

SPECIAL PACKAGING INSTRUCTION

Form Approved
OMB No. 0704-0188

XBM
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1. PART OR DRAWING NO. (CAGE CODE) NOMENCLATURE 12478096 (19207) WELDING ACCESSORY KIT		2. CAGE 19207		3. SPI NO. AK15530279	
4. NATIONAL STOCK NO. 3439-01-553-0279		5. DATE APRIL 30, 2012		6. REVISION A	
7. QUP 1 EACH	8. ICQ NONE	9. UNIT PACK WT (LB.) 167.0	10. UNIT PACK CU (CU. FT.) 9.49	11. UNIT PACK SIZE (INCHES) 41.4 X 26.4 X 15.0	
12. MILITARY PRESERVATION MIL-STD-2073-1D, METHOD 32 AND NOTE A		18. STEPS	19. REQD	20. DESCRIPTION	
13. CLEANING MIL-STD-2073-1D & NOTE B				SEE NOTES FOR PACKAGING DETAILS	
14. DRYING MIL-STD-2073-1D & NOTE B					
15. PACKING					
a. LEVEL A MIL-STD-2073-1D & NOTE AH					
b. LEVEL B NOT APPLICABLE					
16. MARKING MIL-STD-129 AND NOTE AJ					

17. NOTES/DRAWING

A. QUALITY ASSURANCE PROVISIONS:

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

B. CLEAN AND DRY ITEM BY ANY SUITABLE PROCESS BEFORE APPLICATION OF PACKAGING MATERIALS.

C. IN LIEU OF THE ENGINEERING DRAWING HEX NOTE 3, PLACE SEGREGATED PACKS 1 AND 2 INSIDE THE PELICAN CASE.

D. KIT, P/N 12478096, CONTAINS THE FOLLOWING ITEMS AS SHOWN BELOW. ALL PARTS HAVE CAGE CODE 59491.

QUANTITY	DESCRIPTION	PART NUMBER	SEGREGATED PACK NUMBER
1	STIX PAK, 1/4" CUTTING RODS (9 RODS)	1418PC-SPS	1
1	STIX PAK, 3/8" CUTTING RODS (6 RODS)	3818PC-SPS	2
1	REGULATOR, INDUSTRIAL, ADJUSTABLE	HR3500-QD	3
1	MANUAL, OPERATING INSTRUCTIONS	INST-A5V2HR	4
1	ADAPTER, YOKE, MEDICAL OXYGEN	M87-1	5
1	KIT, BATTERY ADAPTER (CLAMPS)	PC/BAK	6
1	PELICAN CASE W/ CUSTOM FOAM	PC/C-1600	7
1	SHIELD, LEATHER	PC/LS	8
1	QUIVER, LONG, ROD HOLDER	PC/NRHL	9
1	EXTENSION SET, 30' HOSE & 35' CABLE	PC/EX-3035	10
4	KIT, COLLET, 3/8" (3 SPARES)	PCRP-305A	11
1	KIT, COLLET, 1/4"	PCRP-305B	12
1	KIT, COLLET, 1/2"	PCRP-305C	13

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QUANTITY	DESCRIPTION	PART NUMBER	SEGREGATED PACK NUMBER
1	KIT, COLLET, 3/16"	PCRP-305D	14
1	COLLET NUT (SPARE)	PCRP-303	15
1	STRIKER PLATE 30' CABLE W/ CONNECTOR	PC/SP-30	16
1	SLAVE CONNECTOR ASSY	PC/SR-CL	17
1	TORCH WITH 30' CABLE & HOSE ASSY	PC/T-30	18
1	EXTENDER, ROD, 16" LONG	PC/TAC-XT	19
1	GOGGLES, SAFETY, #5 SHADE	PC/TSG	20
1	VALVE KIT (SPARE)	PC-VRK	21
1	GLOVES, WELDING, GREEN	PC/WG	22
1	10-WAY CYLINDER WRENCH	W1013	23
1 BOX	CUTTING RODS, 36" X 3/8" (33 RODS)	3836PC-25	24

E. PREPARE ONE STIX PAK, 1/4" CUTTING RODS (9 RODS), P/N 1418PC-SPS, IN ACCORDANCE WITH THE STEPS BELOW.

1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 20 X 4. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "1".
3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.

F. PREPARE ONE STIX PAK, 3/8" CUTTING RODS (6 RODS), P/N 3818PC-SPS, IN ACCORDANCE WITH THE STEPS BELOW.

1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 20 X 4. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "2".
3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.

