

UNITIZATION PROCEDURES FOR 40MM CARTRIDGES PACKED IN SURE-PAK CONTAINERS FOR IN- TRA-THEATER GROUND MOVE- MENT ONLY

NOTICE: THE PROCEDURES DELINEATED IN THIS DRAWING ARE FOR INTRA-THEATER GROUND MOVEMENT ONLY.

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U.S. ARMY MATERIEL COMMAND DRAWING

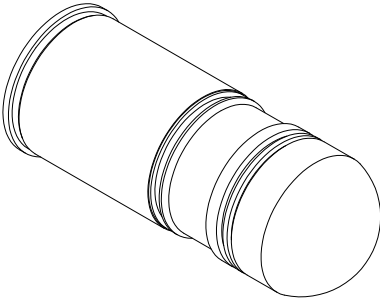
APPROVED, U.S. ARMY RESEARCH, DEVELOPMENT AND ENGINEERING COMMAND PENNOCK.AMA NDA.C.1380042 157 <small>Digitally signed by PENNOCK.AMANDA.C.1380042157 DN: c=US, o=U.S. Government, ou=DoD, ou=PKI, ou=USA, cn=PENNOCK.AMANDA.C.1380042157 Date: 2017.05.02 14:03:36 -05'00'</small>		CAUTION: VERIFY PRIOR TO USE AT HTTPS://MHP.REDSTONE.ARMY.MIL THAT THIS IS THE MOST CURRENT VERSION OF THIS DOCUMENT. THIS IS PAGE 1 OF 10.			
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APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND SHIMP.UPTON .R.1231257183 U.S. ARMY DEFENSE AMMUNITION CENTER <small>Digitally signed by SHIMP.UPTON.R.1231257183 DN: c=US, o=U.S. Government, ou=DoD, ou=PKI, ou=USA, cn=SHIMP.UPTON.R.1231257183 Date: 2013.07.29 13:43:05 -05'00'</small>		ENGINEERING DIVISON	FIEFFER.LAUR A.A.1230375727 <small>Digitally signed by FIEFFER.LAURA.A.1230375727 DN: c=US, o=U.S. Government, ou=DoD, ou=PKI, ou=USA, cn=FIEFFER.LAURA.A.1230375727 Date: 2013.07.31 09:49:22 -05'00'</small>		CLASS
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		TEST REPORT	13-18	DRAWING	
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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 UNITIZATION PROCEDURES ARE APPLICABLE TO LOADS OF LOOSE AND LINKED 40MM CARTRIDGES LOADED IN SURE-PAK CONTAINERS. SUBSEQUENT REFERENCE TO PALLET UNIT HEREIN MEANS THE SURE-PAK WITH AMMUNITION ITEMS. **CAUTION:** REGARDLESS OF THE QUANTITY OF CARTRIDGES TO BE SHIPPED, THE "MAXIMUM GROSS WEIGHT" OF THE SURE-PAK MUST NOT BE EXCEEDED 2,000 POUNDS.
- C. THE LOADS SHOWN ON PAGES 4 AND 8 ARE BASED ON A 48" LONG BY 40" WIDE BY 51-1/2" HIGH SURE-PAK CONTAINER WITH AN INSIDE HEIGHT OF 45", WHILE THE LOAD SHOWN ON PAGE 6 IS BASED ON A 48" LONG BY 40" WIDE BY 30-1/2" HIGH SURE-PAK CONTAINER WITH AN INSIDE HEIGHT OF 24", ALL WITH A MAXIMUM GROSS WEIGHT OF 2,000 POUNDS. ANY OF THE SURE-PAK CONTAINERS LISTED IN THE MATERIAL SPECIFICATIONS BELOW MAY BE USED, BUT MAY RESULT IN EITHER A REDUCTION IN THE QUANTITY SHIPPED OR THE USE OF MORE FILL MATERIAL TO OCCUPY THE VOID.
- D. THE FOLLOWING AMC DRAWINGS ARE APPLICABLE FOR OUTLOADING AND STORAGE OF THE ITEMS COVERED BY THIS DRAWING. THE DELINEATED PROCEDURES ARE INTENDED FOR INTRA-THEATER GROUND MOVEMENT ONLY.
- STORAGE - - - - 19-48-4118-1-2-3-4-14-22PA1002
TACTICAL VEHICLE - 19-48-4901/4-CA1702
TRUCKLOADING - - - 19-48-4117-11PA1003
- E. AMMUNITION SHOULD BE RELOADED AND TRANSPORTED IN ORIGINAL FACTORY PACKAGING WHENEVER POSSIBLE; HOWEVER, THERE ARE SITUATIONS WHEN THIS IS NOT POSSIBLE. IN ORDER TO ENSURE THE HIGHEST LEVEL OF EXPLOSIVES SAFETY PRACTICABLE, USE THE FOLLOWING PACKAGING PRIORITIES WHEN PLANNING AMMUNITION TRANSPORT. FIRST, USE FACTORY PACKAGING IF AT ALL POSSIBLE. SECOND CHOICE FOR PROTECTION IS TO LOAD AMMUNITION IN METAL CANS, AS DEPICTED ON PAGE 9. THE THIRD AND LEAST DESIREABLE METHOD OF SECURING AMMUNITION FOR TRANSPORT IS TO USE AVAILABLE PACKAGING AND CUSHIONING MATERIAL TO PACK LOOSE OR LINKED AMMUNITION DIRECTLY INTO SURE-PAK CONTAINERS, AS DEPICTED ON PAGES 4 THROUGH 7.
- F. WHEN LOADING CARTRIDGES, THEY ARE TO BE POSITIONED SO AS TO ACHIEVE A TIGHT LOAD. THE UNBLOCKED SPACE ACROSS THE WIDTH OR LENGTH OF A SURE-PAK CONTAINER OR ANY DIMENSION IN A METAL BOX IS NOT TO EXCEED 1/2", AND UNBLOCKED SPACE IN THE HEIGHT OF THE SURE-PAK IS NOT TO EXCEED 1". EXCESSIVE SLACK CAN BE ELIMINATED FROM A LOAD BY ADDING FILLER MATERIAL SUCH AS CARDBOARD, EMPTY WATER BOTTLES, EMPTY BOXES, SHREDDED CLOTH, OR OTHER SIMILAR MATERIAL.
- G. METAL BOXES THAT MAY BE USED FOR SHIPMENT OF AMMUNITION USING THE PROCEDURES HEREIN INCLUDE M2 SERIES CONTAINERS, M548 CONTAINERS, AND PA120 CONTAINERS.
- H. FILLER MATERIAL IS DEFINED HEREIN AS ANY AVAILABLE MATERIAL WITH SUFFICIENT CUSHIONING TO PROTECT THE AMMUNITION ITEMS. SOME POTENTIAL SOURCES OF FILLER MATERIAL INCLUDE BUT ARE NOT LIMITED TO EMPTY WATER BOTTLES, SHREDDED UNIFORMS (CLEAN WITHOUT SHARP PROJECTIONS), DISCARDED CARDBOARD CARTONS, EGG CARTONS, WOOD SCRAPS (WITHOUT NAILS), TOILET PAPER AND PAPER TOWEL CARDBOARD TUBES, NEWSPAPER, SHREDDED COPY PAPER, AND DISCARDED BANDOLEERS. **CAUTION:** ALL FILLER MATERIAL MUST BE NON-STATIC PRODUCING AND FREE FROM PROJECTIONS AND SHARP EDGES, AS WELL AS FREE FROM FOOD RESIDUE AND EXCESS WATER OR LIQUID RESIDUE.
- J. CARE SHOULD BE TAKEN WHEN LOADING SURE-PAK CONTAINERS TO ENSURE AN EVENLY BALANCED LOAD. ARRANGE THE LOAD IN SUCH A MANNER THAT THE CENTER OF GRAVITY IS CLOSE TO THE PHYSICAL CENTER OF SURE-PAK.
- K. IF SURE-PAK CONTAINERS ARE TIGHTLY PACKED AND LOADED WITH AMMUNITION ITEMS TO WITHIN 1" OF THE TOP ON THE SIDEWALLS, THE SURE-PAKS MAY BE STACKED FOR SHORT TERM STORAGE UP TO THREE HIGH. IF, HOWEVER, THE SURE-PAK CONTAINER LOAD CONSISTS OF MORE THAN ONE INCH OF FILL MATERIAL ON THE TOP OF THE LOAD, THE SURE-PAK CONTAINERS WILL NOT BE STACKED, AND SHOULD BE MARKED AS SUCH. THE ONLY EXCEPTION TO THIS REQUIREMENT IS IF THE FILL MATERIAL IS AS STRONG AS OR STRONGER THAN THE CARTRIDGES BEING LOADED, SUCH AS THE USE OF EMPTY M2 SERIES CANS. IN THIS CASE, THE SURE-PAK CONTAINERS MAY BE STACKED AS OUTLINED ABOVE.
- L. EACH SURE-PAK CONTAINER MUST BE SECURED WITH A MINIMUM OF TWO WEB STRAPS ORIENTED AROUND THE 40" LENGTH AND THE HEIGHT OF THE LOAD. THE TWO STRAPS SHOULD BE EVENLY SPACED ACROSS THE LENGTH OF THE LOAD. CARE MUST BE TAKEN TO ENSURE THAT STRAP RATCHETS WILL NOT INTERFERE WITH EITHER STACKING OF THE SURE-PAK CONTAINERS OR LONGITUDINAL LOADING FOR TRANSPORT. IF WEB STRAPS ARE NOT AVAILABLE, SIMILAR STRENGTH PLASTIC STRAPPING IAW ASTM D3950 MAY BE USED.
- M. PORTIONS OF THE SURE-PAK CONTAINER DEPICTED WITHIN THIS DRAWING, SUCH AS THE TOP AND SIDEWALL, HAVE NOT BEEN SHOWN IN SOME LOAD VIEWS FOR CLARITY PURPOSES.
- N. THE QUANTITY OF CARTRIDGES SHOWN IN THE LOADS HEREIN MAY BE REDUCED FOR SHIPMENT, IF DESIRED. ADDITIONAL FILL MATERIAL MUST BE INSTALLED IN ORDER TO MEET THE REQUIREMENTS IN GENERAL NOTE "E".
- 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.

