

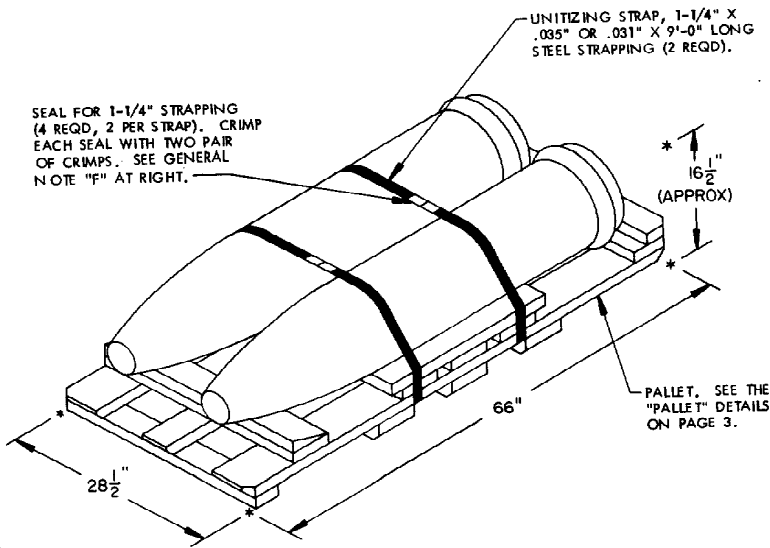
UNITIZATION PROCEDURES FOR BOMB, CHEMICAL, MK94, MOD 0, 500 LB., UNITIZED 2 BOMBS PER WOOD PALLET

DO NOT SCALE

REVISIONS				DRAFTSMAN AP	PROJ ENG MWD/WRE
				GG	LOG ENGRG OFFICE W.F. Ernst
		/		APPROVED, U.S. ARMY ARMAMENT, SUBSTITUTION AND CHEMICAL ORDERS/AM mjs Samuel J. Pakson	
		/		APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIAL COMMAND (AMC) William F. Ernst U.S. ARMY DEFENSE AMMUNITION CENTER AND SCHOOL	
		/		U.S. ARMY AMC DRAWING	
		/		APRIL 1988	
		/		CLASS	DIVISION
		/		DRAWING	FILE
		/		19	48
		/		4536	CB20 PB3

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. DETAILS OF THE PALLET UNIT:
 - DIMENSIONS ----- 66" LONG X 28-1/2" WIDE X 16-1/2" HIGH (APPROX)
 - GROSS WEIGHT -- 1,130 POUNDS (APPROX)
 - CUBE ----- 18 CUBIC FEET (APPROX)
- C. DIMENSIONAL LUMBER SPECIFIED IN THIS PROCEDURAL DRAWING IS OF A NOMINAL SIZE. FOR EXAMPLE, 2" X 4" MATERIAL IS ACTUALLY 1-1/2" THICK BY 3-1/2" WIDE AND 3" X 6" MATERIAL IS ACTUALLY 2-1/2" THICK BY 5-1/2" WIDE.
- D. A PLUS OR MINUS 1/4" IS ALLOWED ON OVERALL DIMENSIONS OF THE PALLET, HOWEVER, SIMILAR PIECES MUST BE WITHIN 1/8" OF THE SAME DIMENSION.
- E. FOR STORAGE OF THE PALLET UNIT COVERED BY THIS DRAWING, REFER TO AMC DRAWING 19-48-4537-CB1-14PB4.
- F. IF A NOTCH-TYPE CRIMPING TOOL IS BEING USED TO SECURE THE STRAP SEAL TO THE STEEL STRAPPING, ONLY ONE SEAL CRIMPED WITH TWO PAIR OF NOTCHES WILL BE REQUIRED TO SECURE THE JOINT.



PALLET UNIT DETAIL

GROSS WEIGHT ----- 1,130 POUNDS (APPROX)
 CUBE ----- 18 CUBIC FEET (APPROX)

MATERIAL SPECIFICATIONS

LUMBER -----: MIL STD 731; GROUP **IV**.

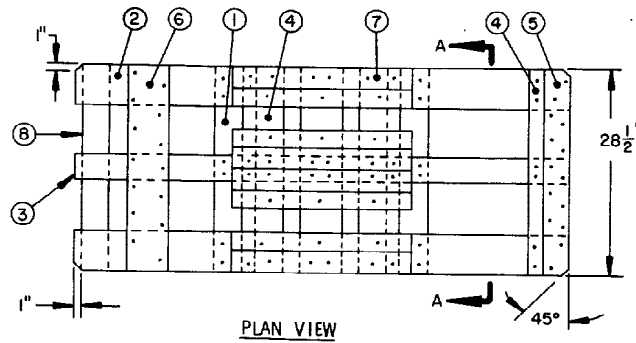
NAILS -----: FED SPEC FF-N-105; TYPE II, STYLE 1B- PALLET NAILS.

