

APPROVED BY  
BUREAU OF EXPLOSIVES

*J m Hest*

DATE 6/4/2000

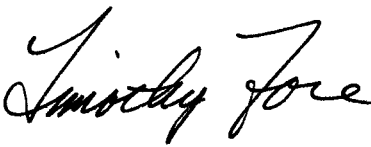

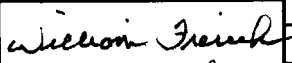

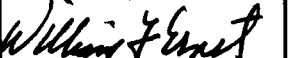
# LOADING AND BRACING\* IN END OPENING ISO CONTAINERS OF MK82 (500 POUND) BOMBS ON MK9 METAL PALLETS

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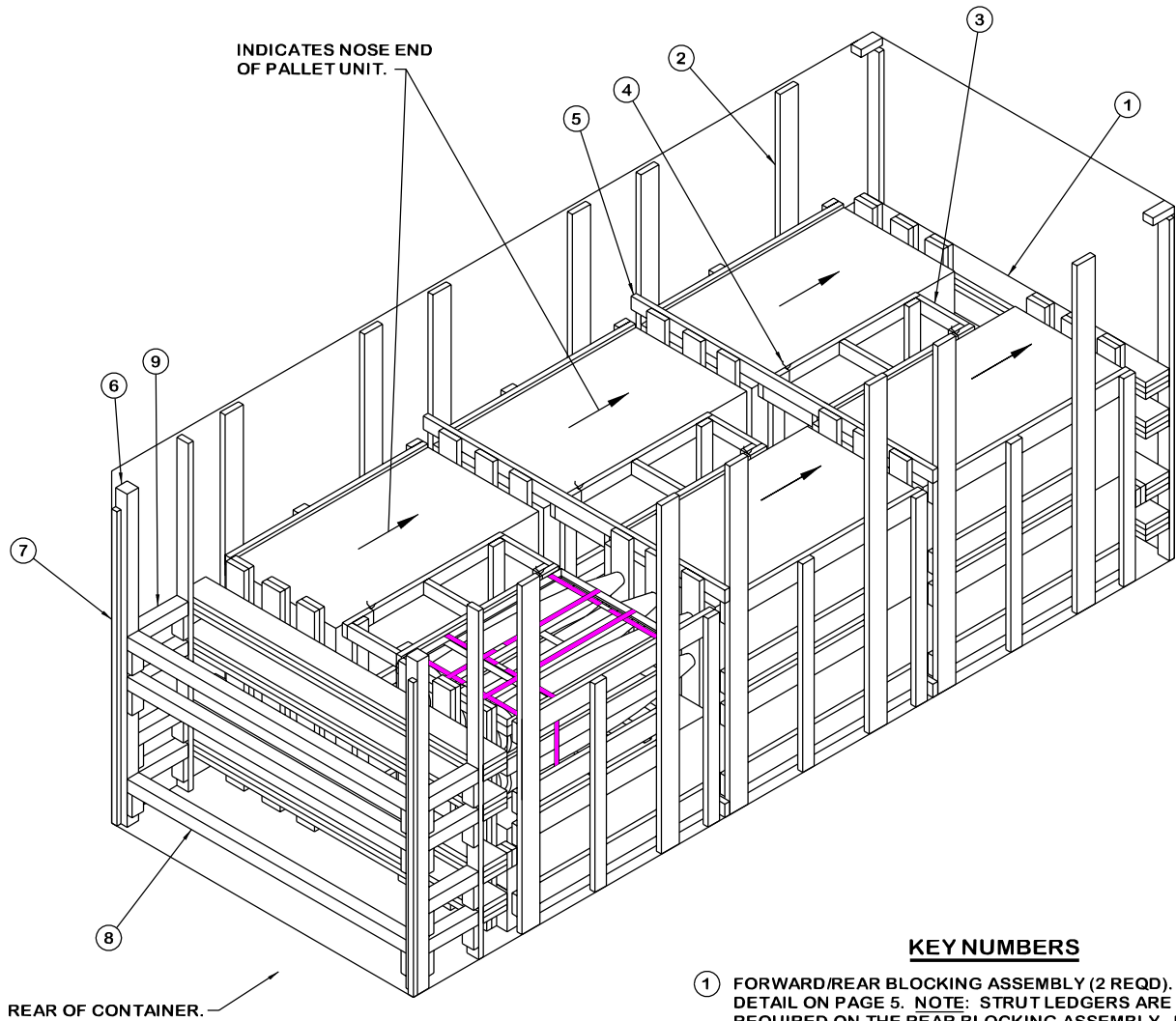
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\* LOADING AND BRACING SPECIFICATIONS SET FORTH WITHIN THIS DRAWING ARE APPLICABLE TO LOADS THAT ARE TO BE SHIPPED BY TRAILER/CONTAINER-ON-FLATCAR (T/COFC) RAIL CARRIER SERVICE. THESE SPECIFICATIONS MAY ALSO BE USED FOR LOADS THAT ARE TO BE MOVED BY MOTOR OR WATER CARRIERS.

## U.S. ARMY MATERIEL COMMAND DRAWING

APPROVED, U.S. ARMY INDUSTRIAL OPERATIONS COMMAND  	ENGINEER	BASIC	LAURA FIEFFER	DO NOT SCALE			
		REV.		WEBSITE: <a href="http://www.dac.army.mil">HTTP://WWW.DAC.ARMY.MIL</a>			
	TECHNICIAN	BASIC		JULY 1999			
	REV.						
	DRAFTSMAN	BASIC					
		REV.					
APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND   U.S. ARMY DEFENSE AMMUNITION CENTER	TRANSPORTATION ENGINEERING DIVISION						
	VALIDATION ENGINEERING DIVISION		 TESTED	CLASS	DIVISION	DRAWING	FILE
	LOGISTICS ENGINEERING OFFICE			19	48	4313	15PB1010

PROJECT CA 333-98



INDICATES NOSE END OF PALLET UNIT.

REAR OF CONTAINER.

