

# SPECIAL PACKAGING INSTRUCTION

*Form Approved -SS RJ  
OMB No. 0704-0188*

<b>1. PART OR DRAWING NO. (CAGE) NOMENCLATURE</b> 12416043 (19207) CYLINDER HYDRAULIC			<b>2. CODE INDENT</b> 19207		<b>3. SPI NO.</b> AK14108058	
<b>4. NATIONAL STOCK NO.</b>			<b>5. DATE OF DRAWING</b> 03-25-2003		<b>6. REVISION</b>	
<b>7. QUP</b> 1 EACH	<b>8. ICQ</b> NONE	<b>9. UNIT PACK WT. (LB)</b> 332.6	<b>10. UNIT PACK CU (CU. FT.)</b> 14.745		<b>11. UNIT PACK SIZE (INCHES)</b> 62.3 X 21.3 X 19.2	
<b>12. PRESERVATION</b>			<b>18. STEPS</b>	<b>19. REQD</b>	<b>20. DESCRIPTION</b>	
<b>a. LEVEL A</b> MIL-STD-2073-1D, METHOD 20			1B		PRESERVATIVE: MIL-L-21260, GRADE 10.	
<b>B. LEVEL B</b> NOT APPLICABLE			2C		CLOSURE: MIL-C-5501.	
<b>13. CLEANING</b> MIL-STD-2073-1D, PROCEDURE 1			3D		BLOCKING AND BRACING: MIL-STD-1186.	
<b>14. DRYING</b> MIL-STD-2073-1D			4F	1	WRAP: MIL-B-121, TYPE I, GRADE A, CLASS 2, SIZE 68 X 26.	
<b>15. PACKING</b>			5E	1	CONTAINER: MIL-B-26195 (MOD), STYLE A, TYPE II, GRADE I, CLASS 1, SIZE 60 X 19 X 13.	
<b>a. LEVEL A</b> MIL-STD-2073-1D AND NOTE H			6G		CLOSURE: SEE NOTE.	
<b>b. LEVEL B</b> NOT APPLICABLE						
<b>16. MARKING</b> MIL-STD-129						

**17. NOTES/DRAWING**

**A. QUALITY ASSURANCE PROVISIONS:**

INSPECT THE PRESERVATION AND UNIT PACK IN ACCORDANCE WITH MIL-STD-2073-1. INSPECT PACKING IN ACCORDANCE WITH MIL-STD-1186 AND THE APPLICABLE CONTAINER SPECIFICATION.

**B. FLUSH OR SLUSH INTERNALLY AND DRAIN EXCESS. APPLY TO ALL UNPAINTED OR UNPLATED METALLIC SURFACES. MANUFACTURER'S TEST OIL IS ACCEPTABLE IF THE MANUFACTURER'S CAPS / PLUGS REMAIN IN PLACE AND NO CONTAMINATION HAS OCCURRED.**

**C. ALL OPEN PORTS SHALL BE SEALED WITH CAPS OR PLUGS CONFORMING TO MIL-C-5501 IN ACCORDANCE WITH MIL-STD-2073-1. MANUFACTURES CAPS ARE ACCEPTABLE.**

**D. FABRICATE BLOCKS "A", "B", "C" AND "D" AS SPECIFIED IN MATERIALS CHART ON PAGE 2, FIGURE 1 AND FIGURE 2 ON PAGE 3.**

FABRICATE BLOCK ASSEMBLY "1" (2 EACH) BY SECURING BLOCK "B" (2 EACH) TO BLOCK "A" (1 EACH) USING FF-N-105 NAILS OR STAPLES AS SHOWN IN FIGURE 3 ON PAGE 3. DRILL HOLES IN BLOCK ASSY "1" AS SHOWN IN FIGURE 3 ON PAGE 3.

FABRICATE BLOCK ASSEMBLY "2" (2 EACH) BY SECURING BLOCK "D" (2 EACH) TO BLOCK "C" (1 EACH) USING FF-N-105 NAILS OR STAPLES AS SHOWN IN FIGURE 4 ON PAGE 3. DRILL HOLES IN BLOCK ASSY "2" AS SHOWN IN FIGURE 4 ON PAGE 3.

