

LOADING AND BRACING (TL & LTL) IN CLOSED OR OPEN TOP VAN TRAILERS OF COMPLETE ROUNDS PACKED IN CYLINDRICAL METAL CONTAINERS AND UNITIZED ON A 42" X 44-1/2" METAL PALLET

PA117 SERIES CONTAINER

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THIS DOCUMENT INCLUDES OUTLOADING PROCEDURES FOR CONVENTIONAL TYPE TRAILERS AND FOR TRAILERS EQUIPPED WITH MECHANICAL BRACING DEVICES AS APPROVED BY THE BUREAU OF EXPLOSIVES, ASSOCIATION OF AMERICAN RAILROADS. CAUTION: THE PROCEDURES SHOWN HEREIN, FOR BOTH TYPES OF TRAILERS, ARE ONLY APPLICABLE FOR HIGHWAY MOVEMENTS; NOT FOR CONTAINER/TRAILER-ON-FLAT-CAR MOVEMENTS.

DO NOT SCALE

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GENERAL NOTES

(GENERAL NOTES CONTINUED)

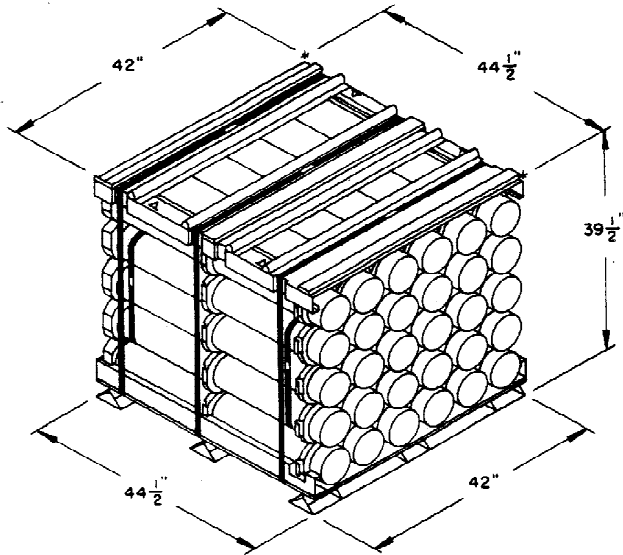
- A. THIS DOCUMENT HAS BEEN PREPARED AND ISSUED IN ACCORDANCE WITH AR 740-1, AND AUGMENTS TM 743-200-1 (CHAPTER 5).
- B. THE OUTLOADING PROCEDURES SPECIFIED IN THIS DRAWING ARE APPLICABLE FOR THE PAT17 COMPLETE ROUND CONTAINER ASSEMBLED ON THE 42" X 44-1/2" 4-WAY ENTRY PALLET. SEE THE PICTORIAL VIEW ON PAGE 3 FOR SIZE AND WEIGHT. REFER TO U.S. ARMY AMC DRAWING 19-48-4079/8-20FM1002 FOR UNITIZATION PROCEDURES FOR THE PAT17 METAL AMMUNITION CONTAINERS.
- C. THE OUTLOADING PROCEDURES DEPICTED WITHIN THIS DOCUMENT ARE APPLICABLE FOR SHIPMENTS IN CONVENTIONAL TYPE VAN TRAILERS AND FOR SHIPMENT IN VAN TRAILERS EQUIPPED WITH VARIOUS TYPES OF SELF-CONTAINED MECHANICAL BRACING DEVICES (CROSS MEMBERS AND WALL MEMBERS) AND APPLY TO TRAILERS HAVING WOOD, OR WOOD AND METAL, OR ALL METAL FLOORS. VAN TRAILERS WHICH ARE 40'-0" LONG BY 7'-6" TO 7'-8-1/2" WIDE (INSIDE DIMENSION) HAVE BEEN SHOWN. HOWEVER, THE PROCEDURES ARE ALSO APPLICABLE FOR TRAILERS WHICH ARE EIGHTY-NINE INCHES (89") THRU NINETY-NINE (99") IN WIDTH AND FOR TRAILERS OF OTHER LENGTHS FROM THE SHORTEST TO THE LONGEST AVAILABLE (REF: 24' TO 53') AND FOR STRAIGHT TRUCK VANS. THE LOADING AND BRACING PROCEDURES SPECIFIED HEREIN ARE ALSO ADEQUATE (CONFIGURATION WISE AND STRENGTH WISE) FOR LOADS IN SHORTER OR LONGER VANS AND IN NARROWER OR WIDER VANS THAN SHOWN. THE SPECIFIED BRACING IS ADEQUATE FOR LOADS WEIGHING UP TO, AND INCLUDING THE MAXIMUM WEIGHTS PERMITTED BY LAW.
- D. THE OUTLOADING PROCEDURES DEPICTED WITHIN THIS DOCUMENT FOR TRAILERS EQUIPPED WITH VARIOUS TYPES OF SELF-CONTAINED MECHANICAL BRACING DEVICES ARE LIMITED TO HIGHWAY MOVEMENTS ONLY. THE HEIGHT REQUIREMENTS SPECIFIED WITHIN THIS DRAWING FOR THE INSTALLATION OF CROSS MEMBERS ARE IDENTICAL WITH THOSE RECOMMENDED BY THE BUREAU OF EXPLOSIVES PAMPHLET 6C AND APPENDICES THERETO. CAUTION: TRAILERS EQUIPPED WITH WALL MEMBERS WHICH DO NOT MEET THE LOCATION REQUIREMENTS MUST NOT BE USED.
1. PALLET UNITS SHOULD BE LOADED TIGHTLY AGAINST EACH OTHER AND/OR AGAINST INSTALLED CROSS MEMBERS. VOIDS LENGTHWISE WITHIN A LOAD SHOULD BE MINIMUM. CROSS MEMBERS MUST BE PLACED AGAINST THE LADING AS TIGHTLY AS THE WALL MEMBER LOCKING HOLE SPACING PERMITS. EACH CROSS MEMBER WILL BE INSTALLED WITH EACH END ATTACHED AS NEARLY AS POSSIBLE IN A "MATED" POSITION (AT EQUAL HEIGHTS, AND AT EQUAL DISTANCES FROM THE END OF THE TRAILER).
 2. CROSS MEMBERS IN EMPTY TRAILERS AND THOSE UNUSED IN LOADED TRAILERS MUST BE "SECURED" FOR SHIPMENT. COMPONENTS ASSIGNED TO EACH TRAILER MUST REMAIN THEREWITH EVEN THOUGH UNUSED DURING SOME SHIPMENTS.
 3. ONE (1) CROSS MEMBER WILL BE REQUIRED FOR EACH 10,000 POUNDS OF LADING AND SHOULD NOT BE RELIED UPON TO RETAIN A GREATER WEIGHT. CROSS MEMBERS WILL NOT BE DOUBLED, THAT IS, TWO CROSS MEMBERS AT THE SAME HEIGHT LOCATION WILL NOT BE PLACED SIDE BY SIDE.
- E. SELECTION OF A VEHICLE TO BE USED TO TRANSPORT THE DESIGNATED ITEM MUST COMPLY WITH AR 55-355, CHAPTER 29 FOR EXPLOSIVES AND OTHER DANGEROUS ARTICLES, IN FULL.
- F. THE GROSS WEIGHT AND AXLE DISTRIBUTION OF WEIGHT FOR A LOAD WILL BE THE RESPONSIBILITY OF THE CARRIER. THE CARRIER WILL ADVISE THE SHIPPER OF THE APPLICABLE LOADING REQUIREMENTS, AND THE SHIPPER WILL LOAD ACCORDINGLY. THE TOTAL WEIGHT OF THE LADING, OF THE DUNNAGE, OF THE TRACTOR AND OF THE SEMI-TRAILER CARRYING THE LADING MUST NOT EXCEED THE MAXIMUM GROSS WEIGHT ALLOWED FOR THE STATE OR STATES THRU WHICH THE LOAD IS TO BE TRANSPORTED BY MOTOR CARRIER. LIKEWISE, THE GROSS WEIGHT ON A SINGLE OR TANDEM AXLE MUST NOT EXCEED THE MAXIMUM ALLOWABLE WEIGHT. IF THERE IS ANY DOUBT AS TO WHETHER THE TOTAL GROSS WEIGHT OF AXLE WEIGHT EXCEEDS THE MAXIMUM ALLOWED WEIGHT SHOULD BE VERIFIED BY ACTUALLY WEIGHING THE LOADED VEHICLE.

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MATERIAL SPECIFICATIONS

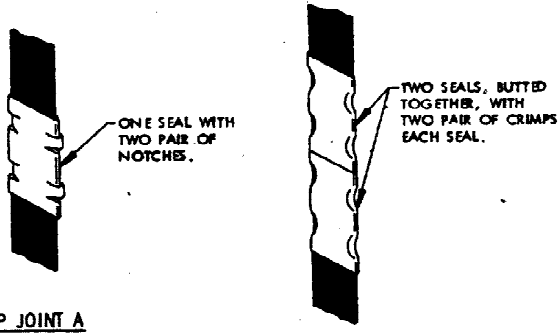
- LUMBER -----: FED SPEC MM-L-751; DUNNAGE LUMBER, SEE TM 743-200-1.
- NAILS -----: FED SPEC FF-N-105; COMMON.
- STRAPPING, STEEL---: FED SPEC QQ-S-781; CLASS I, TYPE I OR IV, HEAVY DUTY, FINISH A, B (GRADE 2), OR C.
- SEAL, STRAP-----: FED SPEC QQ-S-781; TYPE D, STYLE I, II, OR IV, CLASS H, FINISH A, B (GRADE 2) OR C.
- PLYWOOD -----: GROUP B, CONSTRUCTION AND INDUSTRIAL PLYWOOD, INTERIOR WITH EXTERIOR GLUE, GRADE C-D, FED SPEC NN-P-530. IF SPECIFIED GRADE IS NOT AVAILABLE, A BETTER INTERIOR OR AN EXTERIOR GRADE MAY BE SUBSTITUTED.
- WIRE -----: FED SPEC QQ-W-461.
- TYGARD -----: POLYESTER YARN, 1,100 POUNDS/INCH OF WIDTH STRENGTH.
- ADHESIVE -----: TYGARD ADHESIVE.

- G. **NOTICE:** A SHIPMENT WILL BE POSITIONED IN THE TRAILER CONSISTENT WITH STATE WEIGHT LAWS. THE NUMBER OF LADING UNITS MAY BE ADJUSTED TO FIT THE SIZE THE TRAILER TO BE LOADED OR THE QUANTITY TO BE SHIPPED. COMBINATIONS OF THE OUTLOADING PROCEDURES SPECIFIED MAY BE USED; HOWEVER, THE APPROVED METHODS SHOWN MUST BE FOLLOWED AS CLOSELY AS POSSIBLE FOR BLOCKING, BRACING AND STAYING OF THE DESIGNATED ITEMS.
- H. THE "LOAD AS SHOWN" FOR MOST OF THE FULL LOADS DEPICTED HEREIN IS BASED ON AN APPROXIMATE LADING WEIGHT OF 42,000 POUNDS. THE SPECIFIED BLOCKING AND BRACING FOR THE FULL LOADS IS ADEQUATE FOR THE RETENTION OF HEAVIER LOADS, IF IT IS DESIRED TO INCREASE THE LADING WEIGHT.
- J. OTHER TYPES OF LADING ITEMS MAY BE LOADED INTO TRAILERS WHICH ARE PARTIALLY LOADED WITH PALLET UNITS OF COMPLETE ROUNDS, PROVIDING THE TOTAL LOAD IS COMPATIBLE, EXISTING DIRECTIVES ARE NOT VIOLATED AND THE OTHER LADING ITEMS ARE BLOCKED AND BRACED TO EQUAL THE BLOCKING AND BRACING CRITERIA SPECIFIED HEREIN.
- K. SOME LOADS ARE SHOWN IN TRAILERS HAVING ROUNDED CORNERS AT THE FORWARD END. IF THE CONVENTIONAL VAN TRAILER BEING USED IS EQUIPPED WITH A SQUARE FRONT OR WITH AN INSTALLED BULKHEAD, OMIT THE FORWARD BLOCKING ASSEMBLY, PIECE MARKED (1), AND POSITION THE PALLET UNITS DIRECTLY AGAINST THE FORWARD PORTION OF THE TRAILER. OMIT CROSS MEMBERS IN THE FORWARD END OF MECHANICAL VAN TRAILERS HAVING A SQUARE FRONT.
- L. PALLET UNITS WHICH DO NOT CONTAIN A FULL QUANTITY OF ITEMS CAN BE TRANSPORTED. SEE THE "SHIPMENT OF A PARTIAL PALLET UNIT" DETAIL AND SPECIAL NOTES ON PAGE 15. FOR "SHIPMENT OF LEFTOVER CONTAINERS", SEE THE DETAILS AND SPECIAL NOTES ON PAGE 14.
- M. WHEN STEEL STRAPPING IS SEALED AT AN END-OVER-END LAP JOINT, A MINIMUM OF ONE (1) SEAL WITH TWO (2) PAIR OF NOTCHES WILL BE USED TO SEAL THE JOINT WHEN A NOTCH-TYPE SEALER IS BEING USED. A MINIMUM OF TWO (2) SEALS, BUTTED TOGETHER, WITH TWO (2) PAIR OF CRIMPS PER SEAL WILL BE USED TO SEAL THE JOINT WHEN A CRIMP-TYPE SEALER IS BEING USED. REFER TO THE "STRAP JOINT A" AND "STRAP JOINT B" DETAILS ON PAGE 3 FOR GUIDANCE.
- N. DUNNAGE LUMBER SPECIFIED THROUGHOUT THIS PROCEDURAL DRAWING IS OF NOMINAL SIZE. FOR EXAMPLE, 2" X 4" MATERIAL IS ACTUALLY 1-1/2" THICK BY 3-1/2" WIDE AND 2" X 6" MATERIAL IS ACTUALLY 1-1/2" THICK BY 5-1/2" WIDE.
- O. **NOTICE:** A STAGGERED NAILING PATTERN WILL BE USED WHEREVER POSSIBLE WHEN NAILS ARE DRIVEN INTO JOINTS OF DUNNAGE ASSEMBLIES. ALSO, A STAGGERED NAILING PATTERN WILL BE USED WHEN DUNNAGE IS NAILED TO THE FLOOR OF THE TRANSPORTING VEHICLE, OR WHEN LAMINATING DUNNAGE. THE NAILING PATTERN WILL BE ADJUSTED AS REQUIRED SO THAT A NAIL DOES NOT PENETRATE INTO OR NEAR A CRACK BETWEEN FLOOR BOARDS. ADDITIONALLY, THE NAILING PATTERN FOR AN UPPER PIECE OF LAMINATED DUNNAGE WILL BE ADJUSTED AS REQUIRED SO THAT A NAIL FOR THAT PIECE WILL NOT BE DRIVEN THROUGH ONTO OR RIGHT BESIDE A NAIL IN A LOWER PIECE.
- P. POWER DRIVEN STAPLES MAY BE USED AS ALTERNATIVE FASTENERS FOR NAILS WHEN CONSTRUCTING DUNNAGE ASSEMBLIES WHICH ARE TO BE USED IN THE DELINEATED TRAILER LOADS SHOWN THROUGHOUT THIS DRAWING. THE STAPLES TO BE USED MUST BE EQUAL IN LENGTH TO THE SPECIFIED NAIL SIZE AND MUST BE SUBSTITUTED ON A ONE STAPLE FOR ONE NAIL BASIS. STAPLES WHICH ARE 2-1/2" OR LESS IN LENGTH SHOULD BE IN ACCORDANCE WITH FEDERAL SPECIFICATION FF-N-105 AS NEARLY AS PRACTICABLE. STAPLES WHICH ARE LONGER THAN 2-1/2" WILL BE A COMMERCIAL GRADE, OF A QUALITY EQUIVALENT TO THOSE MANUFACTURED BY SENCO PRODUCTS INCORPORATED. **NOTE:** STAPLES WILL NOT BE SUBSTITUTED FOR NAILS IN ANY LOAD RESTRAINING FLOOR DUNNAGE APPLICATION.
- Q. PORTIONS OF THE TRAILERS, SUCH AS SIDEWALLS, END WALLS, AND ROOFS, HAVE NOT BEEN SHOWN IN THE LOAD VIEWS FOR CLARITY PURPOSES.
- R. FOR ADDITIONAL GUIDANCE, ATTENTION IS DIRECTED TO THE "SPECIAL NOTES" SECTIONS WHICH ARE IMMEDIATELY ADJACENT TO THE DEPICTED OUTLOADING METHODS.
- S. CONVERSION TO METRIC EQUIVALENTS: DIMENSIONS WITHIN THIS DOCUMENT ARE EXPRESSED IN INCHES AND WEIGHTS ARE EXPRESSED IN POUNDS. WHEN NECESSARY, THE METRIC EQUIVALENTS MAY BE COMPUTED ON THE BASIS OF ONE INCH EQUALS 25.4 MM AND ONE POUND EQUALS 0.454 KG.
- T. LONGITUDINALLY ADJACENT PALLET UNITS IN A TRAILER WILL BE POSITIONED WITH THE BASE END AGAINST BASE END OR BELL END AGAINST BELL END. THE FRONT LOAD UNIT IN A TRAILER WILL BE POSITIONED WITH THE BASE ENDS OF THE CONTAINERS TOWARD THE FRONT WALL OF THE TRAILER.