**ISOMETRIC VIEW**

**LOAD AS SHOWN**

ITEM	QUANTITY	WEIGHT (APPROX)
PALLET UNIT	12	39,936 LBS
DUNNAGE		1,874 LBS
CONTAINER		4,700 LBS
<b>TOTAL WEIGHT</b>		<b>46,510 LBS (APPROX)</b>

**KEY NUMBERS**

- ① FORWARD/REAR BLOCKING ASSEMBLY (2 REQD). SEE THE DETAIL ON PAGE 5. NOTE: STRUT LEDGERS ARE ONLY REQUIRED ON THE REAR BLOCKING ASSEMBLY. DO NOT INSTALL STRUT LEDGERS ON THE FORWARD BLOCKING ASSEMBLY.
- ② SIDE FILL ASSEMBLY (6 REQD). SEE THE DETAIL ON PAGE 6.
- ③ CENTER FILL ASSEMBLY (3 REQD). SEE THE DETAIL ON PAGE 6.
- ④ TIE WIRE, 24" LONG (6 REQD, 2 PER CENTER FILL ASSEMBLY). INSTALL THE WIRE TO FORM A COMPLETE LOOP AROUND THE LONGITUDINAL PIECE OF THE CENTER FILL ASSEMBLY AND THE PALLET FRAME.
- ⑤ SEPARATOR GATE (2 REQD). SEE THE DETAIL ON PAGE 5.
- ⑥ DOOR POST VERTICAL (2 REQD). SEE THE DETAIL ON PAGE 7, AND "DETAIL A" AND "DETAIL B" ON PAGE 9.
- ⑦ DOOR POST VERTICAL RETAINER (2 REQD). SEE THE DETAIL ON PAGE 10. NAIL THROUGH THE HOLES INTO THE DOOR POST VERTICAL W/4-10d NAILS.
- ⑧ DOOR SPANNER, 4" X 4" MATERIAL, CUT TO A LENGTH THAT WILL PROVIDE FOR A DRIVE FIT (REF: 7'-1-3/8") (3 REQD). TOENAIL TO THE DOOR POST VERTICAL W/2-12d NAILS AT EACH END. SEE THE "BEVEL-CUT" DETAIL ON PAGE 4.
- ⑨ STRUT, 4" X 4" BY CUT-TO-FIT (REF: 15-1/8") (8 REQD). TOENAIL TO THE BUFFER PIECE OF THE REAR BLOCKING ASSEMBLY AND THE DOOR POST VERTICAL W/2-12d NAILS AT EACH END. SEE THE "BEVEL-CUT" DETAIL ON PAGE 4.

**BILL OF MATERIAL**

LUMBER	LINEAR FEET	BOARD FEET
2" X 4"	326	217
2" X 6"	377	377
2" X 8"	182	243
4" X 4"	47	62
NAILS	NO. REQD	POUNDS
10d (3")	1,012	15-3/4
12d (3-1/4")	44	3/4
WIRE, .0800" DIA	12' REQD	0.20 LBS
DOOR POST VERTICAL RETAINER	2 REQD	64 LBS

(GENERAL NOTES CONTINUED)

- H. WHETHER A CONTAINER IS FULL OR IS LOADED WITH A REDUCED QUANTITY OF LADING UNITS, THE LENGTHWISE CENTER OF GRAVITY OF THE LOAD MUST BE WITHIN 12", IN EITHER DIRECTION, OF THE MID-POINT OF THE CONTAINER.
- J. CAUTION: DO NOT NAIL DUNNAGE MATERIAL TO THE CONTAINER WALLS OR FLOOR. ALL NAILING WILL BE WITHIN THE DUNNAGE.
- K. PORTIONS OF THE CONTAINER DEPICTED WITHIN THIS DRAWING, SUCH AS THE SIDEWALL, HAVE NOT BEEN SHOWN IN THE LOAD VIEWS FOR CLARITY PURPOSES.
- L. MAXIMUM LOAD WEIGHT CRITERIA:  
  
THE MAXIMUM LOAD WEIGHTS ARE CONTROLLED BY EQUIPMENT CAPABILITY FACTORS. ALTHOUGH THE HEAVIEST MAXIMUM LOADS ARE DELINEATED IN THE LOAD VIEWS, PROVISIONS ARE INCLUDED WITHIN THIS DRAWING SO THAT THE BASIC LOADS CAN BE ADJUSTED TO SATISFY A LESSER QUANTITY OF LADING UNITS. DEPENDING ON TRANSPORTATION ROUTING, IT MAY BE NECESSARY TO REDUCE THE LOAD WEIGHT TO SATISFY "WEIGHT LAWS" OF CERTAIN STATES. ALSO, IT MAY BE NECESSARY TO REDUCE THE LOAD WEIGHT TO SATISFY OTHER WEIGHT RESTRICTIONS IMPOSED ON THE INTERMODAL CONTAINER SYSTEM.
- M. REQUIREMENTS CITED WITHIN THE ASSOCIATION OF AMERICAN RAILROADS (AAR) INTERMODAL LOADING GUIDE APPLY WHEN THE SHIPMENT MOVES BY TRAILER/CONTAINER-ON-FLATCAR (T/COFC). SPECIAL T/COFC NOTES FOLLOW:
  - 1. A LOADED CONTAINER MUST BE ON A CHASSIS EQUIPPED WITH TWO BOGIE ASSEMBLIES WHEN BEING MOVED IN TOFC SERVICE.
  - 2. THE LOAD LIMIT OF A T/COFC RAILCAR MUST NOT BE EXCEEDED, NOR WILL A CAR BE LOADED SO THAT THE TRUCK UNDER ONE END OF THE CAR CARRIES MORE THAN ONE-HALF OF THE LOAD LIMIT FOR THAT CAR.
- N. DURING INTRASTATE AND/OR INTERSTATE MOVES BY MOTOR CARRIER, A PROPER CHASSIS OR MODIFIED FLATBED TRAILER MUST BE USED TO PRECLUDE VIOLATION OF ONE OR MORE "WEIGHT LAWS" APPLICABLE TO THE STATE OR STATES INVOLVED.
- O. 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 25.4MM AND ONE POUND EQUALS 0.454 KG.
- P. THE QUANTITY OF PALLET UNITS SHOWN IN THE LOAD ON PAGE 2 MAY BE REDUCED FOR SHIPMENT, IF DESIRED. SEE THE "LESS-THAN-FULL-LOAD" DETAILS ON PAGE 10.

