

Document type <b>INSTRUCTION</b>	Title Mixed Pallets of Blue Boxes	Issue 1
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To (department acronym name)	For information (department acronym name)	

## Mixed Pallets of Blue Boxes

This document describes how to mix different part numbers of blue boxes going with parts to Scania. The idea is that by mixing parts going to the same “Ship To/Dock/Gate” location on the VDA transport label we can reduce work load and environmental impact from transport. This is achieved by reducing empty boxes that needs to be handled and in many cases also reducing the amount of pallets that needs to built up with boxes on top of them.

This instruction is valid for mixing parts packed in Scania packaging B3 (MH-6147), B2 (MH-4147) and B1 (MH-3147). Mixing parts within one box is not allowed.

A worst case scenario without mixing could be shipping 1 B1 box with parts and 7 empty B1 boxes. Assuming you need to ship three different part numbers to the “Ship To/Dock/Gate” location would mean 21 empty boxes and 3 used ones. It would also create 3 pallets with all the strapping, labelling and handling required.

Instead 1 pallet with 3 boxes on it could be used, saving a lot of work, material, weight and cubic meters by a small change in process.

### How to mix blue boxes

Start by placing the biggest blue boxes to the same “Ship To/Dock/Gate” regardless of part number (see picture below). Go to next size smaller on top and if possible the final case to fill up 5 layers on a half pallet. A more in depth explanation with pictures follow below. The normal instructions for how to place and label boxes still applies regardless if you mix part numbers or not and will thus not be discussed in detail here.



Receiver SCANIA-CHASSIE SODERTALJE SWEDEN	Ship To/Dock/Gate <b>230G/231TS</b>	Advice Note No. (N) 123
Part No. (P) 1212121	Description <b>TOW PIN</b> Package Type / Dangerous Goods	
Quantity (Q) 25	Date D130102	Engineering
Supplier (V) TEST	Lot No. (H)	
Serial No. (S) 5		

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## **Detailed description**

Start with placing a half pallet (MH-1874) at a suitable work height.



Sort out locked Scania box orders for the same day and to the same "Ship To/Dock/Gate".

Thereafter add the biggest blue box you have to the pallet.

In order:

B3 (MH-6147)

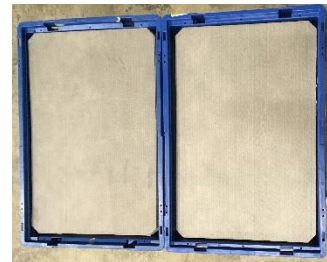
B2 (MH-4147)

B1 (MH-3147)



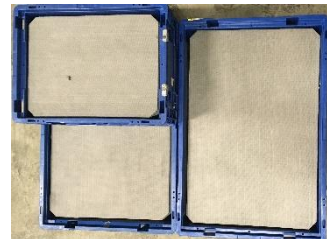
In the example to the right, a B3 box.

Fill out the layer with the same box type regardless of part number (if possible). In this example image it was possible with 2 B3 boxes to fill out the first layer.



Thereafter start on the next layer with the biggest box available.

In the example image it is a B2 that you can place with its long side to fit over the short side of a B3 box.



This example image also highlights how hard it is to remove the tape after labels, so please don't use tape or glue on the boxes for labelling or other usages.



Keep filling up your layer with the biggest boxes you still have available. In this example the entire second layer is B2 boxes.

Continue to the next layer if you still have boxes. In this example, 3 B1 boxes on their long side to cover the short side of a B2 box.



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Fill up the layers until you run out of boxes that should be shipped that day to the same "Ship To/Dock/Gate".

A thing to note in the example to the right, the top right box is placed in the corner to ensure visibility of the most possible labels. If that is filled 180 degrees from the B1 boxes to the left 3 labels are visible on the top layer.



Then fill in with the biggest boxes you have available for stability and reduced work load. In this example the final layer has 5 filled B1 boxes, 1 empty B2 box and 1 empty B1 box.

In total this pallet then ends up with 2 filled B3, 4 filled B2, 5 filled B1. Without mixing this would at a minimum be 3 pallets due to the different box sizes. Perhaps more if the boxes are also of different part numbers.

Below follow more examples of different ways to fill up the last layer depending on the orders you need to ship that day and which types of boxes you have available in your plant. Always fill in with the biggest box you have available to reduce the overall work load.



A picture from the side of a pallet filled up until 5 layers where a few boxes are missing to fill in the last layer.



Finally add on the half pallet plastic lid for box pallets MH-4319 and strap with 2 straps according to the general guideline.





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### ***Things to note***

Try to keep the weight balance on the pallet if packaging a mix of light and heavy boxes. Don't keep all the heavy parts on one side. If content of boxes is below 4kg in weight this is not important.

The master label for mixed pallets has its specification in Scania profile of VDA Transport Label (VDA 4902 version 4) for KLT packaging. The same file as the VDA label for the boxes.

If your order is in Scania unit D1, D2, D3, D4 or D5 you are not allowed to mix the part with other parts. This code is used to show that it goes to a special storage where the box is lifted directly from the pallet to line instead of being unbundled into individual places for each box.

You are allowed to mix boxes of the same packaging code with its own code. For example B4, SB or MB is good to mix with itself but not with other boxes due to their shape.