**E. FABRICATE CONTAINER AS SPECIFIED IN NOTE 4 OF BLOCK 20 WITH RUBBING STRIPS 8-12 INCH IN LENGTH AS SHOWN IN FIGURE 5 ON PAGE 4.**

**F. SECURE BLOCK ASSEMBLY "1" (2 EACH) ON CONTAINER BASE USING FF-N-105 STAPLES AS SHOWN IN FIGURE 5 ON PAGE 4. USING BLOCK ASSEMBLIES "1" AS A GUIDE, MATCH DRILL 3/8 AND 1/2 HOLES THROUGH BASE AS SHOWN IN FIGURE 6 ON PAGE 4. SECURE BLOCK ASSEMBLY "1" (2 EACH) TO THE CONTAINER BASE USING CARRIAGE BOLT "1" (4 EACH), FLATWASHER "2" (4 EACH), LOCKWASHER "3" (4 EACH) AND NUT "4" (4 EACH) AS SPECIFIED IN HARDWARE CHART ON PAGE 2 AND AS SHOWN IN FIGURE 7 ON PAGE 5. INSERT BOLT "5" THROUGH BLOCK ASSEMBLIES "1" AS SPECIFIED IN HARDWARE CHART ON PAGE 2 AND AS SHOWN IN FIGURE "7" ON PAGE 5.**

WRAP CYLINDER ASSEMBLY AS SPECIFIED IN NOTE 4 OF BLOCK 20. SECURE CYLINDER ASSEMBLY TO CONTAINER BASE USING BLOCK ASSEMBLY "2" (2 EACH), BOLT "5" (4 EACH), FLATWASHER "6", LOCKWASHER "7" (4 EACH), NUT "8" (4 EACH) AS SPECIFIED IN HARDWARE CHART ON PAGE 2 AND AS SHOWN IN FIGURE 8 ON PAGE 6.

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G. CLOSE CONTAINER IN ACCORDANCE WITH MIL-C-26195.

H. THE UNIT CONTAINER IS THE SHIPPING CONTAINER.

## MATERIALS

Pad or Block Number	MIL-STD-731, Lumber (Nominal Size)	Critical Dimensions (Inches)			Qty.	Comments
		L	W	D		
A	2 X 4	18			2	
B	2 X 4	8-1/4			4	FABRICATE IN ACCORDANCE WITH FIGURE 1 ON PAGE 3.
C	2 X 4	14			2	
D	2 X 4	5-3/4			4	FABRICATE IN ACCORDANCE WITH FIGURE 2 ON PAGE 3.

## HARDWARE

	DESCRIPTION	SIZE	Qty.	
1	CARRIAGE BOLT	3/8 X 7	4	SEE NOTE 1.
2	FLATWASHER	3/8	20	SEE NOTE 1.
3	LOCKWASHER	3/8	4	SEE NOTE 1.
4	NUT	3/8 UNC	4	SEE NOTE 1.
5	CARRIAGE BOLT	1/2 X 12	4	SEE NOTE 1.
6	FLATWASHER	1/2	4	SEE NOTE 1.
7	LOCKWASHER	1/2	4	SEE NOTE 1.
8	NUT	1/2 UNC	4	SEE NOTE 1.
9	LAG BOLTS	3/8 X 3-1/2	16	SEE NOTE 1.

**NOTE 1:**

COMMERCIAL QUALITY STEEL WITH COMMERCIAL QUALITY ZINC PLATING IS ACCEPTABLE.

TO PREVENT LOOSENING OF NUTS AFTER INSTALLATION, APPLY PAINT, ASPHALTUM, OR MIL-C-16173 GRADE 1 PRESERVATIVE TO, OR PHYSICALLY NICK, THE EXPOSED THREADS OF THE BOLTS.