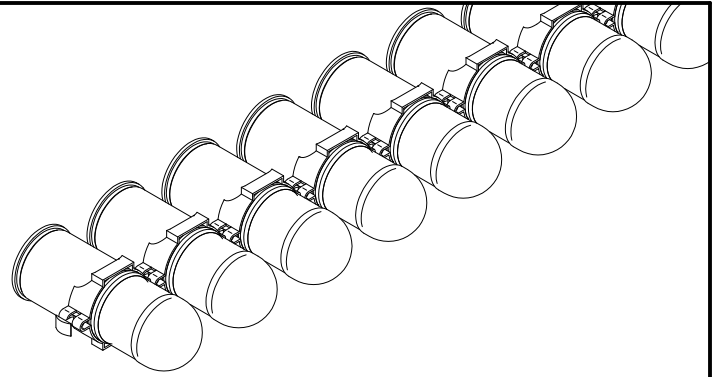
MATERIAL SPECIFICATIONS

- SURE-PAK CONTAINER - : SHIPPING AND STORAGE SYSTEM: SURE-PAK KIT INCLUDING TOP, BASE, SLEEVE AND 8 LOCKING CLIPS; 8115-01-556-2579 (30-1/2" HIGH), 8115-01-556-2580 (36-1/2" HIGH), OR 8115-01-556-2581 (51-1/2" HIGH).
- STRAPPING WEB - - - : TIE DOWN, CARGO, VEHICLE, 2" NOMINAL STRAP, 2,000 POUND MINIMUM WORKING LOAD LIMIT, 3990-01-204-3009 OR EQUIVALENT.
- HARDBOARD - - - - : ANSI/AHA A135.4, CLASS 1.
- FIBERBOARD - - - - : ASTM D4727.
- TAPE DUCT - - - - : COMMERCIAL GRADE.
- HONEYCOMB FILLER - : FIBERBOARD, FACING PAPER WEIGHT 69 POUNDS/1,000 SQUARE FEET, SORE PAPER WEIGHT 33 POUNDS/1,000 SQUARE FEET, 1/2" CORE CELL CENTERS, INTERNATIONAL HONEYCOMB CORPORATION (OR EQUAL).
- FOAM CUSHIONING MATERIAL - - - - : COMMERCIAL ITEM DESCRIPTION A-A-59136, CLASS 1, TYPE III, GRADE A, OR COMMERCIAL EQUIVALENT.



