

# SPECIAL PACKAGING INSTRUCTION

Form Approved  
OMB No. 0704-0188

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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE <b>57K4085 (19207) ALTERNATOR, HONEYWEL</b>			2. CODE IDENT <b>19207</b>		3. SPI NO. <b>AK13058419</b>	
4. NATIONAL STOCK NUMBER <b>2920-01-305-8419</b>			5. DATE OF DRAWING <b>1-10-2005</b>		6. REVISION <b>-</b>	
7. QUP <b>1 EA</b>	8. ICQ <b>NONE</b>	9. UNIT PACK WT. (LB) <b>133.2</b>	10. UNIT PACK CU (CU FT) <b>4.348</b>		11. UNIT PACK SIZE (INCHES) <b>17.3 X 16.9 X 25.7</b>	
12. MILITARY PRESERVATION (METHOD) <b>MIL-STD-2073-1D, SEE BLOCK 17</b>			18. STEPS	19. REQ'D	20. DESCRIPTION	
13. CLEANING <b>MIL-STD-2073-1D</b>						
14. DRYING <b>MIL-STD-2073-1D</b>						
15. PACKING					<b>SEE THE NOTES</b>	
a. LEVEL A <b>MIL-STD-2073-1D AND NOTE P</b>						
b. LEVEL B <b>NOT APPLICABLE</b>						
16. MARKING <b>MIL-STD-129</b>						

17. NOTES / DRAWING
- A. REFER TO THE BILL OF MATERIALS FOR ALL OF THE REFERENCED ITEMS AND CIRCLED NUMBERS ON THE ACCOMPANYING PAGES.
  - B. THIS KIT, AS SHOWN ON REVISION C OF DRAWING 57K4085, CONSISTS OF THE FOLLOWING PARTS CONSOLIDATED INTO 6 SEGREGATED PACKAGES.

SEGREGATED PACKAGE NO.	PART NUMBER	CAGE	NOMENCLATURE	QTY.	METHOD OF PRESERVATION
1	12273135-3	19207	ALTERNATOR	1	10
2	12472989	19207	GASKET, ALTERNATOR	1	10
*3	M83248/1-910	81349	RUBBER, FLUOROCARBON	1	10
*4	MS21916J10-8	96906	REDUCER, EXTERNAL	1	10
*5	MS51552-12SS	96906	ELBOW, TUBE TO	1	10
*6	12345900	19207	PUMP, OIL LEAKAGE	1	10

\* THESE ITEMS ARE SUPPLIED LOOSE WITH THE ALTERNATOR (P/N 12273135-3) SEGREGATED PACKAGE 1.

- C. MARKING, SEGREGATED PACKAGE.
  - 1. MARK EACH SEGREGATED PACKAGE WITH THE SEGREGATED PACKAGE NUMBER.
  - 2. IDENTIFY THE CONSOLIDATION BAG FROM NOTE F WITH THE FOLLOWING: "THESE PARTS MUST BE INSTALLED ON THE ALTERNATOR BEFORE THE ALTERNATOR IS INSTALLED ON THE VEHICLE."

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## D. MARKING.

1. MARK THE UNIT CONTAINER IN ACCORDANCE WITH MIL-STD-129. IN ADDITION, ATTACH A PACKING LIST TO THE UNIT CONTAINER IN ACCORDANCE WITH MIL-STD-129. ON THE PACKING LIST, IDENTIFY THE ITEMS WITHIN EACH SEGREGATED PACKAGE TOGETHER WITH THEIR SEGREGATED PACKAGE NUMBER.
2. MARK THE REUSABLE CONTAINER AS FOLLOWS: "METHOD 50 REUSABLE CONTAINER: DO NOT DESTROY."