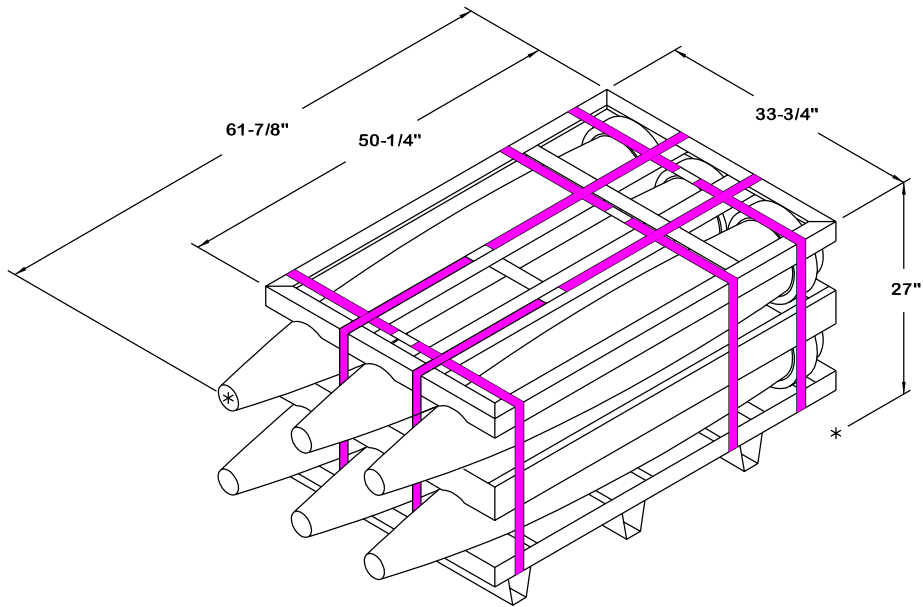
GENERAL NOTES

- A. THIS DOCUMENT HAS BEEN PREPARED AND ISSUED IN ACCORDANCE WITH AR 740-1 AND AUGMENTS TM 743-200-1 (CHAPTER 5).
- B. THE SPECIFIED OUTLOADING PROCEDURES ARE APPLICABLE TO LOADS OF MK82 (500 POUND) BOMBS ON MK9 METAL PALLETS. SUBSEQUENT REFERENCE TO PALLET UNIT HEREIN MEANS THE MK9 METAL PALLET WITH MK82 BOMBS INSTALLED. SEE PAGE 4 AND WR-54/31 FOR DETAILS OF THE PALLET UNIT. CAUTION: REGARDLESS OF THE QUANTITY OF CONTAINERS TO BE SHIPPED, THE "MAXIMUM GROSS WEIGHT" OF THE END OPENING ISO CONTAINER MUST NOT BE EXCEEDED.
- C. THE LOAD AS SHOWN IS BASED ON A 4,700 POUND 20' LONG BY 8' WIDE BY 8'-6" HIGH END OPENING ISO CONTAINER WITH INSIDE DIMENSIONS OF 19'-4" LONG BY 92" WIDE BY 93" HIGH, WITH A MAXIMUM GROSS WEIGHT OF 52,910 POUNDS. OLDER/OTHER CONTAINERS MAY HAVE A TOTAL INSIDE HEIGHT OF 95", BUT A CLEAR HEIGHT UNDER THE ROOF BOWS OF 93". VERIFY INSIDE CONTAINER HEIGHT PRIOR TO FABRICATING DUNNAGE. THE LOAD IS DESIGNED FOR TRAILER/CONTAINER-ON-FLATCAR (T/COFC) SHIPMENT, HOWEVER, THE LOAD AS DESIGNED CAN ALSO BE MOVED BY OTHER SURFACE MODES OF TRANSPORT. NOTICE: OTHER CONTAINERS OF THE SAME DESIGN CONFIGURATION CAN BE USED.
- D. WHEN LOADING PALLET UNITS, THEY ARE TO BE POSITIONED SO AS TO ACHIEVE A TIGHT LOAD (TIGHT AGAINST THE DUNNAGE ASSEMBLIES). THE UNBLOCKED SPACE ACROSS THE WIDTH OF A LOAD BAY IS NOT TO EXCEED 1-1/2". EXCESSIVE SLACK CAN BE ELIMINATED FROM A LOAD BY LAMINATING ADDITIONAL PIECES OF APPROPRIATE THICKNESS TO THE LONGITUDINAL PIECES ON THE CENTER FILL ASSEMBLIES. NAIL EACH ADDITIONAL PIECE W/1 APPROPRIATELY SIZED NAIL EVERY 12". ADDITIONALLY, THE LENGTH OF THE LATERAL PIECES IN THE CENTER FILL ASSEMBLIES MAY BE ADJUSTED AS REQUIRED TO FACILITATE VARIANCE IN THE SIZE OF THE PALLET UNIT.
- E. DUNNAGE LUMBER SPECIFIED IS OF NOMINAL SIZE. FOR EXAMPLE, 1" X 4" MATERIAL IS ACTUALLY 3/4" THICK BY 3-1/2" WIDE AND 2" X 6" MATERIAL IS ACTUALLY 1-1/2" THICK BY 5-1/2" WIDE.
- F. A STAGGERED NAILING PATTERN WILL BE USED WHENEVER POSSIBLE WHEN NAILS ARE DRIVEN INTO JOINTS OF DUNNAGE ASSEMBLIES OR WHEN LAMINATING DUNNAGE. 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.
- G. IN SOME CONTAINERS THERE IS A SLOT AT THE CORNERS OF THE FORWARD WALL. PIECES OF DUNNAGE MATERIAL MUST BE LAMINATED TO THE BUFFER PIECES ON THE FORWARD BLOCKING ASSEMBLY TO PROVIDE A FLAT SURFACE FOR THE BUFFER PIECES. A PIECE OF 2" X 4", 2" X 3" OR A SPECIAL WIDTH PIECE CUT-TO-FIT CAN BE USED. THIS FILL PIECE WILL BE NAILED WITH ONE APPROPRIATELY SIZED NAIL EVERY 12". NOTE THAT SOME CONTAINERS ARE EQUIPPED WITH "TIE-BARS" IN THE CORNER SLOT, WHICH PRECLUDE THE USE OF A FULL HEIGHT FILL PIECE. WHEN "TIE-BARS" ARE PRESENT, THE FILL PIECE MUST BE INSTALLED IN SEGMENTS DESIGNED TO FIT BETWEEN THE "TIE-BARS" VERTICALLY. THE FILL PIECE(S) IS NOT REQUIRED WHEN THE CORNER PORTIONS OF THE CONTAINER FORWARD WALL ARE SMOOTH AND FLAT. DO NOT ALLOW ANY DUNNAGE ASSEMBLY TO CONTACT THE CONTAINER FORWARD WALL, ONLY THE CORNER POSTS OF THE CONTAINER SHOULD BE USED FOR FORWARD LONGITUDINAL BLOCKING.

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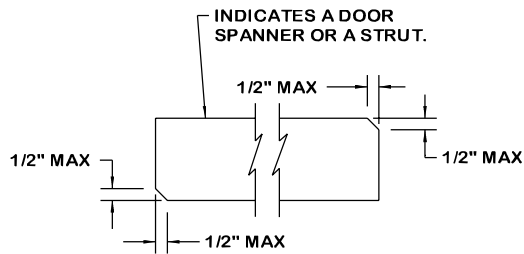
MATERIAL SPECIFICATIONS

- LUMBER - - - - - : SEE TM 743-200-1 (DUNNAGE LUMBER) AND VOLUNTARY PRODUCT STANDARD PS 20.
- NAILS - - - - - : ASTM F1667; COMMON STEEL NAIL (NLCMS OR NLCMS).
- WIRE, CARBON STEEL - : ASTM A853; ANNEALED AT FINISH, BLACK OXIDE FINISH, .0800" DIA, GRADE 1006 OR BETTER.
- STEEL, STRUCTURAL - : ASTM A501, STEEL STRUCTURAL TUBING; AND ASTM A570, STEEL, STRIP, HOT-ROLLED, GRADE 36 (MINIMUM).



