

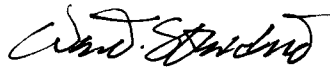
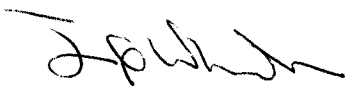
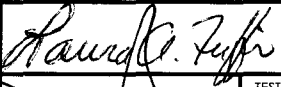

# UNITIZATION PROCEDURES\* FOR 7 INCH X 27 INCH SINGLE ROUND CONTAINERS (SRC) ON 4-WAY EN- TRY PALLETS

\* CAUTION: THE PROCEDURES DEPICTED HEREIN ARE FOR INTRA-INSTALLATION MOVEMENT ONLY.

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## U.S. ARMY MATERIEL COMMAND DRAWING

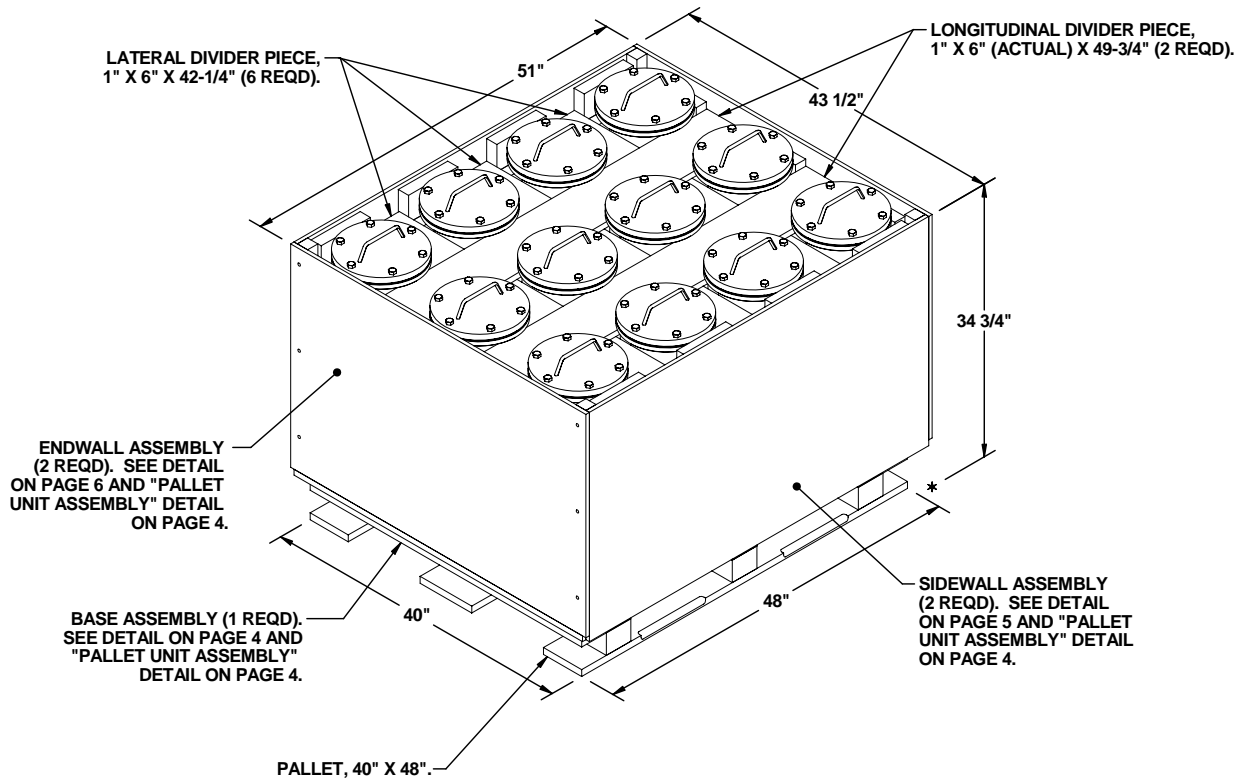
 <b>WM. TROOPER STUDDERT</b> CMA, NATIONAL MAINTENANCE POINT		<u>CAUTION</u> : VERIFY PRIOR TO USE AT WWW.DAC.ARMY.MIL THAT THIS IS THE MOST CURRENT VERSION OF THIS DOCUMENT. THIS IS PAGE 1 OF 6.			
		<b>DO NOT SCALE</b>			
APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND   <b>J. P. WHITE</b> U.S. ARMY DEFENSE AMMUNITION CENTER		ENGINEER OR TECHNICIAN	BASIC REV.	<b>MARK GRACE</b>	<b>JANUARY 2006</b>
		TRANSPORTATION ENGINEERING DIVISION		TESTED	
		ENGINEERING DIRECTORATE			<b>DA-117/2</b>