PALLET UNIT

CONTAINER -----	30 EACH @ 57 LBS (APPROX)
CUBE -----	42.7 CUBIC FEET (APPROX)
GROSS WEIGHT -----	1883 LBS (APPROX)

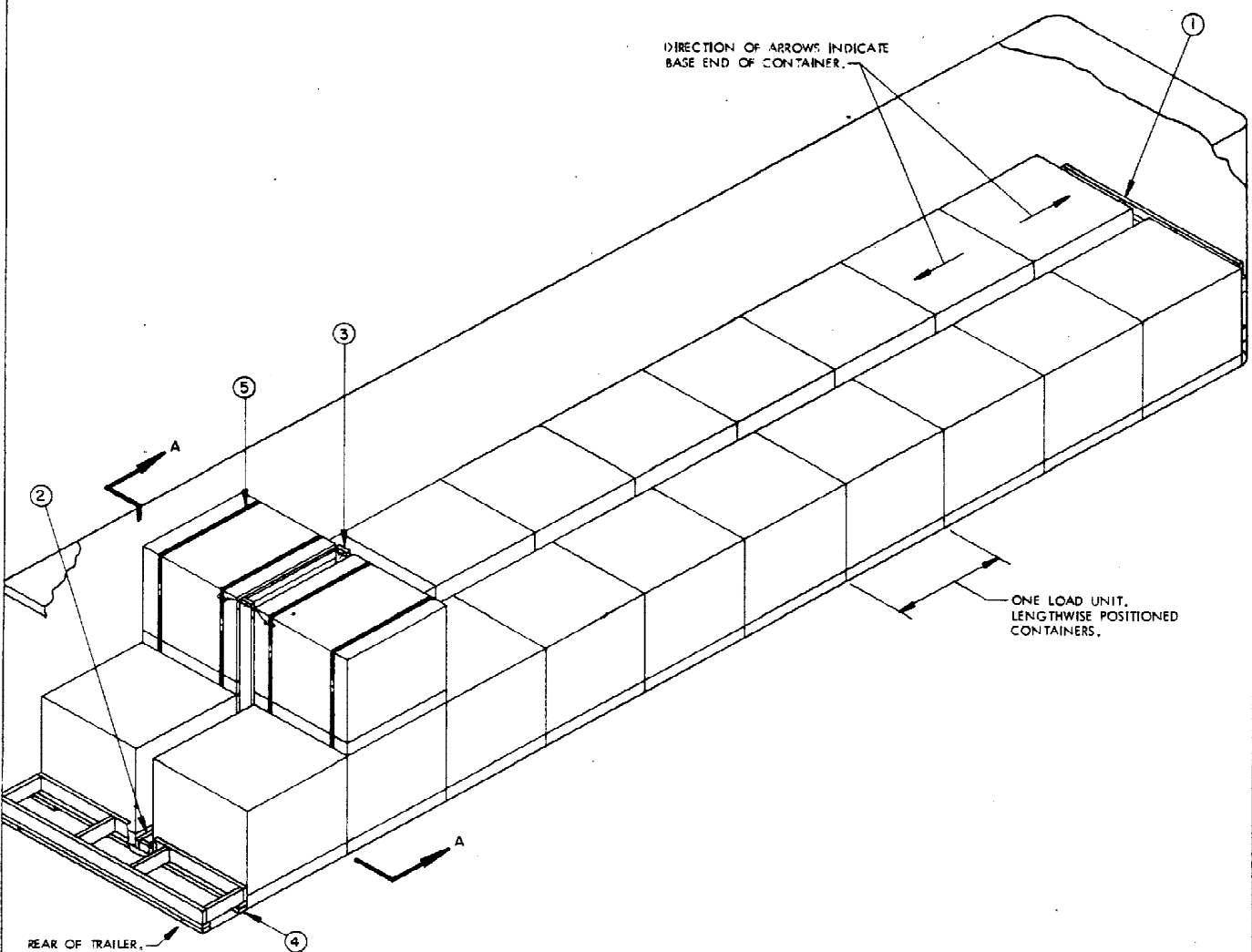


STRAP JOINT A

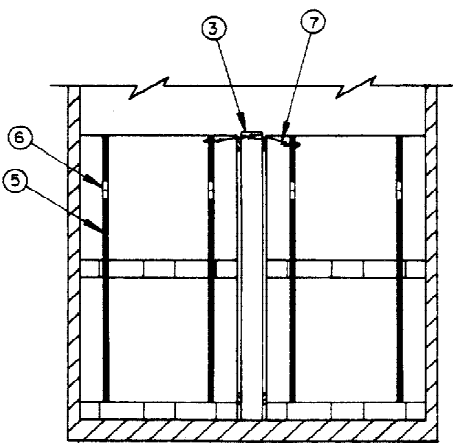
METHOD OF SECURING A STRAP JOINT WHEN USING A NOTCH-TYPE SEALER.

STRAP JOINT B

METHOD OF SECURING A STRAP JOINT WHEN USING A CRIMP-TYPE SEALER.



ISOMETRIC VIEW



SECTION A-A

DIRECTION OF ARROWS INDICATE
BASE END OF CONTAINER.

ONE LOAD UNIT,
LENGTHWISE POSITIONED
CONTAINERS.

REAR OF TRAILER.

KEY NUMBERS

- ① FORWARD BLOCKING ASSEMBLY (1 REQD), SEE THE DETAIL AND THE FORWARD BLOCKING CHART "A" ON PAGE 16. SEE GENERAL NOTE "K" ON PAGE 2.
- ② ANTI-SWAY BRACE (9 REQD), POSITION ON THE FLOOR BETWEEN LATERALLY ADJACENT PALLET UNITS. SEE THE "ANTI-SWAY BRACE" DETAIL ON PAGE 16. SEE GENERAL NOTES "O" AND "P" ON PAGE 2, AND SPECIAL NOTE 2 ON PAGE 5.
- ③ CRIB FILL (1 REQD), SEE THE "CRIB FILL A" DETAIL ON PAGE 16. SEE KEY NUMBER ⑦.
- ④ REAR BLOCKING ASSEMBLY (1 REQD), SEE THE "REAR BLOCKING ASSEMBLY A" DETAIL ON PAGE 17. SEE SPECIAL NOTES 3 AND 8 ON PAGE 5.
- ⑤ STACK UNITIZING STRAP, 1-1/4" X .035" OR .031" X 21'-6" LONG STEEL STRAPPING (4 REQD), INSTALL SO AS TO ENCIRCLE A TOP-LAYER PALLET UNIT AND THE UNIT DIRECTLY BELOW. SEE SPECIAL NOTE 4 ON PAGE 5.
- ⑥ SEAL FOR 1-1/4" STRAPPING (8 REQD, 2 PER STRAP), DOUBLE CRIMP EACH SEAL. SEE GENERAL NOTE "M" ON PAGE 2.
- ⑦ TIE WIRE, NO. 14 GAGE WIRE 60" LONG (2 REQD). INSTALL TO FORM A COMPLETE LOOP AROUND THE TOP OF THE CRIB FILL AND TWIST. TIE EACH END TO A STACK UNITIZING STRAP, PIECE MARKED ⑤. SECURE THE TIE WIRE TO THE CRIB FILL WITH A PARTIALLY DRIVEN 10D NAIL BENT OVER THE WIRE, OR WITH A STRAP STAPLE.

SPECIAL NOTES:

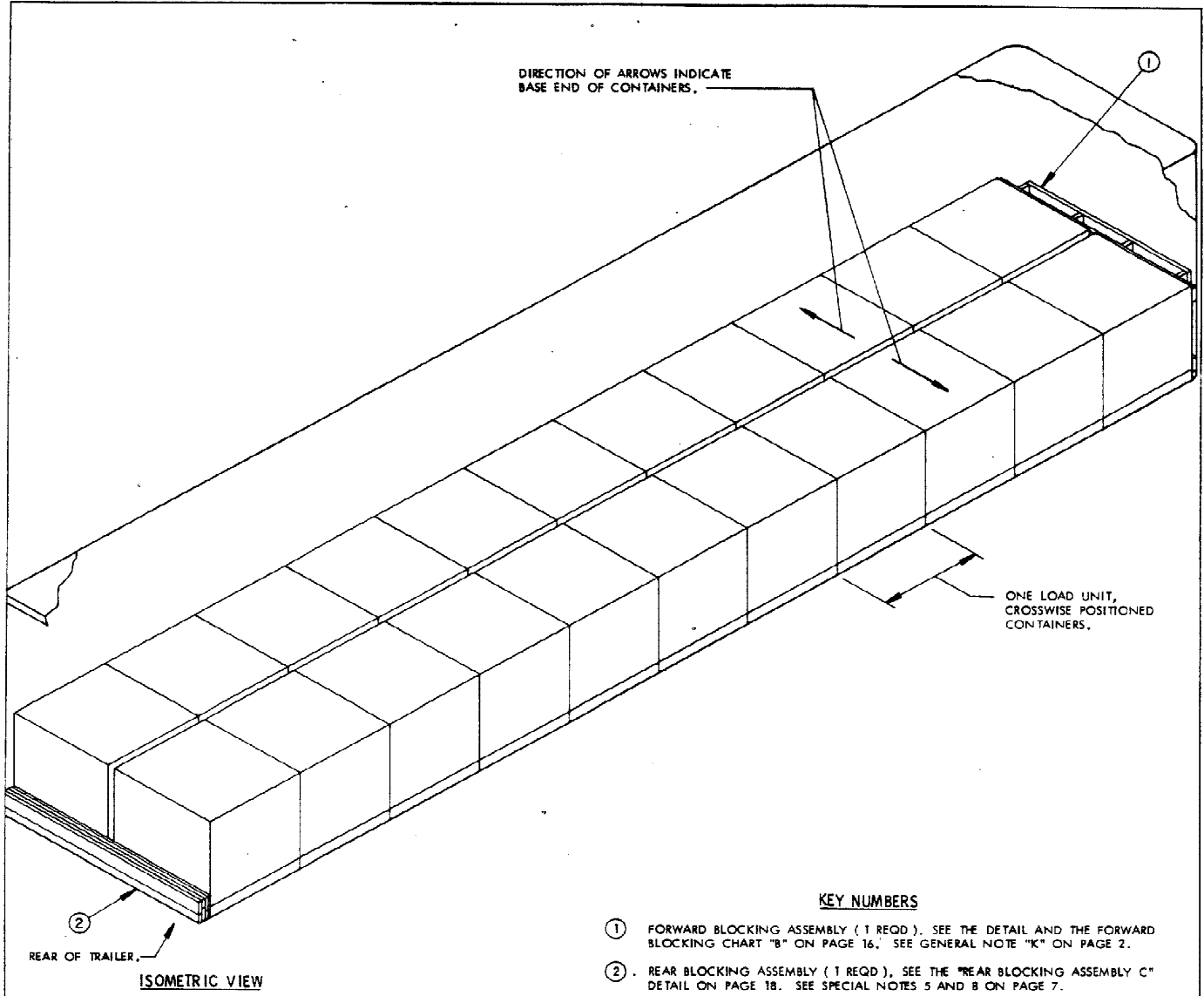
1. A 22-UNIT LOAD IS SHOWN IN A 40'-0" LONG BY 7'-8" WIDE (INSIDE DIMENSION) CONVENTIONAL TYPE VAN TRAILER. TRAILERS OF OTHER DIMENSIONS CAN BE USED.
2. ANTI-SWAY BRACES, SHOWN AS PIECES MARKED (2), IN THE LOAD ON PAGE 4 ARE TO BE POSITIONED BETWEEN ALL Laterally ADJACENT PALLET UNITS.
3. IF THE VOID AT THE REAR OF THE LOAD BETWEEN THE PALLET UNITS AND THE REAR DOOR MEASURES 1-1/2" OR LESS, REAR BLOCKING IS NOT REQUIRED. IF THE VOID AT THE REAR OF THE LOAD IS GREATER THAN 1-1/2" BUT LESS THAN 9", USE "REAR BLOCKING ASSEMBLY C" AS DETAILED ON PAGE 18. IF THE VOID AT THE REAR OF THE LOAD IS 9" OR GREATER, USE THE REAR BLOCKING ASSEMBLY, PIECE MARKED (4) ON PAGE 4. SEE SPECIAL NOTE 8.
4. THE STACK UNITIZING STRAPS, PIECES MARKED (5) IN THE LOAD ON PAGE 4, WILL BE INSTALLED TO SECURE AN UNSUPPORTED PALLET UNIT IN THE SECOND LAYER TO A CORRESPONDING UNIT IN THE FIRST LAYER, EXCEPT AT THE VERY REAR OF THE LOAD. PALLET UNITS MUST NOT BE POSITIONED ON TOP OF THE REAR MOST LOAD UNIT.
5. IF THE QUANTITY OF UNITS IS REDUCED FROM WHAT IS SHOWN, OR IF THE TRAILER TO BE LOADED IS LONGER THAN 40', THE SPACER ASSEMBLY PROCEDURES SPECIFIED IN SPECIAL NOTE 3 ON PAGE 7 CAN ALSO BE USED FOR THE DEPICTED LOAD.
6. REFER TO PAGE 15 FOR GUIDANCE IN THE SHIPMENT OF PARTIAL PALLET UNITS.
7. LEFTOVER CONTAINERS IN AN AMOUNT NOT TO EXCEED FIVE (5) MAY BE SECURED TO THE TOP OF A FULL PALLET UNIT FOR SHIPMENT. REFER TO THE "PROCEDURES FOR SHIPMENT OF LEFTOVER CONTAINERS" ON PAGE 14 FOR GUIDANCE.
8. TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS MAY BE USED. HOWEVER, SPECIAL REAR BLOCKING MUST BE INSTALLED. SEE THE "PROCEDURES FOR CONVENTIONAL VAN TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS" ON PAGES 20 AND 21 FOR GUIDANCE. THE NAILED-HEADER METHOD IS SHOWN ON PAGE 21 AND THE TYGARD METHOD IS SHOWN ON PAGE 20. NOTE THAT THE SPECIAL REAR BLOCKING FOR TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS MAY ALSO BE USED IN TRAILERS EQUIPPED WITH HINGED DOORS.

