

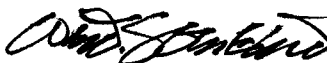

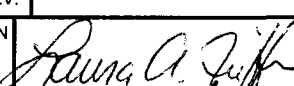
UNITIZATION PROCEDURES* FOR 5.4 INCH BY 36 INCH RETROFIT M55 CONTAINERS (SRC) ON 4-WAY EN- TRY PALLETS

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

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U.S. ARMY MATERIEL COMMAND DRAWING

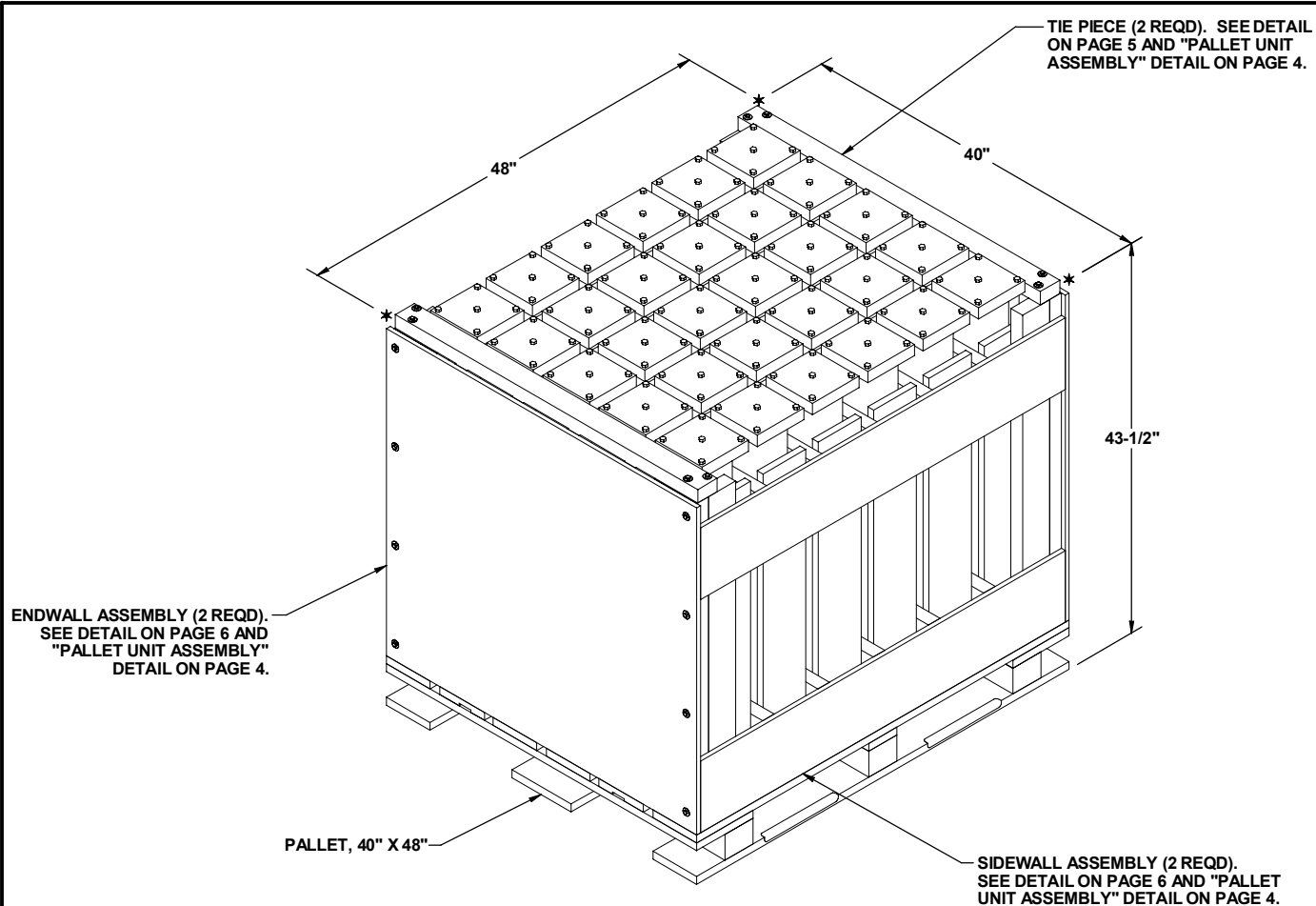
		CAUTION: VERIFY PRIOR TO USE AT WWW.DAC.ARMY.MIL THAT THIS IS THE MOST CURRENT VERSION OF THIS DOCUMENT. THIS IS PAGE 1 OF 6.		
 WM. TROOPER STUDDERT CMA, NATIONAL MAINTENANCE POINT		DO NOT SCALE		
		OCTOBER 2007		
APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND  GARY B. CARNEY U.S. ARMY DEFENSE AMMUNITION CENTER		ENGINEER OR TECHNICIAN	BASIC REV.	
		MELVIN SIX		
		TRANSPORTATION ENGINEERING DIVISION		
		VALIDATION ENGINEERING DIVISION	TESTED	
		ENGINEERING DIRECTORATE		
		DRAWING		
		DA-117/7		