TYPICAL 40MM LOOSE CARTRIDGE

A B546 CARTRIDGE IS SHOWN AS TYPICAL ONLY. SEE THE CHART BELOW FOR APPLICABLE DODICS AND DIMENSIONAL DATA.

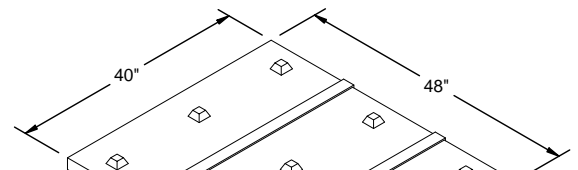


TYPICAL 40MM LINKED CARTRIDGE

A PORTION OF LINKED B542 CARTRIDGES IS SHOWN AS TYPICAL. SEE THE CHART BELOW FOR APPLICABLE DODICS AND DIMENSIONAL DATA.

40MM CARTRIDGE DATA						
DODIC	LENGTH	WIDTH	HEIGHT	WEIGHT	LINKED	LINKED QTY
B504	5.272"	1.719"	1.719"	0.49 LBS	N	NA
B505	5.272"	1.719"	1.719"	0.49 LBS	N	NA
B506	3.895"	1.719"	1.719"	0.49 LBS	N	NA
B508	3.895"	1.719"	1.719"	0.49 LBS	N	NA
B509	3.895"	1.719"	1.719"	0.49 LBS	N	NA
B535	5.272"	1.719"	1.719"	0.56 LBS	N	NA
B536	5.272"	1.719"	1.719"	0.56 LBS	N	NA
B542	4.415"	1.602"	1.602"	0.75 LBS	Y	32, 48 OR 50
B546	4.068"	1.719"	1.719"	0.55 LBS	N	NA
BA03	5.272"	1.719"	1.719"	0.55 LBS	N	NA
BA06	3.950"	1.719"	1.719"	0.15 LBS	N	NA
BA13	4.80"	1.719"	1.719"	0.47 LBS	N	NA

DIMENSIONAL DATA CONTAINED IN THE ABOVE CHART IS FOR GUIDANCE AND INFORMATIONAL PURPOSES ONLY.

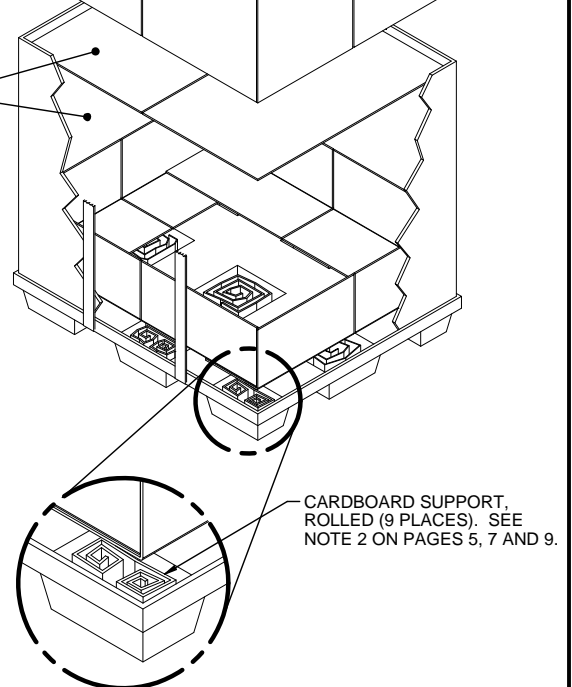


WEB STRAP ASSEMBLY, 2" (2 REQD).
INSTALL AS SHOWN AROUND THE SHORT
DIMENSION OF THE SURE-PAK CONTAINER.
SEE GENERAL NOTE "K" ON PAGE 2.