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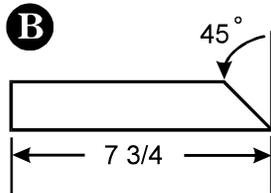


FIGURE 1

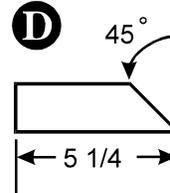


FIGURE 2

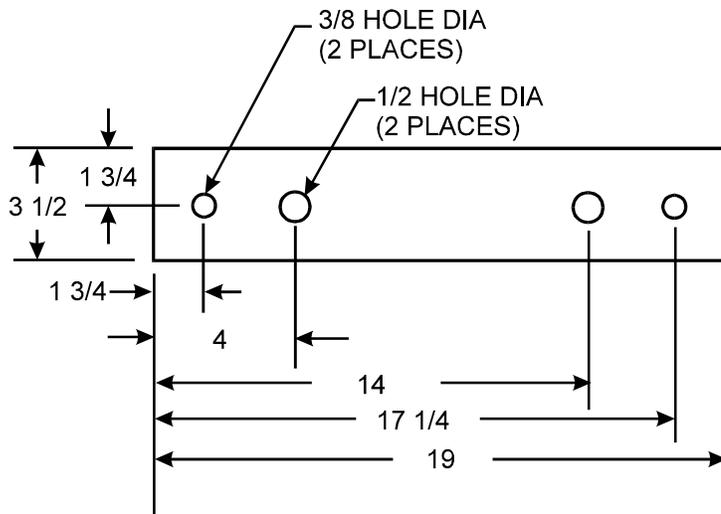


FIGURE 3

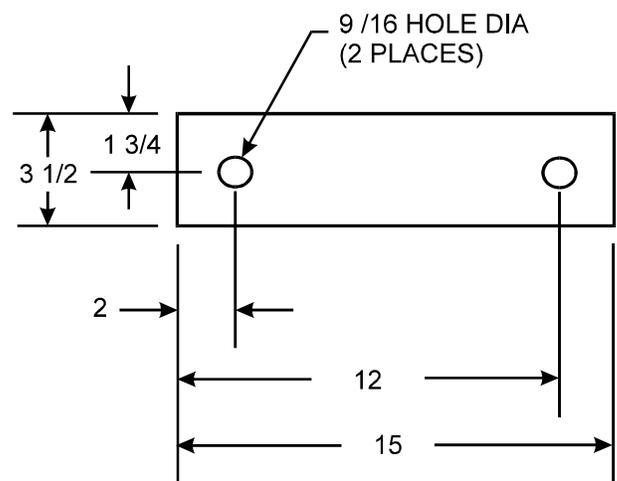
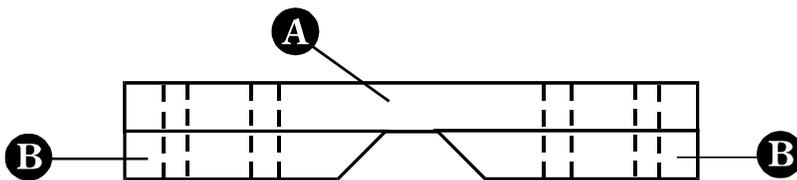
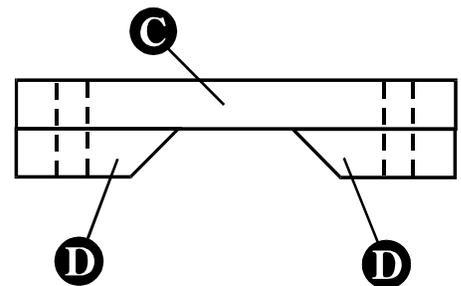


FIGURE 4



BLOCK ASSY **1**



BLOCK ASSY **2**

All dimensions are in inches.  
All dimensions are actual.  
All holes are dimensioned to center.

