

SPECIAL PACKAGING INSTRUCTION

Form Approved
OMB No. 0704-0188

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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE 12473351 (19207) ARM ASSEMBLY, PIVOT			2. CODE IDENT 19207		3. SPI NO. AK15319543	
4. NATIONAL STOCK NUMBER 2530-01-531-9543			5. DATE OF DRAWING 4-25-2007		6. REVISION A	
7. QUP 1 EA	8. ICQ NONE	9. UNIT PACK WT. (LB) 330.0	10. UNIT PACK CU (CU FT) 14.421		11. UNIT PACK SIZE (INCHES) 40.0 X 35.0 X 17.8	
12. MILITARY PRESERVATION (METHOD) MIL-STD-2073-1D, METHOD 43			18. STEPS	19. REQ'D	20. DESCRIPTION SEE NOTES	
13. CLEANING MIL-STD-2073-1D						
14. DRYING MIL-STD-2073-1D						
15. PACKING						
a. LEVEL A MIL-STD-2073-1D AND NOTE O						
b. LEVEL B MIL-STD-2073-1D AND NOTE O						
16. MARKING MIL-STD-129						

17. NOTES / DRAWING
- A. REFER TO THE BILL OF MATERIALS FOR CIRCLED NUMBERS AND REFERENCED ITEM NUMBERS ON THE ACCOMPANYING PAGES.
 - B. APPLY OIL, ITEM 1, TO ALL BARE FERROUS SURFACES. IF PART HAS ALREADY BEEN PRESERVED THEN THIS STEP MAY BE ELIMINATED.
 - C. WRAP ENTIRE ARM ASSEMBLY WITH WRAP, ITEM 3, AND SECURE WITH TAPE.
 - D. WRAP SMALLER SPINDLE WITH CUSHIONING, ITEM 2A, AND LARGER SPINDLE WITH CUSHIONING, ITEM 2B. SECURE WITH TAPE.
 - E. PREPARE BASE OF CONTAINER, ITEM 18, AS ILLUSTRATED ON PAGE 3.
 - F. PREPARE CORRUGATED PADS, ITEM 4, AS ILLUSTRATED ON PAGE 4, AND BARRIER MATERIAL, ITEM 5A, AS ILLUSTRATED ON PAGE 6 AND 7.
 - G. PREPARE LOAD SPREADER, ITEM 8, AS ILLUSTRATED ON PAGE 7. WOOD BLOCKING, ITEM 10, SHALL BE SECURED TO LOAD SPREADER USING ADHESIVE, ITEM 7 OR NAILS. SEE PAGE 7 FOR POSITIONING.
 - H. ADHERE GASKETS, ITEM 6, TO BOTH SIDES OF BARRIER ENVELOPE, ITEM 5A, AT MOUNTING HOLE LOCATIONS USING ADHESIVE, ITEM 7.
 - I. PLACE CORRUGATED PAD, ITEM 4, ON BASE OF CONTAINER, ITEM 18. PLACE BARRIER ENVELOPE, ITEM 5A, OVER ITEM 4. PLACE REMAINING CORRUGATED PAD, ITEM 4, OVER BARRIER ENVELOPE, ITEM 5A. PLACE PREPARED LOAD SPREADER, ITEM 8, OVER CORRUGATED PAD, ITEM 4. REFER TO PAGE 8 FOR ASSEMBLY DIAGRAM.
 - J. SECURE WOOD BLOCKING, ITEM 9, TO PREPARED CONTAINER BASE WITH HARDWARE, ITEMS 12, 13, 14, 15, 16, AND 17. SEE PAGE 8 FOR POSITIONING OF HARDWARE.

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- K. PLACE PREPARED ARM ASSEMBLY, P/N: 12473351 IN THE PREPARED CONTAINER AS SHOWN ON PAGE 8.
- L. PLACE WOOD BLOCKING, ITEM 11, OVER ARM ASSEMBLY AND SECURE TO BASE AS SHOWN ON PAGE 8.
- M. COVER PREPARED PART WITH CUSHIONING, ITEM 2C, SO AS TO PREVENT HARDWARE FROM PUNCTURING BARRIER ENVELOPE WHEN IT IS SEALED.
- N. COMPLETE BARRIER ENVELOPE, ITEM 5, BY HEAT SEALING 5A TO 5B. SEE PAGE 7 FOR ILLUSTRATION ON HOW TO HEAT SEAL BARRIER ENVELOPE.
- O. THE UNIT CONTAINER IS AN ACCEPTABLE LEVEL A AND LEVEL B SHIPPING CONTAINER.
- P. INSPECT THE PRESERVATION, THE UNIT PACK AND THE PACKING IN ACCORDANCE WITH MIL-STD-2073-1D AND THE APPLICABLE CONTAINER SPECIFICATION.