STRAPPING, STEEL -----: FED SPEC QQ-S-781; CLASS I, TYPE I OR **IV**, HEAVY DUTY, FINISH B (GRADE 2).

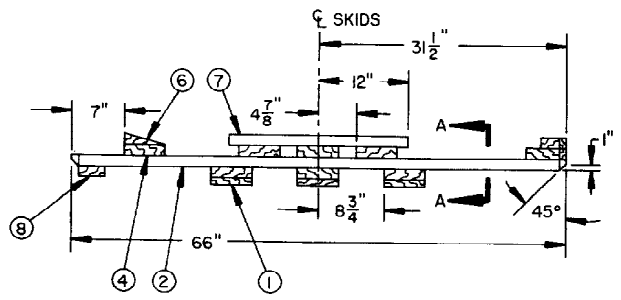
SEAL, STRAP -----: FED SPEC QQ-S-781; TYPE D, STYLE I, II, OR **IV**, CLASS H, FINISH B (GRADE 2).

BILL OF MATERIAL

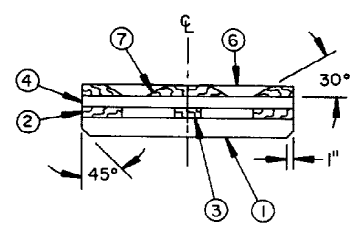
LUMBER	LINEAR FEET	BOARD FEET
2" X 4"	11	8
2" X 6"	34	34
3" X 6"	8	12
NAILS	N.O. REQD	POUNDS
10d (3") (.148" DIA)	158	2-1/2
16d (3-1/2") (.162" DIA)	36	3/4
STEEL STRAPPING, 1-1/4" X .035" OR .031" ----- 18' REQD -----		3 LBS
SEAL FOR 1-1/4" STRAPPING ----- 4 REQD -----		NIL



PLAN VIEW



ELEVATION VIEW



SECTION A-A

KEY NUMBERS

- ① SKID, 3" X 6" X 28-1/2" (3 REQD). BEVEL BOTH ENDS WITH 1" X 45° ANGLE CUT AS SHOWN.
- ② OUTER STRINGER, 2" X 6" X 66" (2 REQD). NAIL TO THE SKIDS, PIECES MARKED ①, W/4-16d NAILS AT EACH JOINT. BEVEL ENDS ON ONE SIDE WITH 1" X 45° ANGLE CUT AS SHOWN. ALSO BEVEL BOTTOM AT BOTH ENDS WITH 1" X 45° ANGLE CUT AS SHOWN.
- ③ CENTER STRINGER, 2" X 4" X 66" (1 REQD). NAIL TO THE SKIDS, PIECES MARKED ①, W/4-16d NAILS AT EACH JOINT. BEVEL BOTTOM AT BOTH ENDS WITH 1" X 45° ANGLE CUT AS SHOWN.
- ④ DECK BOARD, 2" X 6" X 28-1/2" (5 REQD). NAIL TO STRINGERS, PIECES MARKED ② AND ③, W/5-10d NAILS AT EACH JOINT. BEVEL ENDS ON ONE SIDE OF ONE PIECE WITH 1" X 45° ANGLE CUT FOR BASE END.
- ⑤ BASE-END STOP PIECE, 2" X 4" X 28-1/2" (1 REQD). NAIL TO THE DECK BOARD. PIECE MARKED ④, W/14-10d NAILS. BEVEL ENDS ON ONE SIDE WITH 1" X 45° ANGLE CUT AS SHOWN.
- ⑥ NOSE-END SUPPORT PIECE, 2" X 6" X 28-1/2" (1 REQD). BEVEL ONE LONGITUDINAL SIDE OF TOP SURFACE AS SHOWN. NAIL TO THE DECK BOARD, PIECE MARKED ④, W/14-10d NAILS.
- ⑦ SADDLE BLOCK, 2" X 6" X 24" (4 REQD). BEVEL ONE LONGITUDINAL SIDE OF TOP SURFACE AT 30° ANGLE CUT AS SHOWN. NAIL TO THE DECK BOARDS, PIECES MARKED ④, W/3-10d NAILS AT EACH JOINT.
- ⑧ TIE PIECE, 2" X 4" X 28-1/2" (1 REQD). NAIL TO THE BOTTOM OF THE STRINGERS, PIECES MARKED ② AND ③, W/3-10d NAILS AT EACH JOINT.