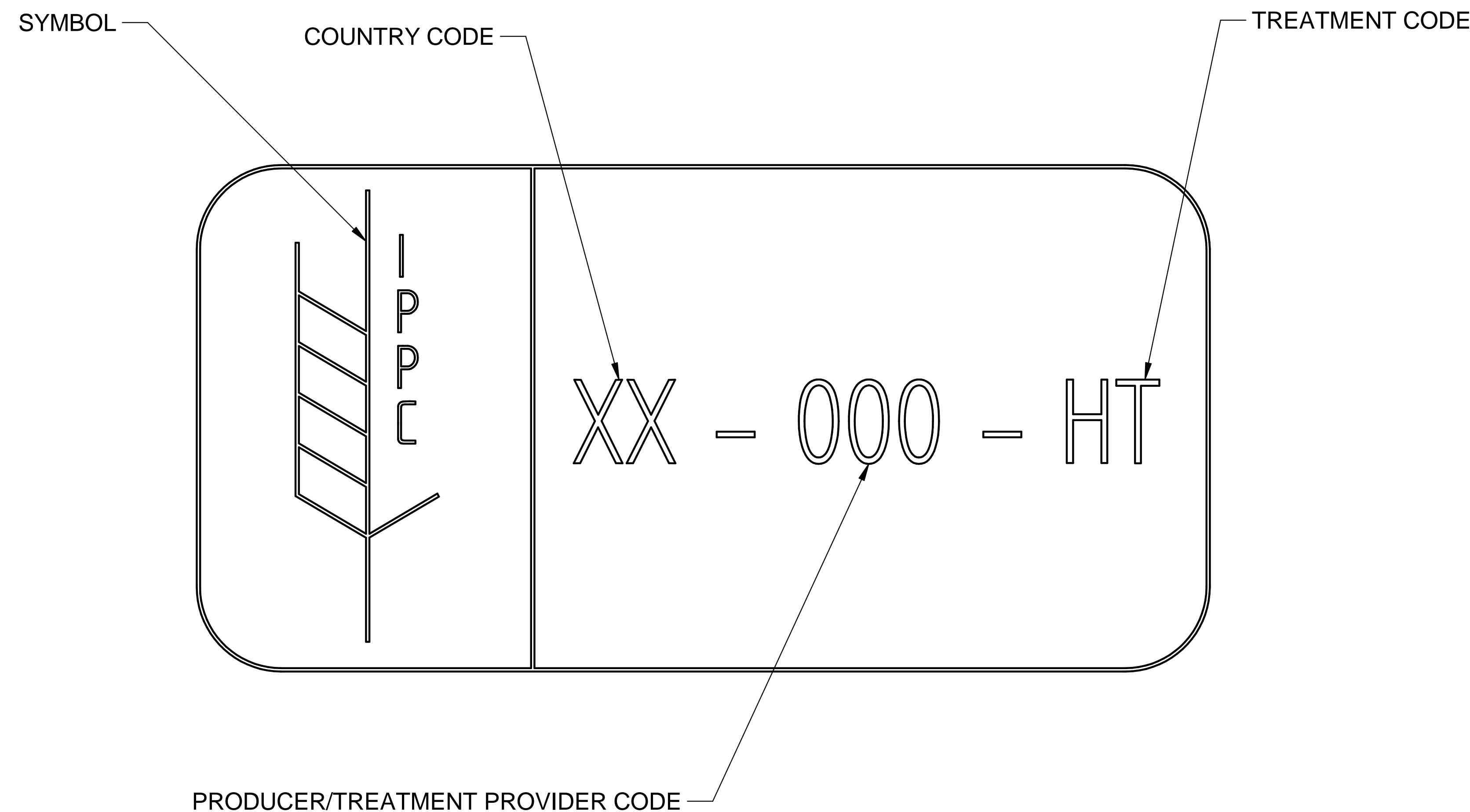


**NOTES:**

1. DOD 4140.65-M, ASME Y14.5, AND ISPM 15 APPLY.
2. IN ACCORDANCE WITH THE REQUIREMENTS OF THE INTERNATIONAL STANDARDS FOR PHYTOSANITARY MEASURES (ISPM) 15; ALL NON-MANUFACTURED WOOD (EXAMPLES: PALLETS, SKIDS, FILLER ASSEMBLIES, DUNNAGE ASSEMBLIES, GATE ASSEMBLIES) SHALL BE HEAT TREATED. ALL HEAT TREATMENT PROCESSES SHALL BE APPROVED BY AN AMERICAN LUMBER STANDARDS COMMITTEE (ALSC) ACCREDITED AGENCY AND IS REQUIRED FOR ALL WOOD PACKAGING MATERIAL (WPM).
3. A PALLET OR SKID MANUFACTURER OR A MANUFACTURER OF LUMBER USED TO BUILD FILLER ASSEMBLIES, DUNNAGE ASSEMBLIES AND GATE ASSEMBLIES FOR PALLETIZED OR SKIDDED LOADS SHALL ENSURE TRACEABILITY TO THE ORIGINAL SOURCE OF THE ISPM 15 CERTIFICATION MARK. FOREIGN MANUFACTURERS SHALL HAVE THE HEAT TREATMENT AND MARKING OF NON-MANUFACTURED WOOD PRODUCTS VERIFIED IN ACCORDANCE WITH THE ISPM 15 COMPLIANCE PROGRAM.
4. INDIVIDUAL PIECES OF LUMBER INTEGRATED INTO A PALLET, SKID, FILLER ASSEMBLY, OR DUNNAGE ASSEMBLY SHOULD NOT BE CONSIDERED INDEPENDENTLY, BUT SHOULD BE CONSIDERED AS A SINGLE UNIT FOR MARKING PURPOSES. THE ISPM 15 CERTIFICATION MARK SHALL BE LEGIBLE, CONTRASTING, AND CLEARLY VISIBLE. ALTHOUGH THESE ASSEMBLIES MUST BE