




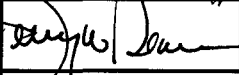
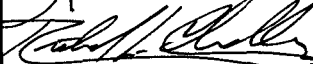
UNITIZATION PROCEDURES* FOR 10 INCH X 96 INCH SINGLE ROUND CONTAINERS (SRC) ON 4-WAY EN- TRY PALLETS

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

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U.S. ARMY MATERIEL COMMAND DRAWING

		<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 4.	
 WM. TROOPER STUDDERT CMA, NATIONAL MAINTENANCE POINT		DO NOT SCALE	
		JANUARY 2006	
APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND  U.S. ARMY DEFENSE AMMUNITION CENTER		ENGINEER OR TECHNICIAN	BASIC REV.
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		ENGINEERING DIRECTORATE	
		DRAWING	
		DA-117/4	

GENERAL NOTES

(GENERAL NOTES CONTINUED)

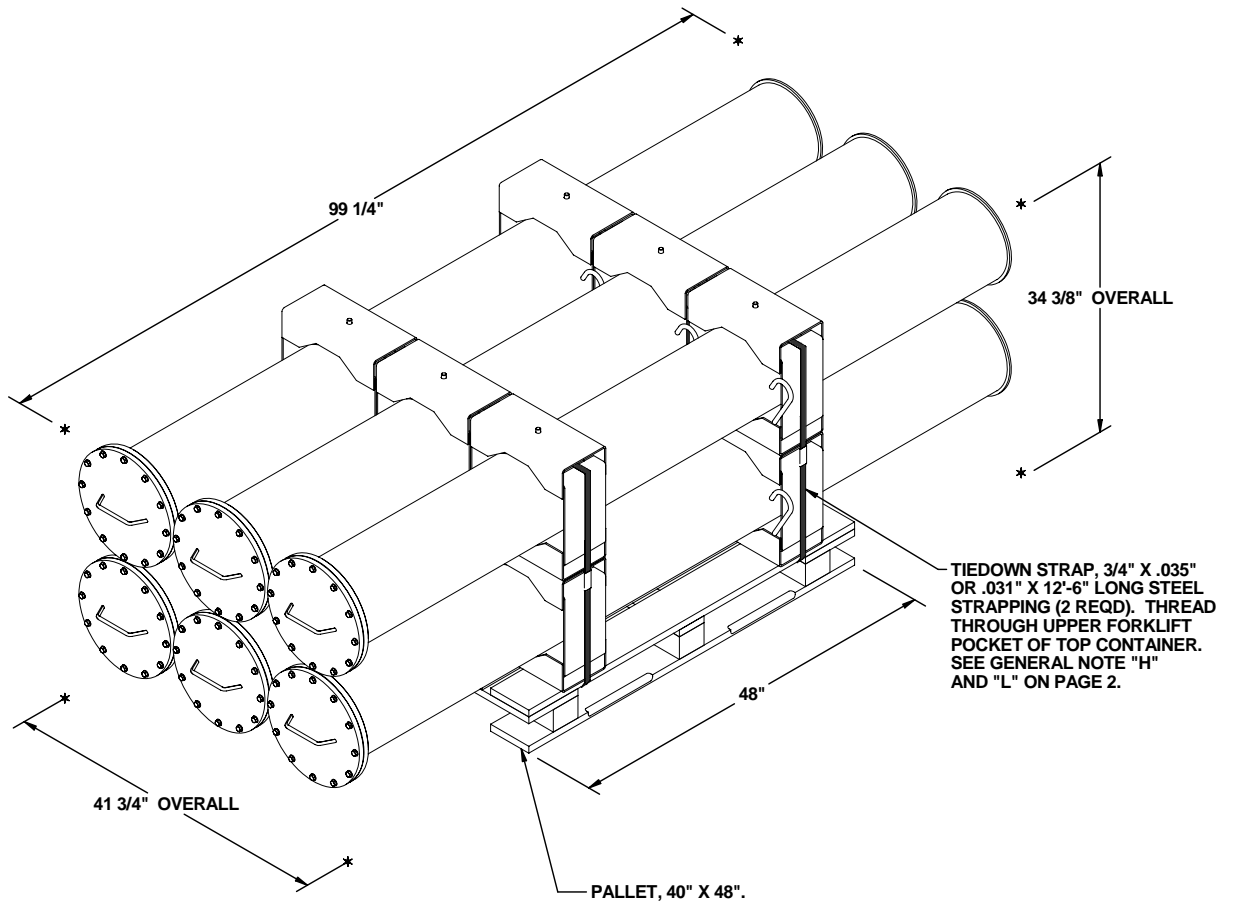
- A. THIS DOCUMENT HAS BEEN PREPARED AND ISSUED IN ACCORDANCE WITH AR 740-1 (CHAPTER 5) AND CONFORMS TO MIL-STD-1660.
- B. FOR DETAILS OF THE 10 INCH X 96 INCH SINGLE ROUND CONTAINER, SEE DAC DRAWING ACV00402.
CONTAINER DIMENSIONS
BASE OUTSIDE DIMENSION - - - 13.50"
OVERALL LENGTH - - - - - 99.25"
GROSS WEIGHT - - - - - 460 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. ALSO, DUE TO VARIATION OF CONTAINER DIMENSIONS AND CONTAINER HANDLES, ADJUSTMENTS MAY BE REQUIRED AS TO THE LOCATION OF CERTAIN PIECES ON SOME DUNNAGE ASSEMBLIES.
- G. THE FOLLOWING AMC DRAWINGS ARE APPLICABLE FOR OUTLOADING AND STORAGE OF THE ITEMS COVERED BY THIS DRAWING.
ON-INSTALLATION MOVEMENT - - - 19-48-4306-5-1101000
STORAGE - - - - - 19-48-4515-CB1-14-22P4
- H. PALLET UNITIZATION TIEDOWN STRAPS ARE REQUIRED FOR "ON SITE" CONTAINER INTRA DEPOT TRANSPORT. PALLET UNITS WILL BE ASSEMBLED AS SHOWN ON PAGE 3.
- J. IN ORDER TO OBTAIN COMPACT (SOUND) UNITS, ALL STRAPS SHALL BE LOCATED IN PROPER ALIGNMENT AND TENSIONED UNTIL THEY CUT INTO THE EDGE OF THE PALLET DECK. AFTER TENSIONING, ALL STRAPS WILL BE SECURED USING ONE SEAL AND TWO PAIR OF NOTCHES PER SEAL. ALL STRAPPING MUST BE STRAIGHT WITHIN 2" ON ANY SURFACE OF THE UNITIZED LOAD.
- K. WHEN APPLYING ANY STRAP, CARE MUST BE EXERCISED TO ASSURE THAT THE END OF THE STRAP ON THE UNDERSIDE OF THE JOINT EXTENDS AT LEAST 6" BEYOND THE SEAL. THIS EXTRA MINIMUM LENGTH OF STRAP IS REQUIRED TO PERMIT SUBSEQUENT TIGHTENING OF LOOSENED STRAPPING. RETENSIONING CAN BE ACCOMPLISHED WITHOUT REPLACING STRAPPING OR SPLICING STRAPPING THROUGH THE USE OF A MANUAL OR PNEUMATIC FEEDWHEEL TYPE TENSIONING TOOL AND THE APPLICATION OF ONE ADDITIONAL SEAL.