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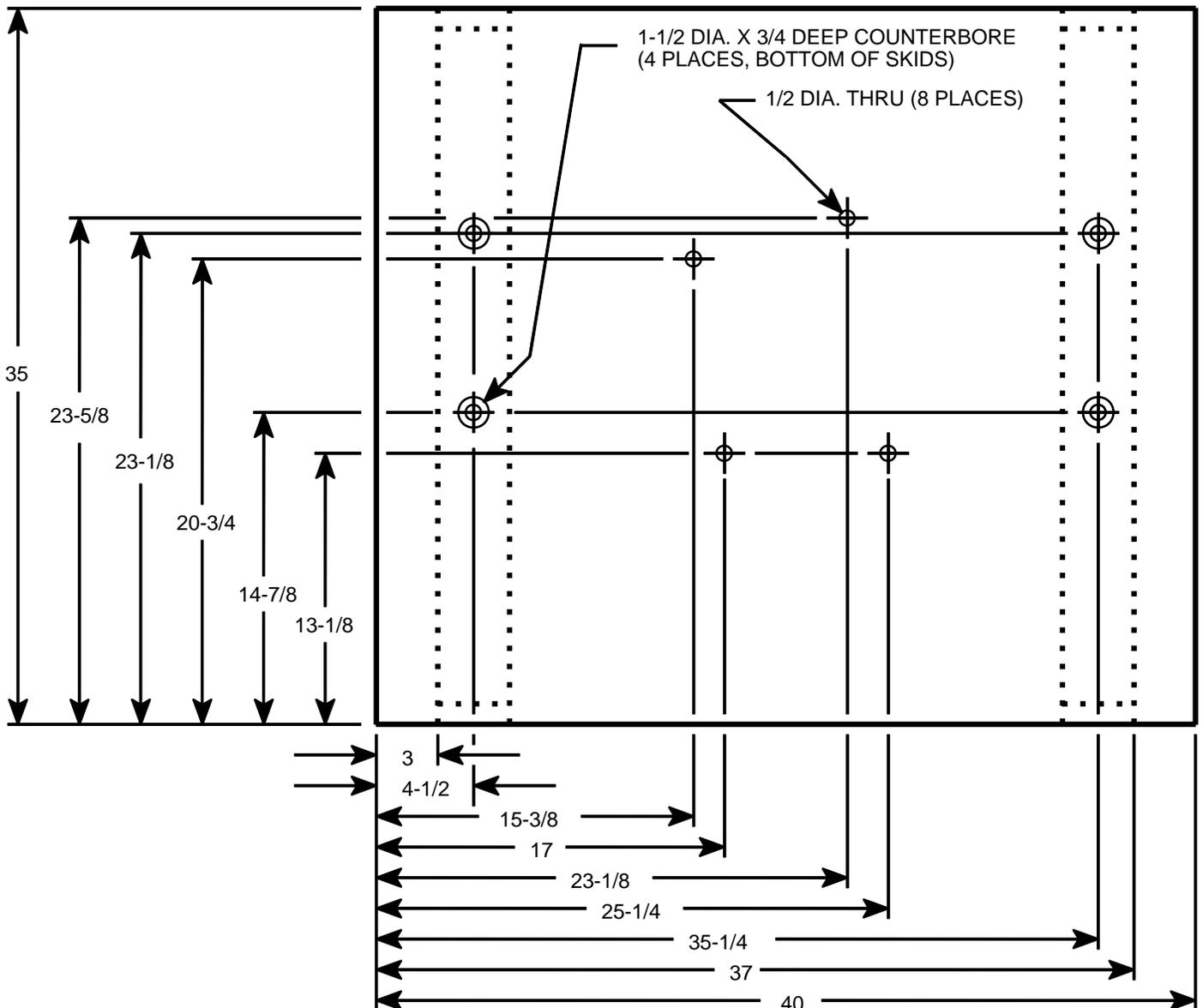
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BASE OF CONTAINER, ITEM 18