## E. PREPARE THE FOLLOWING PARTS AS DESCRIBED BELOW:

<u>PART NUMBER</u>	<u>NOMENCLATURE</u>	<u>QTY.</u>	<u>CAP</u>	<u>BAG</u>	<u>SEGREGATED PACKAGE</u>
M83248/1-910	RUBBER, FLUOROCARBON	1	-	18A	3
MS21916J10-8	REDUCER, EXTERNAL	1	1B & 1C	19A	4
MS51852-12SS	ELBOW, TUBE TO	1	1B	19A	5
12345900	PUMP, OIL LEAKAGE	1	1A & 1B	19B	6

1. WHEN SPECIFIED, INSTALL THE APPROPRIATE CAPS ON THE INDICATED PART NUMBER.
2. IF THE ITEMS WHICH REQUIRE CAPS HAVE BEEN CLEANED AND CAPPED, AND THEY HAVE NOT BEEN CONTAMINATED, CLEANING AND RECAPPING MAY BE ELIMINATED.
3. PLACE EACH PART IN THE SPECIFIED BAG, AND CLOSE THE BAG BY HEAT SEALING.

## F. CONSOLIDATE THE SEGREGATED PACKAGES FROM NOTE E INTO A BAG, ITEM 19C.

## G. 12472989, GASKET, ALTERNATOR, SEGREGATED PACKAGE 2, QUANTITY 1.

1. POSITION THE GASKET BETWEEN TWO STIFFENERS, ITEM 4, AND SECURE WITH FOUR PIECES OF TAPE, ITEM 16, IN SUCH A MANNER THAT THE TAPE WILL NOT TOUCH THE PART OR EXERT PRESSURE THAT WOULD SUBJECT THE PART TO SET OR DISTORTION.
2. PLACE THE PREPARED GASKET IN A BAG, ITEM 18B, AND CLOSE THE BAG BY HEAT SEALING.

## H. PREPARE THE BLOCKING ASSEMBLY AS FOLLOWS:

1. USING A GOOD GRADE OF EXTERIOR ADHESIVE, LAMINATE TWO PIECES OF PLYWOOD, ITEM 5, TOGETHER.
2. DRILL AND CUT THE LAMINATED PLYWOOD IN ACCORDANCE WITH THE ILLUSTRATION ON PAGE 7.
3. INSTALL EACH OF THE FOUR BLOCKING PIECES, ITEM 7, AS IT IS SHOWN ON PAGE 7, BY USING A GOOD QUALITY OF EXTERIOR ADHESIVE, AND DRIVING NAILS, ITEM 8B, THROUGH THE PLYWOOD, AND CLINCHING. FOUR NAILS SHALL BE USED IN EACH BLOCK, ARRANGED IN A STAGGERED PATTERN. TO PREVENT SPLITTING, EITHER BLUNT THE NAILS, OR DRILL PILOT HOLES THROUGH THE BLOCK THAT ARE SLIGHTLY SMALLER THAN THE DIAMETER OF THE NAIL.
4. INSTALL THE SUPPORT BLOCKS, ITEM 6, AS SHOWN ON PAGE 7, BY USING A GOOD QUALITY EXTERIOR ADHESIVE, AND DRIVING THE NAILS, ITEM 8A, THROUGH THE PLYWOOD AND INTO THE BLOCKS. THREE NAILS SHALL BE USED IN EACH BLOCK.

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5. PLACE THE METAL MOUNTING RING, ITEM 9, ON THE UNDERSIDE OF THE BLOCKING ASSEMBLY, AND THE METAL PLATE, ITEM 10, ON TOP OF THE BLOCKING ASSEMBLY, POSITIONED BETWEEN THE SUPPORT BLOCKS, ITEM 6, AS IT IS ILLUSTRATED ON PAGE 8.
6. WITH THE HOLES ALIGNED, SECURE WITH HARDWARE, ITEMS 11, 12, 13, AND 14, IN SIX PLACES, AS IT IS SHOWN ON PAGE 8.
- I. 12273135-3, ALTERNATOR, SEGREGATED PACKAGE 1, QUANTITY 1.
  1. IF THE ALTERNATOR HAS ALREADY BEEN CAPPED/PLUGGED, RECAPPING/REPLUGGING MAY BE ELIMINATED. OTHERWISE, CAP/PLUG THE APPROPRIATE PORT/CONNECTOR ON THE ALTERNATOR AS FOLLOWS:

<u>PORT/CONNECTOR</u>	<u>CAP/PLUG</u>	
MS33649-8		3A
MS33649-10		3B
J1		2A
J2		2B
  2. POSITION THE ALTERNATOR SO THAT THE SPLINE FITS IN THE HOLE IN THE CENTER OF THE BLOCKING ASSEMBLY, AS IT IS ILLUSTRATED ON PAGE 8.
  3. WITH THE FACE OF THE MOUNTING RING, ITEM 9, FLUSH WITH THE FACE OF THE ALTERNATOR, PLACE THE CLAMP, ITEM 15, AROUND THE MOUNTING RING AND THE ALTERNATOR, AND TIGHTEN. SEE THE ILLUSTRATION ON PAGE 8.
- J. SECURE THE PACKAGED GASKET FROM NOTE G TO THE ALTERNATOR WITH TAPE, ITEM 17, IN SUCH A WAY AS TO AVOID BENDING THE STIFFENERS.
- K. SECURE THE CONSOLIDATED ITEMS FROM NOTE F TO THE ALTERNATOR WITH TAPE, ITEM 17. SEE THE ILLUSTRATION ON PAGE 8 FOR PLACEMENT.
- L. SLIDE A BAG, ITEM 20, OVER THE ALTERNATOR AND THE ITEMS SECURED TO IT. GATHER THE BAG MATERIAL UP BETWEEN THE CLAMP, ITEM 15, AND THE BLOCKING ASSEMBLY, WHERE THE MOUNTING RING, ITEM 9, IS ATTACHED. SECURE WITH TAPE, ITEM 17, IN A MANNER THAT TIGHTLY WRAPS THE GATHERED BAG MATERIAL AROUND THE CIRCUMFERENCE OF THE MOUNTING RING.
- M. ATTACH THE DESICCANT, ITEM 21, TO THE BAG FROM NOTE L WITH TAPE, ITEM 17.
- N. PLACE THE ALTERNATOR IN THE DRUM, ITEM 22, ALLOWING THE BLOCKING ASSEMBLY TO REST ON THE INVERTED BEAD, SHOWN ON PAGE 8. PLACE THE SUPPORT DISK (SEE PAGE 5) ON TOP OF THE SUPPORT BLOCKS, ITEM 6.
- O. SEAL THE DRUM WITH THE PROVIDED STYLE 1 COVER, AND THE LOCKING RING TO MAKE A METHOD 50.
- P. THE UNIT CONTAINER IS AN ACCEPTABLE LEVEL A AND LEVEL B SHIPPING CONTAINER. FOR BOTH LEVEL A AND B, WHEN MULTIPLE QUANTITIES ARE TO BE SHIPPED TO THE SAME DESTINATION, EXTERIOR PACKS WITHOUT SKIDS SHALL BE PALLETIZED. MIL-HDBK-774 MAY BE USED FOR GUIDANCE.
- Q. INSPECT THE PRESERVATION (SEE NOTE B), THE SEGREGATED PACKAGES, CONSOLIDATION PACKS (WHEN A METHOD IS SPECIFIED), UNIT PACK AND PACKING IN ACCORDANCE WITH MIL-STD-2073-1D AND THE APPLICABLE CONTAINER SPECIFICATION.