**PALLET UNIT**

GROSS WEIGHT - - 3,228 POUNDS (APPROX)  
 CUBE - - - - - 32.6 CUBIC FEET (APPROX)



**BEVEL-CUT**

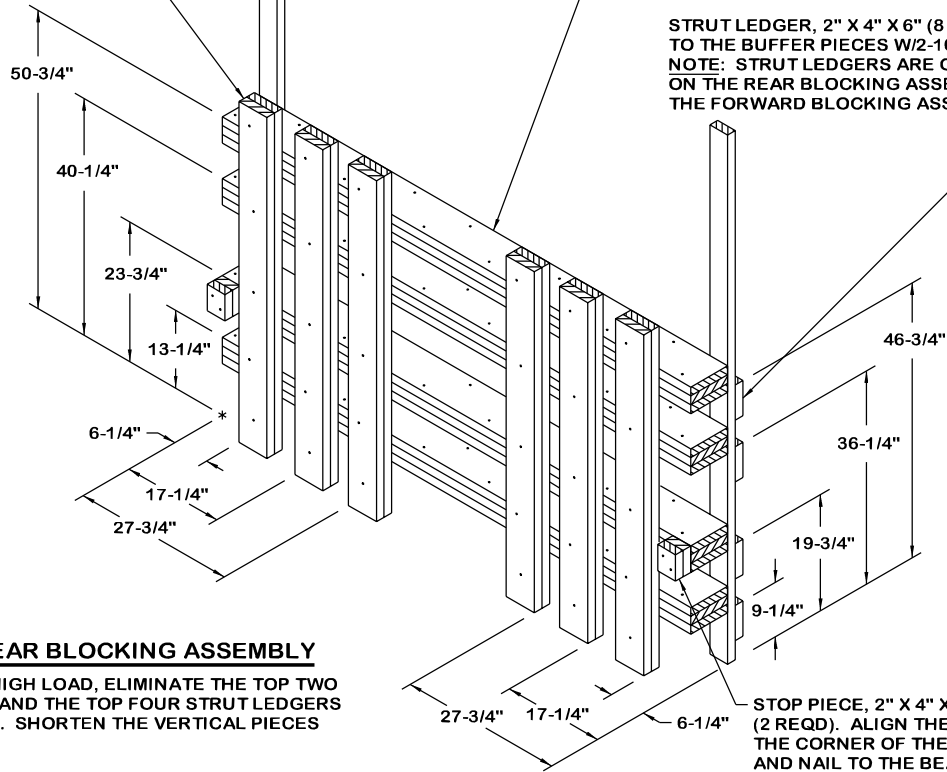
IF DESIRED, EACH END OF A DOOR SPANNER  
 PIECE OR A STRUT MAY BE BEVEL-CUT AS  
 SHOWN ABOVE TO FACILITATE THE ACHIEVEMENT  
 OF A TIGHT DOOR-POST-TO-DOOR-POST OR REAR-  
 BLOCKING-ASSEMBLY-TO-DOOR-POST FIT.

VERTICAL PIECE, 2" X 6" X 58" (DOUBLED) (6 REQD). NAIL THE FIRST PIECE TO THE BEAM ASSEMBLIES W/2-10d NAILS AT EACH JOINT. LAMINATE THE SECOND PIECE TO THE FIRST W/5-10d NAILS.

BUFFER PIECE, 2" X 4" BY INSIDE CONTAINER HEIGHT MINUS 1" (REF: 7'-6" UNDER CORNER BLOCKS, 7'-8" ELSEWHERE) (2 REQD). NAIL TO THE BEAM ASSEMBLIES W/3-10d NAILS AT EACH JOINT. SEE GENERAL NOTE "G" ON PAGE 3.

BEAM ASSEMBLY, 2" X 8" BY INSIDE CONTAINER WIDTH MINUS 1" (REF: 7'-7") (TRIPLED) (4 REQD). LAMINATE THE FIRST PIECE TO THE SECOND W/11-10d NAILS. LAMINATE THE THIRD PIECE IN A LIKE MANNER.

STRUT LEDGER, 2" X 4" X 6" (8 REQD). NAIL TO THE BUFFER PIECES W/2-10d NAILS EACH. NOTE: STRUT LEDGERS ARE ONLY REQUIRED ON THE REAR BLOCKING ASSEMBLY, NOT ON THE FORWARD BLOCKING ASSEMBLY.

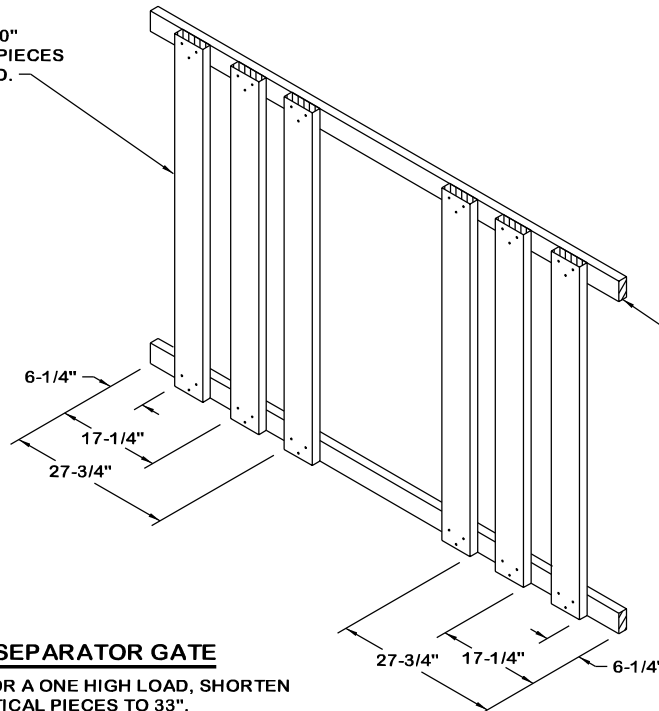


**FORWARD/REAR BLOCKING ASSEMBLY**

NOTE: FOR A ONE HIGH LOAD, ELIMINATE THE TOP TWO BEAM ASSEMBLIES AND THE TOP FOUR STRUT LEDGERS (WHERE REQUIRED). SHORTEN THE VERTICAL PIECES APPROPRIATELY.

STOP PIECE, 2" X 4" X 4-1/2" (DOUBLED) (2 REQD). ALIGN THE FIRST PIECE WITH THE CORNER OF THE BEAM ASSEMBLY AND NAIL TO THE BEAM ASSEMBLY W/2-10d NAILS. LAMINATE THE SECOND PIECE TO THE FIRST W/2-10d NAILS.