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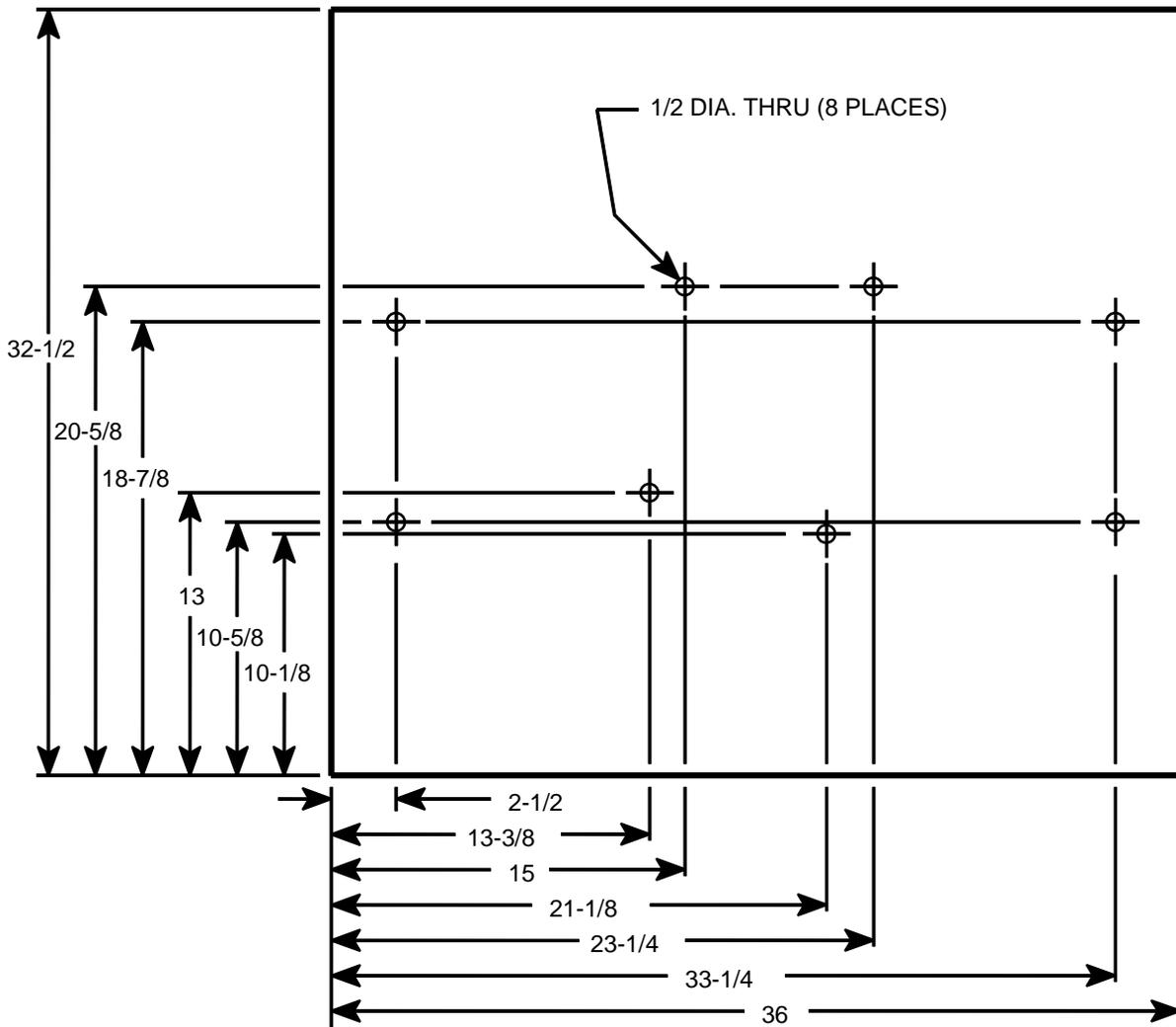
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4



