

APPENDIX 99B

UNITIZATION PROCEDURES FOR BOXED AMMUNITION AND COMPONENTS ON 4-WAY ENTRY PALLETS

SMOKE POT, PACKED ONE PER METAL DRUM,
UNITIZED 24 DRUMS PER 35" X 45 $\frac{1}{2}$ " PALLET;
DRUM SIZE 12 $\frac{1}{2}$ " DIA X 14" H

PALLET UNIT DATA						
ITEMS INCLUDED		HAZARD CLASSIFICATION				WEIGHT
NSN	DODIC	DOT CLASS	CG CLASS	QD CLASS	COMP GROUP	(LBS)
1365- 00-025-3284 00-833-1712	K873 K870	C C	II-C II-C	1.3 1.3	G G	1,029 1,029

REVISION

REVISION NO. 1, DATED OCTOBER 1988, CONSISTS OF:

ADDING ITEM BY NATIONAL STOCK NUMBER TO "PALLET UNIT DATA" CHART.

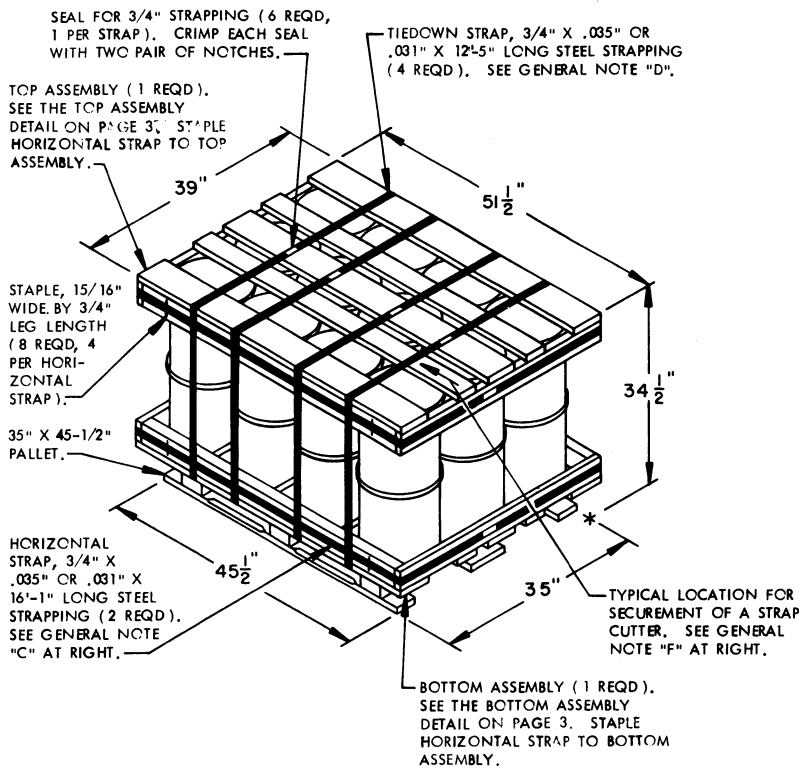
NOTICE: THIS APPENDIX CANNOT STAND ALONE BUT MUST BE USED IN CONJUNCTION WITH THE BASIC UNITIZATION PROCEDURES DRAWING 19-48-4116-20PA1002.

REVISIONS		DRAFTSMAN	PROJ ENG	NIN/ED
1	OCT 88	B.I. / <i>st</i>	WRF / <i>hew</i>	NIN/ED
		CHECKER	LOG ENGRG OFFICE	
		G.R.G.	W & Ernst	
		APPROVED, U. S. ARMY ARMAMENT MATERIEL READINESS COMMAND		
		DRSAR - LEP	DRSAR - TMD	
		APPROVED BY ORDER OF COMMANDING GENERAL, U. S. ARMY MATERIEL DEVELOPMENT AND READINESS COMMAND (DARCOM)		
		U. S. ARMY DEFENSE AMMUNITION CENTER AND SCHOOL		
		U. S. ARMY DARCOM DRAWING		
		JANUARY 1982		
		CLASS	DIVISION	DRAWING
		19	48	4116/ 99B
				FILE 20PA 1002