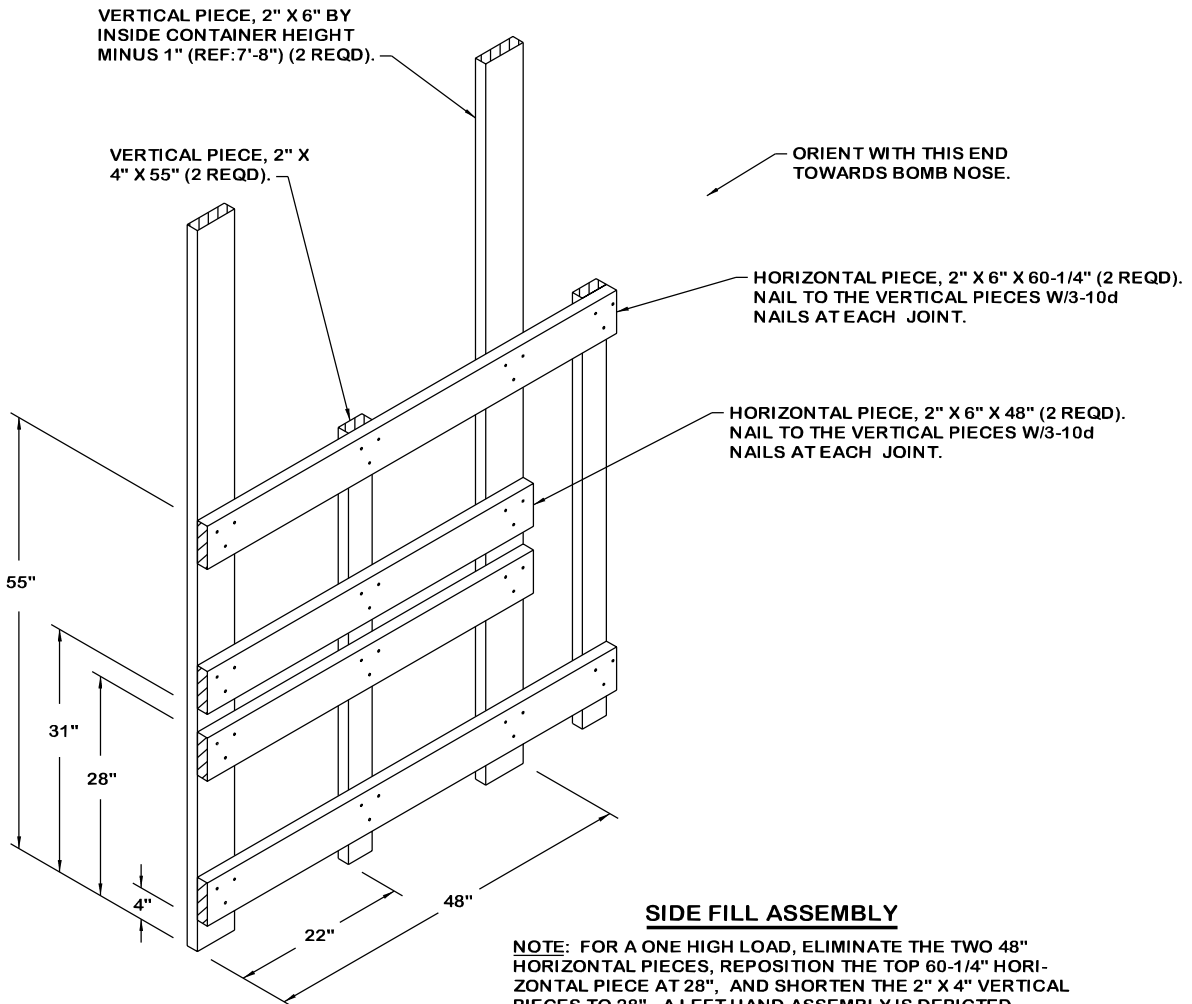
VERTICAL PIECE, 2" X 6" X 60" (6 REQD). NAIL TO THE TIE PIECES W/3-10d NAILS AT EACH END.



TIE PIECE, 2" X 4" BY INSIDE CONTAINER WIDTH MINUS 1" (REF: 7'-7") (2 REQD).

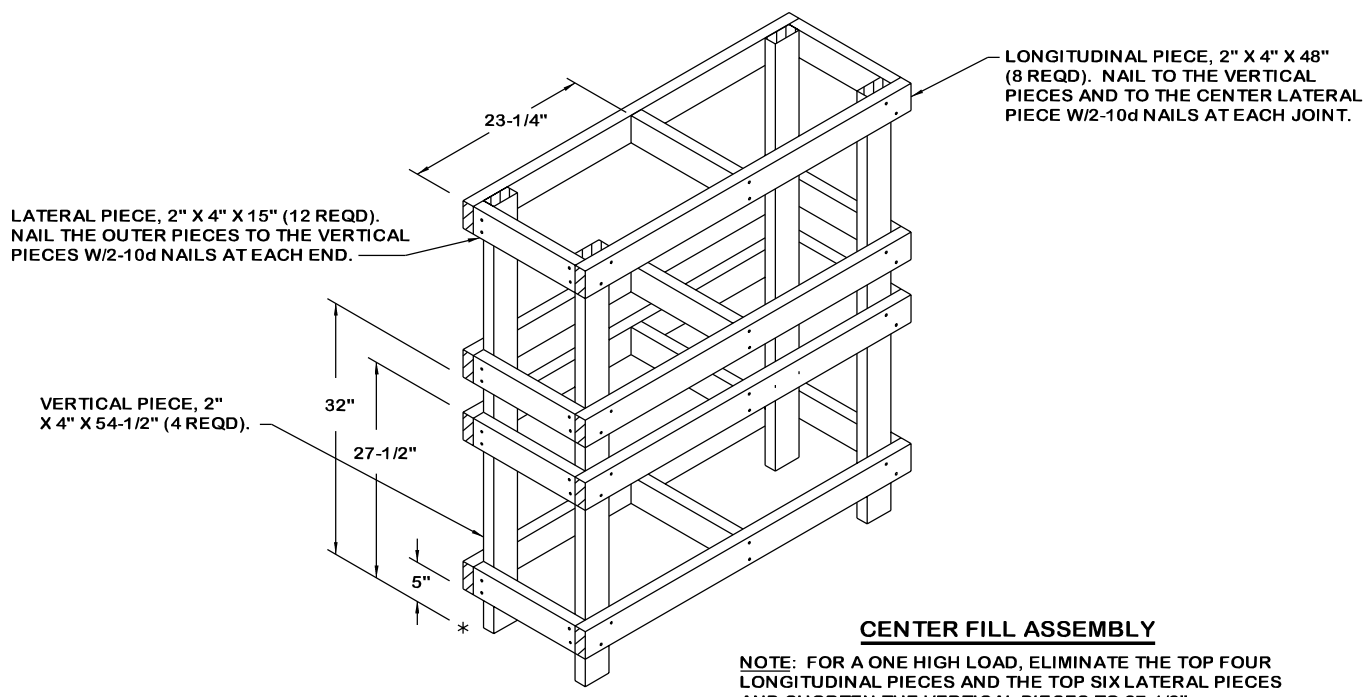
**SEPARATOR GATE**

NOTE: FOR A ONE HIGH LOAD, SHORTEN THE VERTICAL PIECES TO 33".