BILL OF MATERIAL

LUMBER	LINEAR FEET	BOARD FEET
1" X 4"	15	5
2" X 3"	2	1
2" X 4"	115	77
2" X 6"	63	63
NAILS	NO. REQD	POUNDS -
6d (2")	16	NIL
10d (3")	234	3-3/4
STEEL STRAPPING, 1-1/4" X .035" OR .031" --- 86' REQD --- 13 LBS		
SEAL FOR 1-1/4" STRAPPING ----- 8 REQD ----- NIL		
WIRE, NO. 14 GAGE ----- 10' REQD ----- NIL		

LOAD AS SHOWN

ITEM	QUANTITY	WEIGHT (APPROX)
PALLET UNIT	22	41,426 LBS
DUNNAGE		309 LBS
TOTAL WEIGHT		41,735 LBS

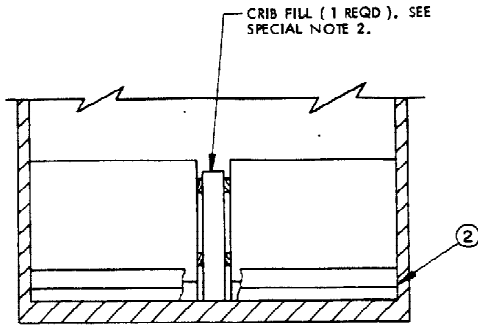


KEY NUMBERS

- ① FORWARD BLOCKING ASSEMBLY (1 REQD). SEE THE DETAIL AND THE FORWARD BLOCKING CHART "B" ON PAGE 16. SEE GENERAL NOTE "K" ON PAGE 2.
- ② REAR BLOCKING ASSEMBLY (1 REQD). SEE THE "REAR BLOCKING ASSEMBLY C" DETAIL ON PAGE 18. SEE SPECIAL NOTES 5 AND 8 ON PAGE 7.

SPECIAL NOTES:

1. A 22-UNIT LOAD IS SHOWN IN A 40'-0" LONG BY 7'-8" WIDE (INSIDE DIMENSION) CONVENTIONAL VAN TYPE TRAILER. TRAILERS OF OTHER DIMENSIONS CAN BE USED. SEE SPECIAL NOTES 2 AND 3.
2. IF A TRAILER WHICH IS WIDER THAN 7'-11" IS TO BE LOADED, CRIB FILL WILL BE REQUIRED BETWEEN LATERALLY ADJACENT PALLET UNITS. SEE THE "TYPICAL REAR VIEW OF AN 8'-2" WIDE VAN" AT LEFT, AND THE "CRIB FILL" DETAIL ON PAGE 16.
3. IF THE QUANTITY OF UNITS IS REDUCED FROM WHAT IS SHOWN, OR IF THE TRAILER TO BE LOADED IS LONGER THAN 40', SPACER ASSEMBLY "A" DETAILED ON PAGE 18 CAN BE USED FOR THE PURPOSE OF PROVIDING FOR PROPER WEIGHT DISTRIBUTION, OR MAY BE USED IN LIEU OF ONE AND/OR TWO OMITTED UNITS. NOTE THAT THE SPACER ASSEMBLIES MUST NOT BE POSITIONED ADJACENT TO THE FORWARD BLOCKING ASSEMBLY PIECE MARKED (1), AND THEY MUST BE POSITIONED WHERE THERE WILL BE A PALLET UNIT AT EACH END OF EACH ASSEMBLY.
4. IF PALLET UNITS ARE TO BE LOADED ON THE TOP LAYER OF THE DEPICTED LOAD, STACK UNITIZING STRAPS, 21'-6" LONG WILL BE INSTALLED TO SECURE AN UNSUPPORTED PALLET UNIT IN THE SECOND LAYER TO A CORRESPONDING UNIT IN THE FIRST LAYER. PALLET UNITS MUST NOT BE POSITIONED ON TOP OF THE REARMOST LOAD UNIT. SEE KEY NUMBER (5) ON PAGE 4 FOR A TYPICAL INSTALLATION.
5. IF THE SPACE AT THE REAR OF THE LOAD BETWEEN THE PALLET UNITS AND THE REAR DOOR IS GREATER THAN 1-1/2" BUT LESS THAN 9", USE REAR BLOCKING ASSEMBLY "C" AS SHOWN IN THE LOAD ON PAGE 6. IF THE VOID AT THE REAR OF THE LOAD IS 9" OR GREATER, USE THE REAR BLOCKING ASSEMBLY "B" SHOWN ON PAGE 17. IF THE VOID AT THE REAR OF THE LOAD MEASURES 1-1/2" OR LESS, REAR BLOCKING IS NOT REQUIRED. SEE SPECIAL NOTE 8.
6. REFER TO PAGE 15 FOR GUIDANCE IN THE SHIPMENT OF PARTIAL PALLET UNITS.
7. LEFTOVER CONTAINERS IN AN AMOUNT NOT TO EXCEED FIVE (5) MAY BE SECURED TO THE TOP OF A FULL PALLET UNIT FOR SHIPMENT. REFER TO THE "PROCEDURES FOR SHIPMENT OF LEFTOVER CONTAINERS" ON PAGE 14 FOR GUIDANCE.
8. TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS MAY BE USED; HOWEVER, SPECIAL REAR BLOCKING MUST BE INSTALLED. SEE THE "PROCEDURES FOR CONVENTIONAL VAN TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS" ON PAGES 20 AND 21 FOR GUIDANCE. A NAILED-HEADER METHOD AND A TYGARD METHOD ARE SHOWN. FOR THE DEPICTED LOAD IN A 40'-0" LONG TRAILER WHEN USING THE NAILED-HEADER METHOD, IT WILL BE NECESSARY TO FORM TEN (10) LOAD UNITS INSTEAD OF ELEVEN (11) AS SHOWN. NOTE THAT THE SPECIAL REAR BLOCKING FOR TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS MAY ALSO BE USED IN CONVENTIONAL VAN TRAILERS EQUIPPED WITH HINGED DOORS.



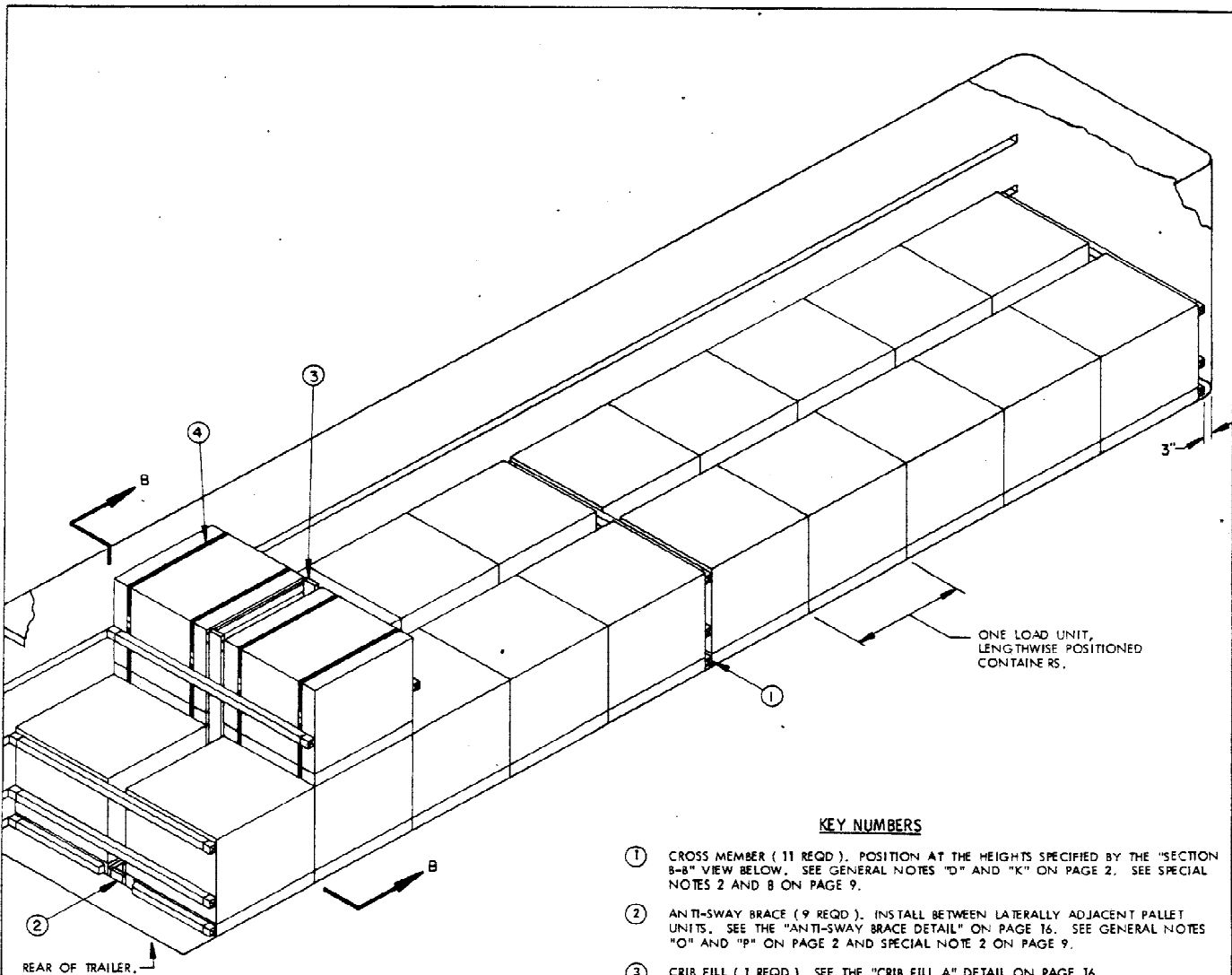
TYPICAL REAR VIEW OF AN 8'-2" WIDE VAN

BILL OF MATERIAL

LUMBER	LINEAR FEET	BOARD FEET
1" X 4"	8	3
1" X 6"	8	4
2" X 4"	36	24
2" X 6"	51	51
NAILS	NO. REQD	POUNDS
10d (3")	80	1-1/4

LOAD AS SHOWN

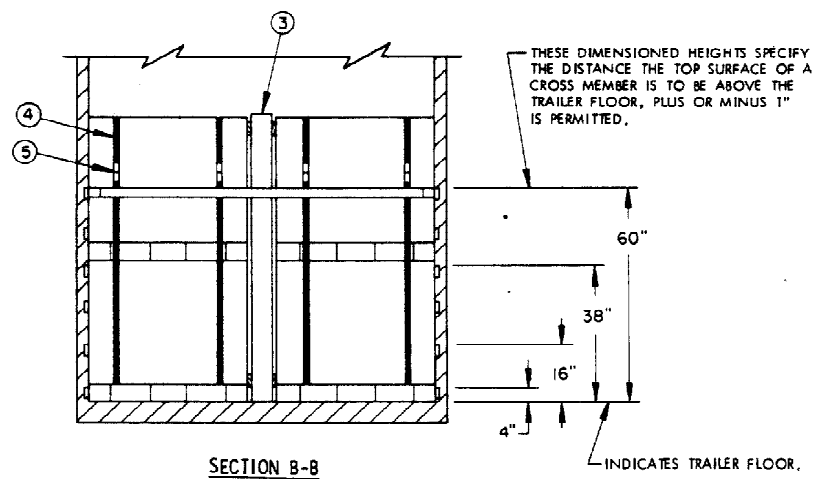
ITEM	QUANTITY	WEIGHT (APPROX)
PALLET UNIT	22	41,426 LBS
DUNNAGE		166 LBS
TOTAL WEIGHT		41,592 LBS



REAR OF TRAILER.
ISOMETRIC VIEW

KEY NUMBERS

- ① CROSS MEMBER (11 REQD). POSITION AT THE HEIGHTS SPECIFIED BY THE "SECTION B-B" VIEW BELOW. SEE GENERAL NOTES "D" AND "K" ON PAGE 2. SEE SPECIAL NOTES 2 AND 8 ON PAGE 9.
- ② ANTI-SWAY BRACE (9 REQD). INSTALL BETWEEN LATERALLY ADJACENT PALLET UNITS. SEE THE "ANTI-SWAY BRACE DETAIL" ON PAGE 16. SEE GENERAL NOTES "O" AND "P" ON PAGE 2 AND SPECIAL NOTE 2 ON PAGE 9.
- ③ CRIB FILL (1 REQD). SEE THE "CRIB FILL A" DETAIL ON PAGE 16.
- ④ STACK UNITIZING STRAP, 1-1/4" X .035" OR .031" X 21'-6" LONG STEEL STRAPPING (4 REQD). INSTALL SO AS TO ENCIROLE A TOP-LAYER PALLET UNIT AND THE UNIT DIRECTLY BELOW. SEE SPECIAL NOTE 7 ON PAGE 9.
- ⑤ SEAL FOR 1-1/4" STRAPPING (8 REQD, 2 PER STRAP). DOUBLE CRIMP EACH SEAL. SEE GENERAL NOTE "M" ON PAGE 2.