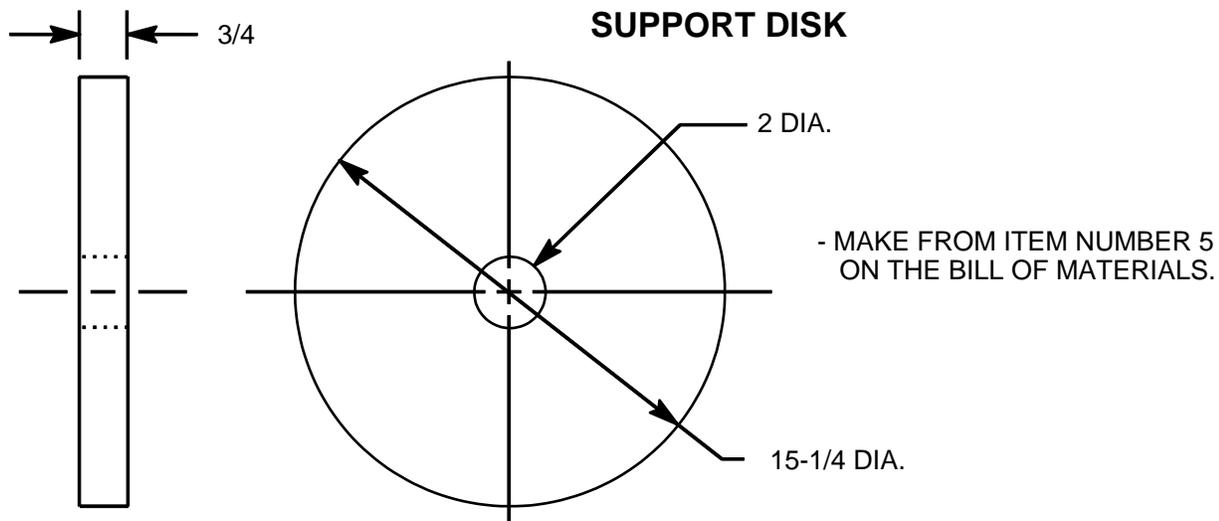
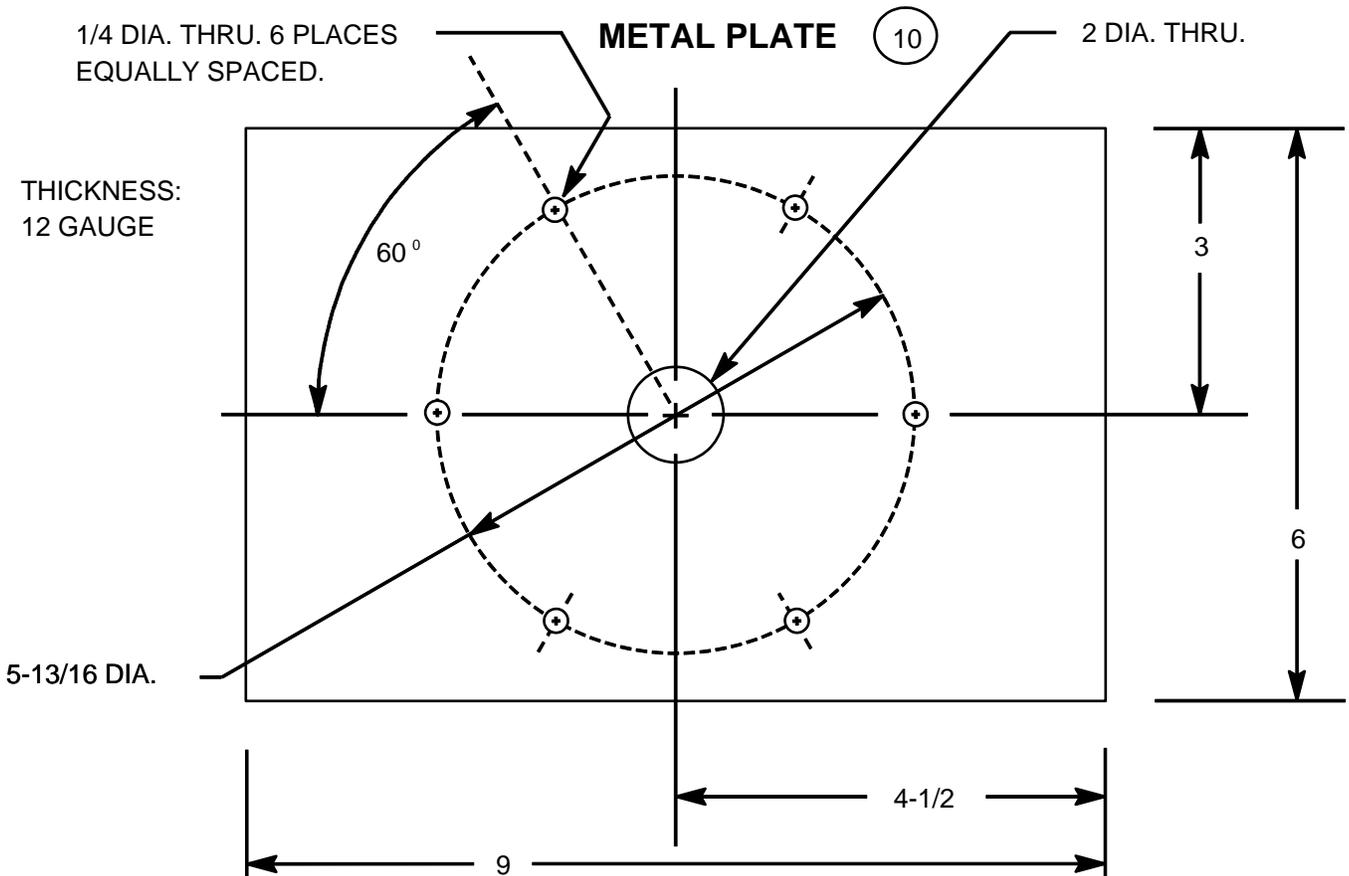
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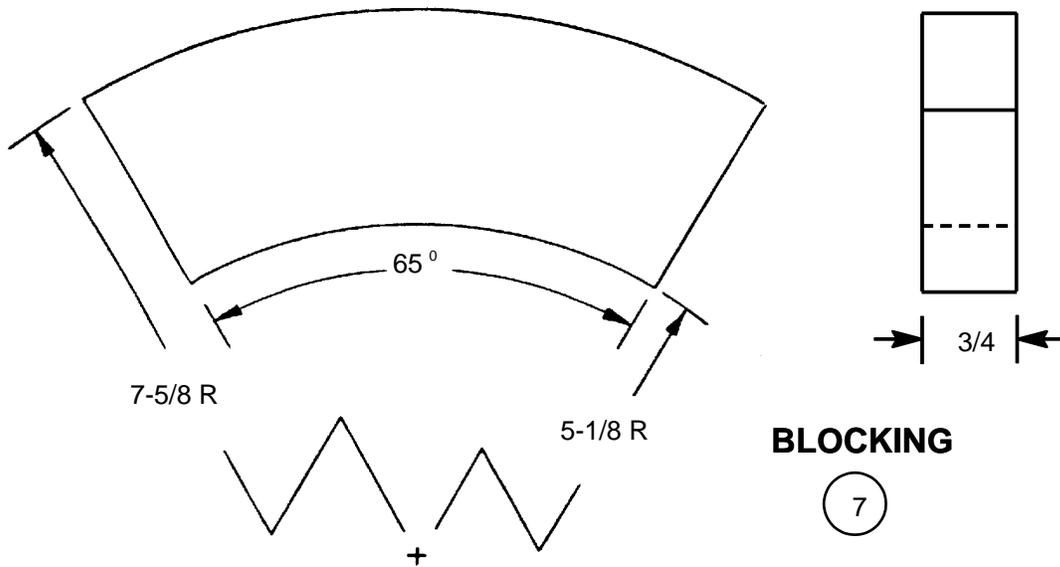