**SIDE FILL ASSEMBLY**

NOTE: FOR A ONE HIGH LOAD, ELIMINATE THE TWO 48" HORIZONTAL PIECES, REPOSITION THE TOP 60-1/4" HORIZONTAL PIECE AT 28", AND SHORTEN THE 2" X 4" VERTICAL PIECES TO 28". A LEFT HAND ASSEMBLY IS DEPICTED ABOVE, RIGHT HAND ASSEMBLIES ARE ALSO REQUIRED.

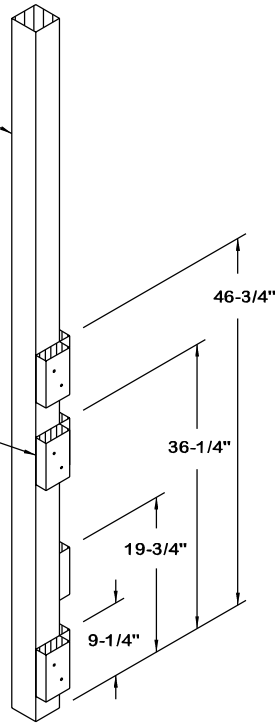


**CENTER FILL ASSEMBLY**

NOTE: FOR A ONE HIGH LOAD, ELIMINATE THE TOP FOUR LONGITUDINAL PIECES AND THE TOP SIX LATERAL PIECES AND SHORTEN THE VERTICAL PIECES TO 27-1/2".

VERTICAL PIECE, 4" X 4"  
BY INSIDE CONTAINER  
HEIGHT MINUS 1"  
(REF: 7'-4") (1 REQD).

STRUT LEDGER,  
2" X 4" X 6"  
(7 REQD). NAIL  
TO THE VERTICAL  
PIECE W/2-10d  
NAILS.



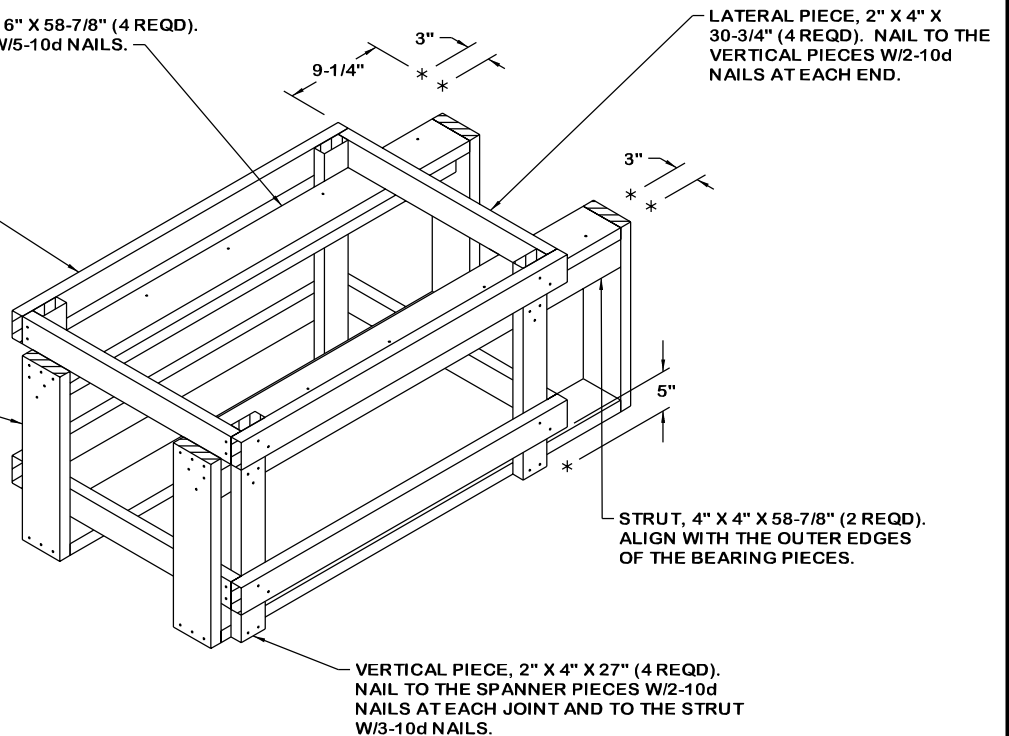
**DOOR POST VERTICAL**

A LEFT HAND ASSEMBLY IS DEPICTED, A RIGHT HAND ASSEMBLY IS ALSO REQUIRED. FOR A ONE HIGH LOAD, ELIMINATE THE UPPER TWO STRUT LEDGERS AND THE UPPER DOOR SPANNER LEDGER. RELOCATE THE MIDDLE DOOR SPANNER LEDGER AT 19-3/4". THE STRUT LEDGERS CAN ONLY BE PRE-NAILED TO THE DOOR POST VERTICAL ON ONE SIDE OF THE CONTAINER FOR THE DOOR SPANNER PIECES. ALSO, THE STRUT LEDGERS FOR THE STRUTS CAN ONLY BE PRE-NAILED TO THE DOOR POST VERTICAL AT THE LOWEST POSITION.

SPANNER PIECE, 2" X 6" X 58-7/8" (4 REQD).  
NAIL TO THE STRUT W/5-10d NAILS.

LONGITUDINAL PIECE, 2" X 4"  
X 48" (4 REQD). NAIL TO THE  
VERTICAL PIECES W/2-10d  
NAILS AT EACH JOINT.

BEARING PIECE, 2" X 6" X 23-1/2"  
(4 REQD). NAIL TO THE SPANNER  
PIECES W/3-10d NAILS AT EACH  
END AND TO THE STRUT  
W/3-10d NAILS.



LATERAL PIECE, 2" X 4" X  
30-3/4" (4 REQD). NAIL TO THE  
VERTICAL PIECES W/2-10d  
NAILS AT EACH END.

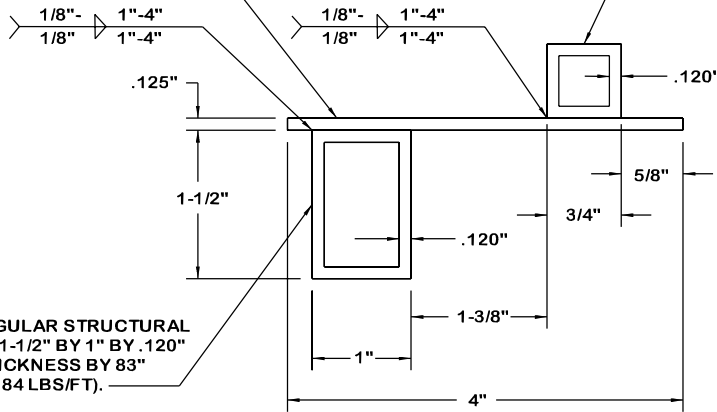
STRUT, 4" X 4" X 58-7/8" (2 REQD).  
ALIGN WITH THE OUTER EDGES  
OF THE BEARING PIECES.