MARKED AS SPECIFIED HEREIN, IT IS UNDERSTOOD AND ACCEPTABLE THE CERTIFICATION MARKING MAY OR MAY NOT BE VISIBLE ON INTERIOR ASSEMBLIES ONCE THE PALLETIZED OR SKIDDED UNIT IS FULLY ASSEMBLED. FIGURE 1 ON SHEET 1 IS DEPICTED FOR INFORMATION PURPOSES ONLY. THE ISPM 15 CERTIFICATION MARK SHALL COMPLY WITH THE SPECIFIC ISPM 15 REQUIREMENTS FOR THE MATERIAL BEING MARKED AND BE LEGIBLE, CONTRASTING, AND CLEARLY VISIBLE.
5. THE ISPM 15 CERTIFICATION MARKS FOR PALLETS, SKIDS, FILLER ASSEMBLIES AND OTHER GATE ASSEMBLIES SHALL BE STENCILED, STAMPED OR BRANDED. AVOID THE USE OF RED OR ORANGE COLORED MARKINGS. THE PALLETS OR SKIDS SHALL BE MARKED ON THE TWO OPPOSITE CORNER END POSTS (SEE FIGURE 2, SHEET 2). CERTIFICATION MARKS SHALL BE APPLIED AT LEAST ON DIAGONALLY OPPOSITE SIDES OF FILLER ASSEMBLIES (SEE FIGURE 3, SHEET 2). FOR THE GATE ASSEMBLIES, WHICH ARE CONSIDERED PART OF THE UNIT LOAD CONFIGURATION, THE CERTIFICATION MARKS SHALL BE APPLIED ON THE DIAGONALLY OPPOSITE SIDES OF THE OUTWARD FACING SURFACES WHEN USED ON THE EXTERIOR SIDE OF THE PALLET LOAD (SEE FIGURE 4, SHEET 2).

REVISION		APPROVED		
LTR.	DESCRIPTION	ENG.	BY	DATE
-	PRODUCTION BASELINE, ERR R10K3003	QT	LF	10-03-01
A	ECP R19K3010, NOR 1 / 22-03-09	QT	LF	22-10-06