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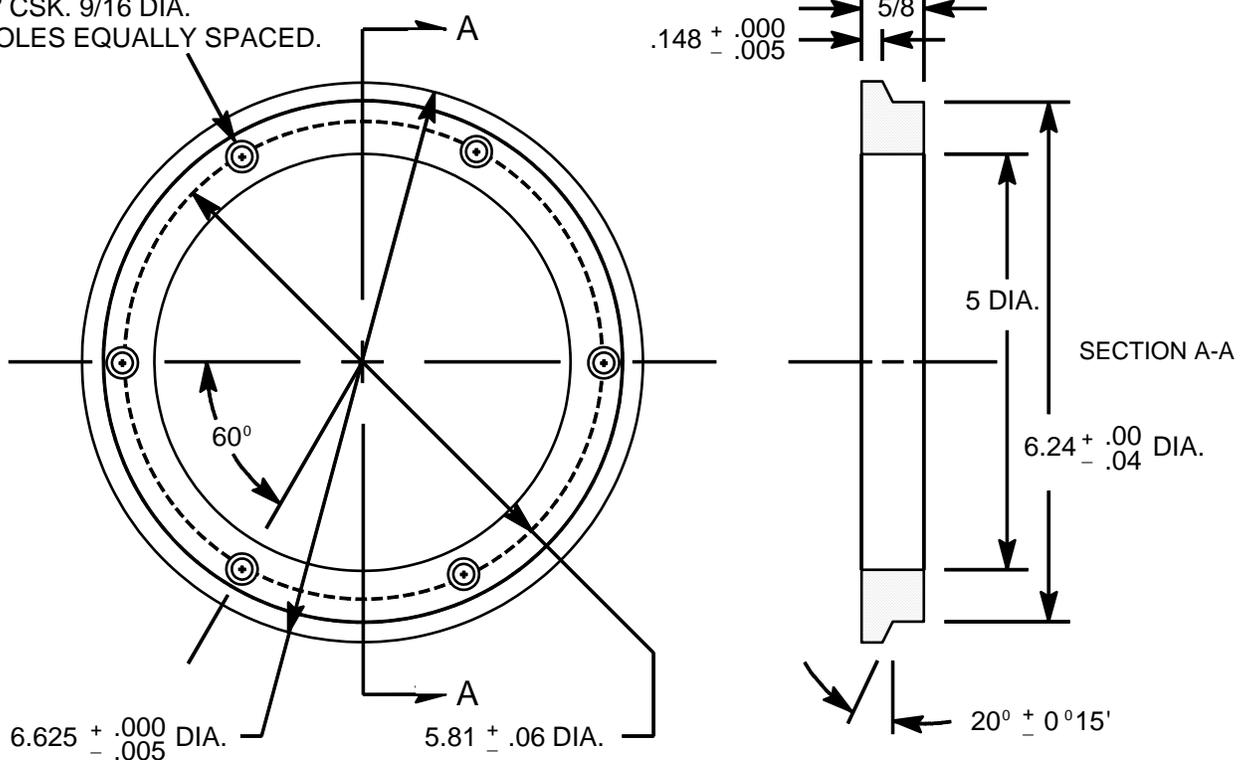
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1/4 DIA. THRU.-  
82° CSK. 9/16 DIA.  
6 HOLES EQUALLY SPACED.