SECTION B-B

SPECIAL NOTES:

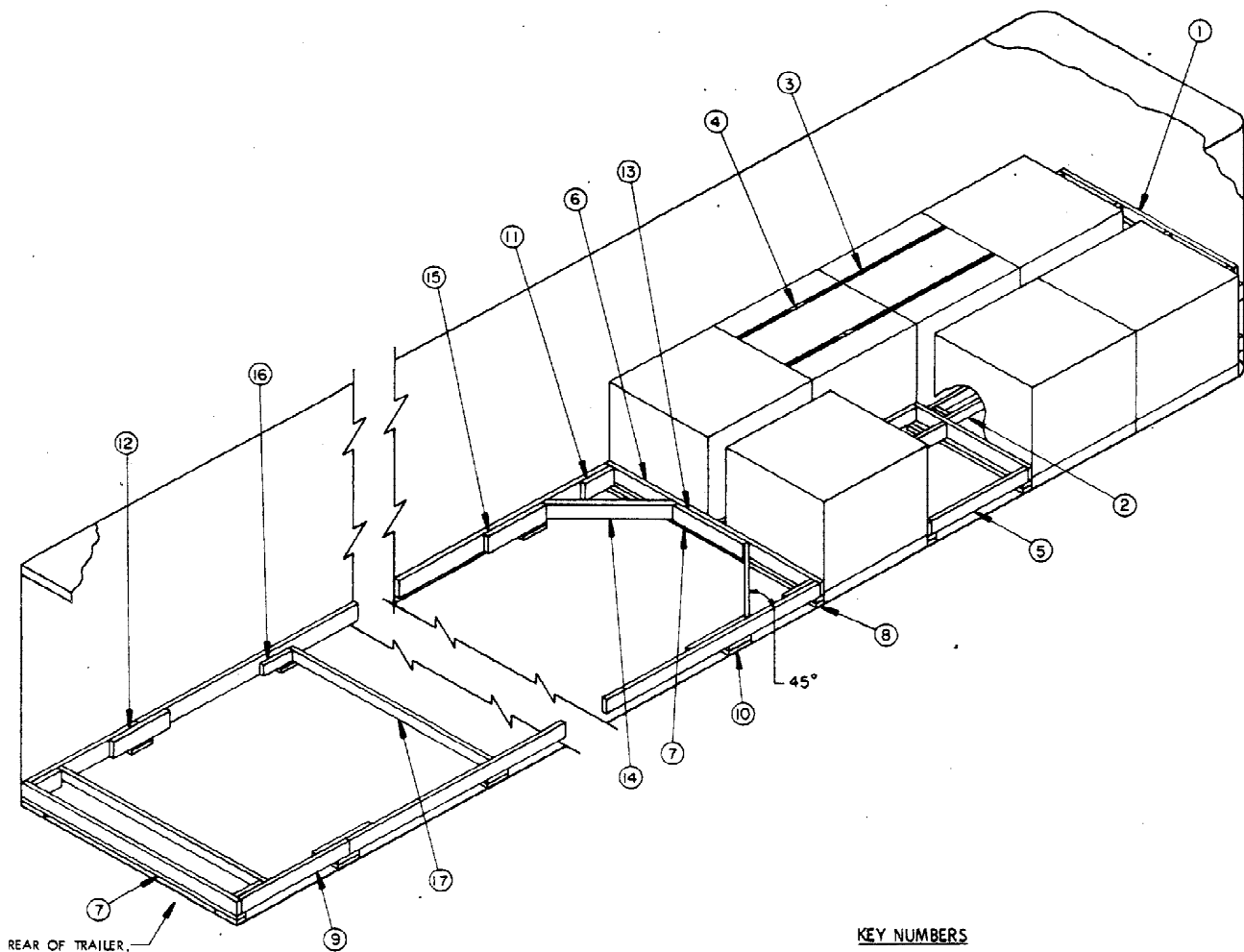
1. A 22-UNIT LOAD IS SHOWN IN A 40'-0" LONG BY 7'-8" WIDE (INSIDE DIMENSION) TRAILER EQUIPPED WITH MECHANICAL BRACING DEVICES. TRAILERS OF OTHER DIMENSIONS CAN BE USED."
2. CROSS MEMBERS ARE REQUIRED AT THE 4" HEIGHT LOCATION TO PREVENT DISPLACEMENT OF THE ANTI-SWAY BRACES SHOWN AS PIECE MARKED (2). THESE CROSS MEMBERS, EXCEPT FOR THE ONE POSITIONED AT THE REAR OF THE LOAD, CAN BE OMITTED IF PALLET UNITS ARE POSITIONED AGAINST THE FROWARD END OF THE TRAILER, OR IF THE CROSS MEMBERS ARE OMITTED FROM THE CENTER PORTION OF THE LOAD AS SPECIFIED IN SPECIAL NOTE 8.
3. IF A PALLET UNIT IS TO BE ADDED OR OMITTED FROM THE DEPICTED LOAD, THE SPACER ASSEMBLY PROCEDURES DEPICTED ON PAGE 13 MAY BE USED. NOTE THAT CROSS MEMBERS ARE REQUIRED AT BOTH ENDS OF THE ODD UNIT.
4. REFER TO PAGE 15 FOR GUIDANCE IN THE SHIPMENT OF PARTIAL PALLET UNITS.
5. LEFTOVER CONTAINERS IN AN AMOUNT NOT TO EXCEED FIVE (5) MAY BE SECURED TO THE TOP OF A FULL PALLET UNIT FOR SHIPMENT. REFER TO THE "PROCEDURES FOR SHIPMENT OF LEFTOVER CONTAINERS " ON PAGE 14 FOR GUIDANCE.
6. FOR SHIPMENT OF LESS THAN FULL LOADS, REFER TO THE APPLICABLE GUIDANCE. ON PAGE 13.
7. A PALLET UNIT IN THE SECOND LAYER MUST BE UNITIZED TO A PALLET UNIT IN THE FIRST LAYER, WITH UNITIZING STRAPS, PIECES MARKED (4).
8. IF THE TRAILER BEING LOADED IS EQUIPPED ONLY WITH SHORT WALL MEMBERS AT THE REAR FOR ATTACHMENT OF THE CROSS MEMBERS, THE CROSS MEMBERS LOCATED AT THE FRONT OF THE TRAILER AND THOSE LOCATED NEAR THE CENTER PORTION OF THE LOAD LENGTH WILL BE OMITTED; TWO (2) PALLET UNITS WILL HAVE TO BE OMITTED, A 1/2" PLYWOOD GATE WHICH IS UNIT HEIGHT BY TRAILER WIDTH MINUS 1/2" MUST BE INSTALLED AT THE REAR OF THE LOAD, AND A CROSS MEMBER MUST BE INSTALLED AT THE 28" HEIGHT LOCATION. IF THE TRAILER BEING LOADED IS LONGER THAN 40'-0" AND/OR IF LESS THAN 20 UNITS ARE TO BE TRANSPORTED, A SPACER ASSEMBLY WILL BE REQUIRED TO PROVIDE FOR PROPER WEIGHT DISTRIBUTION. POSITION BETWEEN THE SECOND AND THIRD OR THIRD AND FOURTH LOAD UNITS, DEPENDING UPON THE LENGTH OF THE TRAILER, AND THE QUANTITY TO BE TRANSPORTED. SEE THE "SPACER ASSEMBLY C" DETAIL ON PAGE 19.

BILL OF MATERIAL

LUMBER	LINEAR FEET	BOARD FEET
1" X 4"	15	5
2" X 4"	82	55
2" X 6"	14	14
NAILS	NO. REQD	POUNDS
6d (2")	16	NIL
10d (3")	144	2-1/4
STEEL STRAPPING, 1-1/4" X .035" OR .031"----- 86' REQD --- 13 LBS		
SEALS FOR 1-1/4" STRAPPING ----- 8 REQD --- NIL		
CROSS MEMBER ----- 11 REQD		

LOAD AS SHOWN

ITEM	QUANTITY	WEIGHT (APPROX)
PALLET UNIT -----	22 -----	41,426 LBS
DUNNAGE -----	-----	164 LBS
TOTAL WEIGHT -----		41,590 LBS



ISOMETRIC VIEW

(KEY NUMBERS CONTINUED)

- ⑫ SPLICE PIECE, 2" X 6" X 24" (AS REQD). CENTER ON JOINT OF PIECES MARKED ⑨ AND NAIL TO SIDE STRUT MARKED ⑨ W/4-10d NAILS AT EACH END. SEE SPECIAL NOTE 4 ON PAGE 11.
- ⑬ CENTER CLEAT, 2" X 6" X 30" (1 REQD). NAIL TO A HEADER, PIECE MARKED ⑥ , W/6-10d NAILS.
- ⑭ DIAGONAL BRACE, 2" X 6" BY CUT-TO-FIT (2 REQD). DOUBLE BEVEL EACH END WITH 45° CUTS. INSTALL AT A 45° ANGLE AS SHOWN AND TOENAIL TO THE ADJACENT HEADER AND SIDE STRUT, PIECES MARKED ⑥ AND ⑨ W/2-16d NAILS AT EACH END.
- ⑮ BACK-UP CLEAT, 2" X 6" X 24" (2 REQD). NAIL TO A SIDE STRUT, PIECE MARKED ⑨ , W/8-10d NAILS.
- ⑯ STRUT BRACE RETAINING CLEAT, 2" X 4" X 12" (AS REQD). NAIL TO A SIDE STRUT, PIECE MARKED ⑨ , W/3-10d NAILS. SEE SPECIAL NOTE 5 ON PAGE 11.
- ⑰ STRUT BRACE, 2" X 4" BY TRAILER WIDTH MINUS 3" IN LENGTH (MINIMUM OF ONE REQUIRED). NAIL TO THE POCKET CLEATS, PIECES MARKED ⑪ , AND/OR TO THE STRUT BRACE RETAINING CLEATS, PIECES MARKED ⑯ , W/2-12d NAILS AT EACH END. SEE SPECIAL NOTE 5 ON PAGE 11.

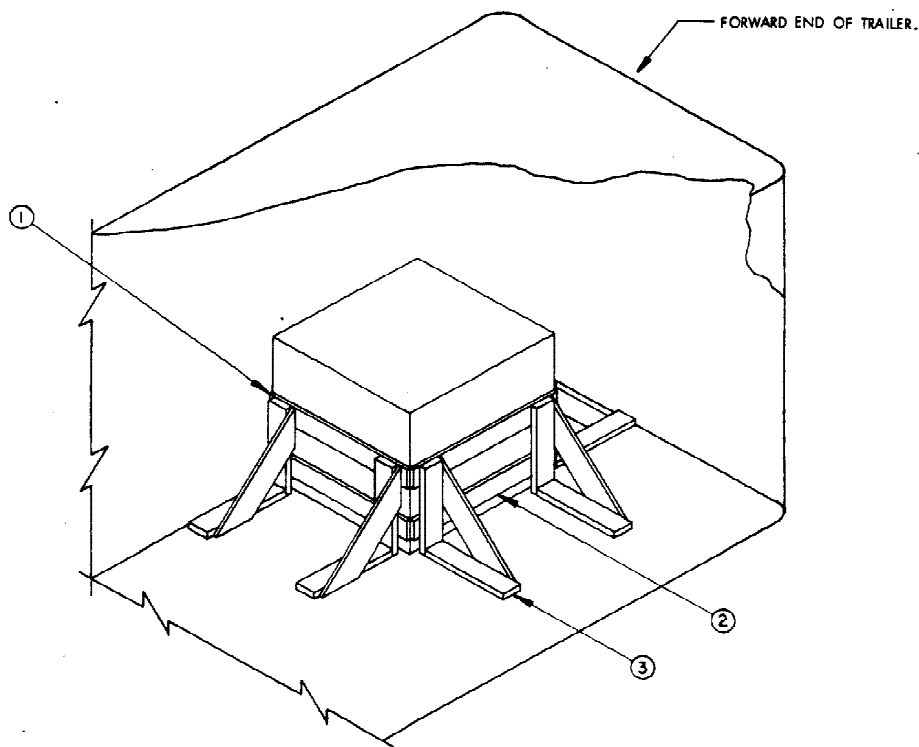
KEY NUMBERS

- ① FORWARD BLOCKING ASSEMBLY (1 REQD). SEE THE DETAIL AND FORWARD BLOCKING CHART "A" ON PAGE 16. SEE GENERAL NOTE "K" ON PAGE 2.
- ② ANTI-SWAY BRACE (3 REQD). POSITION ON THE FLOOR BETWEEN LATERALLY ADJACENT PALLET UNITS. SEE THE "ANTI-SWAY BRACE" DETAIL ON PAGE 16.
- ③ BUNDLING STRAP, 1-1/4" X .0035" OR .0031" X 24'-6" LONG STEEL STRAPPING (2 REQD). INSTALL SO AS TO ENCIRCLE TWO (2) PALLET UNITS. SEE SPECIAL NOTE 2 ON PAGE 11.
- ④ SEAL FOR 1-1/4" STRAPPING (4 REQD, 2 PER STRAP). DOUBLE CRIMP EACH SEAL. SEE GENERAL NOTE "M" ON PAGE 2.
- ⑤ SPACER ASSEMBLY (1 REQD). SEE THE "SPACER ASSEMBLY A" DETAIL ON PAGE 18. SEE SPECIAL NOTE 3 ON PAGE 11.
- ⑥ HEADER, 2" X 6" BY TRAILER WIDTH MINUS 1/2" IN LENGTH (2 REQD). SEE SPECIAL NOTES 9 AND 10 ON PAGE 11.
- ⑦ HEADER AND SIDE STRUT SUPPORT, 2" X 4" BY TRAILER WIDTH MINUS 1/2" IN LENGTH (2 REQD). NAIL TO THE BOTTOM EDGE OF A HEADER, PIECE MARKED ⑥ , W/1-10d NAILS EVERY 8".
- ⑧ RISER PIECE, 2" X 4" X 9" (4 REQD). POSITION UNDER EACH END OF HEADER AND SIDE STRUT SUPPORT PIECES MARKED ⑦ . NAIL TO PIECE MARKED ⑦ W/2-10d NAILS.
- ⑨ SIDE STRUT, 2" X 6" BY CUT-TO-FIT BETWEEN THE FORWARD AND REAR HEADERS, PIECES MARKED ⑥ (2 REQD). SEE SPECIAL NOTE 4 ON PAGE 11.
- ⑩ RISER PIECE, 2" X 4" X 9" (DOUBLED) (AS REQD). LAMINATE W/2-10d NAILS CENTER UNDER THE JOINTS OF PIECES MARKED ⑭ AND ⑮ , ⑯ AND ⑰ AND UNDER THE SPLICE OF PIECES MARKED ⑨ IF APPLICABLE. NAIL TO SIDE STRUT MARKED ⑨ W/2-10d NAILS.
- ⑪ POCKET CLEAT, 2" X 6" X 12" (4 REQD). NAIL TO A SIDE STRUT, PIECE MARKED ⑨ , W/3-10d NAILS. TOENAIL TO THE ADJACENT HEADER, PIECE MARKED ⑥ , W/3-12d NAILS.