**GENERAL NOTES**

- A. THIS DOCUMENT HAS BEEN PREPARED AND ISSUED IN ACCORDANCE WITH AR 740-1 (CHAPTER 5) AND CONFORMS TO MIL-STD-1660.
- B. FOR DETAILS OF THE 7 INCH X 27 INCH SINGLE ROUND CONTAINER, SEE EDGEWOOD CBC DRAWING S727001.
  - CONTAINER DIMENSIONS
  - BASE OUTSIDE DIAMETER - - - 10.40"
  - OVERALL LENGTH - - - - - 30.13"
  - GROSS WEIGHT - - - - - 155 LBS (MAX)
- C. DIMENSIONAL LUMBER SPECIFIED THROUGHOUT THIS PROCEDURAL DRAWING IS OF A NOMINAL SIZE, UNLESS OTHERWISE SPECIFIED. FOR EXAMPLE, 1" X 4" MATERIAL IS ACTUALLY 3/4" THICK BY 3-1/2" WIDE AND 2" X 4" MATERIAL IS ACTUALLY 1-1/2" THICK BY 3-1/2" WIDE.
- D. UNLESS OTHERWISE SPECIFIED, A PLUS OR MINUS 1/4" IS ALLOWED ON OVERALL LENGTH AND WIDTH DIMENSIONS OF ANY DUNNAGE ASSEMBLY. HOWEVER, SIMILAR PIECES IN AN ASSEMBLY MUST BE WITHIN 1/8" OF THE SAME DIMENSION. FOR THICKNESS DIMENSIONS, A PLUS ZERO, MINUS 1/8" IS ALLOWED.
- E. WHEN ASSEMBLING A PALLET UNIT, CARE SHALL BE TAKEN TO ENSURE THAT THE ASSEMBLIES ARE EVENLY ALIGNED HORIZONTALLY AND VERTICALLY SO THAT THE SIDES AND ENDS OF THE PALLET UNIT DO NOT EXCEED A 1/2" TOLERANCE.
- F. DIMENSIONS GIVEN FOR DUNNAGE ASSEMBLIES WILL BE FIELD CHECKED PRIOR TO THEIR ASSEMBLY. CONTAINERS MUST FIT SNUGLY IN THE DUNNAGE ASSEMBLIES. THIS GUIDANCE MUST BE APPLIED PRIOR TO BEGINNING A PALLETIZING OPERATION.
- G. THE FOLLOWING AMC DRAWINGS ARE APPLICABLE FOR OUTLOADING AND STORAGE OF THE ITEMS COVERED BY THIS DRAWING.
  - ON-INSTALLATION MOVEMENT - - 19-48-4306-5-11Q1000
  - STORAGE - - - - - 19-48-4515-CB1-14-22P4
- H. WHEN ASSEMBLING THE PALLET UNIT WITH CONTAINERS, CARE SHOULD BE EXERCISED TO PRECLUDE INTERFERENCE WITH THE VARIOUS DIVIDERS. FILL EACH 3-WIDE ROW COMPLETELY AND PLACE LATERAL DIVIDERS INTO THEIR PROPER LOCATION PRIOR TO STARTING AN ADDITIONAL ROW.
- J. THE STYLE 1 PALLET DELINEATED IN THE DETAIL ON PAGE 3 NEED NOT HAVE CHAMFERS OR STRAP SLOTS AS SPECIFIED WITHIN MILITARY SPECIFICATION MIL-P-15011 WHEN USED FOR THE UNITIZATION OF ITEMS COVERED BY THIS DRAWING.
- K. LESS-THAN-FULL PALLET UNITS SHOULD HAVE THE CONTAINERS CENTERED ON THE PALLET TO BALANCE THE LOAD.
- L. 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.
- M. IF LEAKING OR SUSPECT ITEMS COVERED HEREIN ARE UNITIZED PRIOR TO ISSUANCE OF THIS REVISION TO THIS APPENDIX, THE CONTAINERS NEED NOT BE REUNITIZED SOLELY TO CONFORM TO THIS REVISION.
- N. **CAUTION:** DO NOT STACK PALLET UNITS ONE ON TOP OF ANOTHER IN STORAGE OR IN TRANSIT.