## MOUNTING RING

9



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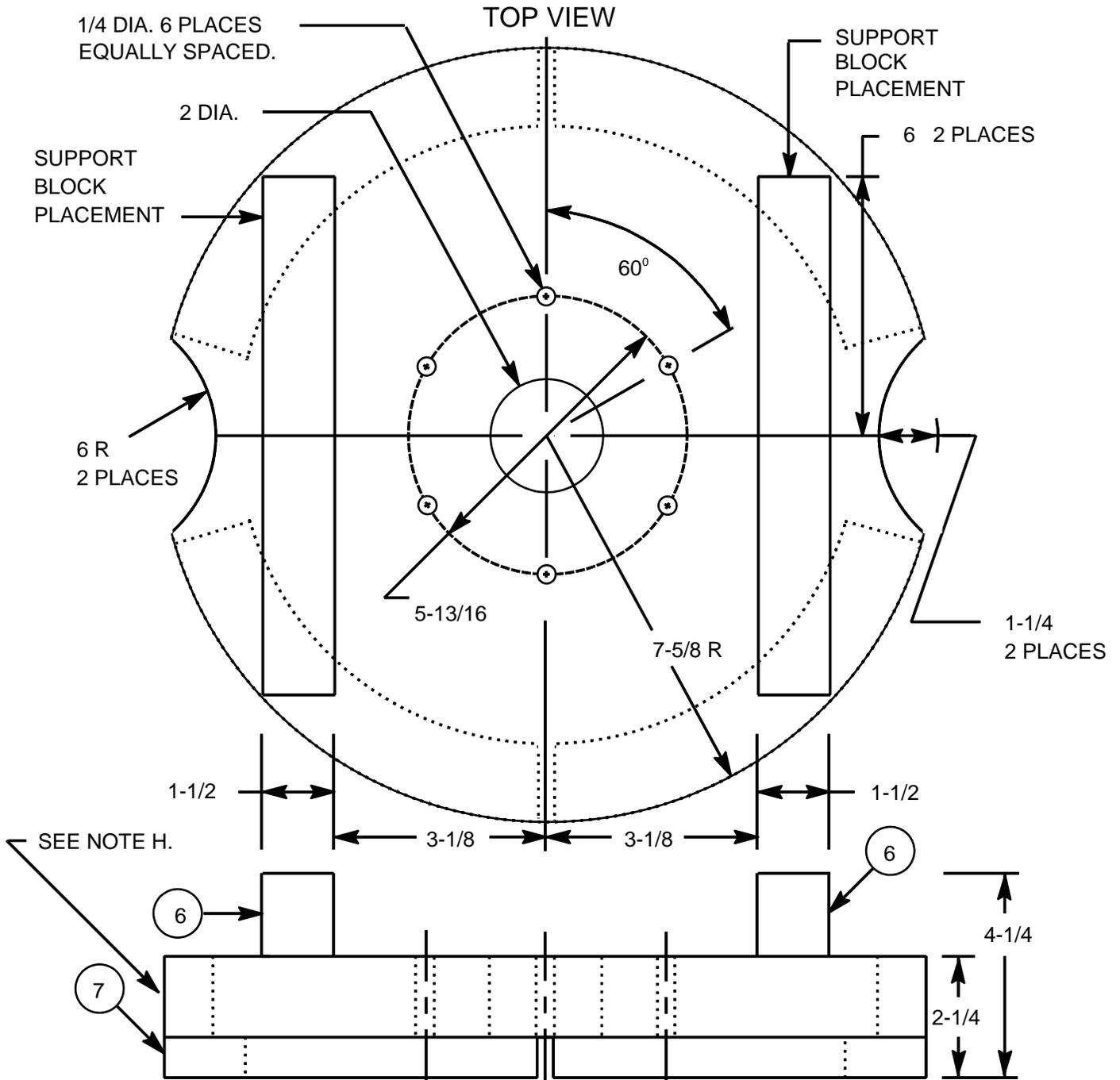
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## BLOCKING ASSEMBLY (SEE NOTE H)