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



**FIGURE 1**  
(REFERENCE ONLY)

**DISTRIBUTION STATEMENT A.**

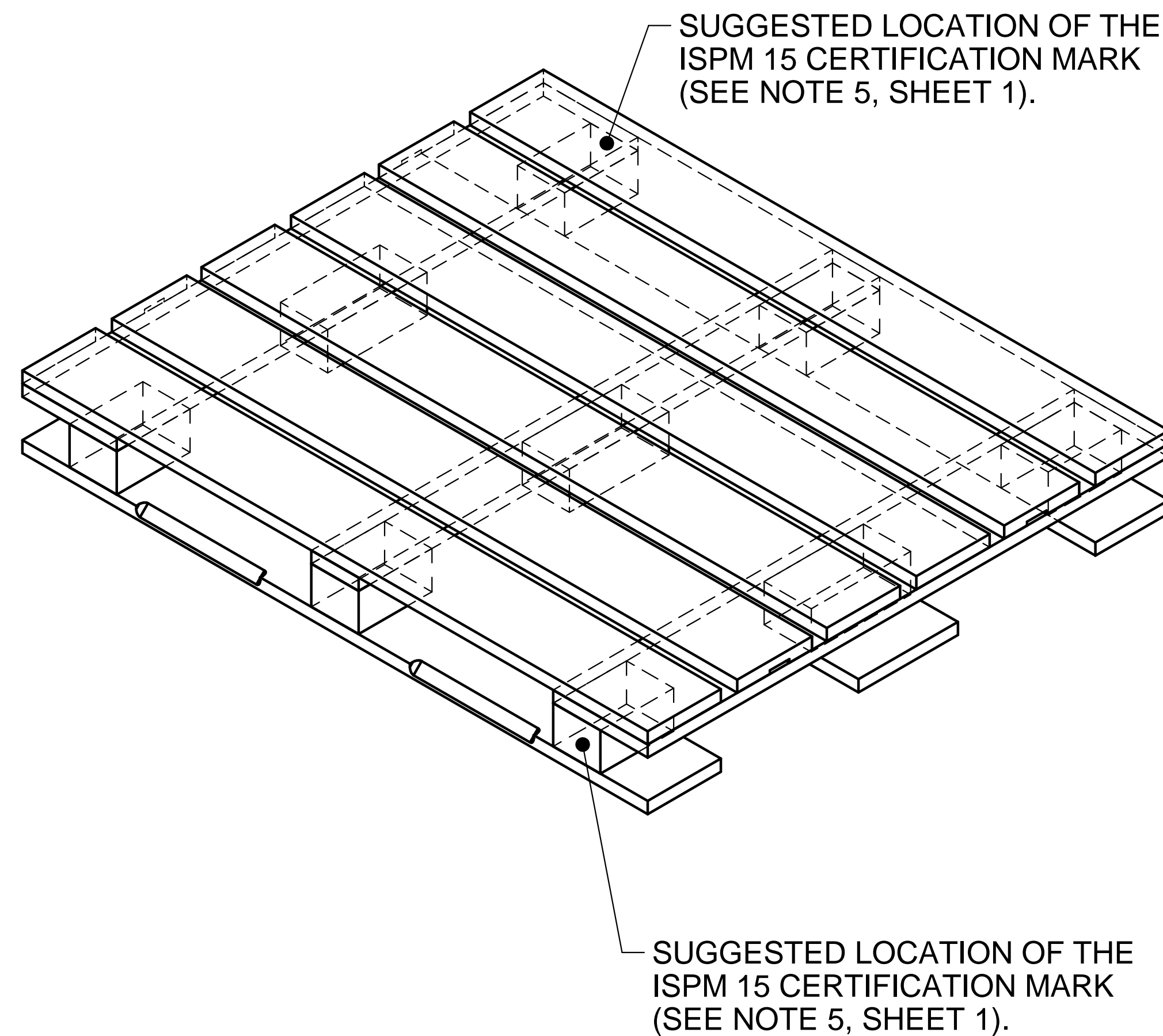
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REVISION STATUS OF SHEETS	
SHEET	REVISION
1 OF 2	A
2 OF 2	A