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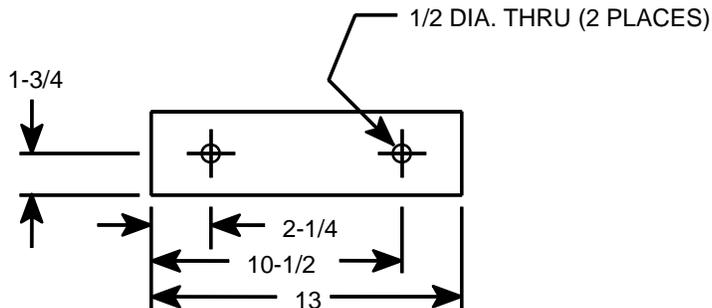
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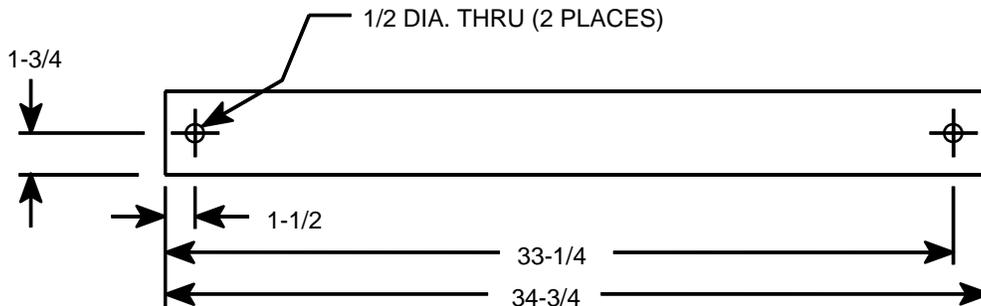
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9



