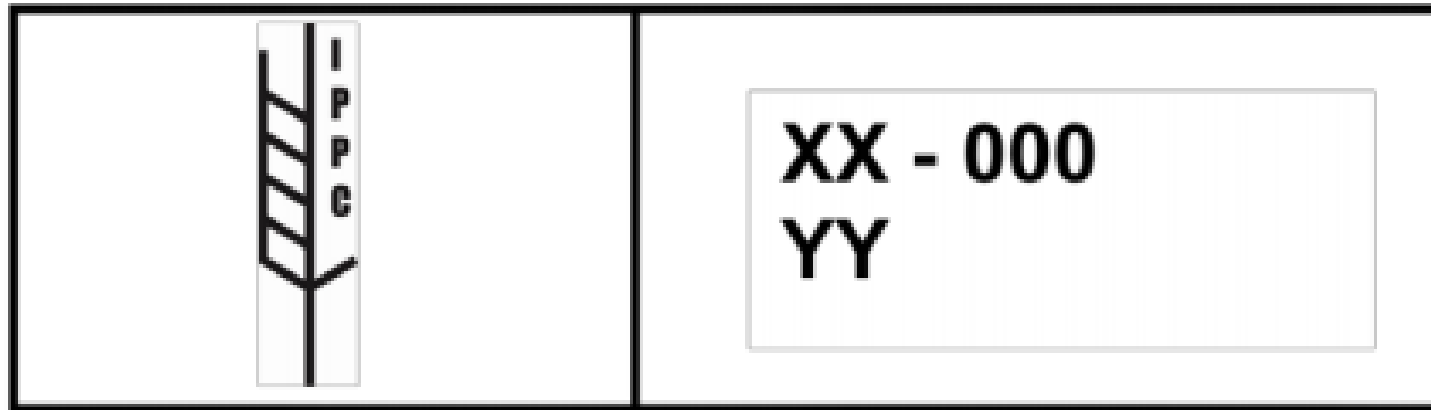
RIVETED TO WALL OF
MOLDED TOTE

FIG 1.1

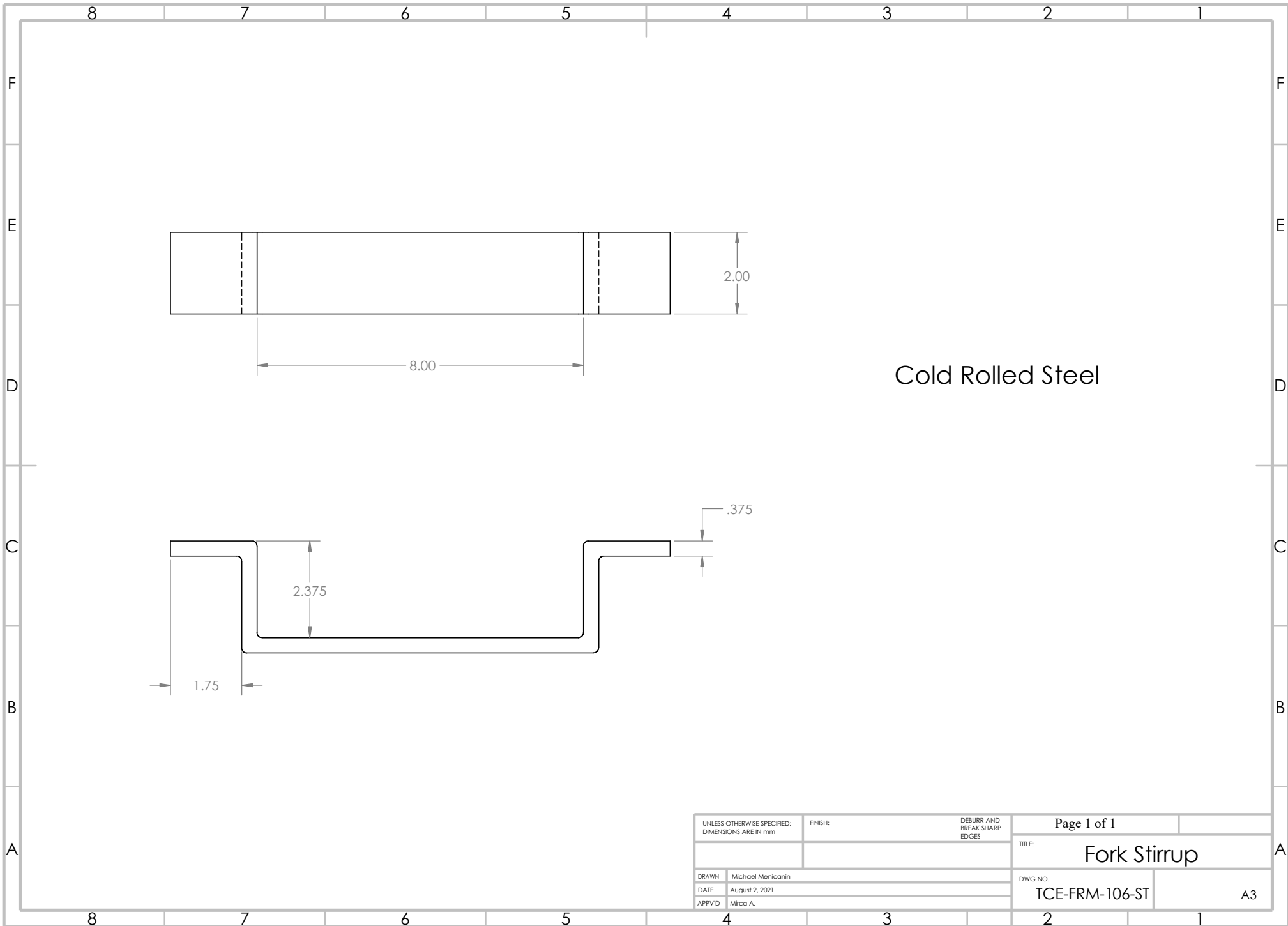


OPEN LID VIEW

Example of International Standard for Phytosanitary Measures Article 15 (ISPM-15) symbol to be present on wooden pallets



https://www.ippc.int/static/media/files/publication/en/2019/02/ISPM_15_2018_En_WoodPackaging_Post-CPM13_Rev_Annex1and2_Fixed_2019-02-01.pdf



Cold Rolled Steel

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN mm		FINISH:	DEBURR AND BREAK SHARP EDGES	Page 1 of 1
			TITLE:	Fork Stirrup
DRAWN	Michael Menicanin	DWG NO.		TCE-FRM-106-ST
DATE	August 2, 2021			A3
APPV'D	Mirca A.			

Revision	Date	Description of Change	Revised By
011	2022/01/07	Added Revision table; added Fork Stirrup drawing.	J. Messina
012	2022/04/01	Updated form number	B. Beech
013	2023/04/17	Updated to add 4 ID labels per tote	Mirca Andrei
014	2023/10/30	Updated to add standard bottom/top for totes	Mirca Andrei
015	2024/01/10	Updated to add review of side doors on KD's	Mirca Andrei
016	2024/03/06	Updated to add 1.50.5.1	Mirca Andrei
017	2025/02/25	Added 1.70.4 - Cable Ties Spec.	Mirca Andrei