VERTICAL PIECE, 2" X 4" X 27" (4 REQD).  
NAIL TO THE SPANNER PIECES W/2-10d  
NAILS AT EACH JOINT AND TO THE STRUT  
W/3-10d NAILS.

**OMITTED UNIT ASSEMBLY**

STEEL STRIP, 1/8" THICK BY 4" WIDE BY 83" LONG (1.70 LBS/FT).

SQUARE STRUCTURAL TUBING, 3/4" SQUARE BY .120" WALL THICKNESS BY 83" LONG (1.03 LBS/FT).



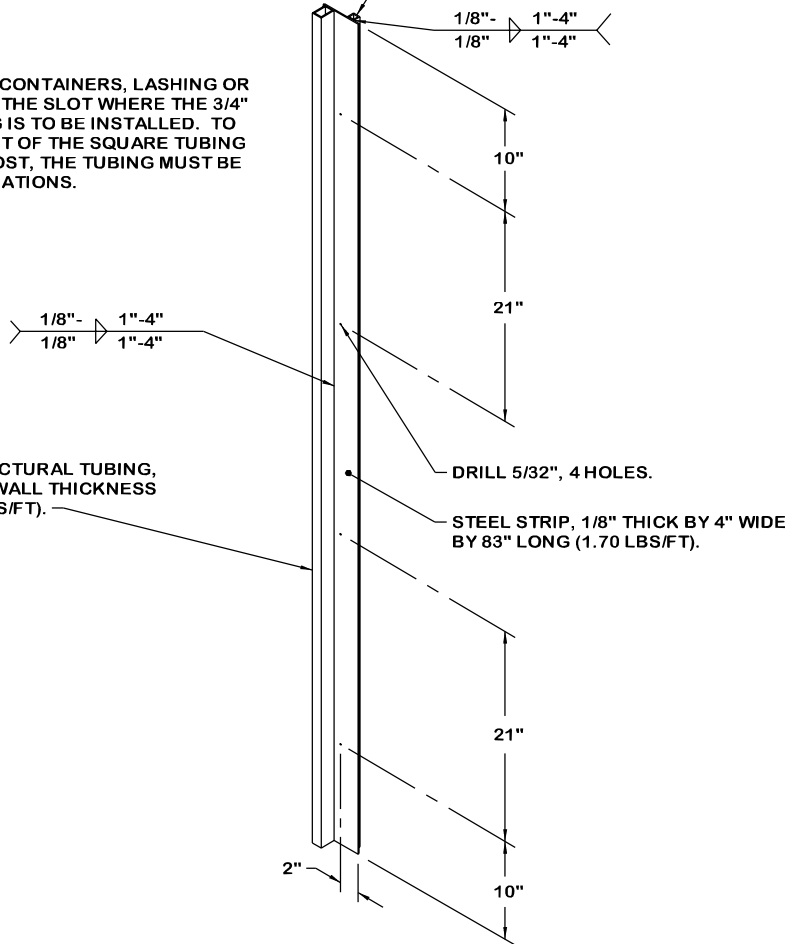
RECTANGULAR STRUCTURAL TUBING, 1-1/2" BY 1" BY .120" WALL THICKNESS BY 83" LONG (1.84 LBS/FT).

**VIEW A**

**SPECIAL NOTE:**

IN MOST CORRUGATED STEEL CONTAINERS, LASHING OR TIE BARS WILL BE PRESENT IN THE SLOT WHERE THE 3/4" SQUARE STRUCTURAL TUBING IS TO BE INSTALLED. TO ENSURE PROPER ENGAGEMENT OF THE SQUARE TUBING AND THE CONTAINER DOOR POST, THE TUBING MUST BE NOTCHED AT THE TIE BAR LOCATIONS.

SQUARE STRUCTURAL TUBING, 3/4" SQUARE BY .120" WALL THICKNESS BY 83" LONG (1.03 LBS/FT).



RECTANGULAR STRUCTURAL TUBING, 1-1/2" BY 1" BY .120" WALL THICKNESS BY 83" LONG (1.84 LBS/FT).

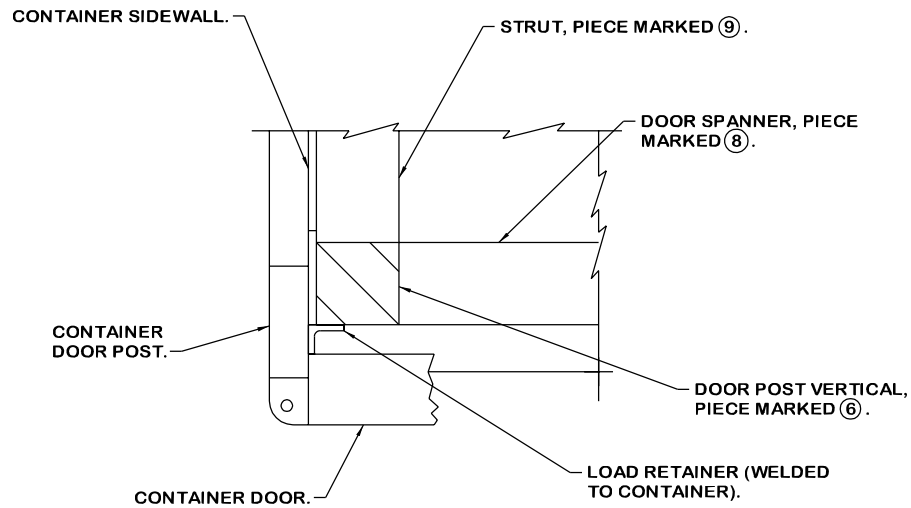
DRILL 5/32", 4 HOLES.

STEEL STRIP, 1/8" THICK BY 4" WIDE BY 83" LONG (1.70 LBS/FT).

**DOOR POST VERTICAL RETAINER**

NOTE: THE ABOVE ASSEMBLY HAS BEEN SHOWN ROTATED 90° FROM THE ORIENTATION IN WHICH IT IS INSTALLED IN THE LEFT REAR CORNER OF THE CONTAINER. THE ASSEMBLY HAS BEEN ROTATED FOR HOLE LOCATION CLARITY.