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 5.4 INCH X 36 INCH RETROFIT M55 CONTAINER (SRC), SEE ARMY ARMAMENTS, CHEMICAL AND MUNITIONS COMMAND DRAWING S54360001.
- CONTAINER DIMENSIONS
BASE OUTSIDE DIAMETER - - - 5.4"
OVERALL LENGTH - - - - - 36"
GROSS WEIGHT - - - - - 70 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- - - 19-48-4306-5-11Q1000
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 FIVE-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 DRAWING, THE CONTAINERS NEED NOT BE REUNITIZED SOLELY TO CONFORM TO THIS DRAWING.
- N. **CAUTION:** DO NOT STACK PALLET UNITS ONE ON TOP OF ANOTHER IN STORAGE OR IN TRANSIT.

MATERIAL SPECIFICATIONS

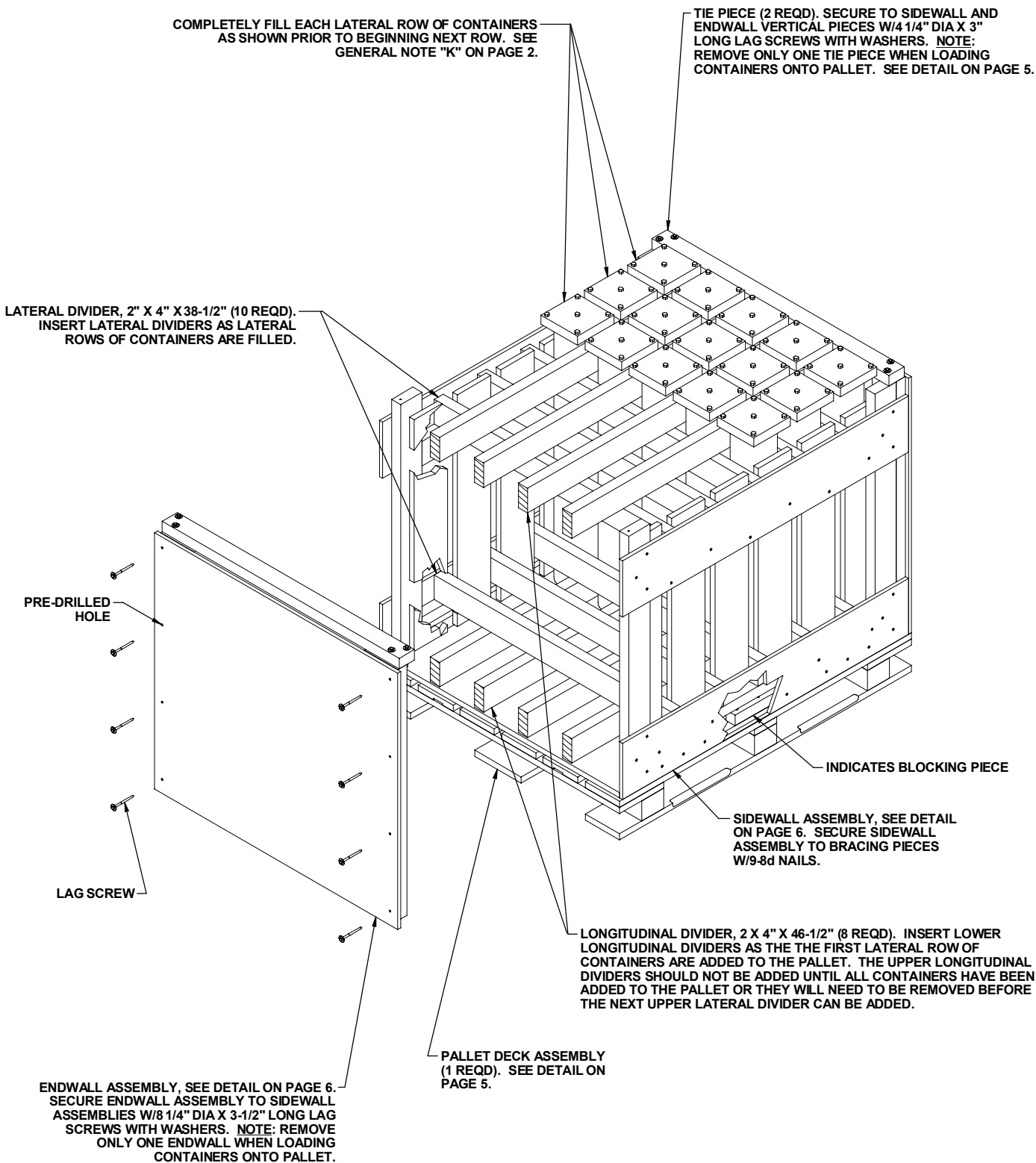
- LUMBER - - - - - : SEE TM 743-200-1 (DUNNAGE LUMBER) AND VOLUNTARY PRODUCT STANDARD PS 20.
- NAILS - - - - - : ASTM F1667; COMMON STEEL NAIL (NLCMS OR NLCMMS) AND PALLET NAIL (NLPL-03). ALT (FOR COMMON NAILS ONLY): UNDERLAYMENT NAIL (NLUL), PALLET NAIL (NLPL), OR COOLER NAIL (NLCL) OF SAME SIZE.
- PALLET - - - - - : MIL SPEC MIL-P-15011; 4-WAY ENTRY, STYLE 1, TYPE I, 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.
- 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