(CONTINUED AT LEFT)

SPECIAL NOTES:

1. A 7'-6" WIDE (INSIDE DIMENSION) CONVENTIONAL VAN TRAILER IS SHOWN. TRAILERS OF OTHER WIDTHS CAN BE USED. SEE SPECIAL NOTES 9 AND 10.
2. A PALLET UNIT THAT DOES NOT HAVE A PALLET UNIT DIRECTLY OPPOSITE MUST BE SECURED BY INSTALLING BUNDLING STRAPS, SHOWN AS PIECES MARKED (3) IN THE LTL LOAD ON PAGE 10, AROUND THAT PALLET UNIT AND THE PALLET UNIT IMMEDIATELY ADJACENT.
3. THE SPACER ASSEMBLY, SHOWN AS PIECE MARKED (5) IN THE LTL LOAD ON PAGE 10, IS ONLY SHOWN TO DEPICT A TYPICAL INSTALLATION. IF A PALLET UNIT IS LOADED IN PLACE OF THE SPACER ASSEMBLY, BUNDLING STRAPS, SHOWN AS PIECE MARKED (3), WILL NOT BE REQUIRED. NOTE THAT A SPACER ASSEMBLY MUST BE POSITIONED WHERE THERE WILL BE A PALLET UNIT AT EACH END. A SPACER ASSEMBLY MUST NOT BE POSITIONED ADJACENT TO THE FORWARD BLOCKING ASSEMBLY PIECE MARKED (1).
4. DEPENDING ON THE NUMBER OF UNITS BEING LOADED, EACH OF THE SIDE STRUTS, PIECES MARKED (9), MAY NEED TO BE FORMED FROM MORE THAN ONE PIECE OF MATERIAL. IF SUCH IS THE CASE, THE SIDE STRUTS MUST BE SPLICED. SPLICING CAN BE ACCOMPLISHED BY CENTERING A 2" X 6" X 24" PIECE ON THE JOINT OF THE SIDE STRUTS AND NAILING IT TO THE SIDE STRUTS W/4-10# NAILS AT EACH END. CAUTION: A RISER PIECE, PIECE MARKED (10), MUST BE POSITIONED UNDER EACH SPLICE JOINT. NOTE: IF DESIRED, THE STRUT BRACING PIECE (5), PIECE MARKED (17), MAY BE NAILED TO THE SPLICE PIECES IN LIEU OF USING ADDITIONAL STRUT BRACE RETAINING CLEATS, PIECES MARKED (16).
5. ALL LTL LOADS, REGARDLESS OF THEIR SIZE, REQUIRE ONE STRUT BRACE POSITIONED AT THE REAR OF THE TRAILER AND NAILED TO PIECE MARKED (11). IF THE SIDE STRUTS, PIECES MARKED (9), ARE LONGER THAN 7'-0", AN ADDITIONAL STRUT BRACE, PIECE MARKED (17), AND TWO (2) STRUT BRACE RETAINING CLEATS, PIECES MARKED (16), AND TWO (2) RISER PIECES MARKED (10), MUST BE APPLIED FOR EVERY 7'-0" OF SIDE STRUT LENGTH.
6. THE "K-BRACE" BLOCKING, SHOWN AS PIECES MARKED (6) THRU (17), IS ADEQUATE FOR RETAINING A MAXIMUM LTL LOAD OF 20,000 POUNDS.
7. REFER TO PAGE 15 FOR GUIDANCE IN THE SHIPMENT OF PARTIAL PALLET UNITS.
8. LEFTOVER CONTAINERS, IN AN AMOUNT NOT TO EXCEED FIVE (5), MAY BE SECURED TO THE TOP OF A FULL PALLET UNIT FOR SHIPMENT. REFER TO THE "PROCEDURES FOR SHIPMENT OF LEFTOVER CONTAINERS" ON PAGE 14 FOR GUIDANCE.
9. TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS MAY BE USED; HOWEVER, SPECIAL REAR BLOCKING MUST BE INSTALLED. SEE THE "PROCEDURES FOR CONVENTIONAL VAN TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS" ON PAGES 20 AND 21 FOR GUIDANCE. THE NAILED-HEADER METHOD SHOWN ON PAGE 21 OR THE TYGARD METHOD SHOWN ON PAGE 20 SHOULD BE USED IF POSSIBLE IN LIEU OF PIECES MARKED (6) THRU (17) WHICH APPLY TO TRAILERS HAVING NON-NAILABLE FLOORS. NOTE THAT THE SPECIAL REAR BLOCKING FOR TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS MAY ALSO BE USED IN TRAILERS EQUIPPED WITH HINGED DOORS.
10. IF DESIRED, IN TRAILERS EQUIPPED WITH NAILABLE FLOORS, THE NAILED-HEADER METHOD OF REAR BLOCKING MAY BE USED IN LIEU OF THE K-BRACE BLOCKING SHOWN AS PIECES MARKED (6) THRU (17). REFER TO PAGE 21 FOR GUIDANCE. AS AN ALTERNATIVE IN NAILABLE FLOOR TRAILERS, OR IN TRAILERS HAVING NON-NAILABLE FLOORS, THE TYGARD METHOD DEPICTED ON PAGE 20 MAY BE USED.



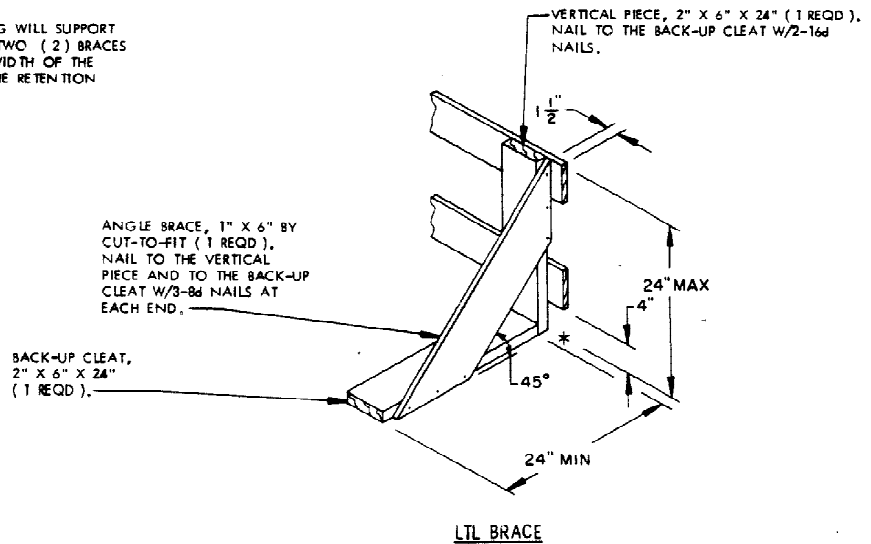
ISOMETRIC VIEW

SPECIAL NOTES:

1. A 7'-6" WIDE (INSIDE DIMENSION) TRAILER WHICH HAS A NAILABLE FLOOR IS SHOWN. TRAILERS OF OTHER WIDTHS CAN BE USED.
2. THE POSITIONING OF A SINGLE PALLET UNIT IS OPTIONAL. IF THE TRAILER HAS A SQUARE FRONT, THE TWO (2) FORWARD LTL BRACES MAY BE OMITTED AND THE UNIT POSITIONED AGAINST THE END WALL.
3. MORE THAN ONE PALLET UNIT CAN BE SHIPPED PROVIDING THE CAPACITY OF THE LTL BRACES IS NOT EXCEEDED. THE LOAD SHOULD BE FORMED IN ROWS, WITH THE UNITS POSITIONED AGAINST OPPOSITE SIDEWALLS. THE "ANTI-SWAY BRACE", DETAILED ON PAGE 16, MUST BE INSTALLED BETWEEN LATERALLY ADJACENT UNITS. A STOP PIECE, SHOWN BY DOTTED LINES ON THE DETAIL, WILL BE REQUIRED.
4. EACH LTL BRACE AS APPLIED FOR LONGITUDINAL BRACING WILL SUPPORT 2,000 POUNDS OF LADING, HOWEVER, NOT LESS THAN TWO (2) BRACES WILL BE USED AGAINST EACH PALLET UNIT ACROSS THE WIDTH OF THE TRAILER. ADDITIONAL BRACES MAY BE INSTALLED FOR THE RETENTION OF A HEAVIER LOAD.

KEY NUMBERS

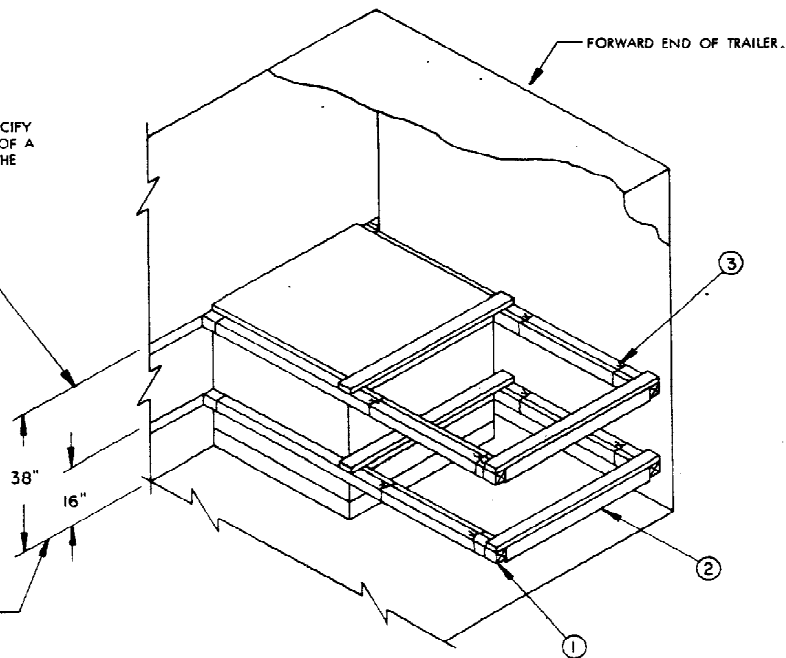
- ① LOAD BEARING PIECE, 1" X 6" X 42" (4 REQD). LOCATE AT THE HEIGHTS AS SPECIFIED IN THE "LTL BRACE" DETAIL BELOW. NAIL TO THE LTL BRACES W/4-6d NAILS AT EACH JOINT. SEE GENERAL NOTE "O" ON PAGE 2.
- ② LOAD BEARING PIECE, 1" X 6" X 44" (2 REQD). LOCATE AT THE HEIGHTS AS SPECIFIED IN THE "LTL BRACE" DETAIL BELOW. NAIL TO THE LTL BRACES W/4-6d NAILS AT EACH JOINT.
- ③ LTL BRACE (6 REQD). SEE THE "LTL BRACE" DETAIL BELOW. NAIL TO THE TRAILER FLOOR W/10-10d NAILS.



TYPICAL LTL (1-UNIT LOAD) IN A CONVENTIONAL VAN TRAILER

THESE DIMENSIONED HEIGHTS SPECIFY THE DISTANCE THE TOP SURFACE OF A CROSS MEMBER IS TO BE ABOVE THE TRAILER FLOOR, PLUS OR MINUS 1" IS PERMITTED.

INDICATES TRAILER FLOOR.



ISOMETRIC VIEW

SPECIAL NOTES:

1. A 7'-6" WIDE (INSIDE DIMENSION) VAN TRAILER EQUIPPED WITH MECHANICAL BRACING DEVICES IS SHOWN. TRAILERS OF OTHER WIDTHS MAY BE USED.
2. A TYPICAL LTL LOAD OF ONE (1) PALLETIZED UNIT IS SHOWN. IF TWO (2) PALLETIZED UNITS ARE TO BE TRANSPORTED, POSITION THE UNITS TWO ACROSS THE WIDTH OF THE TRAILER. OMIT THE SPACER ASSEMBLIES AND THE TIE WIRES SHOWN AS PIECES MARKED (2) AND (3). NOTE: WHEN LOADING TWO (2) PALLETIZED UNITS ACROSS THE WIDTH OF THE TRAILER, POSITION THE UNITS AGAINST THE FORWARD END WALL (UNLESS THE TRAILER HAS ROUNDED CORNERS) AND OMIT THE TWO CROSS MEMBERS AT THE FORWARD END. POSITION ONE ANTI-SWAY BRACE, SHOWN AS PIECE MARKED (2) ON PAGE 4 BETWEEN THE UNITS. NOTE THAT CROSS MEMBERS MUST BE POSITIONED AT THE 4" HEIGHT LOCATION TO PREVENT DISPLACEMENT OF ANTI-SWAY BRACE.

KEY NUMBERS

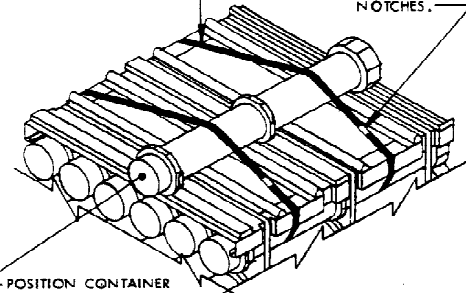
- (1) CROSS MEMBER (4 REQD). POSITION AT THE HEIGHTS AS SPECIFIED BY THE ISOMETRIC VIEW ABOVE. SEE GENERAL NOTES "D" AND "K" ON PAGE 2.
- (2) SPACER ASSEMBLY (2 REQD). SEE THE SPACER ASSEMBLY "B" DETAIL ON PAGE 18.
- (3) TIE WIRE, NO. 14 GAGE WIRE 30" LONG (8 REQD). INSTALL TO FORM A COMPLETE LOOP AROUND THE CROSS MEMBER AND THE SPACER ASSEMBLY. BRING ENDS TOGETHER AND TWIST TAUT. SECURE TO THE SPACER ASSEMBLY WITH A PARTIALLY DRIVEN 10d NAIL BENT OVER THE WIRE, OR WITH A STRAP STAPLE.