11



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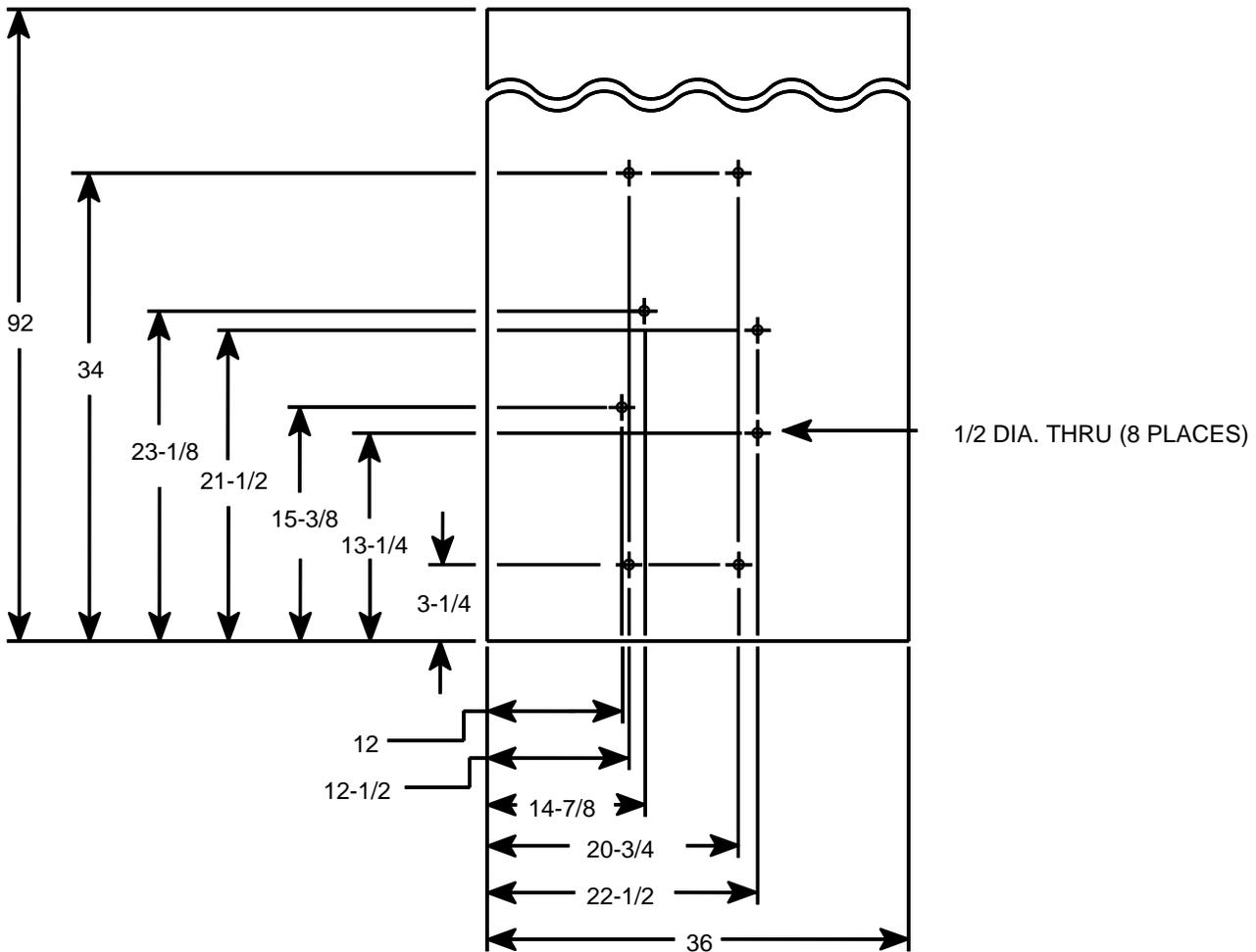
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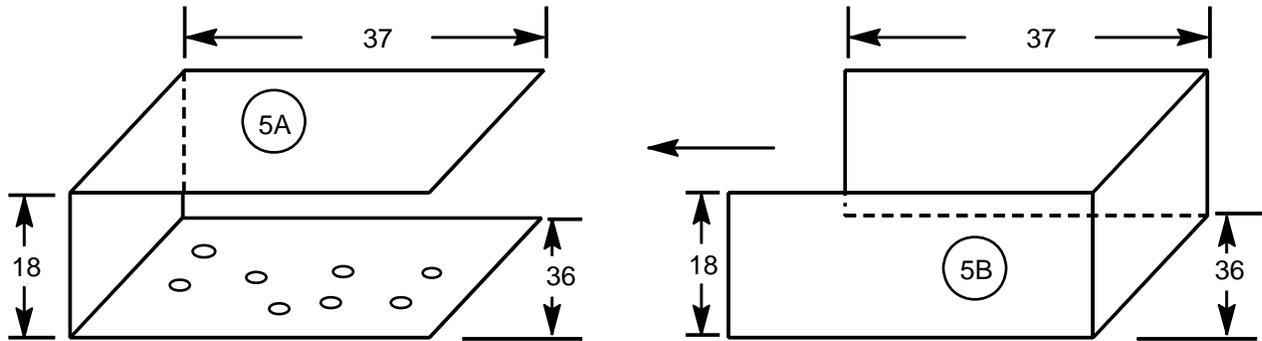
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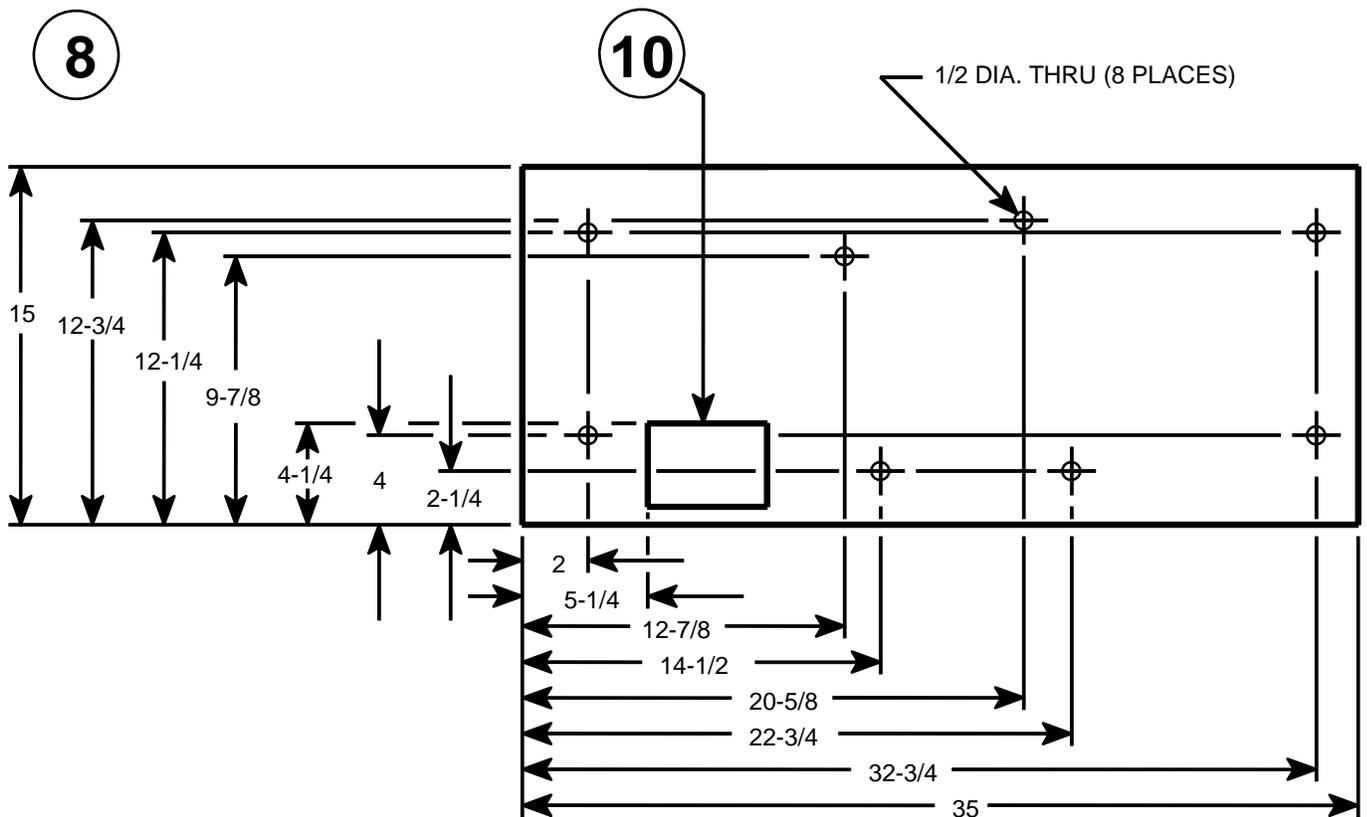
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BARRIER ENVELOPE MATERIAL AND ASSEMBLY



