

**NOTES:**

1. THE SEALLESS (CLIPLESS) SEALING TOOL LISTED BELOW IS AUTHORIZED FOR USE IN PLACE OF SEALS CURRENTLY SPECIFIED.
2. FOR A PROPER SEAL, FOLLOW THE MANUFACTURER INSTRUCTIONS FOR PROPER OPERATION OF THE TOOL. INSPECTION OF THE SEAL IS REQUIRED TO INSURE A PROPER SEAL. FOR INSPECTION CRITERIA, SEE SHEET 2 OF THIS DRAWING FOR FURTHER INFORMATION. **WARNING:** IMPROPERLY FORMED SEALLESS JOINT, OR A SEALLESS JOINT WITH THE INCORRECT NUMBER OF INTERLOCKING KEYS, COULD RESULT IN STRAP SEPARATION.
3. ONLY ITEMS DESCRIBED ON THIS DRAWING ARE APPROVED FOR USE IN THE APPLICATIONS SPECIFIED HEREIN. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY THE COGNIZANT DESIGN ACTIVITY.
4. IDENTIFICATION OF THE APPROVED SOURCE(S) WITHIN THIS DRAWING IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR THE ITEM (S).
5. IN ORDER TO BECOME AN APPROVED ALTERNATIVE SEALLESS STRAPPING TOOL, THE FOLLOWING TEST CRITERIA MUST BE MET TO A MINIMUM:

(NOTES CONTINUED)

- A. THREE SAMPLES OF PARENT STRAPPING WILL BE PULL TESTED PER ASTM D3953 AND MEET THE MINIMUM BREAKING STRENGTH REQUIREMENT FOR THAT SIZE OF STRAPPING.
- B. THREE SAMPLES OF JOINED STRAPPING WILL BE PULL TESTED PER ASTM D3953 AND MEET THE MINIMUM 75% JOINT EFFICIENCY STRENGTH REQUIREMENT FOR THAT SIZE OF STRAPPING AS SPECIFIED IN ASTM D3953.
- C. THREE SAMPLES OF JOINED STRAPPING WILL BE PULL TESTED PER ASTM D3953 AND MEET THE MINIMUM 75% JOINT EFFICIENCY STRENGTH REQUIREMENT FOR THAT SIZE OF STRAPPING AFTER 336 HOURS OF SALT FOG/SPRAY TESTING PER ASTM B117.
- D. TWO OF THREE PALLET UNITS WEIGHTED TO AT LEAST 4,000 POUNDS USING THE SEALLESS JOINED STRAPPING WILL PASS UNIT LOAD TESTING PRESCRIBED IN MIL-STD-1660.

REVISION			APPROVED	
LTR.	DESCRIPTION	ENG.	BY	DATE
-	PRODUCTION BASELINE ERR R9T2343 / 99-12-20	MB	FRERICHS	99-12-20
A	ECP R06K3011 / 06-06-16	MB	WILLIS	06-07-12
B	ECP R08K3011 / 08-12-24	MB	FIEFFER	09-01-27
C	ECP R10K2003-13 / 10-04-27	DO	FIEFFER	11-09-15
D	ECP R11S2057-1 / 12-11-14	MT	FIEFFER	13-06-13

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

(CONTINUED AT RIGHT)

APPROVED SOURCES OF SUPPLY

VENDOR NUMBER	NAME AND ADDRESS	APPROVED FOR USE WITH	APPROVED APPLICATION	NOTCH TYPE	PART NUMBER
SPC 3431	SIGNODE 3650 WEST LAKE AVE GLENVIEW, IL 60026	3/4" X 0.031" STEEL STRAPPING ONLY	PNEUMATIC HAND TOOL	FOUR KEY REVERSE LOCK JOINT	ACV00617-1
WS 19/3 + 1 FREY AND WEISCHE HEAD	SAMUEL STRAPPING 1401 DAVEY ROAD #300 WOODRIDGE, IL 60517	3/4" X 0.031" STEEL STRAPPING ONLY	HYDRAULIC AUTOMATED PALLETIZER EQUIPMENT	THREE KEY W/1 TEAR DROP NOTCH	ACV00617-2

SOURCE CONTROL DRAWING

REVISION STATUS OF SHEETS	
SHEET	REVISION
1 OF 2	D
2 OF 2	D

DISTRIBUTION STATEMENT A.

APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

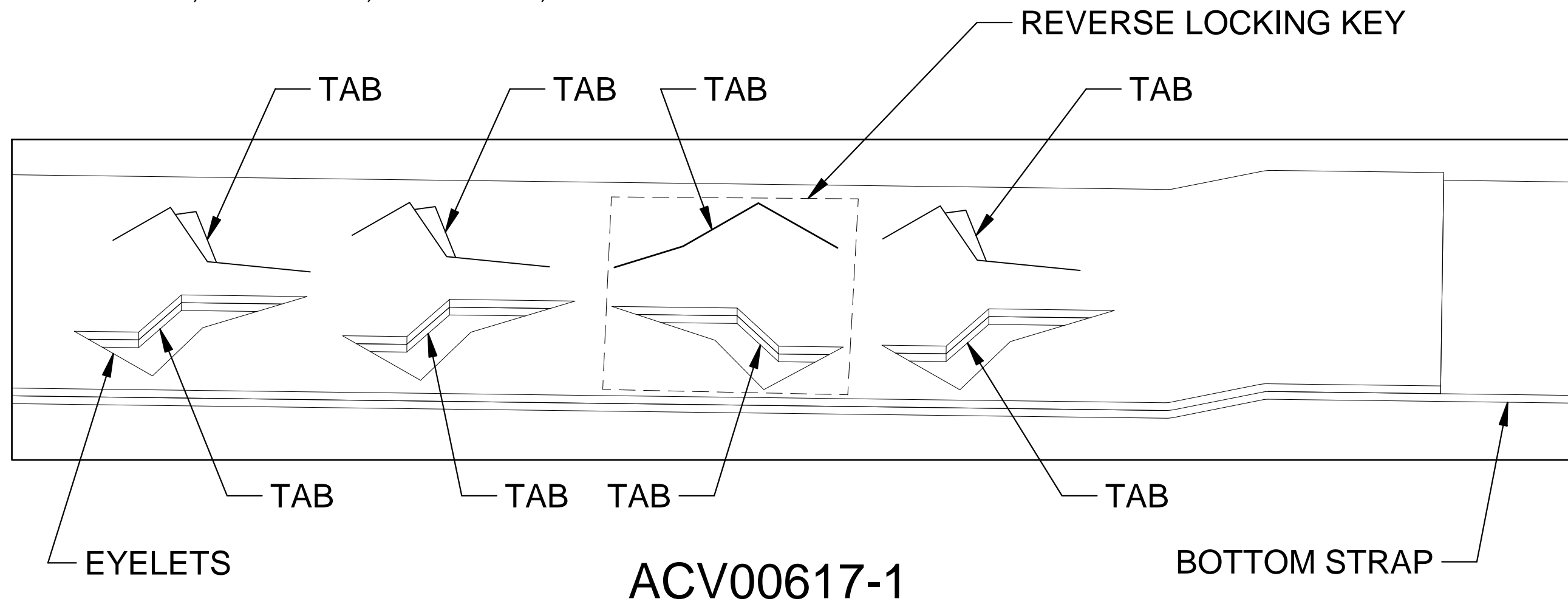
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES		DATE 99-06-18	PROJECT ENGINEER M. Bartosiak	DESIGN ACTIVITY U.S. ARMY COMBINED ARMS SUPPORT COMMAND DEFENSE AMMUNITION CENTER (DAC) MCALESTER, OKLAHOMA 74501-9053	
TOLERANCES: .XX ±.06    .XXX ±.005    FRACTIONS ±0°15'    125 ±1/64		TEST REPORT NA	TEST ENGINEER Jerry Beaver	SEALLESS COMBINATION TOOL FOR 3/4" STEEL STRAPPING	
REMOVE ALL BURRS AND SHARP EDGES .010 R OR CHAMFER MAX.		Mark Jordan CHIEF, MAINTENANCE ENGINEERING DIVISION			
MATERIAL 19-48-4015 SERIES 19-48-4138 SERIES 19-48-4042A SERIES 19-48-4116 SERIES		SUBMITTED William R. Frereichs ASSOCIATE DIRECTOR FOR ENGINEERING APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIAL COMMAND			
NEXT ASSEMBLY    USED ON		James Q. Wheeler DEFENSE AMMUNITION CENTER			
APPLICATION		SIZE C	CAGE 28620	DRAWING No. ACV00617	REV. D
		SCALE 1/1	UNIT WT	SHEET 1 OF 2	

**NOTES:**

1. THE SEAL SHALL BE PERIODICALLY INSPECTED IN ACCORDANCE WITH THE QUALITY INSPECTION PLAN OR WITH THE MANUFACTURER'S OPERATING INSTRUCTIONS.
2. THE SEALS ON THIS DRAWING ARE ONLY APPROVED FOR USE ON AMC UNITIZATION DRAWINGS IN THE 19-48-4116, 19-48-4015, 19-48-4138, OR 19-48-4042A SERIES.