**MATERIAL SPECIFICATIONS**

- LUMBER - - - - - : SEE TM 743-200-1 (DUNNAGE LUMBER) AND VOLUNTARY PRODUCT STANDARD PS 20.
- NAILS - - - - - : ASTM F1667; COMMON STEEL NAIL (NLCMS OR NLCMMS) AND PALLET NAIL (NLPL-03). ALT (FOR COMMON NAILS ONLY): UNDERLAYMENT NAIL (NLUL), PALLET NAIL (NLPL), OR COOLER NAIL (NLCL) OF SAME SIZE.
- PALLET - - - - - : MIL SPEC MIL-P-15011; 4-WAY ENTRY, STYLE 1, TYPE 1, CLASS 1, PRESERVATIVE TREATED.
- PLYWOOD - - - - - : COMMERCIAL ITEM DESCRIPTION A-A-55057, INDUSTRIAL PLYWOOD, INTERIOR WITH EXTERIOR GLUE, GRADE C-D. IF SPECIFIED GRADE IS NOT AVAILABLE, A BETTER INTERIOR OR AN EXTERIOR GRADE MAY BE SUBSTITUTED.
- STAPLE - - - - - : ASTM F1667; STFCS-189 OR STFCS-207, 3/8" CROWN WIDTH X 3/4" LEG.
- WIRE, CARBON STEEL - : ASTM A853; ANNEALED AT FINISH, BLACK OXIDE FINISH, 0.0800" DIA, GRADE 1006 OR BETTER.
- WOOD SCREW, LAG - - : COMMERCIAL GRADE; HEX HEAD WOOD SCREW, ZINC PLATE FINISH, LAG SCREW.
- WASHER - - - - - : COMMERCIAL GRADE; WASHER, PLAIN, FLAT. ZINC PLATE FINISH.