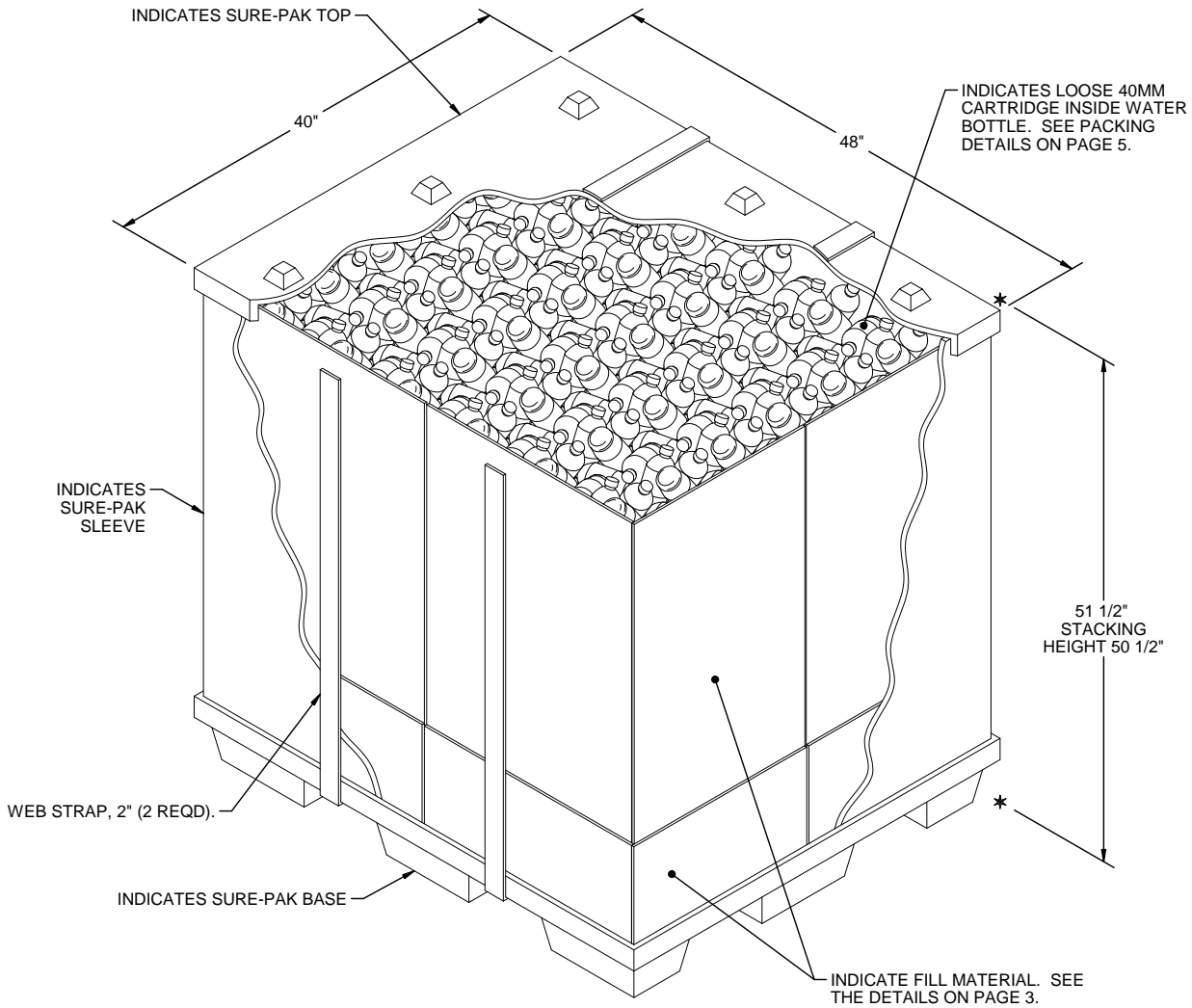
TYPICAL FILL MATERIAL (CARDBOARD SHOWN).

TYPICAL STRAPPED SURE-PAK CONTAINER

THE DETAIL AT RIGHT DEPICTES A SURE-PAK CONTAINER WITH THE MINIMUM REQUIRED FILL MATERIAL (CARDBOARD SHOWN) AND THE REQUIRED WEB STRAPS. THE 40MM CARTRIDGES HAVE NOT BEEN SHOWN FOR CLARITY PURPOSES.



CARDBOARD SUPPORT,
ROLLED (9 PLACES). SEE
NOTE 2 ON PAGES 5, 7 AND 9.



LOOSE CARTRIDGE PALLET UNIT

SEE GENERAL NOTE "E" ON PAGE 2. UPPER FILL MATERIAL NOT SHOWN FOR CLARITY.

3,287 B535 40MM CARTRIDGES (MAXIMUM) @ 0.56 LB	----	1,841 LBS
DUNNAGE	----	97 LBS
PALLET	----	63 LBS
<hr/>		
TOTAL WEIGHT	----	2,000 LBS (APPROX)
CUBE	----	57.2 CU FT (APPROX)

BILL OF MATERIAL		
SURE-PAK, 40" X 48" X 51-1/2"	- 1 REQD	63.0 LBS
EMPTY WATER BOTTLE, 20 OZ	- 3,287	72.4 LBS
CARDBOARD	- AS REQD	15.0 LBS
WEB STRAP ASSEMBLY, 2"	- 2 REQD	8.8 LBS