SPECIAL NOTES:

1. SHIPMENTS OF COMPLETE ROUNDS SHOULD CONSIST OF FULL-HIGHT AND FULL-LAYER UNITS TO THE MAXIMUM EXTENT POSSIBLE, HOWEVER, THE END OF A LOT, OR THE QUANTITY OF ITEMS NEEDED TO FILL A REQUISITION, MAY NECESSITATE THE SHIPMENT OF ONE OR MORE LEFTOVER CONTAINERS. LEFTOVER CONTAINERS ARE DESCRIBED AS A QUANTITY OF CONTAINERS WHICH IS INSUFFICIENT TO FORM A FULL-LAYERED PARTIAL UNIT FOR SECUREMENT ON TOP OF A FULL PALLET UNIT AS SHOWN ON PAGE 15.
2. SHIPMENT OF LEFTOVER CONTAINERS IS APPLICABLE FOR CONUS AND OCONUS MOTOR CARRIER SHIPMENTS FROM DEPOT TO DEPOT OR FROM DEPOT TO POSTS, CAMPS, AND STATIONS, OR UPON APPROVAL FROM HIGHER HEAD-QUARTERS, FOR SHIPMENTS FROM LOAD, ASSEMBLY, AND PACK PLANTS TO DEPOTS. CAUTION: A LOAD CONTAINING LEFTOVER CONTAINERS IN AN AMOUNT WHICH IS LESS THAN A FULL LAYER, AND SECURED TO THE TOP OF A FULL OR PARTIAL UNIT, MUST NOT BE DESTINED FOR SHIPMENT OVERSEAS BY WATER CARRIER.
3. THE PROCEDURES ON THIS PAGE ARE APPLICABLE FOR THE SHIPMENT OF LEFTOVER CONTAINERS IN ANY OF THE LOADS DEPICTED HEREIN.

UNITIZING STRAP, 1-1/4" X .031"
OR .035" X 9'-0" LONG STEEL
STRAPPING (2 REQD).

SEAL FOR 1-1/4" STRAP
(2 REQD), CRIMP EACH
SEAL WITH TWO PAIR OF
NOTCHES.

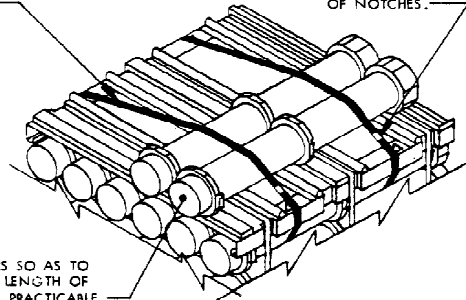


POSITION CONTAINER
SO AS TO BE CENTERED
ON THE LENGTH OF
THE UNIT AS NEAR AS
PRACTICABLE.

SECUREMENT OF ONE CONTAINER

UNITIZING STRAP, 1-1/4" X .031"
OR .035" X 9'-6" LONG STEEL
STRAPPING (2 REQD).

SEAL FOR 1-1/4" STRAP
(2 REQD), CRIMP EACH
SEAL WITH TWO PAIR
OF NOTCHES.



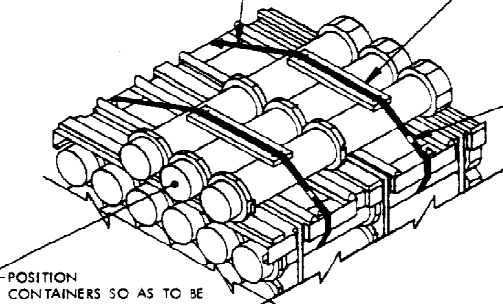
POSITION CONTAINERS SO AS TO
BE CENTERED ON THE LENGTH OF
THE UNIT AS NEAR AS PRACTICABLE.

SECUREMENT OF TWO CONTAINERS

UNITIZING STRAP, 1-1/4" X .031" OR .035"
X 10'-0" LONG STEEL STRAPPING (2 REQD),
STAPLE TO THE STRAPPING BOARD W/2
STAPLES AS APPLICABLE.

STRAPPING BOARD, 1" X 4" X 14" (2 REQD).
INCREASE THE LENGTH OF THE STRAPPING
BOARD BY 7" FOR EACH ADDITIONAL CONTAINER.

SEAL FOR 1-1/4" STRAP (2 REQD),
CRIMP EACH SEAL WITH
TWO PAIR OF NOTCHES.

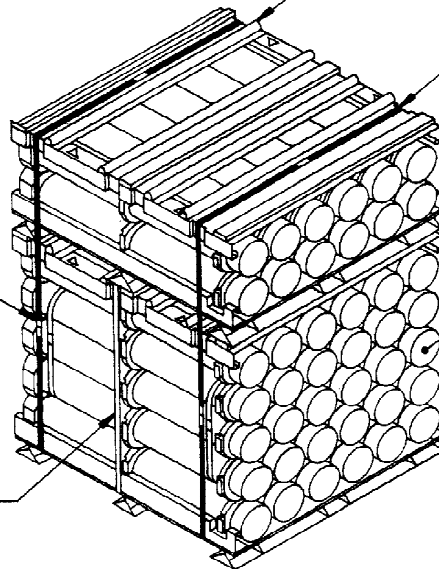


POSITION
CONTAINERS SO AS TO BE
CENTERED ON THE LENGTH
OF THE UNIT.

SECUREMENT OF THREE CONTAINERS

SEAL FOR 1-1/4" STEEL STRAPPING
(4 REQD, 2 PER STRAP). DOUBLE
CRIMP EACH SEAL. SEE GENERAL
NOTE "M" ON PAGE 2.

INDICATES TIEDOWN STRAP
ON THE FULL PALLETIZED UNIT.



INDICATES A TYPICAL 2-LAYER
PARTIAL PALLETIZED UNIT.

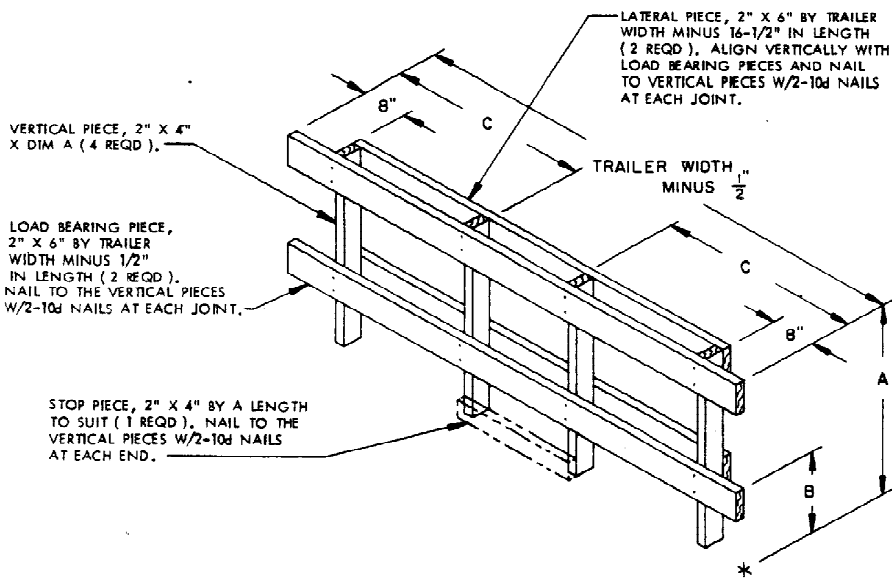
VERTICAL UNITIZING STRAP, 1-1/4" X .031"
OR .035" BY A LENGTH TO SUIT STEEL
STRAPPING (2 REQD). POSITION OVER THE
OUTER TIEDOWN STRAPS ON UNITS AS SHOWN.

INDICATES A TYPICAL PALLETIZED
UNIT AS SHOWN ON PAGE 3 OF
THIS DRAWING.

SECUREMENT OF A PARTIAL PALLET UNIT
ON TOP OF A FULL PALLET UNIT

SPECIAL NOTES:

1. THE VIEW SHOWN ABOVE DEPICTS A PARTIAL 2-LAYER PALLET UNIT POSITIONED ON TOP OF A FULL-HEIGHT PALLET UNIT AND UNITIZED WITH TWO VERTICAL UNITIZING STRAPS. PLACEMENT WITHIN THE LOAD IS OPTIONAL, EXCEPT THAT IT WILL NOT BE POSITIONED IN THE REAR LOAD UNIT, OR WITHIN A GROUP WHICH IS BUNDLED TOGETHER.
2. SHIPMENTS OF PALLET UNITS SHOULD CONSIST OF FULL-HEIGHT AND FULL-LAYER UNITS TO THE MAXIMUM EXTENT POSSIBLE. HOWEVER, THE END OF A LOT, OR THE QUANTITY OF ITEMS NEEDED TO FILL A REQUISITION MAY NECESSITATE THE SHIPMENT OF ONE OR MORE LESS-THAN-FULL PALLET UNITS WITHIN A LOAD. THE PROCEDURES ON THIS PAGE AND ON PAGE 14 ARE PRESENTED AS GUIDANCE IN THE SHIPMENT OF THESE PARTIAL UNITS.
3. THE "SHIPMENT OF A PARTIAL PALLET UNIT" PROCEDURES ON THIS PAGE ARE APPLICABLE FOR LOADS IN CONVENTIONAL TYPE VAN TRAILERS AND IN TRAILERS EQUIPPED WITH MECHANICAL BRACING DEVICES."
4. FOR SHIPMENT OF ONE THRU FIVE "LEFTOVER" CONTAINERS, SEE THE PROCEDURES ON PAGE 14 OF THIS DRAWING.



FORWARD BLOCKING CHART A

DIM	A	B	C
	36"	15"	36"

FORWARD BLOCKING CHART "A" IS USED FOR LENGTHWISE POSITIONED CONTAINERS AS SHOWN IN THE LOAD ON PAGE 4.

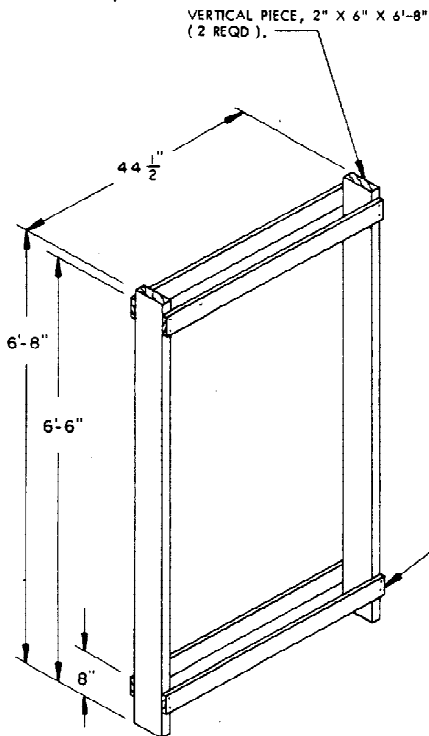
FORWARD BLOCKING CHART B

DIM	A	B	C
	39"	9"	41"

FORWARD BLOCKING CHART "B" IS USED FOR CROSSWISE POSITIONED CONTAINERS AS SHOWN IN THE LOAD ON PAGE 6. OMIT THE STOP PIECE ON "FORWARD BLOCKING ASSEMBLY".

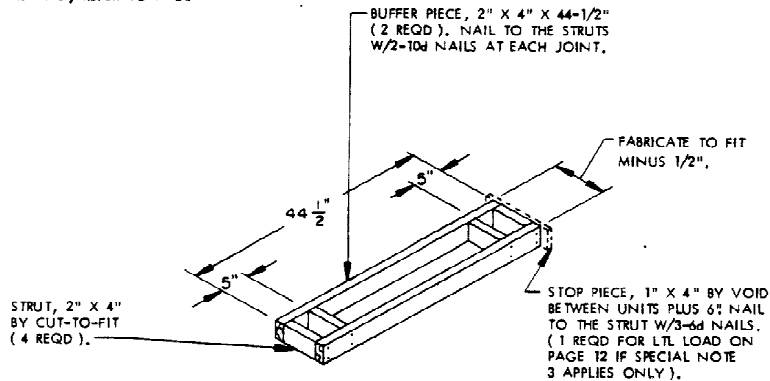
FORWARD BLOCKING ASSEMBLY

THIS ASSEMBLY IS DESIGNED FOR USE AT THE FRONT END OF A TRAILER HAVING ROUNDED CORNERS, AND IS APPLICABLE FOR A CORNER RADIUS OF NOT MORE THAN 6-1/2". IF THE RADIUS IS FROM 6-1/2" TO 8", 2" X 6" VERTICAL PIECES WILL BE USED IN LIEU OF THE 2" X 4" PIECES. IF THE TRAILER TO BE LOADED HAS LARGE-ANGLED CORNERS AT THE FORWARD END, REFER TO PAGE 22 FOR GUIDANCE.



CRIBS FILL A

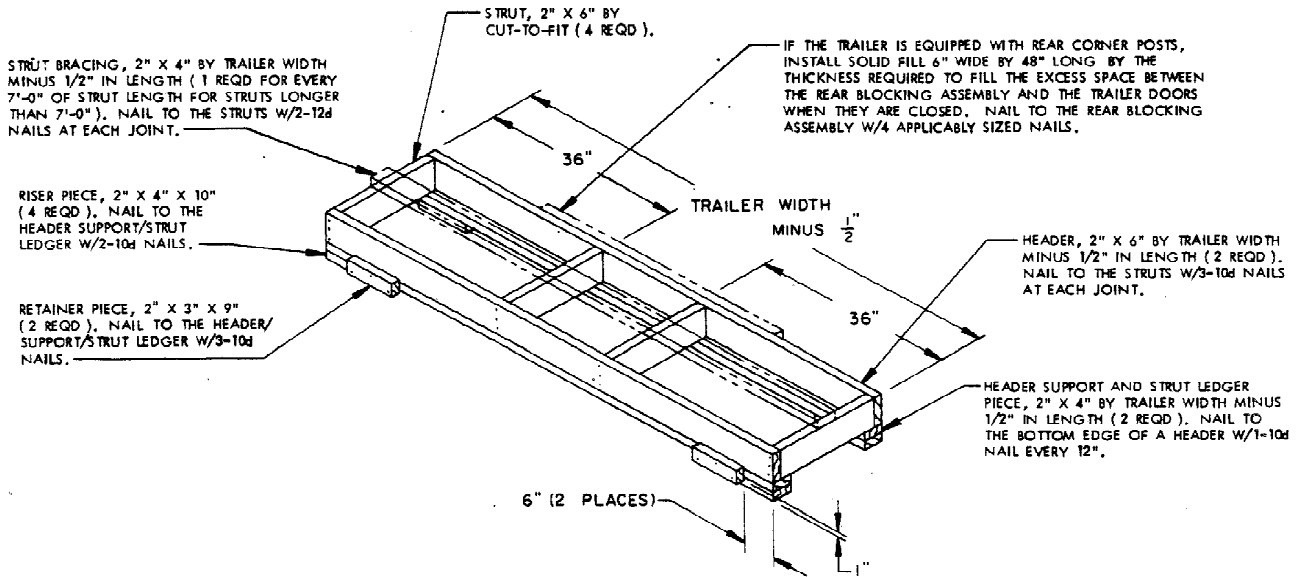
THE DEPICTED CRIBS FILL IS APPLICABLE FOR A 7'-8" WIDE TRAILER. IF A 7'-6" WIDE TRAILER IS TO BE LOADED, 2" X 4" VERTICAL PIECES MUST BE USED IN LIEU OF THE 2" X 6" PIECES. IF A TRAILER WIDER THAN 7'-8" IS USED, 2" X 4" HORIZONTAL PIECES MUST BE USED IN LIEU OF THE 1" X 4" PIECES.