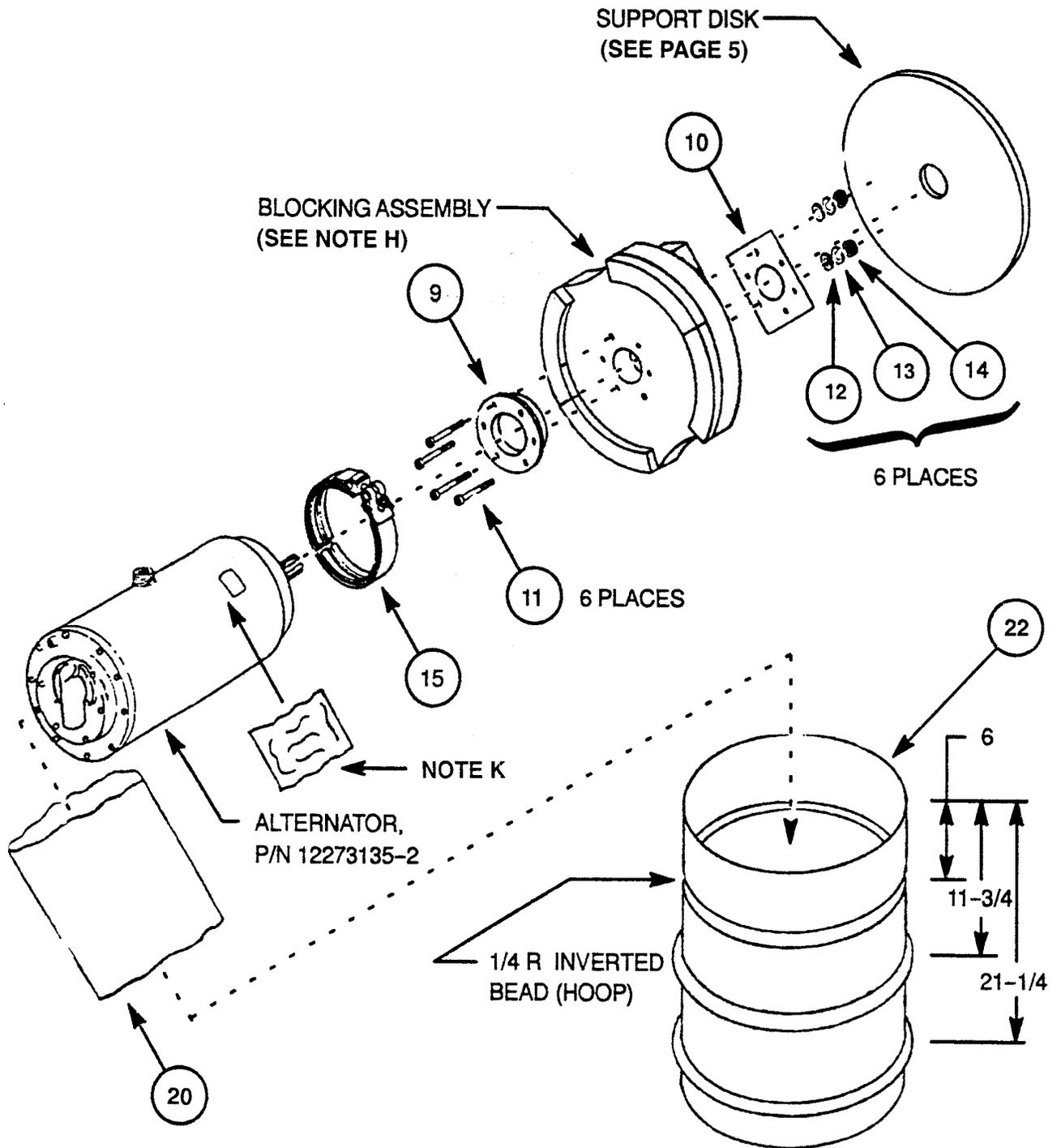
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## BILL OF MATERIALS