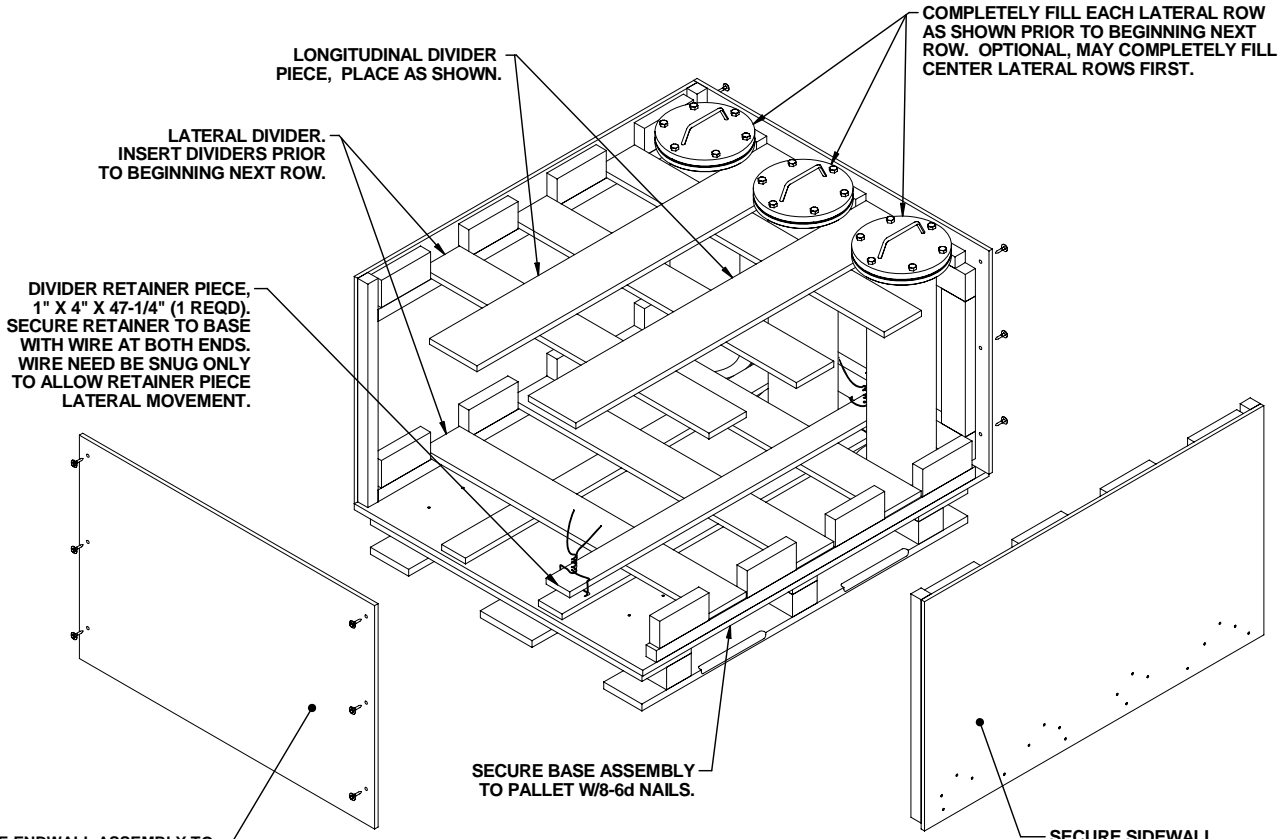


**PALLET UNIT**

12 7 INCH X 27 INCH SRCs @ 155 LBS	-----	1,860 LBS
DUNNAGE	-----	198 LBS
PALLET	-----	80 LBS

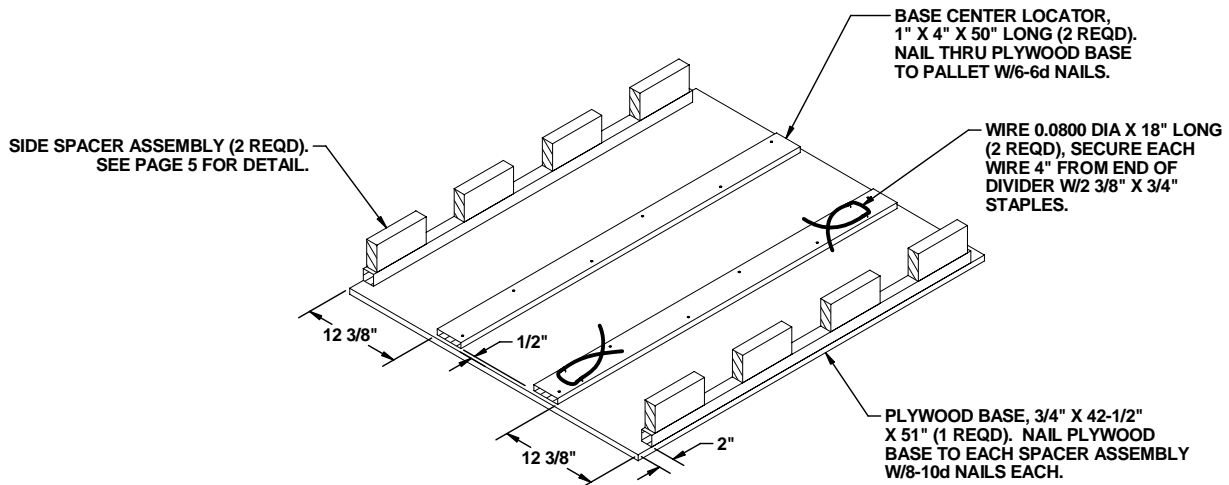
TOTAL WEIGHT	-----	2,138 LBS (APPROX)
CUBE	-----	44.6 CU FT (APPROX)