SURE-PAK CONTAINER LOADING PROCEDURES



FIGURE 1

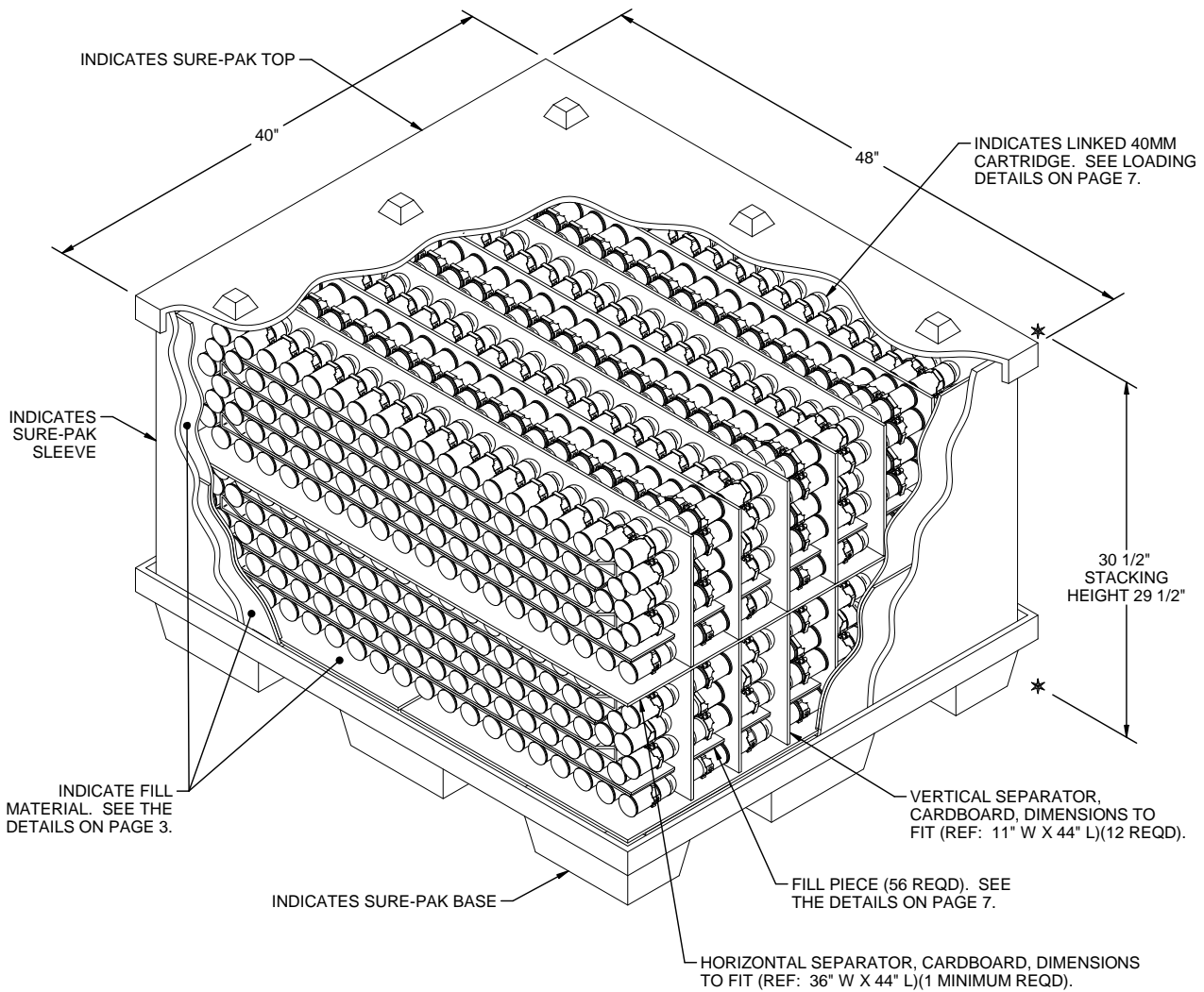


FIGURE 2



FIGURE 3

1. SET UP THE SURE-PAK BASE AND SLEEVE, ENGAGING THE FOUR BOTTOM LOCKING DEVICES.
2. INSTALL CARDBOARD IN THE BOTTOM OF THE SURE-PAK BASE TO FILL VOID AREAS. SEE FIGURE 4 ON PAGE 10.
3. INSTALL CARDBOARD, BENT AT 90°, AROUND THE BOTTOM INTERIOR EDGE OF THE SURE-PAK, ENSURING THAT THE CARDBOARD EXTENDS AT LEAST 8" ONTO THE SURE-PAK BASE AND 8" UP THE SURE-PAK SIDEWALL. SEE FIGURE 5 ON PAGE 10.
4. CUT A WATER BOTTLE IN HALF AT THE NARROWEST POINT.
5. LOAD 40MM CARTRIDGES IN THE WATER BOTTLE BOTTOM HALF, WITH CARTRIDGE NOSE POINTED TOWARDS BOTTLE BASE. INSTALL WATER BOTTLE TOP HALF (WITH CAP IF POSSIBLE) OVER CARTRIDGE BASE. TWIST WATER BOTTLE HALVES UNTIL BOTTLE GROOVES LOCK HALVES IN PLACE. SEE FIGURES 1 AND 2 AT LEFT. **CAUTION:** IF THE WATER BOTTLE HALVES DO NOT SNUGLY LOCK TOGETHER, TAPE MUST BE APPLIED TO ENSURE A TIGHT PACK. APPLY AT A MINIMUM ONE COMPLETE LOOP AROUND THE LENGTH OF THE WATER BOTTLE. SEE FIGURE 3 AT LEFT.
6. REPEAT STEP 5 AS MANY TIMES AS NECESSARY TO LOAD ALL THE CARTRIDGES INTO WATER BOTTLES.
7. BEGIN LOADING THE CARTRIDGES INTO THE SURE-PAK. CARDBOARD MUST BE INSTALLED AT A MINIMUM AGAINST ALL SURE-PAK SIDEWALLS AND THE BASE, TO THE HEIGHT OF THE TOP OF THE CARTRIDGES OR TO THE TOP OF THE SIDE WALLS. SEE FIGURE 6 ON PAGE 10.
8. INSTALL EXTRA FILL MATERIAL AS NEEDED TO THROUGHOUT LOADING, ENSURING THAT THE SURE-PAK LOAD IS RELATIVELY TIGHT.
9. DO NOT EXCEED 2,000 POUNDS GROSS WEIGHT FOR THE SURE-PAK AND CONTENTS.
10. WHEN THE SURE-PAK IS FILLED, ADD CARDBOARD OR OTHER VOID FILLER AS NEEDED TO FILL OUT THE TOP OF THE SURE-PAK, SEE GENERAL NOTE "H" ON PAGE 2.
11. INSTALL THE SURE-PAK TOP.
12. INSTALL TWO WEB STRAPS (MINIMUM) AROUND THE SHORT DIMENSION OF THE SURE-PAK. SEE PAGE 3 FOR DETAILS.



LINKED CARTRIDGE PALLET UNIT

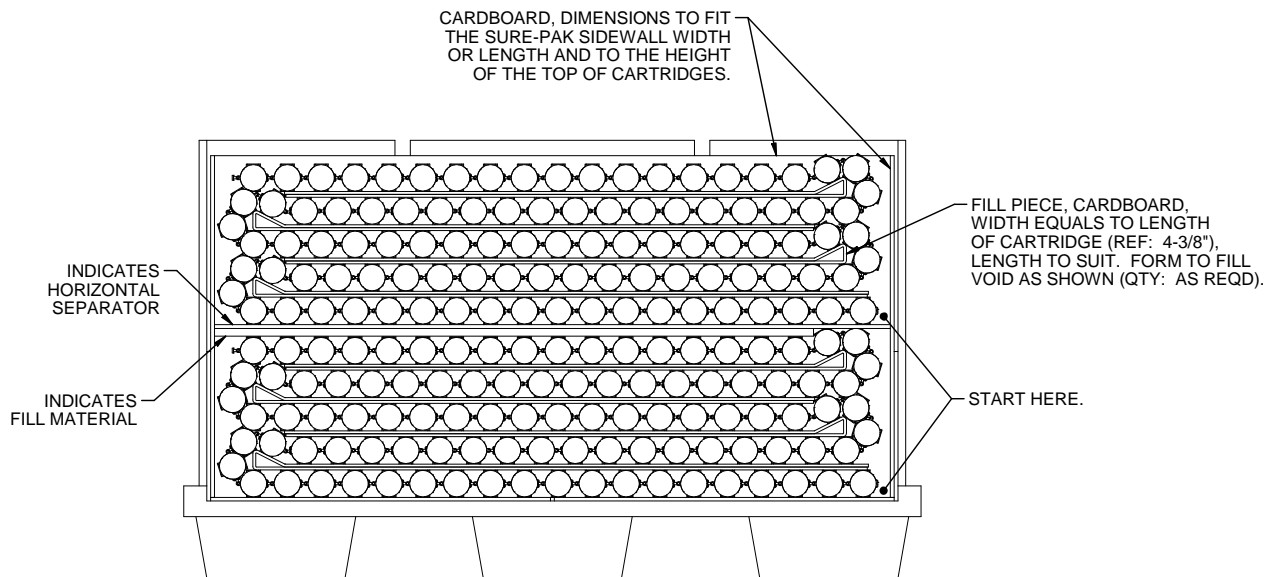
SEE GENERAL NOTE "E" ON PAGE 2. UPPER FILL MATERIAL AND WEB STRAPS NOT SHOWN FOR CLARITY. SEE "FRONT VIEW" ON PAGE 7 FOR DETAILS.