ANTI-SWAY BRACE

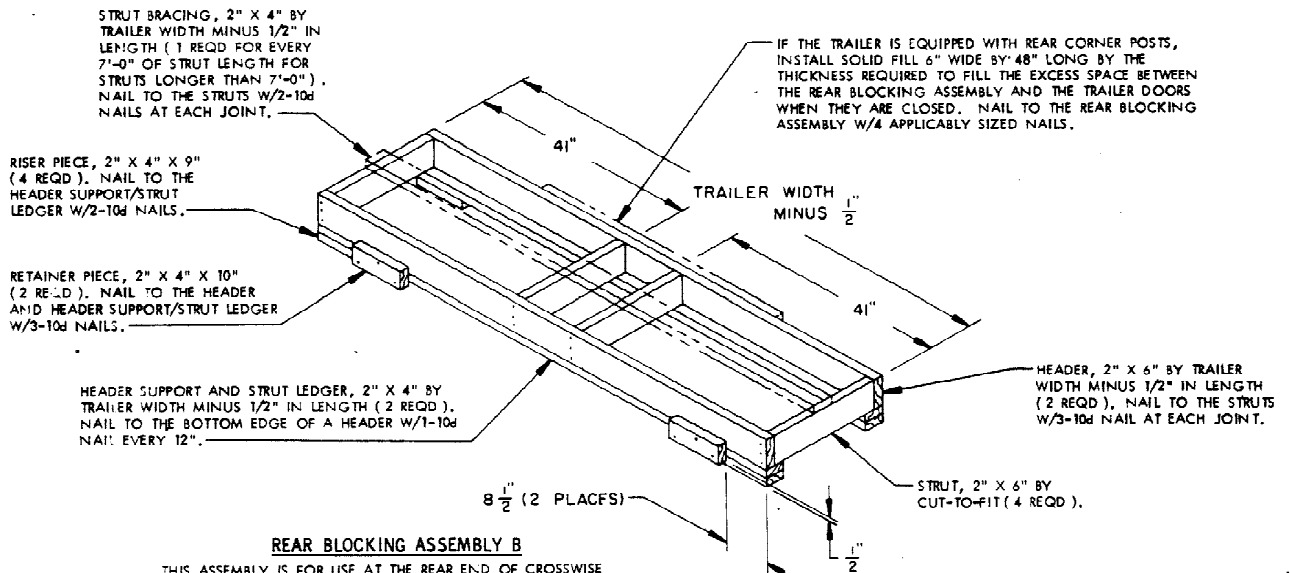
THIS ASSEMBLY IS DESIGNED FOR USE ON THE FLOOR BETWEEN LATERALLY ADJACENT PALLET UNITS. NOTE THAT AN ASSEMBLY NEED NOT BE CONSTRUCTED FOR A TIGHT FIT: UP TO ONE HALF INCH (1/2") IS PERMITTED.

HORIZONTAL PIECE, 1" X 4" X 44-1/2" (4 REQD). NAIL TO THE VERTICAL PIECES W/2-6d NAILS AT EACH END.



REAR BLOCKING ASSEMBLY A

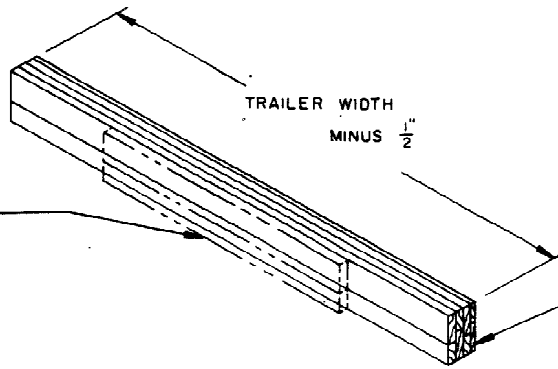
THIS ASSEMBLY IS FOR USE AT THE REAR END OF LENGTHWISE POSITIONED CONTAINERS WHEN THE SPACE BETWEEN THE LADING AND THE TRAILER DOORS IS GREATER THAN 9". NOTE THAT THE ABOVE VIEW IS ROTATED 180° FROM THE POSITION IN WHICH IT WILL BE INSTALLED.



REAR BLOCKING ASSEMBLY B

THIS ASSEMBLY IS FOR USE AT THE REAR END OF CROSSWISE POSITIONED CONTAINERS WHEN THE SPACE BETWEEN THE LADING AND THE TRAILER DOORS IS GREATER THAN 9". NOTE THAT THE ABOVE VIEW IS ROTATED 180° FROM THE POSITION IN WHICH IT WILL BE INSTALLED.

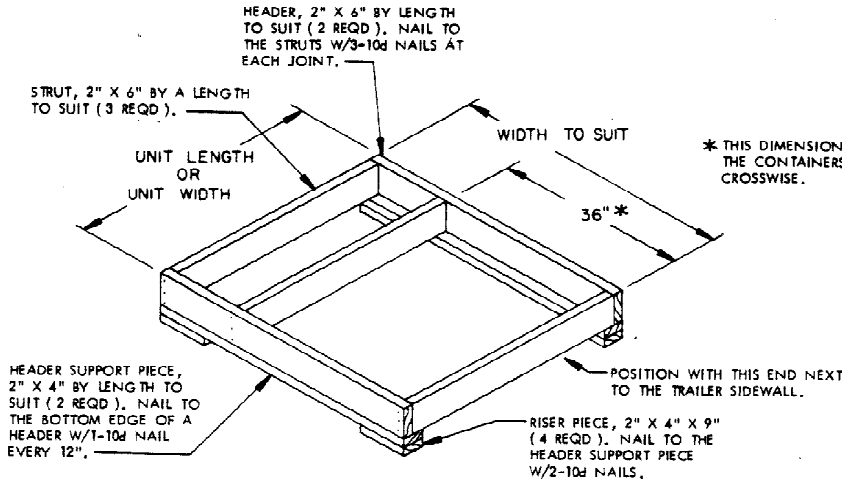
IF THE TRAILER IS EQUIPPED WITH REAR CORNER POSTS, INSTALL SOLID FILL, 4" AND 6" WIDE BY 48" LONG BY THE THICKNESS REQUIRED TO FILL THE EXCESS SPACE BETWEEN THE REAR BLOCKING AND THE REAR DOORS OF THE TRAILER WHEN THEY ARE CLOSED. POSITION PIECES ON EDGE, ONE ON TOP OF THE OTHER AS SHOWN, AND NAIL TO THE REAR BLOCKING W/4 APPLICABLE SIZED NAILS.



SOLID FILL, 4" AND 6" WIDE MATERIAL BY TRAILER WIDTH MINUS 1/2" IN LENGTH BY THE THICKNESS REQUIRED TO CONTACT REAR DOORS OF THE TRAILER WHEN THEY ARE CLOSED. POSITION PIECES ON EDGE, ONE ON TOP OF THE OTHER AS SHOWN, AND LAMINATE W/1-10d NAILS EVERY 12".

REAR BLOCKING ASSEMBLY C

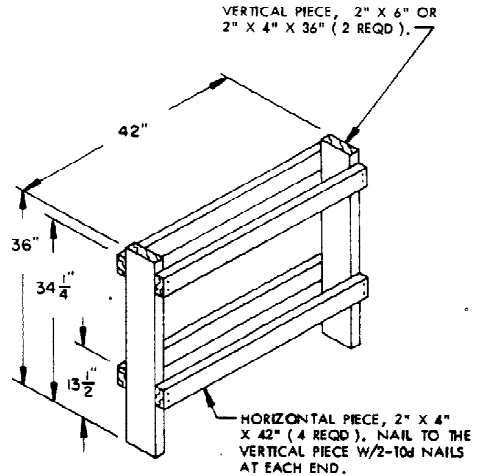
THIS REAR BLOCKING IS DESIGNED FOR USE AT THE REAR END OF A LOAD WHEN THE SPACE BETWEEN THE LADING AND THE TRAILER DOORS IS LESS THAN 9".



* THIS DIMENSION WILL BE 40" IF THE CONTAINERS ARE POSITIONED CROSSWISE.

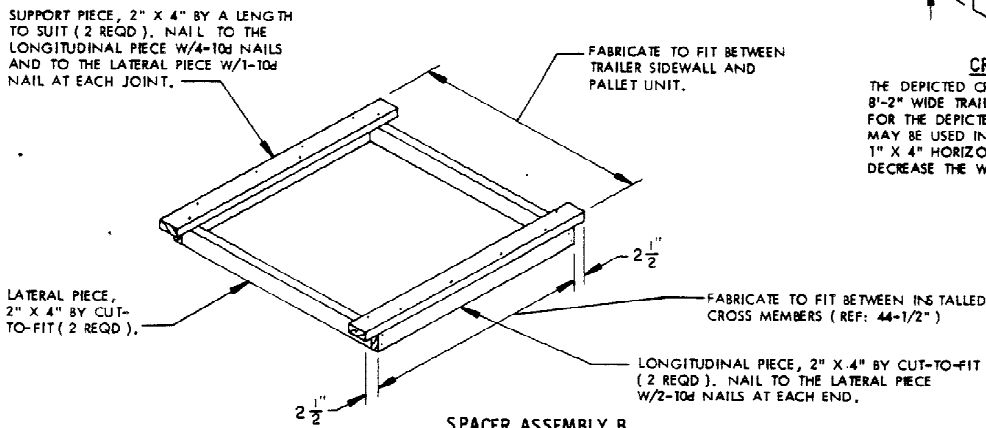
SPACER ASSEMBLY A

THIS ASSEMBLY IS DESIGNED FOR USE IN THE PLACE OF A PALLET UNIT WHICH IS OMITTED FROM THE LOAD IN A CONVENTIONAL VAN TRAILER, AS TYPICALLY SHOWN IN THE LOAD ON PAGE 10.



CRIB FILL B

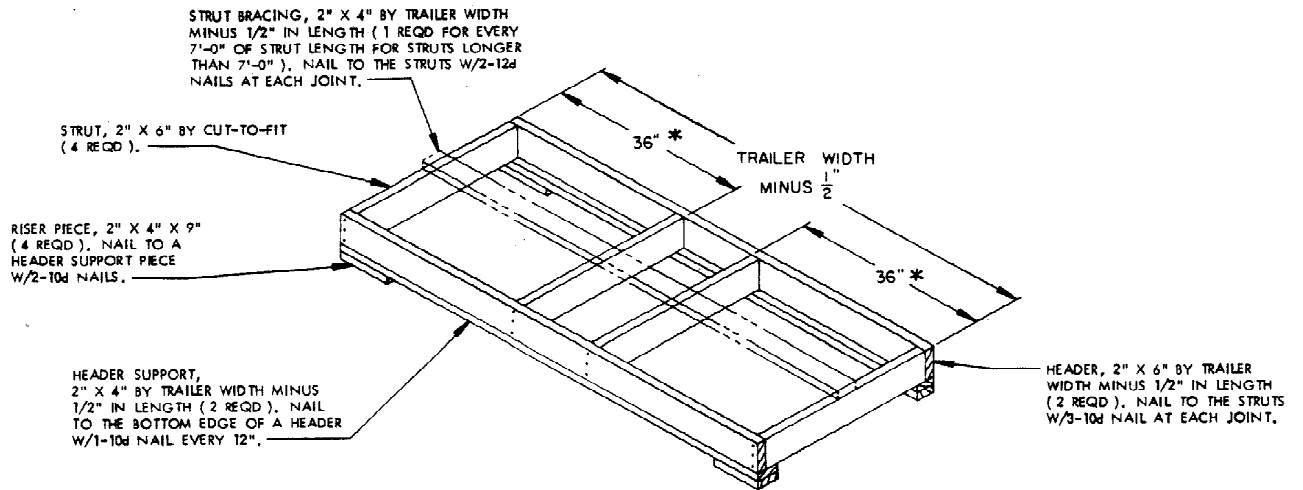
THE DEPICTED CRIB FILL IS APPLICABLE FOR AN 8'-2" WIDE TRAILER, IF NARROWER TRAILERS ARE USED FOR THE DEPICTED LOAD, 2" X 4" VERTICAL PIECES MAY BE USED IN LIEU OF WHAT IS SHOWN. ALSO, 1" X 4" HORIZONTAL PIECES MAY BE USED TO DECREASE THE WIDTH OF THE CRIB FILL.



SPACER ASSEMBLY B

THIS ASSEMBLY IS DESIGNED FOR USE AS LATERAL BRACING IN A TRAILER EQUIPPED WITH MECHANICAL BRACING DEVICES.

DETAILS

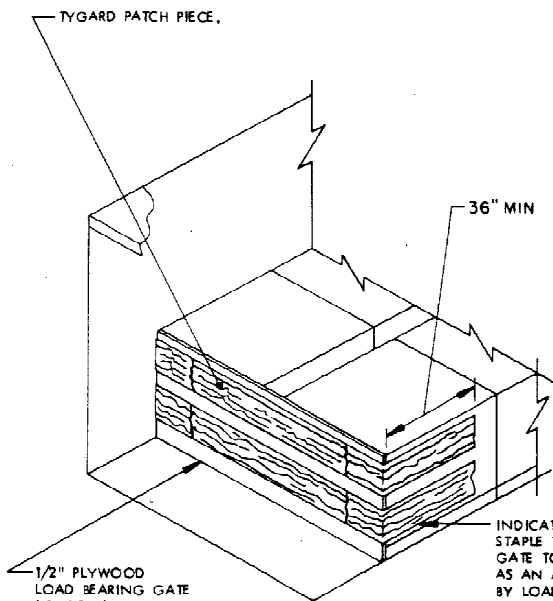


SPACER ASSEMBLY C

* THIS DIMENSION WILL BE 41" IF CONTAINERS ARE POSITIONED CROSSWISE IN THE TRAILER.