BILL OF MATERIAL		
LUMBER	LINEAR FEET	BOARD FEET
1" X 4"	8.88	2.78
1" X 6"	21.13	10.56
1" X 7" (ACT)	8.29	4.84
2" X 2"	28.79	9.60
2" X 4"	30.08	28.83
NAI LS	NO. REQD	POUNDS
6d (2")	114	3/4
10d (3")	76	1-1/4
LAG SCREWS	NO. REQD	POUNDS
1/4" X 1-1/2"	12	NIL
WASHERS	NO. REQD	POUNDS
1/4" FLAT	12	NIL
PALLET, 40" X 48"	1 REQD	80 LBS
PLYWOOD, 1/2"	37.53 FT REQD	51.61 LBS
PLYWOOD, 3/4"	15.05 FT REQD	31.04 LBS
WI RE, 0.0800" DIA	3.00 FT REQD	NIL
STAPLE, 3/8" X 3/4"	4 REQD	NIL

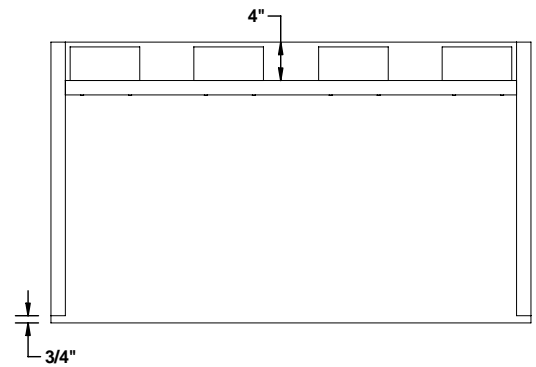
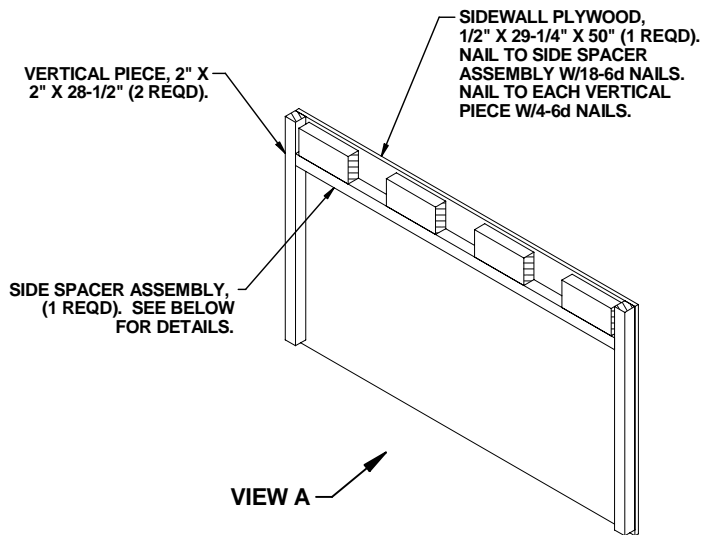