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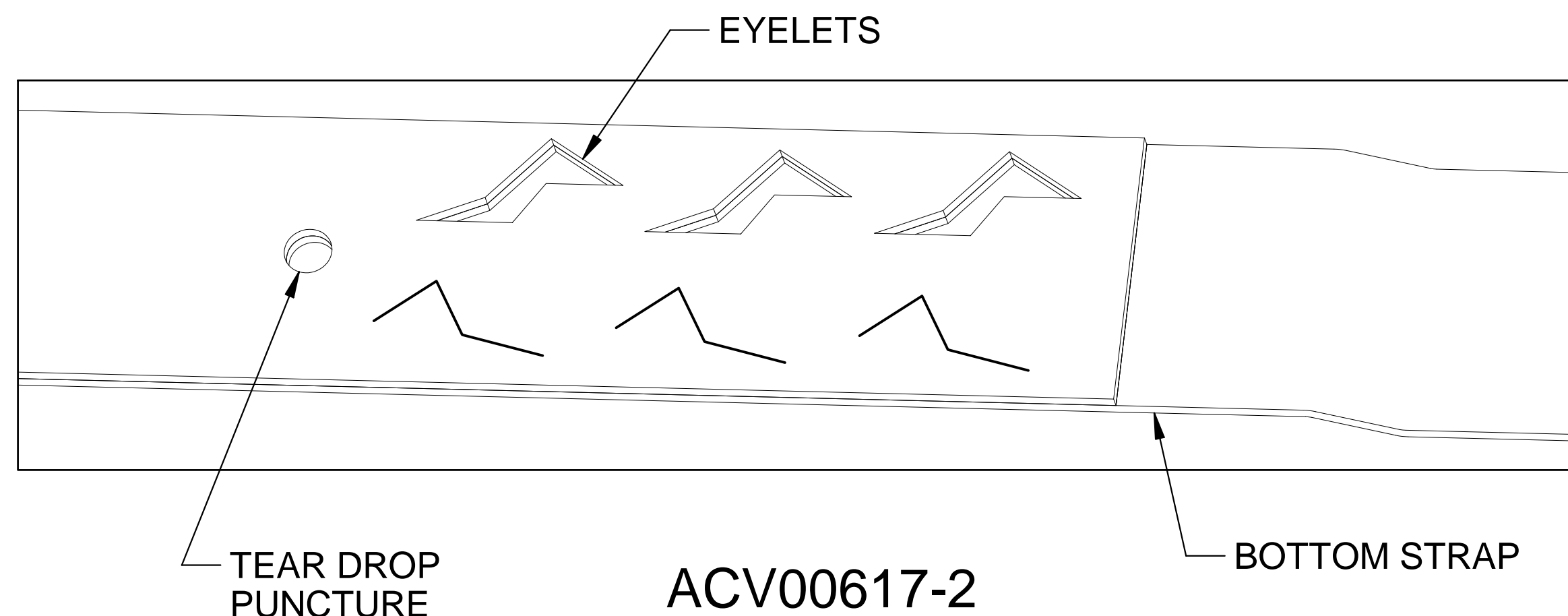
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.



**INSPECTION CRITERIA FOR FOUR KEY REVERSE LOCK JOINT (ACV00617-1)**

LOOK THROUGH BOTH SIDES OF THE EYELETS AND AT THE TOP OF THE JOINT, MAKING CERTAIN THAT IN ALL EIGHT EYELETS YOU CAN SEE THE TABS FROM THE BOTTOM STRAP. IF YOU CANNOT SEE ANY ONE OF THESE TABS, PROCEED AS FOLLOWS:

1. REVIEW THE TOOL'S OPERATING INSTRUCTIONS TO BE CERTAIN THAT THE TOOL IS BEING OPERATED PROPERLY BEFORE APPLYING ANOTHER STRAP.
2. CUT THE STRAP OFF, AND APPLY A NEW STRAP.



**INSPECTION CRITERIA FOR THREE KEY W/1 TEAR DROP NOTCH (ACV00617-2)**

LOOK THROUGH BOTH SIDES OF THE EYELETS AND AT THE TOP OF THE JOINT, MAKING CERTAIN THAT IN ALL SIX EYELETS YOU CAN SEE THE BOTTOM STRAP. ALSO ENSURE "TEAR DROP" PUNCTURE HAS COMPLETELY PENETRATED BOTTOM STRAP. IF YOU CANNOT SEE ANY ONE OF THESE TABS, PROCEED AS FOLLOWS:

1. REVIEW THE TOOL'S OPERATING INSTRUCTIONS TO BE CERTAIN THAT THE TOOL IS BEING OPERATED PROPERLY BEFORE APPLYING ANOTHER STRAP.
2. CUT THE STRAP OFF, AND APPLY A NEW STRAP.

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DATE 99-06-18	PROJECT ENGINEER M. Bartosiak	DESIGN ACTIVITY U.S. ARMY COMBINED ARMS SUPPORT COMMAND DEFENSE AMMUNITION CENTER (DAC) MCALESTER, OKLAHOMA 74501-9053			
TEST REPORT NA	TEST ENGINEER Jerry Beaver	SEALLESS COMBINATION TOOL FOR 3/4" STEEL STRAPPING			
Mark Jordan CHIEF, MAINTENANCE ENGINEERING DIVISION SUBMITTED					
William R. Frerichs ASSOCIATE DIRECTOR FOR ENGINEERING APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIAL COMMAND		SIZE C	CAGE 28620	DRAWING No. ACV00617	REV. D
James Q. Wheeler		SCALE 1/1	UNIT WT	SHEET 2 OF 2	