

Document type

**INSTRUCTION**

Approved by (department acronym, name)

Issued by (department acronym name phone)

**OIPH, Doris Lanke +31618581150**

To (department acronym name)

Title

**SPG045-INST-Plastic Boxes**

File name

**Plastic Boxes**

Date

**2022-05-22**

For information (department acronym name)

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## SPG045-INST-Plastic Boxes

For the usage of plastic boxes STD4172 applies.

### Plastic boxes assortment



B1



B2



B3



B4



B5

Description	MH-number	Dimension (LxW)	Qty in dist. unit
B1	MH-3147	300 x 200	The quantity of MH's in the distribution unit can be found on PackIT under distribution units.
B1, lid	MH-3148		
B2	MH-4147	400 x 300	
B2, lid	MH-4374		
B3	MH-6147	600 x 400	
B3, lid	MH-4375		
B4	MH-0476	600 x 400	
B5, ESD	MH-0474	600 x 400	

The lids for the blue boxes shall be ordered separately. Plastic lids for box B1/B2/B3 shall not be used for the Chassis and Cab workshops. A plastic lid for box B1/B2/B3 shall always be used into the component workshop – Engine (DE). To other component workshops, such as Gearbox and Axles a plastic lid shall only be used on the box B1/B2/B3 if stated in the packaging instruction.

The weight limit of the box including parts is 10 kg, unless otherwise stated by the responsible Packaging Engineer.

Plastic boxes shall be positioned on the pallet so that the pallets can be stacked during transport.

On a pallet with B3 boxes a plywood pallet lid shall be put uppermost on the unit with the lists turned upwards. On a pallet with B1 or B2 boxes or on a pallet with mixed boxes a plastic lid shall be placed uppermost on the unit.

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A plastic H-lid MH-4319 shall be put uppermost on the unit when H-pallet MH-1874 is used. A wooden E-lid MH-2318 shall be put uppermost on the unit with the lists turned upwards when E-pallet MH-1875 is used.

Tape or glue on the boxes for labelling or other usages shall not be used..

## Number of plastic boxes on a pallet

Pallet	Allowed boxes	Layer 1	Layer 2	Layer 3	Layer 4	Layer 5
H-	B1	8	16	24	32	40
H-	B2	4	8	12	16	20
H-	B3	2	4	6	8	10
H-	B4	2	4	6	-	-
H-	B5	2	4	6	-	-
E-	B3	-	-	12	16	20
E-	B4	-	8	12	16	-
E-	B5	-	8	12	16	-

The lowest box layer in a stack shall not be loaded with more than:

B1	MH-3147	400 kg
B2	MH-4147	600 kg
B3	MH-6147	600 kg
B4	MH-0476	400 kg
B5	MH-0474	400 kg

### Plastic box as inner unit

Parts in plastic boxes shall be delivered on H- or E-pallets. This is indicated in the packaging instruction on PackIT by a figure "10" (E-pallet), "20" (H-pallet), "D", "J", "N" or "A" under the heading "Pallet unit". The number of plastic boxes that should be included in the pallet unit is specified under the heading "Inner unit".

Packing code	Pallet	Number of blue boxes / foldable boxes				
		B1	B2	B3	B4	B5
D1 = 1 level	21 (H)	8	4	2	-	-
D2 = 2 levels	22 (H)	16	8	4	-	-
D3 = 3 levels	23 (H)	24	12	6	-	-
D4 = 4 levels	24 (H)	32	16	8	-	-
D5 = 5 levels	25 (H)	40	20	10	-	-
J1 = 1 level	21 (H)	-	-	-	2	2
J2 = 2 levels	22 (H)	-	-	-	4	4
J3 = 3 levels	23 (H)	-	-	-	6	6
N2 = 2 levels	12 (E)	-	-	-	8	8
N3 = 3 levels	13 (E)	-	-	-	12	12
N4 = 4 levels	14 (E)	-	-	-	16	16
A3 = 3 levels	13 (E)	-	-	12	-	-
A4 = 4 levels	14 (E)	-	-	16	-	-
A5 = 5 levels	15 (E)	-	-	20	-	-

Send only one (1) part number on one (1) full pallet with the quantity of boxes ordered by the call-off when a D-, J-, N- or A-code is used.

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## **Plastic box as pallet unit**

Plastic boxes can also be used as pallet units to achieve greater flexibility when calling-off parts. The number of parts in each box is specified in the packaging instruction on PackIT. Plastic boxes that are modified as pallet units shall be delivered on a pallet. When there is an uneven number of boxes, use additional boxes with another part number, or use empty boxes without label to fill up the pallet to the given quantity above. It is not allowed to mix part numbers to different delivery addresses on the same pallet. Mixing parts within one box is also not allowed.

The pallet with the boxes goes directly into our warehouse, so please follow the specification of levels on the pallet, otherwise a manual repacking has to be done.

By mixing parts going to the same “Ship To/Dock/Gate” location on the VDA transport label the workload and environmental impact from transport can be reduced. 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 build-up with boxes on top of them.

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.



## **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”.



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

In order:

B3 (MH-6147)

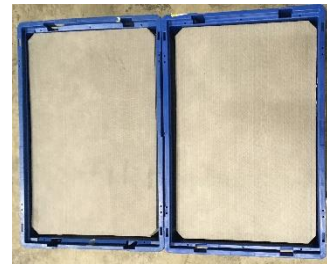
B2 (MH-4147)

B1 (MH-3147)

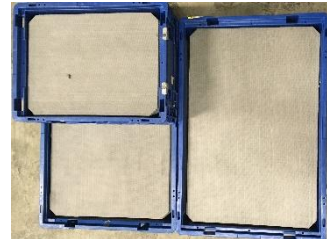
In the example to the right, a B3 box.



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



Then start with the next layer with the biggest box available. In the example it is a B2 that is placed with its long side over the short side of the B3 box.



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. 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.



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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 according to the general guideline.



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 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 is good to mix with itself but not with other boxes due to their shape. It is not allowed to mix B4 with B5 since the B5 parts are ESD-classified. It is allowed to mix B5 with itself.



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## **Strapping of plastic boxes**

Strapping shall be done in accordance with the information on *Scania Supplier Portal > Supplying to Scania > Logistics > Automotive Products > Packaging > Packaging Instruction > Strapping of Units.*

## **Labelling of plastic boxes**

For labelling STD4172-10 applies. Self-adhesive labels and staples are not allowed to use on blue boxes.