**PALLET UNIT ASSEMBLY**

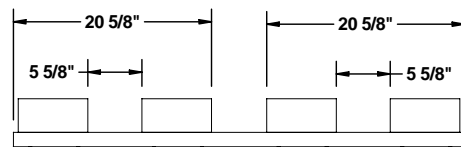
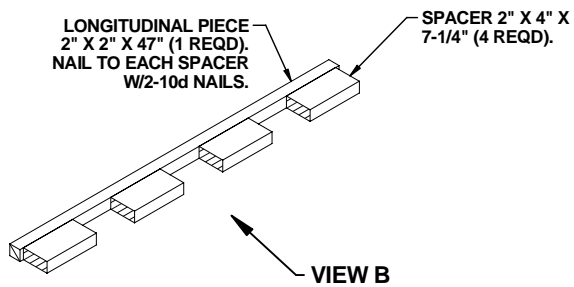
REMOVE ONE ENDWALL OF PALLET ASSEMBLY TO ADD OR REMOVE CONTAINERS. REMOVE DIVIDER RETAINER, LONGITUDINAL DIVIDERS AND LATERAL DIVIDERS. FILL PALLET UNIT FROM END (OR CENTER TO MAINTAIN PROPER BALANCE). NOTE: FILL EACH THREE WIDE LATERAL ROW COMPLETELY BEFORE STARTING NEXT ROW. ADD LATERAL DIVIDERS AS EACH 3 WIDE LATERAL ROW IS COMPLETED. REASSEMBLE IN REVERSE ORDER.



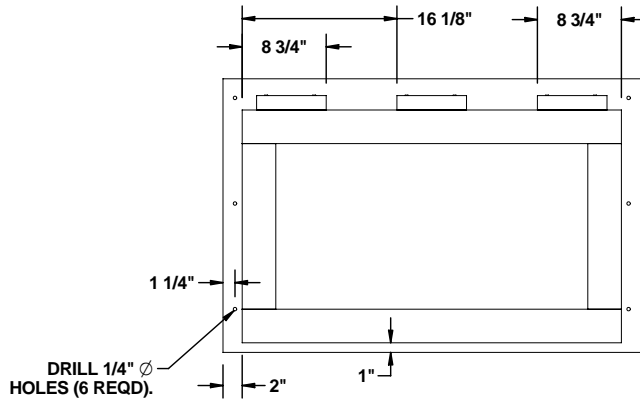
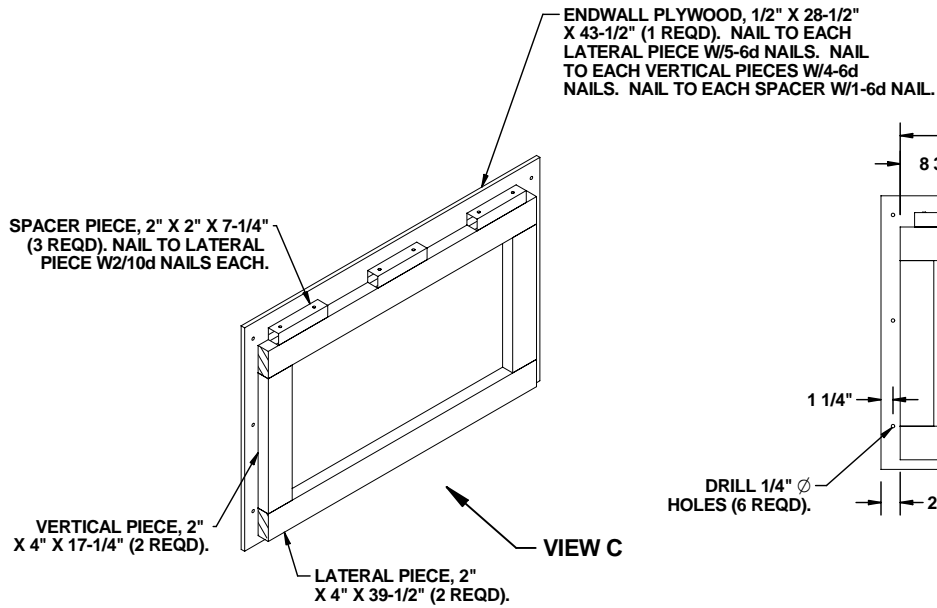
**BASE ASSEMBLY**



**SIDEWALL ASSEMBLY**



**SIDE SPACER ASSEMBLY**



VIEW C

ENDWALL ASSEMBLY