- L. INSTALL EACH TIEDOWN STRAP TO PASS UNDER THE TOP DECK BOARDS OF THE PALLET. NOTE THAT THE STRAPS WILL BE LOCATED AS SHOWN.
- M. 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.
- N. LESS-THAN-FULL PALLET UNITS SHOULD HAVE THE CONTAINERS CENTERED ON THE PALLET TO BALANCE THE LOAD. SEE "PARTIAL PALLET UNITS" DETAIL ON PAGE 4.
- 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. 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.
- Q. **CAUTION:** DO NOT STACK PALLET UNITS ONE ON TOP OF ANOTHER IN STORAGE OR IN TRANSIT.

(CONTINUED AT RIGHT)

MATERIAL SPECIFICATIONS

- PALLET - - - - - : MIL SPEC MIL-P-15011: 4-WAY ENTRY, STYLE 1, TYPE I, CLASS 1, PRESERVATIVE TREATED.
- STRAPPING, STEEL - - : ASTM D3953: FLAT STRAPPING, TYPE 1, HEAVY DUTY, FINISH B (GRADE 2), SIZE 3/4" X .035" OR .031". NOTE: BRIGHT OR SLIT EDGES SHALL HAVE FINISH A OVERLAY.
- SEAL, STRAP - - - - : ASTM D3953: CLASS H, FINISH B (GRADE 2), DOUBLE NOTCH TYPE, STYLE I, II, III, OR IV. ALTERNATIVE SEAL FINISH: SIGNODE PAINTED SEALS MAY BE USED AS AN ALTERNATIVE IF ALL SURFACES ARE PAINTED. GRITTED BACKING IS NOT PERMITTED.
- STAPLE - - - - - : ASTM F1667: STFCS-189 OR STFCS-207, 1" CROWN WIDTH X 1" LEG.