30 5.4" x 36" RETROFIT M55 SRC @ 70 LBS	-----	2,100 LBS
DUNNAGE	-----	294 LBS
PALLET	-----	80 LBS
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TOTAL WEIGHT	-----	2,474 LBS (APPROX)
CUBE	-----	48.3 CU FT (APPROX)

BILL OF MATERIAL		
LUMBER	LINEAR FEET	BOARD FEET
1" X 6"	33.00	16.50
2" X 2"	10.67	3.56
2" X 3"	6.50	3.25
2" X 4"	90.50	60.33
2" X 6"	41.50	41.50
NAILS	NO. REQD	POUNDS
6d (2")	172	1
10d (3")	90	1-1/2
LAG SCREWS	NO. REQD	POUNDS
1/4" X 3"	8	1/2
1/4" X 3-1/2"	16	3/4
WASHERS	NO. REQD	POUNDS
1/4" FLAT	24	NIL
PALLET, 40" X 48"	----- 1 REQD	80 LBS
PLYWOOD, 1/2"	10.99 SQ FT REQD	15.11 LBS
PLYWOOD, 3/4"	12.08 SQ FT REQD	24.91 LBS

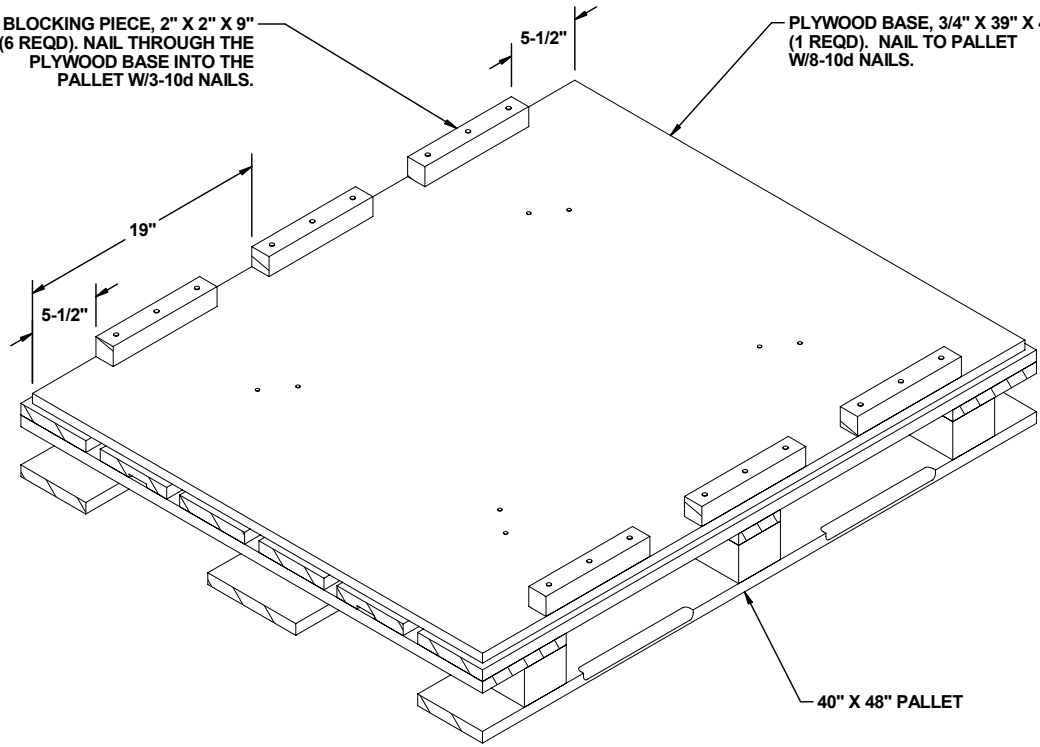


PALLET UNIT ASSEMBLY

REMOVE ONLY ONE SIDEWALL ASSEMBLY AND TIE PIECE WHEN PLACING CONTAINERS ONTO PALLET. FILL EACH FIVE-WIDE LATERAL ROW OF CONTAINERS COMPLETELY PRIOR TO BEGINNING ANOTHER ROW AS SHOWN. PLACE LATERAL DIVIDERS INTO PROPER LOCATION PRIOR TO BEGINNING ANOTHER ROW.

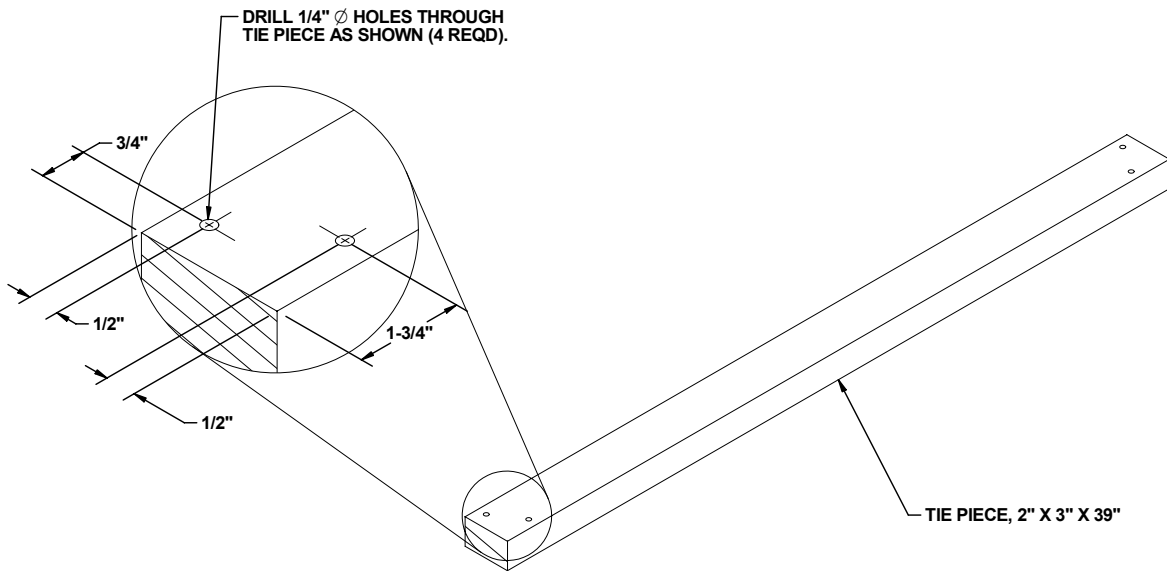
BLOCKING PIECE, 2" X 2" X 9"
(6 REQD). NAIL THROUGH THE
PLYWOOD BASE INTO THE
PALLET W/3-10d NAILS.