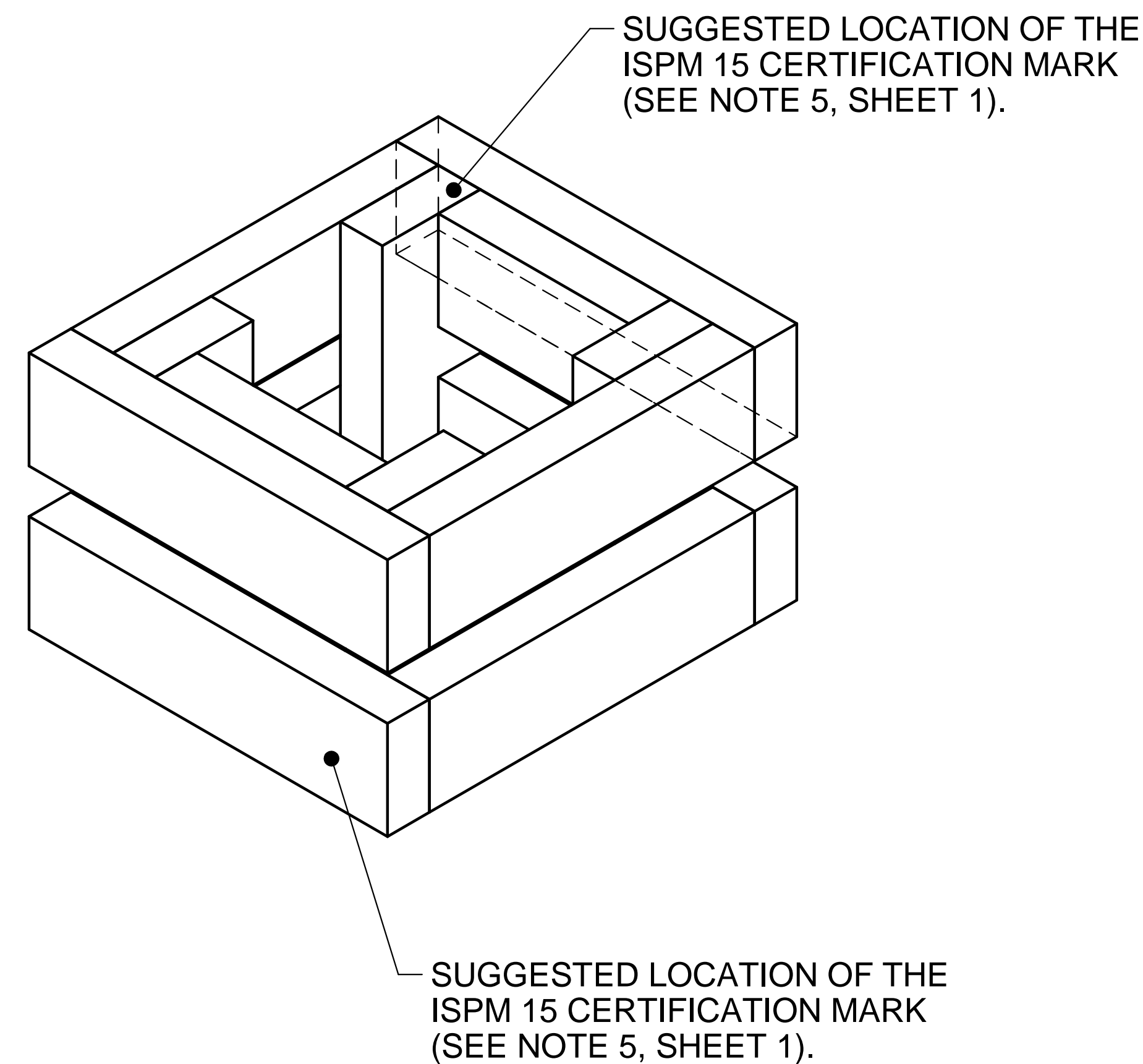
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES		DATE	PROJECT ENGINEER	DESIGN ACTIVITY
TOLERANCES: .XX .XXX ±.01 ±.005 ±0°15' FRACTIONS 125 REMOVE ALL BURRS AND SHARP EDGES .010 R OR CHAMFER MAX.		10-03-01	Tran	U.S. ARMY COMBINED ARMS SUPPORT COMMAND DEFENSE AMMUNITION CENTER (DAC) MCALESTER, OKLAHOMA 74501-9053
MATERIAL		TEST REPORT	TEST ENGINEER	HEAT TREATMENT OF WOODEN PALLETS, SKIDS, FILLER ASSEMBLIES, AND DUNNAGE ASSEMBLIES
NEXT ASSEMBLY		NA	P. Barickman	
USED ON		SUBMITTED: Laurie Fieffer CHIEF, TRANSPORTATION ENGINEERING DIVISION Jerry Beaver DEPUTY DIRECTOR FOR EXPLOSIVE SAFETY APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIAL COMMAND		
APPLICATION		GARY CARNEY DEFENSE AMMUNITION CENTER		SIZE
				D 28620
				DRAWING No.
				ACV00831
				REV.
				A
				SCALE
				NONE
				UNIT WT
				SHEET
				1 OF 2

REVISION		APPROVED		
LTR.	DESCRIPTION	ENG.	BY	DATE
-	PRODUCTION BASELINE, ERR R10K3003	QT	LF	10-03-01
A	ECP R19K3010, NOR 1 / 22-03-09	QT	LF	22-10-06