G. PREPARE ONE REGULATOR, INDUSTRIAL, ADJUSTABLE, P/N HR3500-QD, IN ACCORDANCE WITH THE STEPS BELOW.

1. WRAP: MIL-DTL-17667, TY II, SIZE: 27 X 15. APPLY A SINGLE WRAP TO THE REGULATOR. SECURE WITH TAPE ASTM D5486.
2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "3".
3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.

H. PREPARE ONE MANUAL, OPERATING INSTRUCTIONS, P/N INST-A5V2HR, IN ACCORDANCE WITH THE STEPS BELOW.

1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 7 X 11. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "4".
3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.

J. PREPARE ONE ADAPTER, YOKE, MEDICAL OXYGEN, P/N M87-1, IN ACCORDANCE WITH THE STEPS BELOW.

1. WRAP: MIL-P-17667, TY II, CL 1, SIZE: 11 X 7. APPLY A SINGLE WRAP TO THE REGULATOR. SECURE WITH TAPE ASTM D5486.
2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "5".
3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.

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- K. PREPARE ONE KIT, BATTERY ADAPTER (CLAMPS), P/N PC/BAK, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 9 X 11. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "6".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- L. PREPARE ONE PELICAN CASE W/ CUSTOM FOAM, P/N PC/C-1600, IN ACCORDANCE WITH THE STEPS BELOW.
1. IDENTIFICATION: IDENTIFY THE CASE WITH PART NUMBER PC/C-1600 IN ACCORDANCE WITH THE ENGINEERING DRAWING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "7".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- M. PREPARE ONE SHIELD, LEATHER, P/N PC/LS, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 7 X 12. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "8".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- N. PREPARE ONE QUIVER, LONG, ROD HOLDER, P/N PC/NRHL, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 7 X 24. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "9".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- P. PREPARE ONE EXTENSION SET, 30' HOSE & 35' CABLE W/ QD COUPLING, P/N PC/EX-3035, IN ACCORDANCE WITH THE STEPS BELOW.
1. CAPS/PLUGS: NAS 847. SEAL ALL OPENINGS TO THE INTERIOR OF THE HOSE AND CABLE WITH CAPS/PLUGS OF THE APPROPRIATE SIZE.
 2. ITEM PREPARATION: COIL HOSE AND CABLE TO AN APPROXIMATE 22 INCH DIAMETER.
 3. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "10".
 4. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- Q. PREPARE FOUR KIT, COLLET, 3/8", P/N PCRP-305A SEPARATELY, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 5 X 6, QUANTITY 4. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "11".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- R. PREPARE ONE KIT, COLLET, 1/4", P/N PCRP-305B, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 3 X 4. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "12".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- S. PREPARE ONE KIT, COLLET, 1/2", P/N PCRP-305C, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 3 X 4. CLOSURE SHALL BE BY TAPING, OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "13".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.