1,400 B542 40MM CARTRIDGES (MAXIMUM) @ 0.75 LBS	-----	1,050 LBS
DUNNAGE	-----	39 LBS
PALLET	-----	55 LBS
<hr/>		
TOTAL WEIGHT	-----	1,144 LBS (APPROX)
CUBE	-----	33.9 CU FT (APPROX)

BILL OF MATERIAL		
SURE-PAK, 40" X 48" X 30-1/2"	- 1 REQD	----- 55.4 LBS
CARDBOARD	----- AS REQD	----- 30.0 LBS
WEB STRAP ASSEMBLY, 2"	- 2 REQD	----- 8.8 LBS

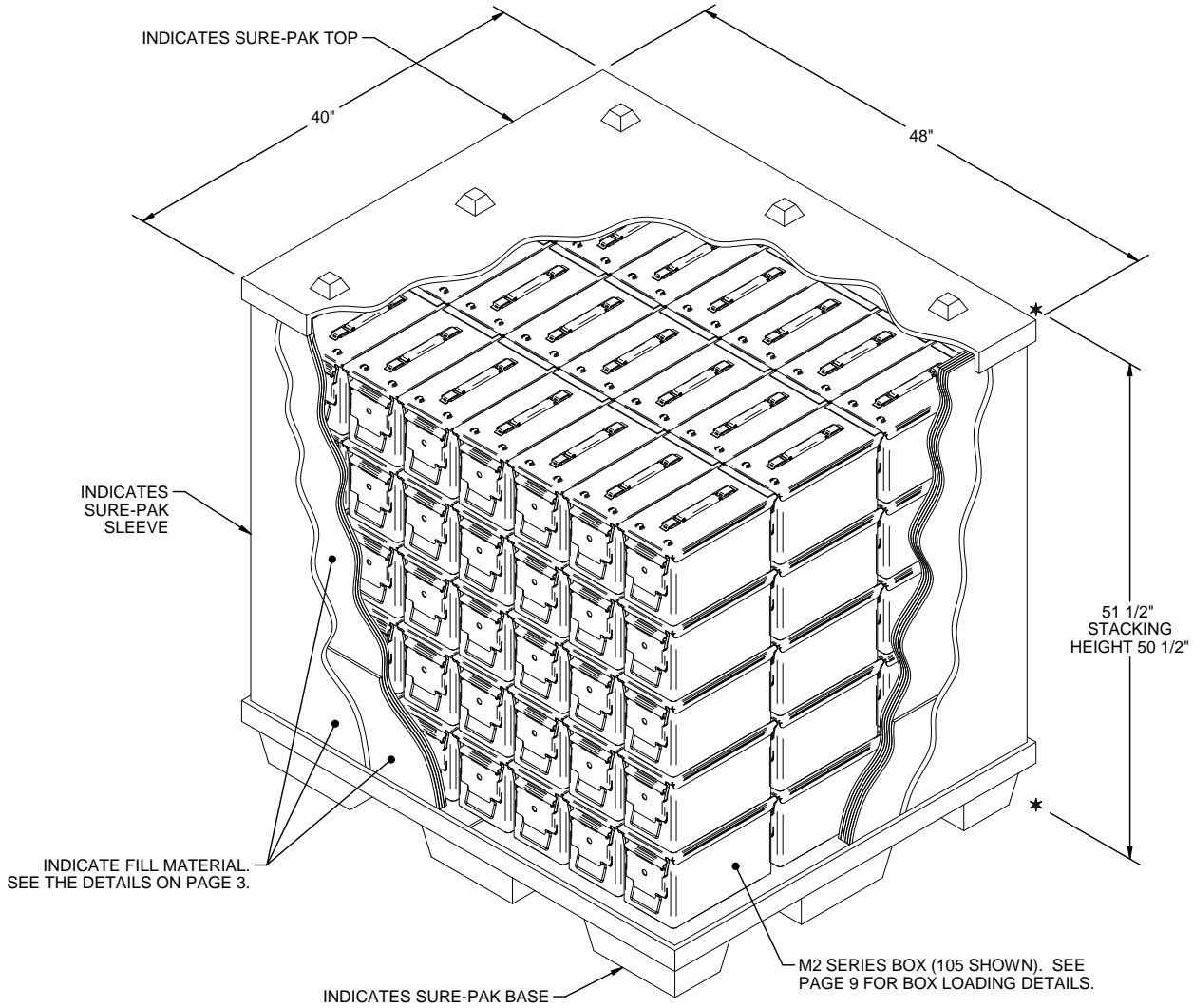
SURE-PAK CONTAINER LOADING PROCEDURES

1. SET UP THE SURE-PAK BASE AND SLEEVE, ENGAGING THE FOUR BOTTOM LOCKING DEVICES.
2. INSTALL CARDBOARD IN THE BOTTOM OF THE SURE-PAK TO FILL VOID AREAS. SEE FIGURE 4 ON PAGE 10.
3. INSTALL CARDBOARD, BENT AT 90°, AROUND THE BOTTOM INTERIOR EDGE OF THE SURE-PAK, ENSURING THAT THE CARDBOARD EXTENDS AT LEAST 8" ONTO THE SURE-PAK BASE AND 8" UP THE SURE-PAK SIDEWALL. SEE FIGURE 5 ON PAGE 10.
4. START LOADING THE LINKED CARTRIDGES AT THE START POINTS SHOWN IN THE FRONT VIEW BELOW, LOADING PARALLEL TO THE LONG SURE-PAK DIMENSION. ONCE THE CARTRIDGES REACH THE OPPOSITE WALL, INSTALL FILL MATERIAL ON TOP OF THE CARTRIDGES AND LOOP THE CARTRIDGES BACK IN THE OPPOSITE DIRECTION. WHEN THE LINKS REACH NEAR HALF OF THE SURE-PAK HEIGHT, REPEAT NEXT COLUMN IN SIMILAR PATTERN AS OF THE FIRST COLUMN. IF THE LAST ROW BEFORE STARTING NEXT COLUMN YIELDS A VOID, FILL IN THE VOID WITH FILL MATERIAL. CONTINUE THE COLUMN PATTERNS UNTIL REACHING THE OPPOSITE SIDE WALL. VERTICAL SEPARATORS SHOULD BE USED BETWEEN ADJACENT COLUMNS. ADJACENT COLUMNS SHOULD BE LOADED WITH ORIENTED HEAD TO HEAD OR TAIL TO TAIL.