DO NOT SCALE

GENERAL NOTES

- A. THIS APPENDIX CANNOT STAND ALONE BUT MUST BE USED IN CONJUNCTION WITH THE BASIC UNITIZATION PROCEDURES DRAWING 19-48-4116-20PA1002. TO PRODUCE AN APPROVED UNIT LOAD, ALL PERTINENT PROCEDURES, SPECIFICATIONS AND CRITERIA SET FORTH WITHIN THE BASIC DRAWING WILL APPLY TO THE PROCEDURES DELINEATED IN THIS APPENDIX. ANY EXCEPTIONS TO THE BASIC PROCEDURES ARE SPECIFIED IN THIS APPENDIX.
- B. DIMENSIONS, CUBE AND WEIGHT OF A PALLET UNIT WILL VARY SLIGHTLY DEPENDING UPON THE ACTUAL DIMENSIONS OF THE DRUMS AND THE WEIGHT OF THE SPECIFIC ITEM BEING UNITIZED.
- C. INSTALL EACH HORIZONTAL STRAP TO ENCIRCLE A DUNNAGE ASSEMBLY. HORIZONTAL STRAPS MUST BE TENSIONED AND SEALED PRIOR TO APPLICATION OF TIEDOWN STRAPS.
- D. INSTALL EACH TIEDOWN STRAP TO PASS UNDER THE TOP DECK BOARDS OF THE PALLET AND TO BE LOCATED AS SHOWN. TIEDOWN STRAPS WILL NOT BE APPLIED UNTIL THE HORIZONTAL STRAPS HAVE BEEN TENSIONED AND SEALED.
- E. THE FOLLOWING DARCOM DRAWINGS ARE APPLICABLE FOR OUTLOADING AND STORAGE OF THE ITEMS COVERED BY THIS APPENDIX.
 CARLOADING----- DRAWING 19-48-4115-5PA1002
 TRUCKLOADING----- DRAWING 19-48-4117-11PA1003
 STORAGE----- DRAWING 19-48-4118-1-2-3-4-14-22PA1002
- F. FOR METHOD OF SECURING A STRAP CUTTER TO THE PALLET UNIT, SEE DARCOM DRAWING 19-48-4127-20P1000.
- G. IF ITEMS COVERED HEREIN ARE UNITIZED PRIOR TO ISSUANCE OF THIS APPENDIX, THE DRUMS NEED NOT BE REUNITIZED SOLELY TO CONFORM TO THIS APPENDIX.
- H. THE UNITIZATION PROCEDURES DEPICTED HEREIN MAY ALSO BE USED FOR UNITIZING SMOKE POTS WHEN IDENTIFIED BY DIFFERENT NATIONAL STOCK NUMBERS (NSN) THAN WHAT IS SHOWN ON THE TITLE PAGE, PROVIDED THE DRUM DOES NOT VARY FROM WHAT IS DELINEATED HEREIN. THE EXPLOSIVE CLASSIFICATION OF OTHER ITEMS MAY BE DIFFERENT THAN WHAT IS SHOWN.
- J. IF THERE IS A NEED TO USE FILLER ASSEMBLIES AND AT LEAST TWO PALLET UNITS ARE BEING CONSTRUCTED, NOT MORE THAN 8 FILLERS WILL BE INSTALLED IN ANY ONE PALLET UNIT. ADDITIONAL FILLERS CAN BE PLACED IN A SECOND PALLET UNIT AS REQUIRED WHEN THE QUANTITY OF 8 FILLERS IN THE FIRST REDUCED PALLET UNIT IS INSUFFICIENT TO SATISFY THE TOTAL REDUCTION NEEDED. ALSO, THE FILLERS MUST BE INSTALLED ONLY IN THE TOP LAYER OF THE PALLET UNIT. USING TWO PALLET UNITS TO SATISFY THE PALLETIZATION CRITERIA APPLICABLE TO LESS-THAN-FULL PALLET UNITS IS AN EXCEPTION TO THE BASIC PROCEDURES. HOWEVER, THE EXCEPTION IS NECESSARY FOR THE AMMUNITION PACK COVERED BY THIS APPENDIX, TO MOST EFFECTIVELY OBTAIN AN ACCEPTABLE, COMPACT AND SOUND PALLET UNIT.
- K. THE STYLE 1A PALLET DELINEATED IN THE DETAIL AT LEFT NEED NOT HAVE CHAMFERS OR STRAP SLOTS AS SPECIFIED WITHIN MILITARY SPECIFICATION MIL-P-15011 WHEN USED FOR THE UNITIZATION OF THE ITEMS COVERED BY THIS APPENDIX.