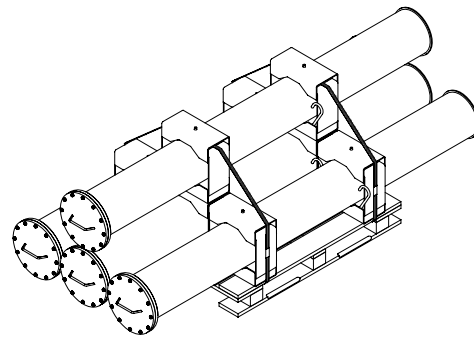
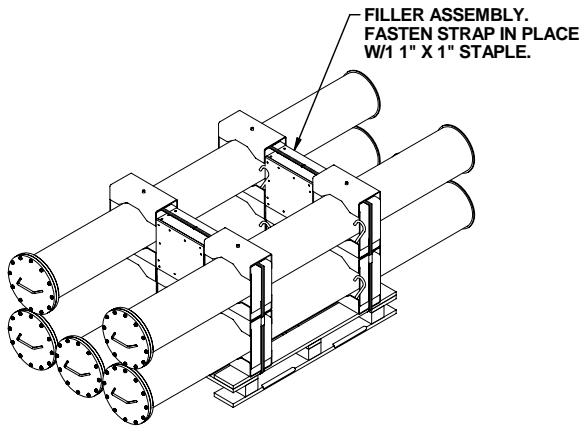


PALLET UNIT

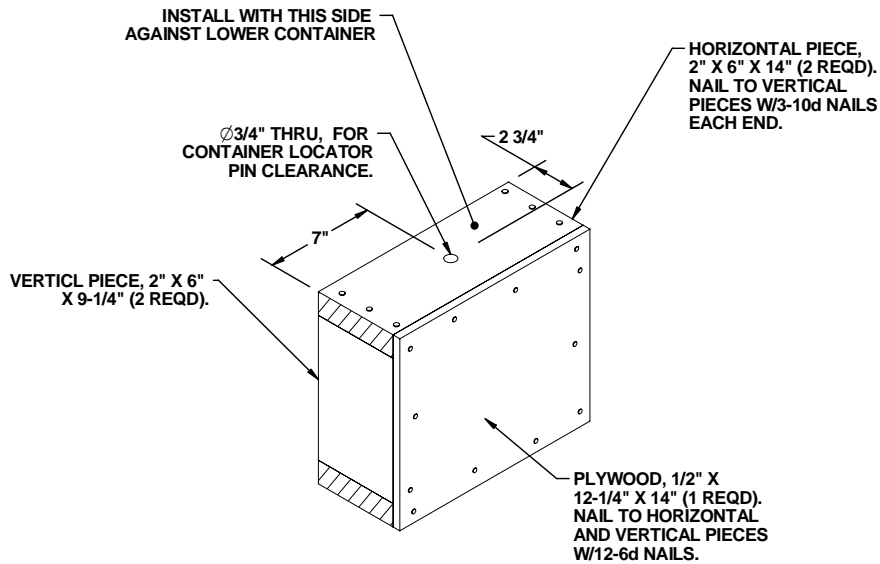
6 10 INCH X 96 INCH SRCs @ 460 LBS	-----	2,760 LBS
DUNNAGE	-----	2 LBS
PALLET	-----	80 LBS

TOTAL WEIGHT	-----	2,842 LBS (APPROX)
CUBE	-----	81.6 CU FT (APPROX)

BILL OF MATERIAL		
PALLET, 40" X 48"	-----	1 REQD ----- 80 LBS
STEEL STRAPPING, 3/4"	-----	25.00' REQD ----- 2.23 LBS
SEAL FOR 3/4" STRAPPING	-----	2 REQD ----- NIL



PARTIAL PALLET UNITS



FILLER ASSEMBLY