5. START THE NEXT LAYER IN SIMILAR MANNER AS PREVIOUS LAYER. USE HORIZONTAL SEPARATOR BETWEEN LAYERS.
6. CARDBOARD MUST BE INSTALLED AT A MINIMUM AGAINST ALL SURE-PAK SIDEWALLS AND THE BASE, TO THE HEIGHT OF THE TOP OF THE CARTRIDGES. SEE THE "FRONT VIEW" BELOW AND FIGURE 6 ON PAGE 10.
7. INSTALL EXTRA FILL MATERIAL AS NEEDED TO THROUGHOUT LOADING, ENSURING THAT THE SURE-PAK LOAD IS RELATIVELY TIGHT.
8. DO NOT EXCEED 2,000 POUNDS GROSS WEIGHT FOR THE SURE-PAK AND CONTENTS.
9. WHEN THE SURE-PAK IS FILLED, ADD CARDBOARD OR OTHER VOID FILLER AS NEEDED TO FILL OUT THE TOP OF THE SURE-PAK, SEE GENERAL NOTE "H" ON PAGE 2.
10. INSTALL THE -PAK TOP.
11. INSTALL TWO WEB STRAPS (MINIMUM) AROUND THE SHORT DIMENSION OF THE SURE-PAK. SEE PAGE 3 FOR DETAILS.



FRONT VIEW

SURE-PAK TOP, UPPER FILL MATERIAL, WEB STRAPS, AND PORTION OF BASE NOT SHOWN FOR CLARITY.



BOXED CARTRIDGE PALLET UNIT

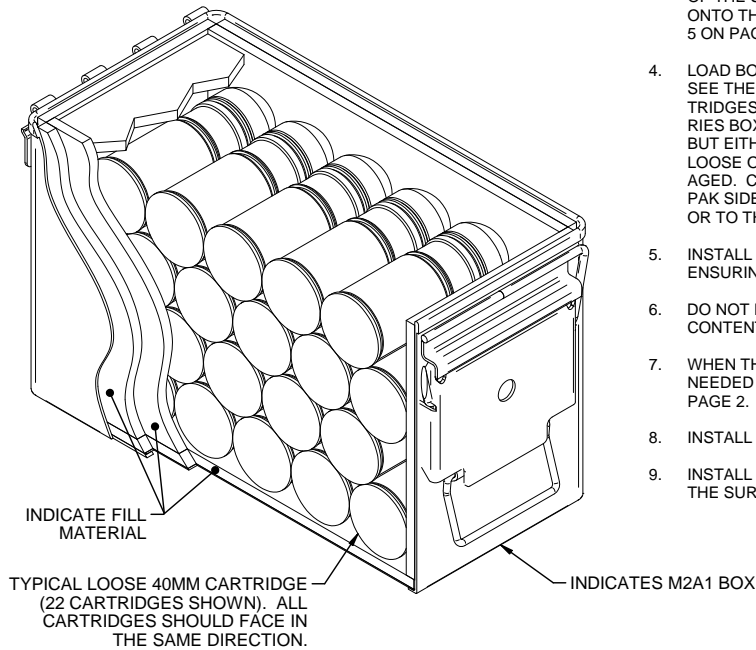
SEE GENERAL NOTE "E" ON PAGE 2 AND BOX LOADING DETAILS ON PAGE 9. UPPER FILL MATERIAL AND WEB STRAPS NOT SHOWN FOR CLARITY.

105 M2 SERIES BOXES (22 B546/BOX) @ 18 LBS PER BOX	- -	1,890 LBS
DUNNAGE	- - - - -	47 LBS
PALLET	- - - - -	63 LBS
<hr/>		
TOTAL WEIGHT	- - - - -	2,000 LBS (APPROX)
CUBE	- - - - -	57.2 CU FT (APPROX)

BILL OF MATERIAL		
SURE-PAK, 40" X 48" X 51-1/2"	- 1 REQD	63.0 LBS
CARDBOARD	- AS REQD	38.0 LBS
WEB STRAP ASSEMBLY, 2"	- 2 REQD	8.8 LBS