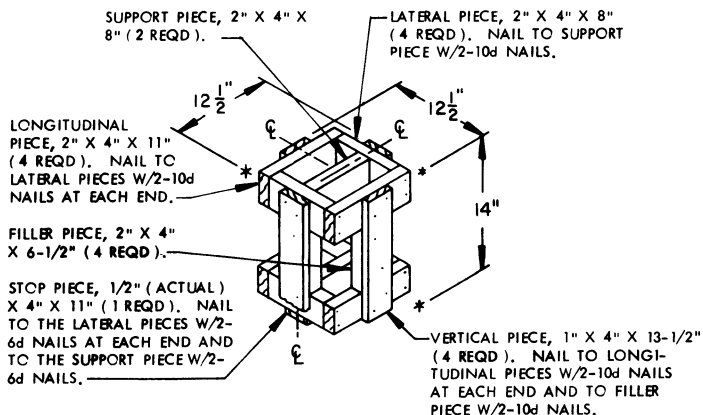
PALLET UNIT

SEE GENERAL NOTE "B" AT RIGHT.

24 DRUMS OF SMOKE POTS (1 PER DRUM) @ 37 LBS-----888 LBS (APPROX)
 DUNNAGE-----76 LBS
 PALLET-----65 LBS

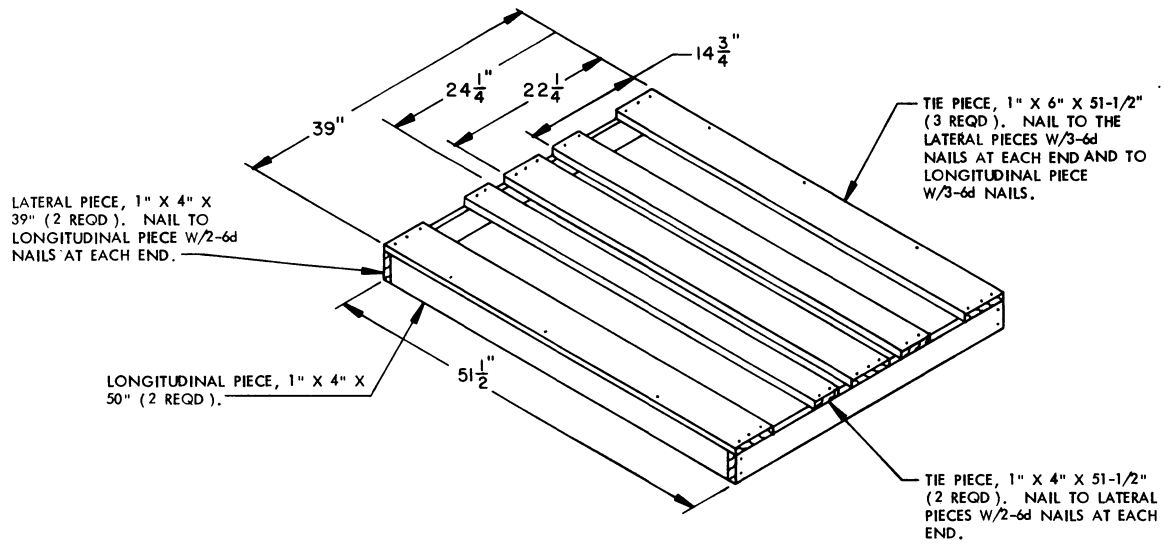
TOTAL WEIGHT-----1,029 LBS (APPROX)
 CUBE-----40.1 CU FT (APPROX)