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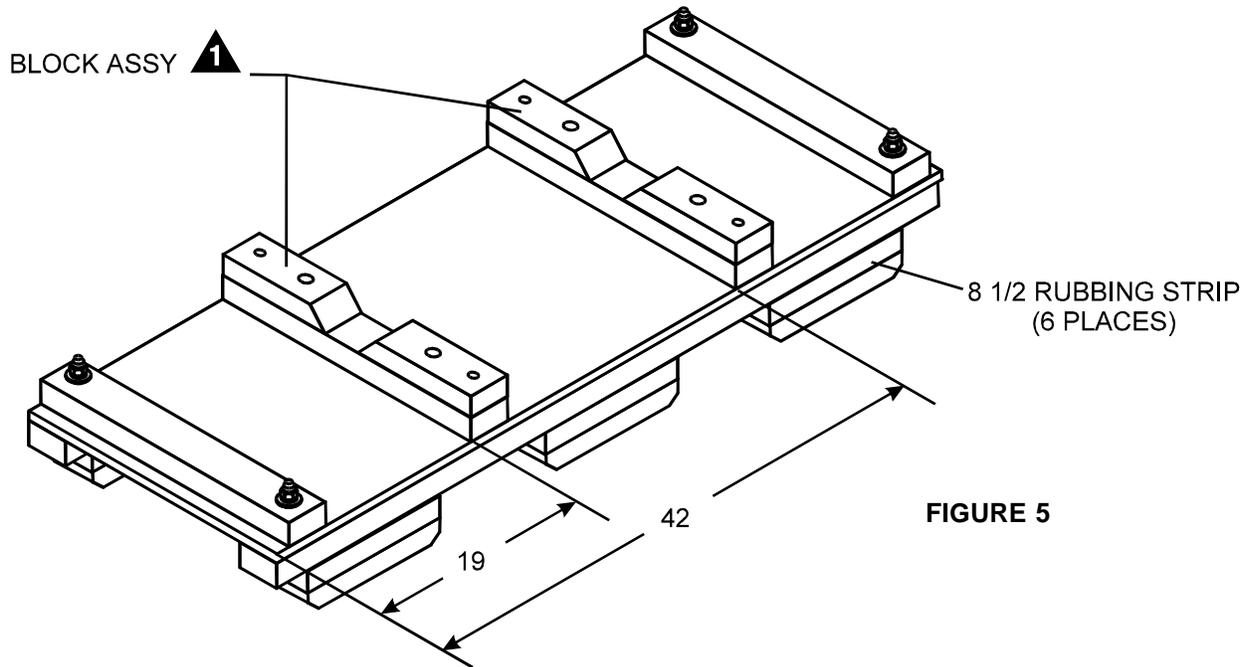
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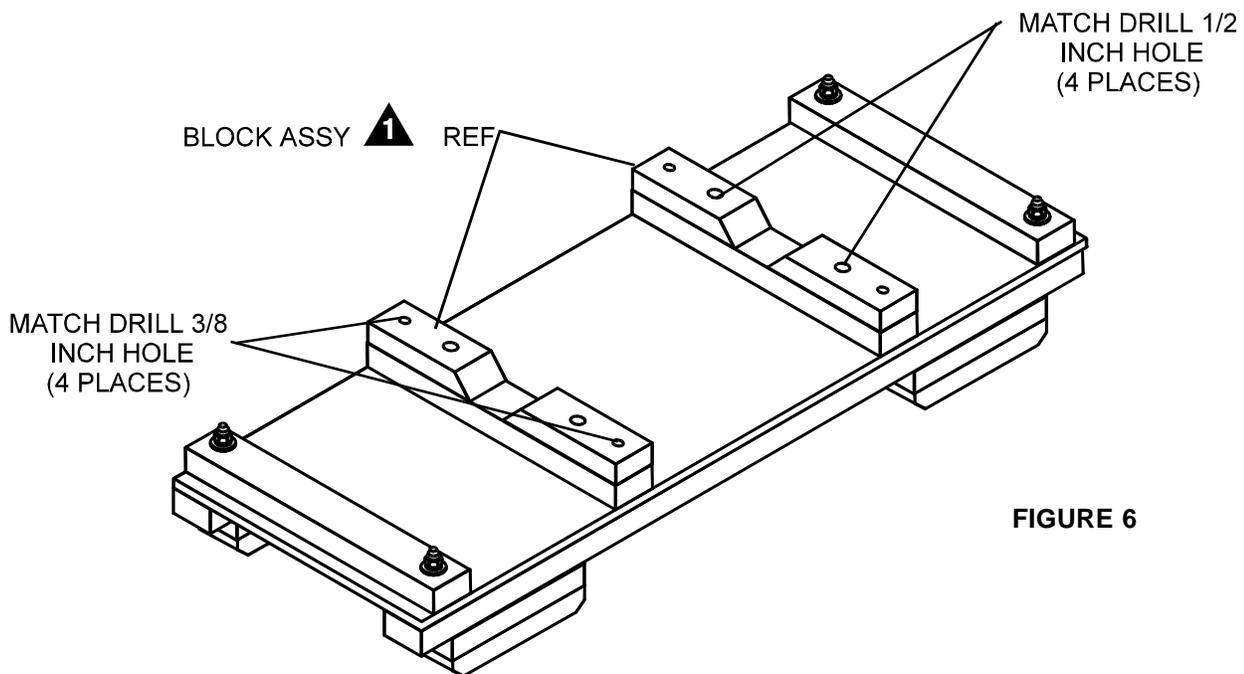
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**FIGURE 5**



