Specifications for Drop Front Boxes, Drop on the Short Side
For the Storage of Artifacts

1. Composition and Chemical Requirements

1.1 Fiber
The stock must be made from rag or other high alpha-cellulose content pulp, minimum of 87%. It must not contain any post consumer waste recycled pulp.

1.2 Lignin
The stock must give a negative reading for lignin as determined by the phloroglucinol test when tested according to TAPPI T 401, Appendix F, and shall have a Kappa number of 5 or less when tested according to TAPPI T 236.

1.3 Impurities
The stock must be free of metal particles, waxes, plasticizers, residual bleach, peroxide, sulfur (which will be less than 0.0008% reducible sulfur as determined by TAPPI T 406), and other components that could lead to the degradation of the box itself, or the artifacts stored therein.

1.4 Metallic Impurities
Iron must not exceed 150 ppm and copper shall not exceed 6 ppm when tested according to TAPPI T 266.

1.5 Optical Brighteners
The stock must be free of optical brightening agents.

1.6 pH
The stock must have a pH value within a range of 8.0 - 9.5 as determined by TAPPI T 509, cold extraction (modified by slurrying sample pulp before measurement).

1.7 Alkaline Reserve
The stock must contain an alkaline reserve with a minimum of 2% and a maximum of 5% calculated as CaCO₃ when tested according to TAPPI T 553 (modified by slurrying sample pulp before measurement).
1.8 Sizing
Only neutral or alkaline sizing shall be used. No alum rosin or rosin sizing should be used, as determined by TAPPI T 408.

2. Physical and Performance Requirements

2.1 Thickness and Basis Weight
The stock must meet the following minimum requirements for basis weight as determined by TAPPI T 410.

2.1.1 60 pt. Board
The minimum basis weight should be 800 lbs/ 3,000 ft²

2.2 Color
The color of the stock should be tan, unless otherwise specified on the purchase order. The color must not be so dark that it obscures color-dependent test evaluations, e.g., spot stain tests.

2.3 Color Bleeding
The color must show no bleeding when soaked in distilled water for 48 hours while held under suitable weight in contact with white bond paper. The color must not rub off.

2.4 Color Retention
The color of the stock must not change more than 5 points of brightness as measured by directional reflectance at 457 nm (TAPPI T 452), when exposed 24 hours to a Xenon arc lamp in an Atlas Weatherometer under the following conditions: Irradiance Level: 1.0 watts/m² at 420 nm. Inner filter: Borosilicate glass. Outer filter: clear soda lime glass. Black panel temperature: 50°C. Wet bulb depression: 8.5°C.

2.5 Surfaces
The surfaces of the stock must be free of fingerprints, dirt, bubbles, knots, shives and other imperfections.

2.6 Creases and Folds
The stock must not fray, crack or split when folded and/or creased.

2.7 Stiffness
The stock must meet the following minimum requirements for stiffness. Test will be conducted according to TAPPI T 489, after conditioning by TAPPI method T 402.

2.7.1 60 pt. Board
The minimum internal stiffness must be not less than 5,600 Taber units in the machine direction and 2,500 in the cross direction.
2.8 Adhesive
If an adhesive is required, it must not soften or run. The adhesive must not cause the stock to become transparent or alter the color of the stock. The adhesive must not yellow, discolor, or fail (causing delamination) over time. The adhesive should not contain sulfur, iron, copper or other ingredients that may be detrimental to photographic materials. The adhesive should not contain or generate oxidants. Pressure-sensitive or rubber-based adhesives are not acceptable. When used, the adhesive must not extend beyond the joined area.

2.9 Durability
The boxes must be sturdy enough to withstand normal wear and tear during use. The lid must be able to withstand repeated opening and closing without delamination of the plies, fraying along the cut edges, or splitting along the joints.

2.10 Metal Edge Stays
The metal edge stays must be made from a single unit of 0.0088 gauge cold rolled steel coated on the exterior with chrome, lacquer or baked enamel. The metal edge stays must be one inch wide and contain a minimum of eight 4-prong eyelets per 2 inch length. The metal edge stays must be chrome in color or as specified on the purchase order.

3. Product Requirements

3.1 Construction
The boxes must consist of two blanks of 60 pt. board stock constructed as two separate units comprising a base and a detached lid. (Illustration below)

3.1.1 Base
The grain direction of the board stock should run parallel to the long dimension of the box. The four walls of the base should be the same height. There must be no cut-out holes or pulls on the base of the box. Two corners of the base along one short side will remain unsealed to permit the short wall to be pulled down flat and flush with the bottom of the box to allow access to the contents from the open side. Boxes larger than 20 x 24 x 1 1/2 inches must have the two long sides of the base reinforced by folding the side onto itself towards the inside of the box. The folded area should come flush to the edge of the 90 degree corner.