PLYWOOD BASE, 3/4" X 39" X 47"
(1 REQD). NAIL TO PALLET
W/8-10d NAILS.

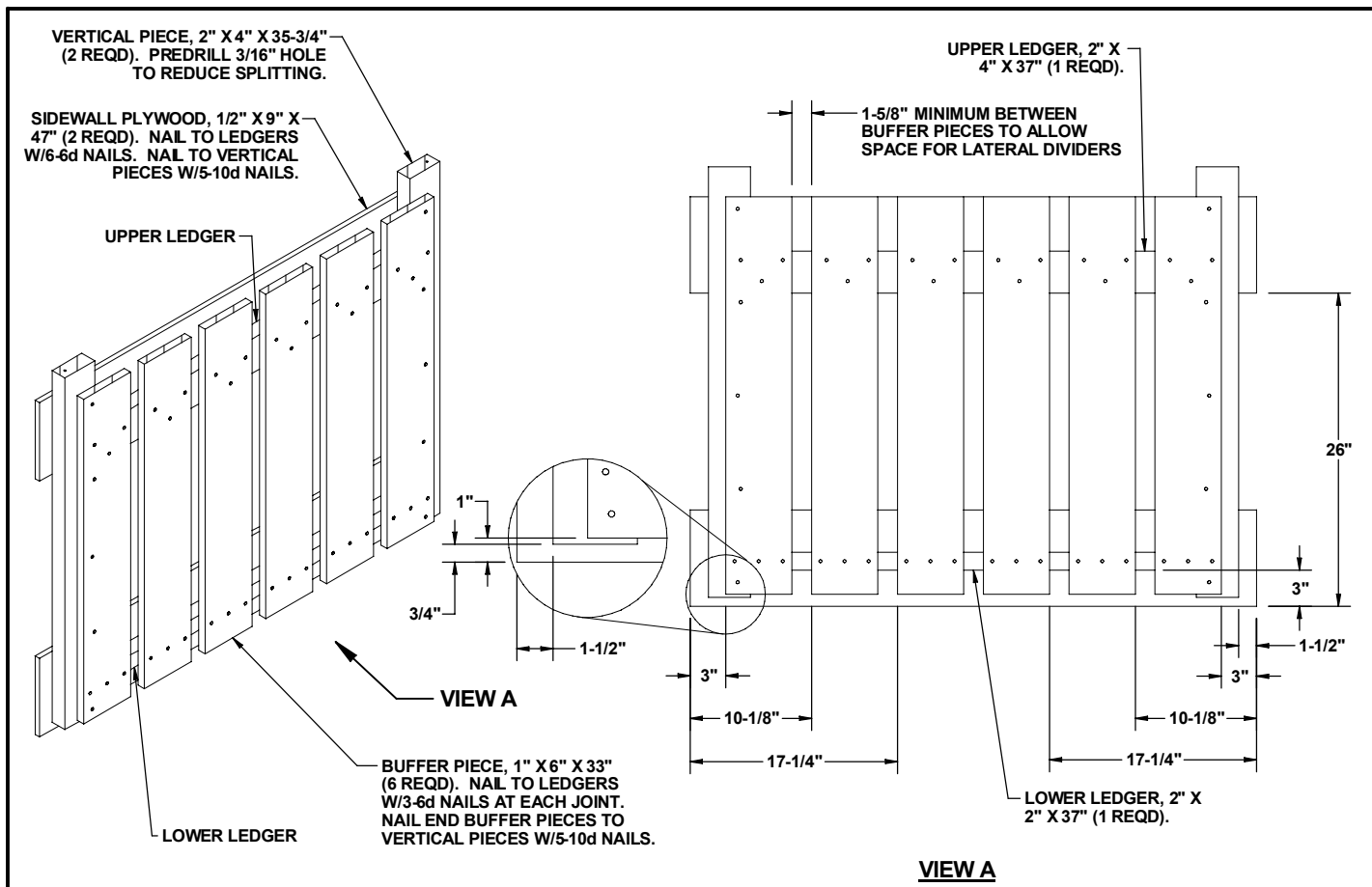


PALLET DECK ASSEMBLY