**FIGURE 6**

**All dimensions are in inches.  
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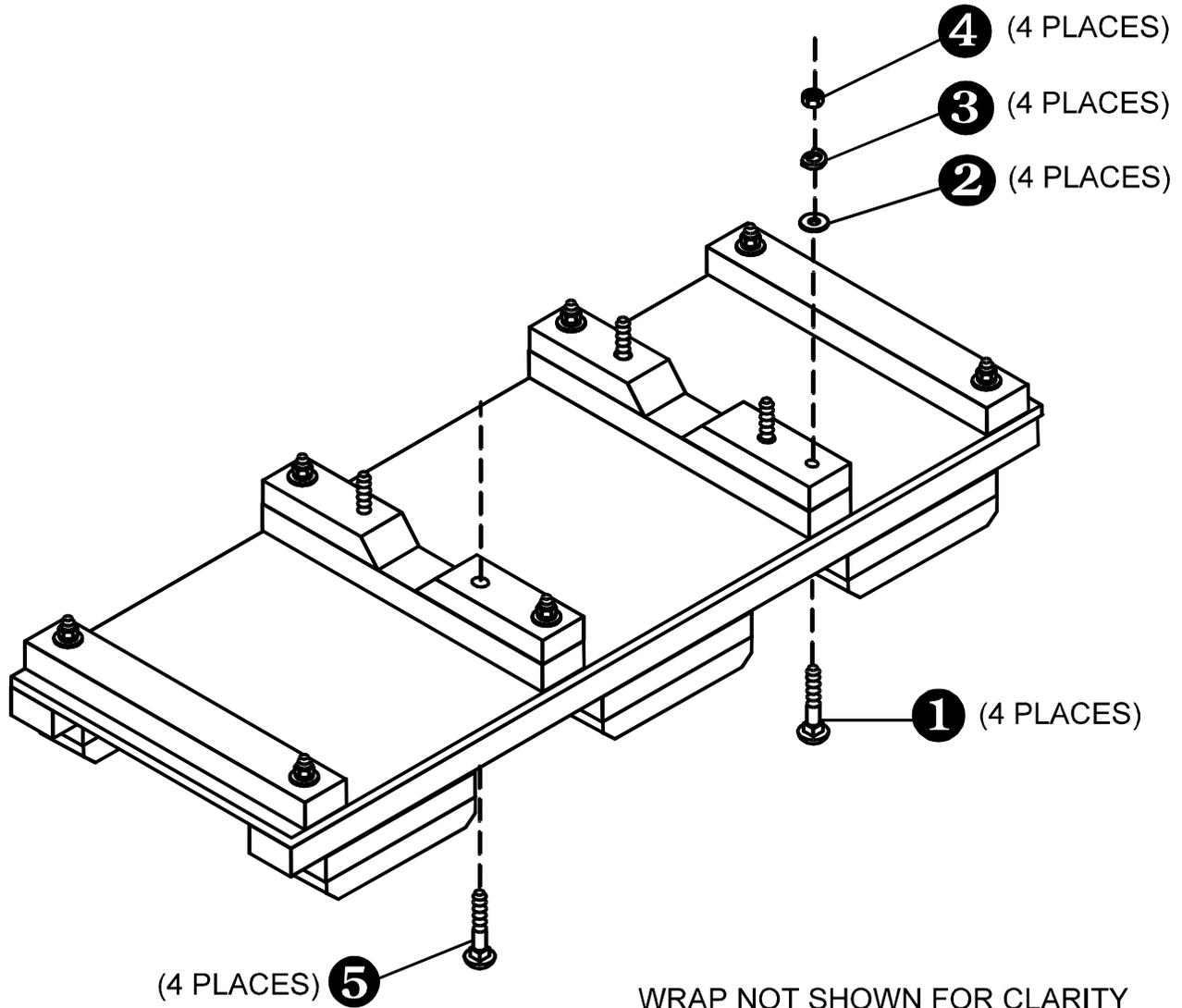