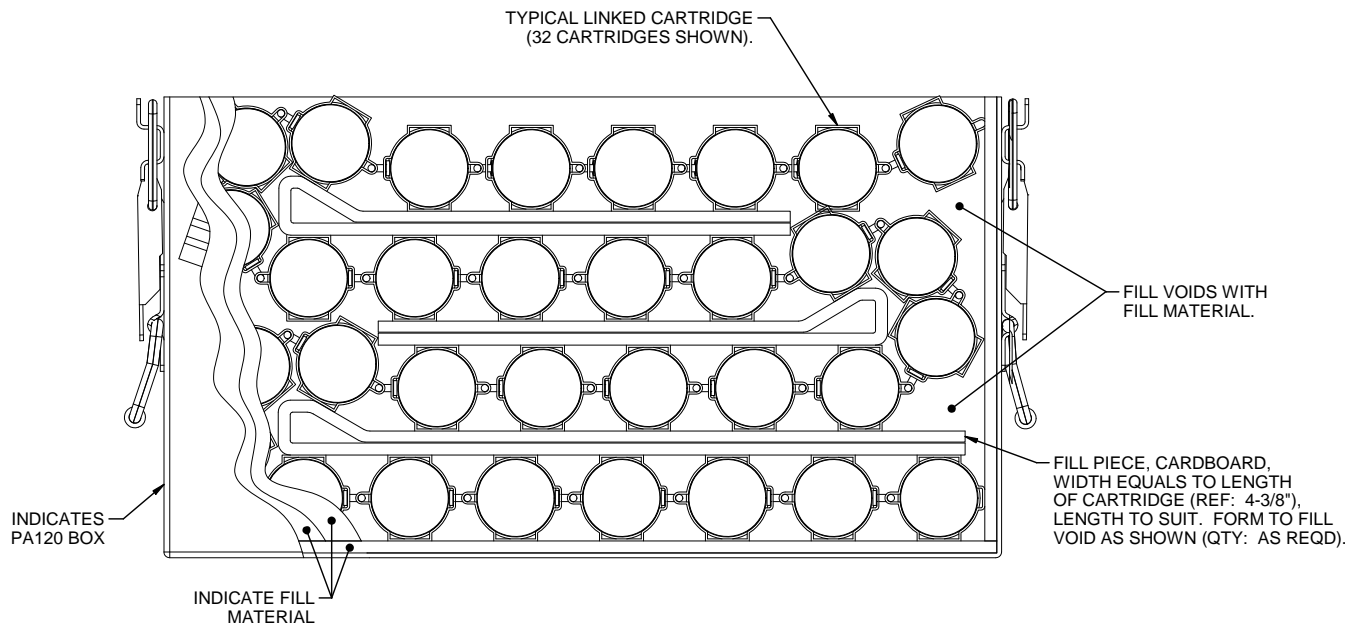
SURE-PAK CONTAINER LOADING PROCEDURES

1. SET UP THE SURE-PAK BASE AND SLEEVE, ENGAGING THE FOUR BOTTOM LOCKING DEVICES.
2. INSTALL CARDBOARD IN THE BOTTOM OF THE SURE-PAK TO FILL VOID AREAS. SEE FIGURE 4 ON PAGE 10.
3. INSTALL CARDBOARD, BENT AT 90°, AROUND THE BOTTOM INTERIOR EDGE OF THE SURE-PAK, ENSURING THAT THE CARDBOARD EXTENDS AT LEAST 8" ONTO THE SURE-PAK BASE AND 8" UP THE SURE-PAK SIDEWALL. SEE FIGURE 5 ON PAGE 10.
4. LOAD BOXES INTO SURE-PAK WITH THE HINGES FACING SAME DIRECTION. SEE THE DETAILS AT LEFT AND BELOW FOR TYPICAL LOADING OF 40MM CARTRIDGES INTO BOXES; LOOSE CARTRIDGES ARE SHOWN LOADED IN M2 SERIES BOXES AND LINKED CARTRIDGES ARE SHOWN LOADED IN PA120 BOXES, BUT EITHER BOX, AS WELL AS M548 BOXES, MAY BE USED TO LOAD EITHER LOOSE OR LINKED CARTRIDGES, AS LONG AS THE BOXES ARE NOT DAMAGED. CARDBOARD MUST BE INSTALLED AT A MINIMUM AGAINST ALL SURE-PAK SIDEWALLS AND THE BASE, TO THE HEIGHT OF THE TOP OF THE BOXES OR TO THE TOP OF THE SIDEWALLS. SEE FIGURE 6 ON PAGE 10.
5. INSTALL EXTRA FILL MATERIAL AS NEEDED TO THROUGHOUT LOADING, ENSURING THAT THE SURE-PAK LOAD IS RELATIVELY TIGHT.
6. DO NOT EXCEED 2,000 POUNDS GROSS WEIGHT FOR THE SURE-PAK AND CONTENTS.
7. WHEN THE SURE-PAK IS FILLED, ADD CARDBOARD OR OTHER VOID FILLER AS NEEDED TO FILL OUT THE TOP OF THE SURE-PAK, SEE GENERAL NOTE "H" ON PAGE 2.
8. INSTALL THE SURE-PAK TOP.
9. INSTALL TWO WEB STRAPS (MINIMUM) AROUND THE SHORT DIMENSION OF THE SURE-PAK. SEE PAGE 3 FOR DETAILS.



TYPICAL M2A1 BOX LOAD OF LOOSE CARTRIDGE

BOX LID NOT SHOWN FOR CLARITY.



TYPICAL PA120 BOX LOAD OF LINKED CARTRIDGE

BOX LID NOT SHOWN FOR CLARITY.

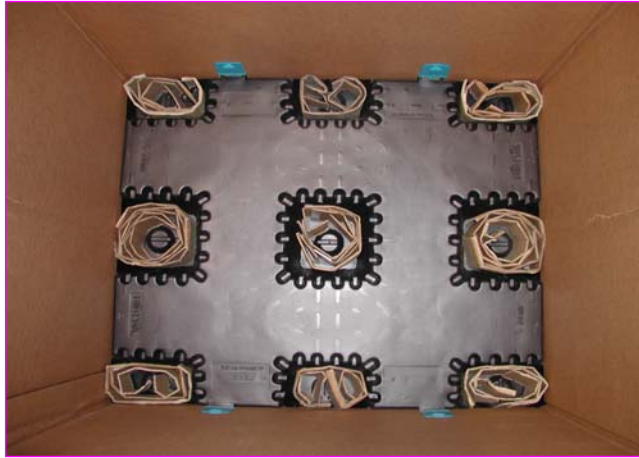


FIGURE 4



FIGURE 5



FIGURE 6