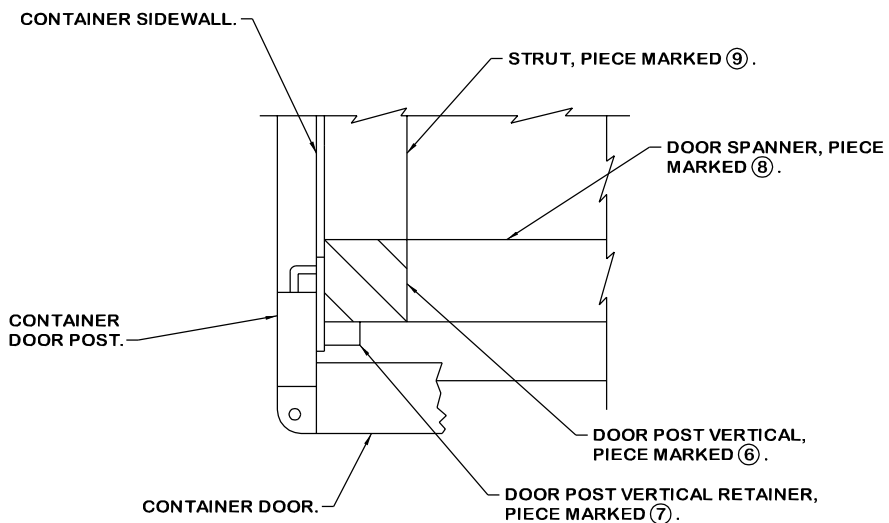


**DETAIL A**

A PARTIAL PLAN VIEW OF THE LEFT REAR PORTION OF THE CONTAINER IS SHOWN DEPICTING THE PROPER POSITION OF THE DOOR POST VERTICAL AND ADJACENT DUNNAGE PIECES. KEY NUMBERS REFER TO KEY NUMBERS ON PAGE 2.

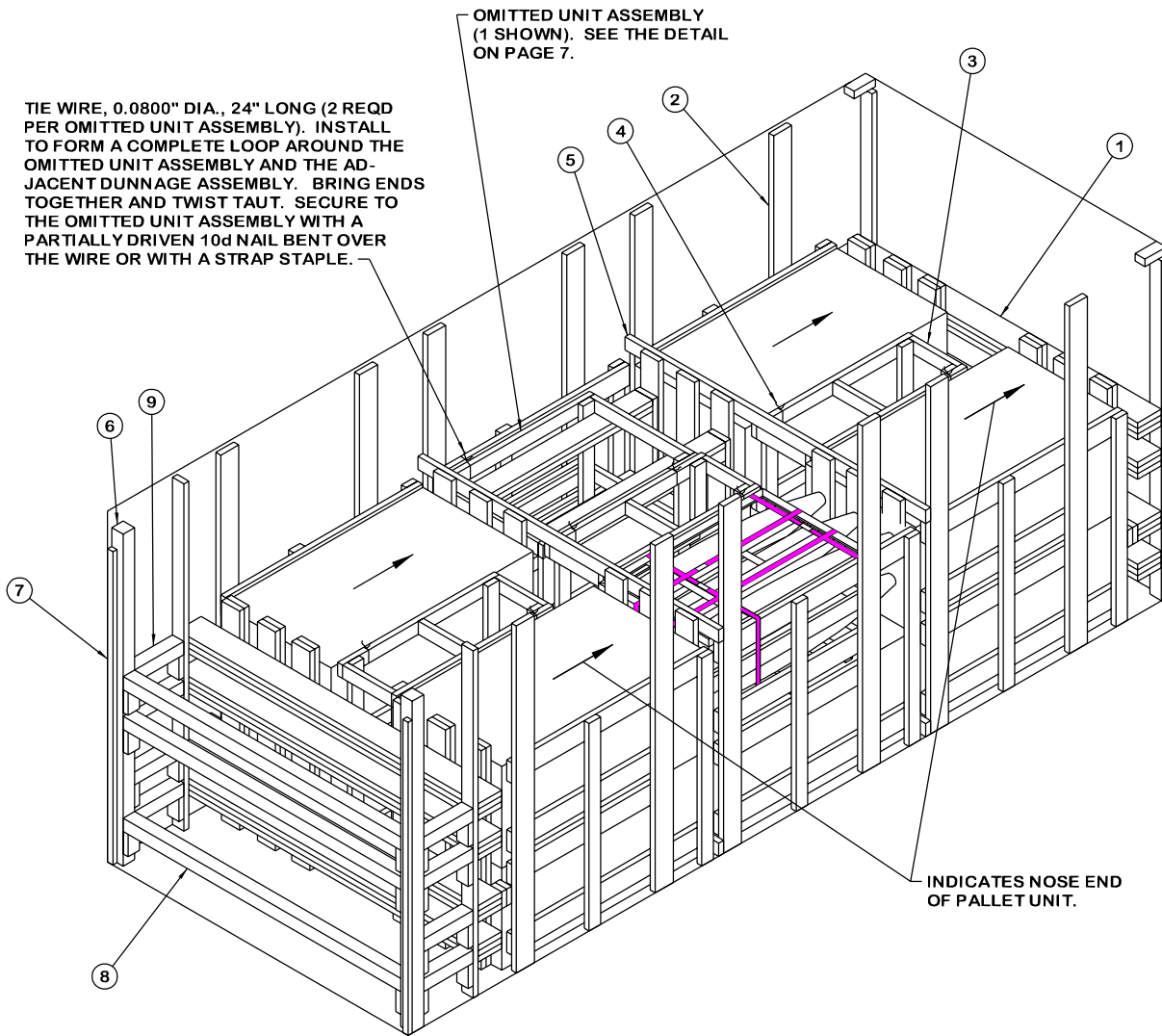
**SPECIAL NOTE:**

WHEN ISO CONTAINERS ARE NOT EQUIPPED WITH PRE-WELDED LOAD RETAINERS, AS DEPICTED IN "DETAIL B" BELOW, DOOR POST VERTICAL RETAINERS WILL BE REQUIRED FOR THE LOADS ON PAGES 2 AND 10, AS SHOWN. WHEN ISO CONTAINERS ARE EQUIPPED WITH PRE-WELDED LOAD RETAINERS, AS DEPICTED IN "DETAIL A" ABOVE, THE DOOR POST VERTICAL RETAINER IS NOT REQUIRED, AND THE DOOR POST VERTICALS WILL BE INSTALLED DIRECTLY AGAINST THE LOAD RETAINER. SEE PAGE 8 FOR DETAILS OF THE METAL DOOR POST VERTICAL RETAINER.



**DETAIL B**

A PARTIAL PLAN VIEW OF THE LEFT REAR PORTION OF THE CONTAINER IS SHOWN DEPICTING THE PROPER POSITION OF THE DOOR POST VERTICAL RETAINER AND ADJACENT DUNNAGE PIECES. KEY NUMBERS REFER TO KEY NUMBERS ON PAGE 2.



**LESS-THAN-FULL-LOAD PROCEDURE**

THE DETAIL ABOVE DEPICTS A BLOCKING METHOD TO BE USED IN A LESS-THAN-FULL CONTAINER LOAD (LESS THAN 12 UNITS). KEY NUMBERS REFER TO KEY NUMBERS ON PAGE 2. SEE GENERAL NOTE "H" ON PAGE 3.