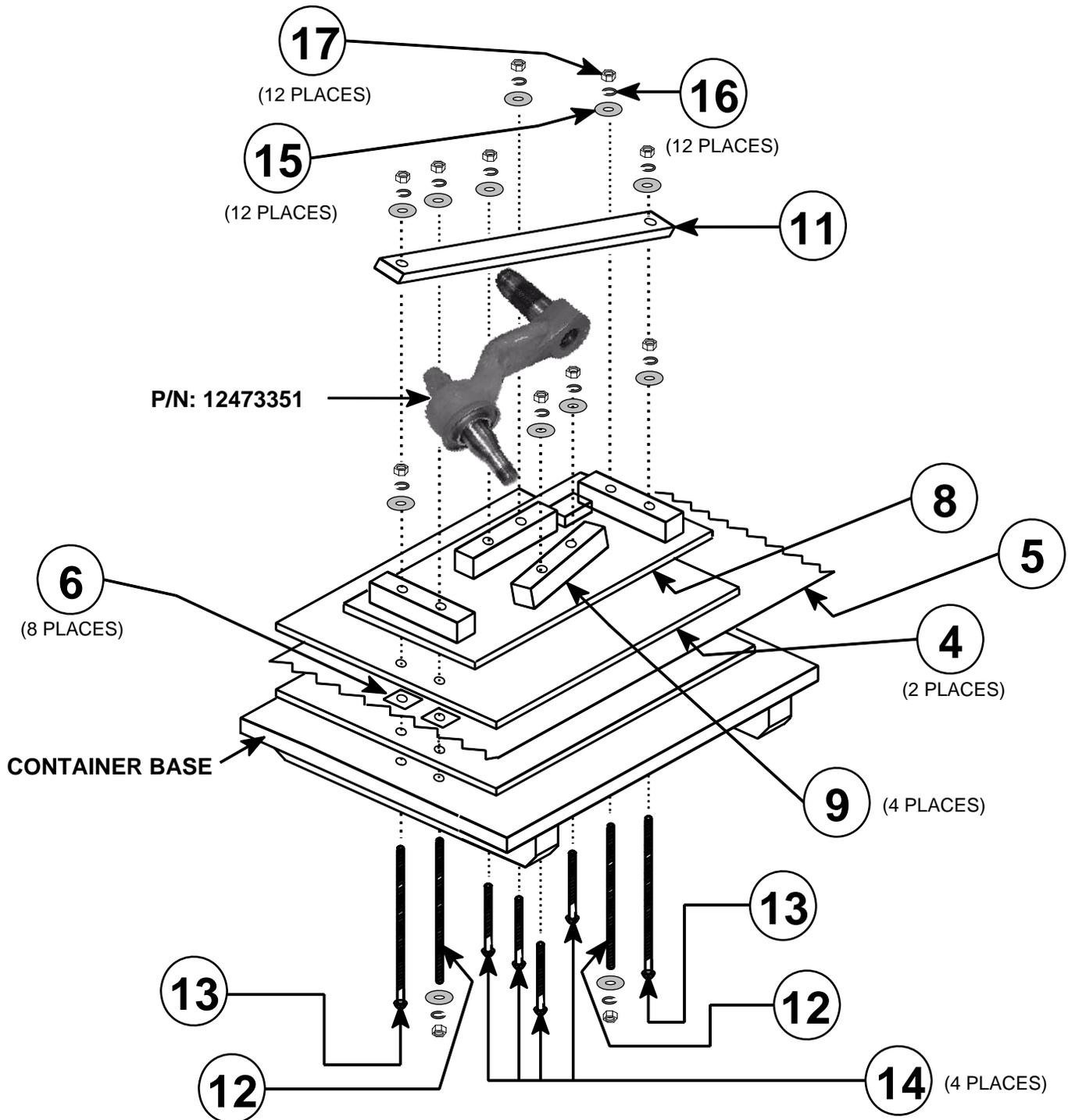
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BILL OF MATERIALS