SPECIAL NOTES:

1. THE TYGARD METHOD OF REAR BLOCKING DEPICTED, CAN ONLY BE USED IN TRAILERS WHICH HAVE REASONABLY SMOOTH AND ADEQUATELY SECURED SIDEWALL PANELS IN THE AREA WHERE THE TYGARD MATERIAL IS TO BE APPLIED. NOTE THAT TYGARD MATERIAL MUST BE INSTALLED AT TWO LEVELS ON THE REAR LOAD UNIT.
2. A 48" HIGH PLYWOOD GATE MUST BE INSTALLED AT THE REAR OF THE LOAD TO PROVIDE A SMOOTH SURFACE FOR THE TYGARD MATERIAL TO EXTEND AROUND. IF THE REAR LOAD UNIT IS 2-WIDE INSTALL A GATE WHICH IS TRAILER WIDTH MINUS 1/2" IN LENGTH AS SHOWN BY THE "TYGARD METHOD A" DETAIL AT LEFT. IF THE REAR LOAD UNIT IS 1-WIDE, ROTATE THE PALLET, INSTALL ONE (1) PALLET WIDTH GATE, AND ONE (1) TRAILER WIDTH MINUS 1/2" IN LENGTH GATE, AS SHOWN BY THE "TYGARD METHOD B" DETAIL BELOW.
3. THE TYGARD MATERIAL AND THE ADHESIVE FOR ATTACHING IT ARE COMMERCIAL PRODUCTS. FOR A SOURCE OF SUPPLY, CONTACT WALNUT INDUSTRIES, INC., 1344 ADAMS ROAD, P.O. BOX "E", BENSALEM, PA 10920-0860, PHONE 1-800-523-6536. APPLICATION INSTRUCTIONS AND GUIDANCE CAN ALSO BE OBTAINED FROM THAT OFFICE.
4. THE TYGARD METHOD, ALTHOUGH ESPECIALLY FOR TRAILERS HAVING ROLL-UP TYPE DOORS, MAY ALSO BE USED IN TRAILERS EQUIPPED WITH HINGED DOORS.
5. NOTICE: IF THE AREA OF A SIDEWALL WHERE THE TYGARD SHOULD BE ATTACHED IS ROUGH AND/OR BROKEN, THE APPLICABLE PIECE (S) OF TYGARD CAN BE LENGTHENED A SUITABLE AMOUNT AND ATTACHED TO THE SIDEWALL AHEAD OF THE INDICATED PREFERRED LOCATION.



INDICATES TYGARD MATERIAL, STAPLE TO THE LOAD BEARING GATE TO PREVENT SAGGING. AS AN ALTERNATIVE, A 1" X 4" BY LOAD HEIGHT PIECE MAY BE NAILED THRU THE TYGARD MATERIAL INTO THE LOAD BEARING GATE. CAUTION: PLACE 1" X 4" SO AS TO BE ALIGNED WITH THE VOID BETWEEN THE ROWS OF PALLET UNITS.

TYGARD METHOD A

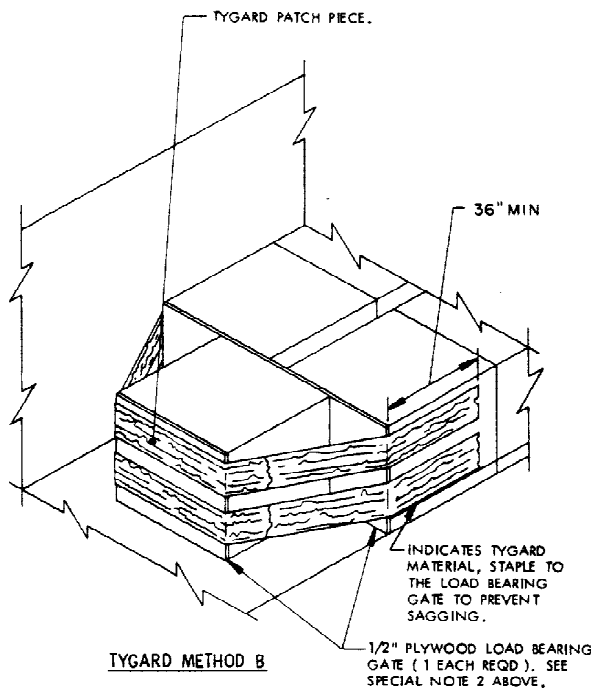
RECOMMENDED EQUIPMENT/INSTALLATION PROCEDURES

EQUIPMENT REQUIRED

- PAINT ROLLER, LATEX
- PAINT ROLLER PAN
- TENSIONING ROD/TOOL
- PRESSURE ROLLER
- RATCHET WRENCH (12" TO 15" HANDLE)
- OPEN END OR BOX WRENCH (12" TO 15" HANDLE)
- SCISSORS OR KNIFE
- TYGARD (15" WIDE ROLL)
- TYGARD ADHESIVE

BASIC INSTALLATION GUIDANCE

1. CUT TO LENGTH THE REQUIRED NUMBER OF TYGARD PIECES (FROM 2 TO 8 DEPENDING UPON THE LOAD CONFIGURATION) FOR ATTACHMENT TO THE TRAILER SIDEWALL. PIECES WILL BE OF A LENGTH AS REQUIRED TO PROVIDE PROPER BONDING TO THE TRAILER SIDEWALL AND TO EXTEND 60" ACROSS THE REAR OF THE LOAD. ALSO, CUT 72" LONG "PATCH" PIECES OF TYGARD MATERIAL, ONE FOR EACH SET OF TWO PIECES PREVIOUSLY CUT.
2. PRIOR TO POSITIONING OF THE PALLETS IN THE REARMOST LOAD UNIT, APPLY TYGARD ADHESIVE TO THE PROPER PORTIONS OF THE TRAILER SIDEWALLS AND TO THE CORD SIDE OF A CORRESPONDING LENGTH OF EACH OF THE TYGARD PIECES THAT ARE TO BE ATTACHED TO THE SIDEWALLS OF THE TRAILER. ALLOW TIME FOR THE ADHESIVE TO "CURE" BEFORE PLACING A STRIP OF TYGARD ONTO A SIDEWALL (ADHESIVE WILL FEEL ALMOST DRY WHEN TOUCHED). NOTE: APPLICATION OF TYGARD IS SIMILAR TO THE APPLICATION OF "FORMICA".
3. APPLY THE TYGARD PIECES TO EACH SIDEWALL OF THE TRAILER SO THAT THE PIECES ARE PARALLEL OR NEARLY PARALLEL TO THE FLOOR. ROLL THE TYGARD WITH THE PRESSURE ROLLER TO ENSURE PROPER BONDING IS ACHIEVED. TEMPORARILY SECURE THE LOOSE ENDS TO THE TRAILER SIDEWALL OR TO AN OPEN HINGED TYPE DOOR OR TO THE OUTSIDE WALL, AS APPLICABLE.
4. POSITION THE PALLETS OF THE REARMOST LOAD UNIT INTO THE TRAILER AND INSTALL THE SPECIFIED ANTI-SWAY BRACES OR CRIB FILL, AS APPLICABLE.
5. UNDO THE PREVIOUSLY SECURED LOOSE ENDS AND BRING A SET OF TWO PIECES TOGETHER ACROSS THE REAR OF THE LOAD. POSITION THE TENSIONING ROD SO THAT THE LOOSE ENDS OF THE TYGARD MATERIAL EXTEND THRU THE SLOT IN ROD. USING THE TWO WRENCHES, ROLL UP THE TYGARD TO TENSION IT ACROSS REAR OF THE LOAD. POSITION A WRENCH SO AS TO MAINTAIN THE TENSION IN THE TYGARD PIECES. CUT OFF AND DISCARD EXCESS MATERIAL FROM ONE PIECE OF THE TYGARD.
6. APPLY TYGARD ADHESIVE TO THE TENSIONED TYGARD PIECES AND ALSO TO THE CORD SIDE OF THE PREVIOUSLY CUT "PATCH" PIECE. APPLY THE "PATCH" AND ROLL WITH THE PRESSURE ROLLER TO ENSURE PROPER BONDING.

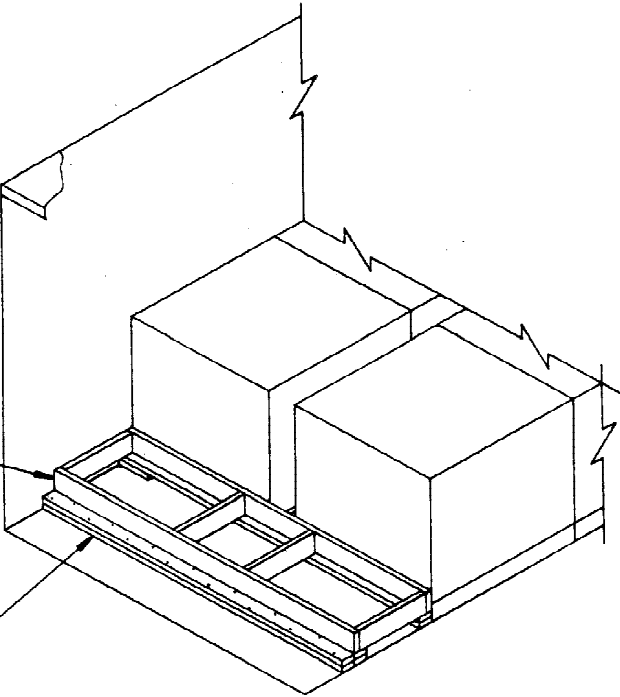


INDICATES TYGARD MATERIAL, STAPLE TO THE LOAD BEARING GATE TO PREVENT SAGGING.

TYGARD METHOD B

1/2" PLYWOOD LOAD BEARING GATE (1 EACH REQD). SEE SPECIAL NOTE 2 ABOVE.

TYGARD METHOD PROCEDURES FOR CONVENTIONAL VAN TRAILERS EQUIPPED WITH ROLL-UP TYPE DOORS



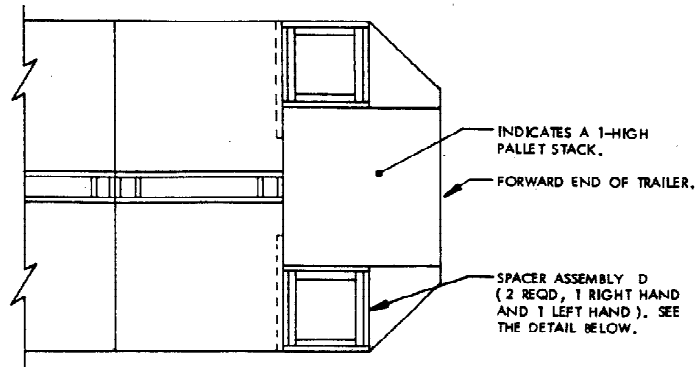
REAR BLOCKING ASSEMBLY (1 REQD).
SEE SPECIAL NOTE 2 BELOW.

HEADER, 2" X 4" BY TRAILER WIDTH
MINUS 1/2" IN LENGTH (DOUBLED)
(1 REQD). POSITION AGAINST THE
REAR BLOCKING ASSEMBLY. NAIL
THE FIRST PIECE TO THE TRAILER FLOOR
W/15-10d NAILS (1 EVERY 6"). NAIL
THE SECOND PIECE TO THE FIRST IN A
LIKE MANNER AND TOENAIL TO THE
REAR BLOCKING ASSEMBLY W/4-10d
NAILS.

NAILED-HEADER METHOD

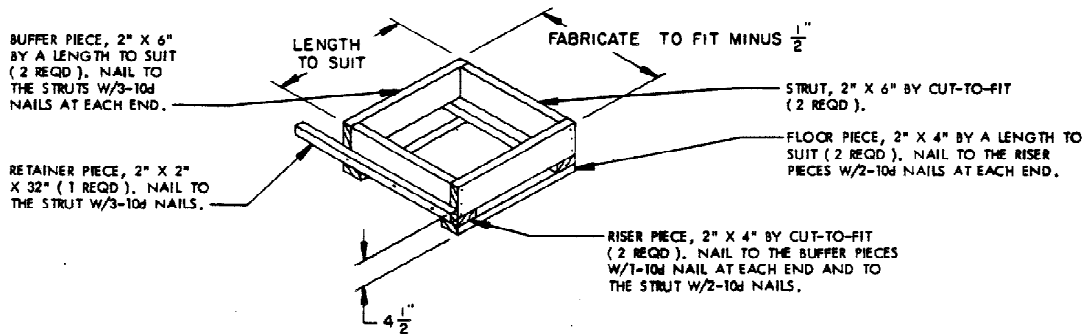
SPECIAL NOTES:

1. THE NAILED-HEADER METHOD OF REAR BLOCKING DEPICTED ABOVE CAN ONLY BE USED IN TRAILERS HAVING A NAILABLE FLOOR AREA BETWEEN THE LADING AND THE METAL THRESHOLD, OR A THRESHOLD PLATE IF THE TRAILER IS SO EQUIPPED, OF AT LEAST FOURTEEN INCHES (14").
2. REAR BLOCKING ASSEMBLY "A" IS SHOWN FOR A TYPICAL INSTALLATION. CONSTRUCT THE ASSEMBLY USING 6" (MINIMUM) LONG STRUTS.
3. THE NAILED-HEADER METHOD OF REAR BLOCKING IS ADEQUATE FOR THE RETENTION OF THE MAXIMUM WEIGHT LOAD.
4. THE NAILED-HEADER METHOD, ALTHOUGH DESIGNED ESPECIALLY FOR TRAILERS HAVING ROLL-UP TYPE DOORS, MAY ALSO BE USED IN TRAILERS EQUIPPED WITH HINGED DOORS.



ALTERNATIVE FORWARD LOADING PATTERN

THIS PROCEDURE IS APPLICABLE TO THE LOADING OF ONE (1) PALLET UNIT IN THE FORWARD END OF A CONVENTIONAL VAN TRAILER HAVING LARGE ANGLED FRONT CORNERS (REF: 18°). THE PROCEDURES MAY ALSO BE USED IN TRAILERS HAVING SQUARE CORNERS, OR ROUNDED FRONT CORNERS, OR ANGLED CORNERS OF ANOTHER SIZE.



SPACER ASSEMBLY D

THIS ASSEMBLY IS DESIGNED FOR LATERAL BRACING OF A SINGLE PALLET UNIT WHICH IS TURNED 90° FROM THE NORMAL LOADING ORIENTATION AND POSITIONED IN THE FRONT OF AN ANGLED CORNER CONVENTIONAL VAN TRAILER AS SHOWN IN THE "ALTERNATIVE LOADING PATTERN" VIEW ABOVE. RIGHT HAND AND LEFT HAND SPACER ASSEMBLIES ARE REQUIRED.