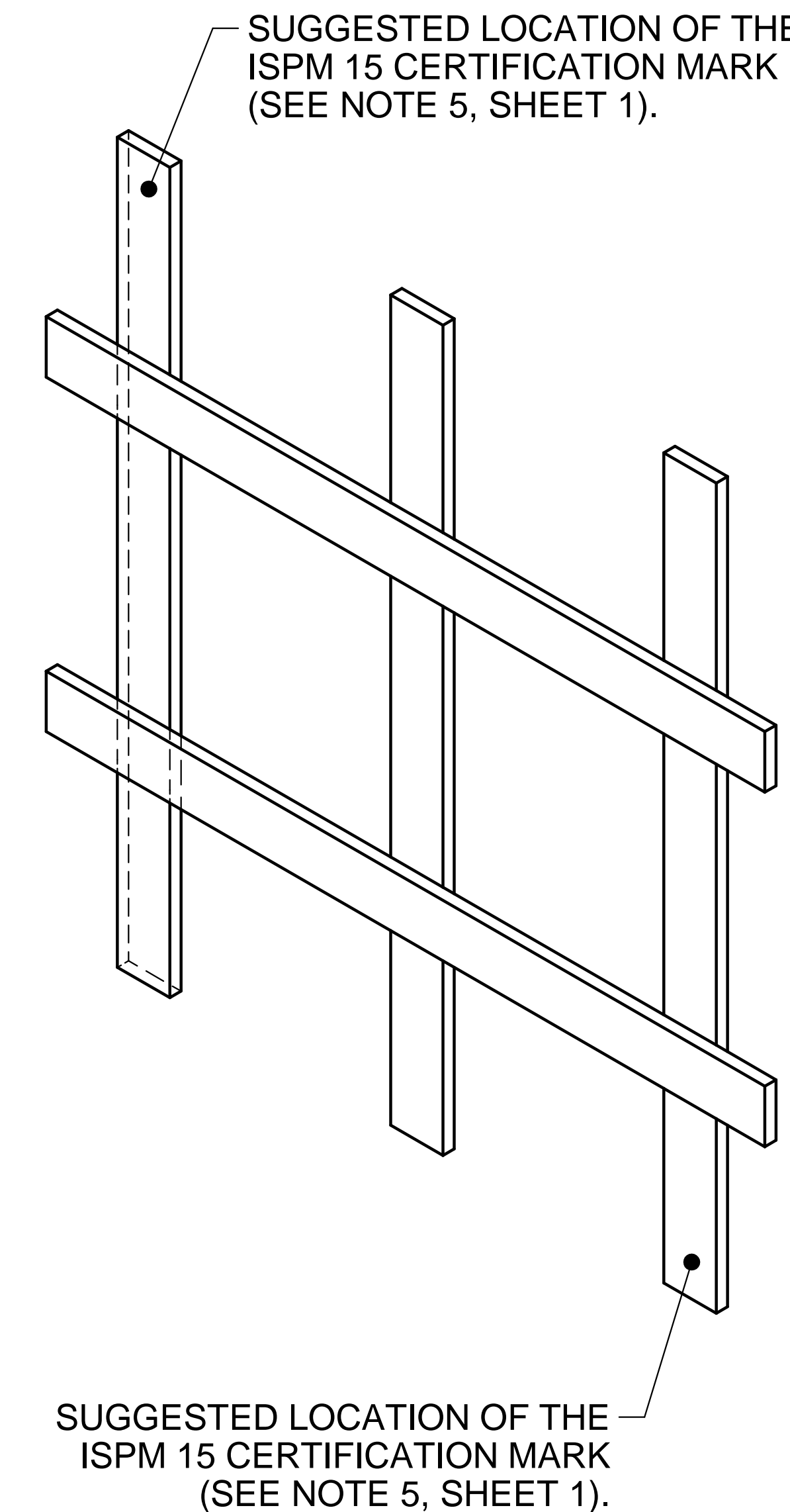
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.



**FIGURE 2**  
TYPICAL PALLET, SOME HIDDEN LINES OMITTED FOR CLARITY.



**FIGURE 3**  
TYPICAL FILLER ASSEMBLY, SOME HIDDEN LINES OMITTED FOR CLARITY.



**FIGURE 4**  
TYPICAL GATE ASSEMBLY, SOME HIDDEN LINES OMITTED FOR CLARITY (SEE NOTE 5, SHEET 1).

DISTRIBUTION STATEMENT A.  
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DATE 10-03-01	PROJECT ENGINEER Tran	DESIGN ACTIVITY U.S. ARMY COMBINED ARMS SUPPORT COMMAND DEFENSE AMMUNITION CENTER (DAC) MCALESTER, OKLAHOMA 74501-9053		
TEST REPORT NA	TEST ENGINEER P. Barickman	SUBMITTED Laurie Fieffer CHIEF, TRANSPORTATION ENGINEERING DIVISION		
APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIAL COMMAND Gary Carney		HEAT TREATMENT OF WOODEN PALLET, SKIDS, FILLER ASSEMBLIES, AND DUNNAGE ASSEMBLIES		
SIZE D	CAGE 28620	DRAWING No. ACV00831	REV. A	
SCALE NONE	UNIT WT	SHEET 2 OF 2		