3.1.2 Corner Joints
The closed corners of the box base and the lid must be joined with continuous metal edge stays. The stays should stop 1/4 inch from the cut edge of the top and the folded crease at the bottom of the corners to avoid the problem of the stays working loose. The prongs of the stays should fully penetrate the box board so that they are visible on the inside, and must be free of sharp raised edges inside and outside.
3.1.3 Lid
The lid must fit securely, but not bind. Boxes larger than 20 x 24 x 1 1/2 inches must have the two short sides of the lid reinforced by folding the side onto itself towards the inside of the box. The folded area should come flush to the edge of the 90 degree corner. Boxes over 2 1/2 inches high or with reinforced sides should have a half-round thumb cut in the middle of the long sides of the lid. The thumb cut should be approximately 2 1/2 inches long and 3/4 inches high, measured from the lower edge of the lid side.

Drop front boxes with drop on the short side

3.2 Workmanship
The boxes must have clean cut edges and properly aligned panels with no unnecessary scores or cuts. All dimensions of the box maker’s blank must be accurately cut, scored and slotted so that the assembled parts fit closely without binding. The edges must be straight, corner joints must meet exactly, and corners must be squared to 90 degrees.

3.3 Dimensions
Dimensions will be specified on the purchase order.

3.4 Thickness
The boxes should be constructed of 60 pt. board stock.

3.5 Marking
Each box must be marked with the name of the manufacturer, year of manufacture, and the actual pH.

3.5.1 Placement and Size
The identifying information must not be larger than 2 1/2 inches long and 1 1/2 inches high. It should be centered on the bottom of the box, legible from the outside.

3.5.2 Marking Method
The information can be stamped in ink or embossed.

3.5.2.1 Ink Stamping
The stamping must be done on the outside of the box. The ink must not smear, fade, or rub off after drying. The ink must not run, bleed through, or transfer to other materials if it becomes wet. There must be no ink on the interior of the box.
3.5.2.2 Embossing
The embossing must be done from the outside of the box. The impression must be legible from the outside only, with no penetration to the interior of the box.

4. Packaging and Identification

4.1 Packages
The items must be packed in standard commercial containers that are constructed to ensure that they arrive at the Library of Congress in dry, undamaged condition. The outside of each container must be identified by type, size and number of items within; manufacturing run or batch number; LC Purchase Order / Contract number and line number.

5. Compliance with Specification

5.1 Quality Assurance Testing
The Library of Congress has the right to perform any of the tests set forth in the specification where such tests are deemed necessary to ensure that supplies conform to prescribed requirements.

5.2 Sampling
To sample for testing, shipments will be sampled according to ANSI/ASQ Z1.4, inspection level S-2, AQL 2.5%.

5.3 Methods
Tests will be conducted in accordance with specified test methods of the American National Standards Institute (ANSI), the American Society for Testing and Materials (ASTM), the Technical Association of the Pulp and Paper Industry (TAPPI), and the International Organization for Standardization (ISO). Publications describing these tests may be ordered directly from the technical associations, their websites, or other on-line standards vendors.

5.4 Acceptance
Materials will be accepted when the Library of Congress has ascertained that the products comply with all parts of the specification. A quick reference table of the physical and chemical requirements and test methods used to ascertain compliance is provided in section 5.5.

FAILURE TO MEET ANY PART OF THE SPECIFICATION WILL BE CAUSE FOR REJECTION
5.5 Table of Physical and Chemical Requirements and Test Methods

<table>
<thead>
<tr>
<th>Property</th>
<th>Requirement</th>
<th>Test Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lignin</td>
<td>Negative / Kappa 5</td>
<td>TAPPI T 401, Appendix F or TAPPI T 236</td>
</tr>
<tr>
<td>Reducible Sulfur</td>
<td>&lt; 0.0008%</td>
<td>TAPPI T 406</td>
</tr>
<tr>
<td>Iron</td>
<td>≤ 150 ppm</td>
<td>TAPPI T 266</td>
</tr>
<tr>
<td>Copper</td>
<td>≤ 6 ppm</td>
<td>TAPPI T 266</td>
</tr>
<tr>
<td>pH</td>
<td>8.0 – 9.5</td>
<td>TAPPI T 509, cold extraction, slurried pulp</td>
</tr>
<tr>
<td>Alkaline Reserve</td>
<td>2 – 5%</td>
<td>TAPPI T 553, slurried pulp</td>
</tr>
<tr>
<td>Alum Rosin Sizing</td>
<td>Negative</td>
<td>TAPPI T 408</td>
</tr>
<tr>
<td>Basis Weight</td>
<td>60 pt: 800 lbs./3,000 ft²</td>
<td>TAPPI T 410</td>
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<tr>
<td>Color Bleeding</td>
<td>No bleed in 48 hours</td>
<td>See section 2.3</td>
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<tr>
<td>Color Retention</td>
<td>≤ 5 pts</td>
<td>TAPPI T 452</td>
</tr>
<tr>
<td>Stiffness</td>
<td>60 pt: 5600 MD, 2500 CD</td>
<td>TAPPI T 489</td>
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Configuration Management

<table>
<thead>
<tr>
<th>Date</th>
<th>Revision History</th>
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<tbody>
<tr>
<td>19-Jun-2002</td>
<td>Initial release of document on website, html format.</td>
</tr>
<tr>
<td>14-Dec-2009</td>
<td>Revised and reformatted for release as PDF document.</td>
</tr>
<tr>
<td>30-Sept-2016</td>
<td>Revised Sections 1.1, 1.2, 2.2, 5.5. Deleted 2.7. Editorial update to footer.</td>
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