	DESCRIPTION	SIZE	SPECIFICATION DATA	QTY.
1*	CAP		NAS835.	
1A			NAS835N4.	1
1B			NAS835N8.	3
1C			NAS835N10.	1
2*	CAP		MS90376.	
2A			MS90376-8R.	1
2B			MS90376-16R.	1
3*	PLUG		NAS833.	
3A			NAS833-8.	1
3B			NAS833-10.	1
4	STIFFENERS	7 X 7	ASTM-D4727, TYPE CF, CLASS D, GRADE 125.	2
5	PLYWOOD	15-1/4 DIA. X 3/4	A-A-55057, TYPE A, EXTERIOR EXPOSURE, GRADE C-D.	3
6	SUPPORT BLOCK	1-1/2 X 2 X 12	ASTM-D6199-97, GROUP II OR III.	2
7	BLOCKING	SEE PAGE 6	ASTM D6199-97, GROUP IV, CLASS 1.	4
8	NAILS		COMMERCIAL GRADE BOX CEMENT COATED.	
8A		8d		6
8B		10d		16
9	MOUNTING RING	SEE PAGE 6	MATERIAL: STEEL ASTM-A576 OR ASTM-A108. FINAL PROTECTIVE FINISH: MIL-STD-171 5.3.1.3 OR 5.3.2.3.	1

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	DESCRIPTION	SIZE	SPECIFICATION DATA	QTY.
10	METAL PLATE	SEE PAGE 5	MATERIAL: STEEL ASTM-A576 OR ASTM-A108. FINAL PROTECTIVE FINISH: MIL-STD-171 5.3.1.3 OR 5.3.2.3.	1
11**	MACHINE SCREW	1/4 X 2-1/2	82 DEGREE FLAT COUNTERSUNK HEAD.	6
12**	FLAT WASHER	1/4		6
13**	LOCK WASHER	1/4	HEAVY DUTY.	6
14**	HEX NUT	1/4		6
15	CLAMP		PART NUMBER 12310653, NSN: 5340-01-139-3747, FSCM: 19207.	1
16	TAPE	3/4 X AS REQUIRED	A-A-883, TYPE I.	4
17	TAPE	2 X AS REQUIRED	MIL-T-22085, TYPE II.	A/R

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18	BAG		MIL-B-117, TYPE I, CLASS E, STYLE 1.	
18A		2-1/2 X 3		1
18B		10 X 10		1
19	BAG		MIL-B-117, TYPE III, CLASS B, STYLE 2.	
19A		3 x 5		2
19B		4 X 6		1
19C		10 X 10		1
20	BAG	24 X 30	MIL-B-117, TYPE III, CLASS B, STYLE 2, 6 MIL.	1
21	DESICCANT		MIL-D-3464, TYPE 1.	88 UNITS
22***	DRUM		MS27683-1-I (MODIFIED).	1

\* OR EQUIVALENT

\*\* COMMERCIAL QUALITY STEEL IS ACCEPTABLE WITH ZINC PLATING, OR PRESERVATIVE COATING CONFORMING TO MIL-PRF-16173, GRADE 4.

\*\*\* THE DRUM IS MODIFIED AS IT IS SHOWN ON PAGE 8.