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- T. PREPARE ONE KIT, COLLET, 1/2", P/N PCRP-305C, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 3 X 4. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "14".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- U. PREPARE ONE COLLET NUT, P/N PCRP-303, IN ACCORDANCE WITH THE STEPS BELOW
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 4 X 4. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "15".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- V. PREPARE ONE STRIKER PLATE 30' CABLE W/ CONNECTOR, P/N PC/SP-30, IN ACCORDANCE WITH THE STEPS BELOW.
1. ITEM PREPARATION: COIL STRIKER PLATE AND CABLE TO AN APPROXIMATE 13 INCH DIAMETER.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "16".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- W. PREPARE ONE SLAVE CONNECTOR ASSY, P/N PC/SR-CL, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 10 X 20. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "17".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- X. PREPARE ONE TORCH WITH 30' CABLE & HOSE ASSEMBLY W/ QD COUPLING, P/N PC/T-30, IN ACCORDANCE WITH THE STEPS BELOW.
1. ITEM PREPARATION: TORCH AND HOSE ASSEMBLY TO AN APPROXIMATE 18 INCH DIAMETER.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "18".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- Y. PREPARE ONE EXTENDER, ROD, 16" LONG, P/N PC/TAC-XT, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 4 X 22. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "19".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- Z. PREPARE ONE GOGGLES, SAFETY, #5 SHADE, P/N PC/TSG, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 8 X 13. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "20".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- AA. PREPARE ONE VALVE KIT, P/N PC-VRK, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 3 X 5. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "21".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- AB. PREPARE ONE PAIR OF GLOVES, WELDING, GREEN, P/N PC/WG, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 10 X 18. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "22".
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- AC. PREPARE ONE 10-WAY CYLINDER WRENCH, P/N W1013, IN ACCORDANCE WITH THE STEPS BELOW
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 5 X 12. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "23".
 3. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 10.
- AD. PREPARE ONE BOX OF CUTTING RODS, 36" X 3/8" (33 RODS), P/N 3836PC-25, IN ACCORDANCE WITH THE STEPS BELOW.
1. CONTAINER: ASTM D5118, ST RSC, TY CF, CL DOM, VAR SW, GR 275 SIZE: 37-1/4 X 3-1/4 X 2-1/2. CLOSURE SHALL BE IN ACCORDANCE WITH CLOSURE 2B6 OF ASTM D1974.
 2. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 9 X 44. CLOSURE SHALL BE BY HEAT SEALING.
 3. CONTAINER: ASTM D5118, ST FOL, TY CF, CL WR, VAR SW, GR W5c, SIZE: 37-3/4 X 3-3/4 X 3-1/2. CLOSURE SHALL BE IN ACCORDANCE WITH CLOSURE 4B2 OF ASTM D1974.
 4. IDENTIFICATION: IDENTIFY THE PACK AS A SEGREGATED PACK NUMBER "24".
 5. INSPECTION: INSPECT THE PACK IN ACCORDANCE WITH THE CRITERIA FOR METHOD 32.
- AE. PREPARE THE ITEMS FROM NOTES G, L, P THROUGH T, Z AND AB, TOGETHER, IN ACCORDANCE WITH THE STEPS BELOW.
1. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 8 X 12. CLOSURE SHALL BE BY TAPING OR HEAT SEALING.
 2. INSPECTION: INSPECT UNIT PACK IN ACCORDANCE WITH CRITERIA FOR METHOD 10.
- AF. CONSOLIDATE THE ITEMS FROM NOTES D, E, F, H, J, M, N, U THROUGH Y, AA AND AD IN ACCORDANCE WITH THE STEPS BELOW.
1. CONSOLIDATE: THE PARTS INTO THE PELICAN CASE, PART NUMBER PC/C-1600. NEATLY ARRANGE IN VOID OF CASE ENSURING ITEMS ARE NOT SUBJECT TO DAMAGE OR DEFORMATION. SECURELY CLOSE PELICAN CASE LATCHES.
 2. CONTAINER: ASTM D5118, ST RSC, TY CF, CL DOM, VAR SW, GR 275, SIZE: 24-1/8 X 19-1/2 X 8-1/2. CLOSURE SHALL BE IN ACCORDANCE WITH CLOSURE 2B6 OF ASTM D1974.
 3. BAG: MIL-DTL-117, TY III, CL B, ST 2, SIZE: 31 X 37. CLOSURE SHALL BE BY HEAT SEALING.
 4. CONTAINER: ASTM D5118, ST RSC, TY CF, CL WR, VAR SW, GR W5c, SIZE: 24-5/8 X 20 X 9-1/4. CLOSURE SHALL BE IN ACCORDANCE WITH CLOSURE 2B6 OF ASTM D1974.
 5. INSPECTION: INSPECT UNIT PACK IN ACCORDANCE WITH CRITERIA FOR METHOD 32.
- AG. CONSOLIDATE THESE ITEMS FROM NOTES AC AND AE IN ACCORDANCE WITH THE STEPS BELOW.
1. BLOCKING AND BRACING: MIL-STD-1186 AND ASTM D6199, GROUP I OR II. SEE PAGE 6.
 2. CONTAINER: ASTM D6880 CL 2, ST 2 (MODIFIED), SIZE 38-3/4 X-24-7/8 X 10. CONTAINER IS CONSTRUCTED OF ALL 1-INCH THICK NOMINAL LUMBER AND IS MODIFIED TO INCLUDE BEVELED SKIDS. SIZE AND APPLICATION OF SKIDS ARE IN ACCORDANCE WITH ASTM D6880.
 3. INSPECTION: INSPECT UNIT PACK IN ACCORDANCE WITH CRITERIA FOR METHOD 32.
- AH. UNIT CONTAINER IS THE SHIPPING CONTAINER.
- AJ. PROVIDE A PACKING LIST WITH THE UNIT PACK IN ACCORDANCE WITH MIL-STD-129. ON THE PACKING LIST, IDENTIFY THE ITEMS WITHIN EACH SEGREGATED PACK TOGETHER WITH THEIR SEGREGATED PACK NUMBER.

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