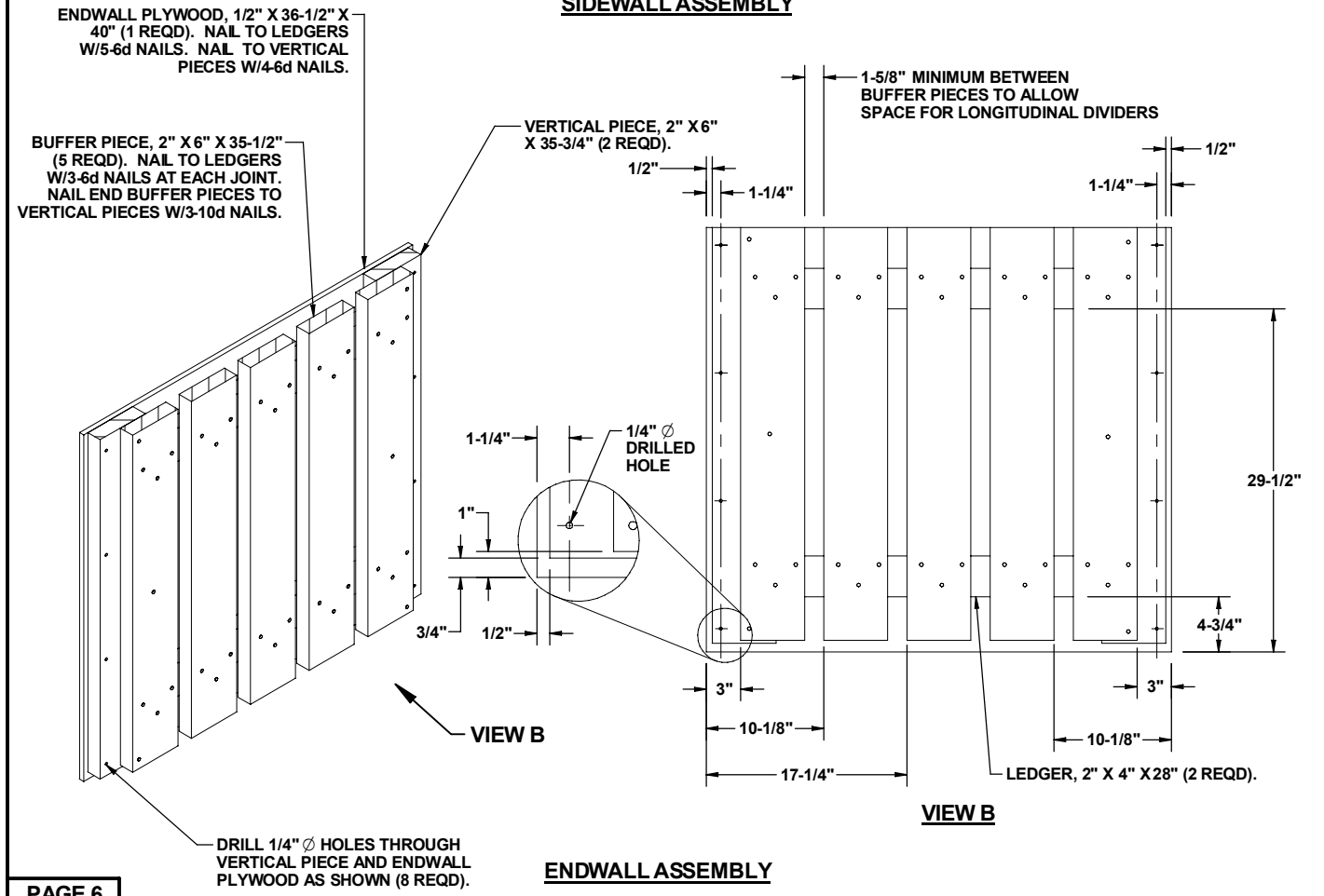
DRILL 1/4" Ø HOLES THROUGH
TIE PIECE AS SHOWN (4 REQD).



TIE PIECE



SIDEWALL ASSEMBLY



ENDWALL ASSEMBLY