FIGURE 7

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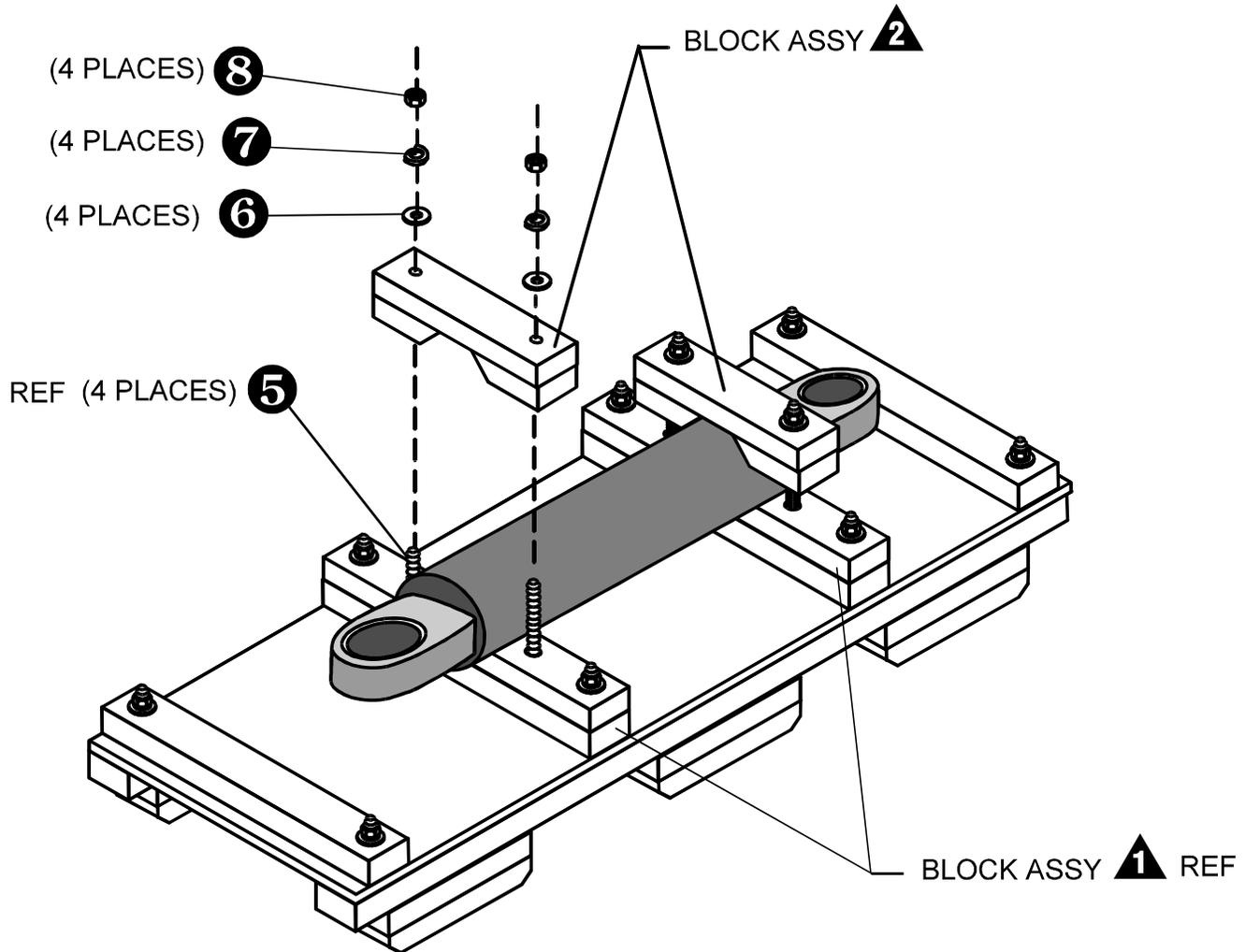
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WRAP NOT SHOWN FOR CLARITY

FIGURE 8