ITEM NUMBER	DESCRIPTION	SIZE	SPECIFICATION DATA	QTY.
1	OIL		MIL-PRF-2104, GRADE 30.	A/R
2	CUSHIONING		A-A-59135, CLASS 1, GRADE A.	
2A		22 X 18 X 1/4		1
2B		25 X 21 X 1/4		1
2C		36 X 18 X 1/4		1
3	INTIMATE WRAP	75 X 36	MIL-PRF-121, TYPE 1.	1
4	CORRUGATED PAD	SEE PAGE 4	ASTM-D4727, TYPE CF, CLASS WR, VARIETY SW, GRADE W5c.	2
5	BARRIER ENVELOPE		MIL-E-6060.	
5A		92 X 36 (SEE PAGE 6)		1
5B		110 X 18		1
6	GASKET	3 X 3 X 1/8	ASTM-F104.	16
7	ADHESIVE		MMM-A-260.	A/R
8	LOAD SPREADER	35 X 15 X 1/4 (SEE PAGE 7)	A-A-55057, TYPE A.	1
9	WOOD BLOCKING	4 X 4 (NOM) X 13 (SEE PAGE 5)	ASTM-D6199, CLASS 2, GROUP II OR III.	4
10	WOOD BLOCKING	2 X 4 (NOM) X 5	ASTM-D6199, CLASS 2, GROUP II OR III.	1
11	WOOD BLOCKING	2 X 4 (NOM) X 34-3/4 (SEE PAGE 5)	ASTM-D6199, CLASS 2, GROUP II OR III.	1
12**	THREADED ROD	1/2 X 16	COMMERCIAL GRADE.	2
13**	CARRIAGE BOLT	1/2 X 11	COMMERCIAL GRADE.	2
14**	CARRIAGE BOLT	1/2 X 7	COMMERCIAL GRADE.	4
15**	FLAT WASHER	1/2	COMMERCIAL GRADE.	12
16**	LOCK WASHER	1/2	COMMERCIAL GRADE.	12
17**	HEX NUT	1/2	COMMERCIAL GRADE.	12

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ITEM NUMBER	DESCRIPTION	SIZE	SPECIFICATION DATA	QTY.
*18	CONTAINER	37 X 33-1/2 X 12	PPP-B-621, CLASS 2, STYLE 2, GRADE B, MODIFIED.	1

*CONTAINER SHALL CONFORM TO PPP-B-621, CLASS 2, STYLE 2, GRADE B, WITH THE EXCEPTION THAT THE SKIDS SHALL BE 3 INCHES FROM THE EDGE OF THE CONTAINER, AND THE BASE SHALL BE 2 INCH (NOM) LUMBER.

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