BILL OF MATERIAL		
LUMBER	LINEAR FEET	BOARD FEET
1" X 4"	47.88	15.96
1" X 6"	25.75	12.88
2" X 4"	8.33	5.56
NAILS	NO. REQD	POUNDS
4d (1-1/2")	15	0.05
6d (2")	92	0.54
PALLET, 35" X 45-1/2"	1 REQD	65 LBS
STEEL STRAPPING, 3/4"	81.83' REQD	5.84 LBS
SEAL FOR 3/4" STRAPPING	6 REQD	NIL
STAPLE, 15/16" X 3/4"	8 REQD	NIL

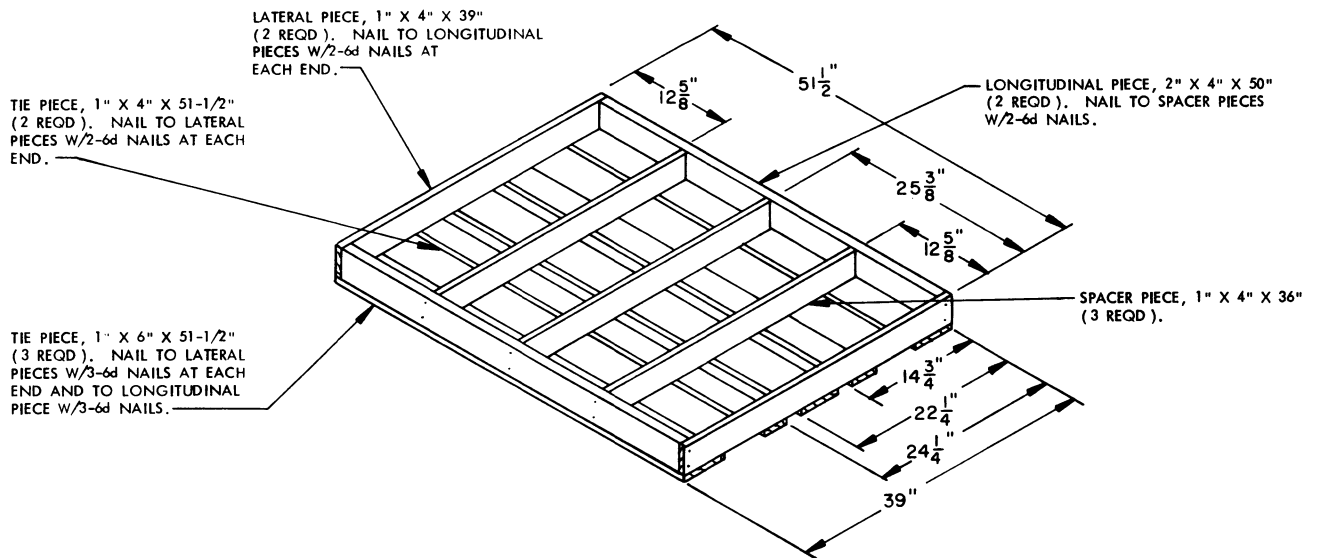


FILLER ASSEMBLY

(FOR MINUS ONE BOX)



TOP ASSEMBLY



BOTTOM ASSEMBLY

NAIL EACH BOTTOM ASSEMBLY TIE PIECE TO PALLET DECK W/3-6d NAILS.

