

SPECIAL PACKAGING INSTRUCTION

Form Approved
OMB No. 0704-0188

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PLEASE DO NOT RETURN YOUR COMPLETED FORM TO THE ABOVE ORGANIZATION.

1. PART OR DRAWING NO. (CAGE) NOMENCLATURE 12522469 (19207) ARM ASSEMBLY, RH		2. CODE IDENT 19207	3. SPI NO. AK15887023
4. NATIONAL STOCK NUMBER 2530-01-588-7023		5. DATE OF DRAWING 11/26/2013	6. REVISION -
7. QUP 1 EA	8. ICQ NONE	9. UNIT PACK WT. (LB) 360.0	10. UNIT PACK CU (CU FT) 16.852
12. MILITARY PRESERVATION (METHOD) MIL-STD-2073-1D, METHOD 43		18. STEPS	19. REQ'D
13. CLEANING MIL-STD-2073-1D			20. DESCRIPTION
14. DRYING MIL-STD-2073-1D			
15. PACKING			SEE THE NOTES
a. LEVEL A MIL-STD-2073-1D AND NOTE P			
b. LEVEL B MIL-STD-2073-1D AND NOTE P			
16. MARKING MIL-STD-129			

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

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- K. PLACE THE PREPARED ARM ASSEMBLY, RH IN THE PREPARED CONTAINER, AS IT IS SHOWN ON PAGE 8.
- L. PLACE THE WOOD BLOCKING, ITEM 11, OVER THE ARM ASSEMBLY, RH AND SECURE IT TO THE BASE AS IT IS SHOWN ON PAGE 8.
- M. COVER THE PREPARED PART WITH CUSHIONING, ITEM 2C, IN ORDER TO PREVENT THE HARDWARE FROM PUNCTURING THE BARRIER ENVELOPE WHEN IT IS SEALED.
- N. COMPLETE THE BARRIER ENVELOPE, ITEM 5, BY HEAT SEALING 5A TO 5B. SEE THE ILLUSTRATION ON PAGE 7.
- O. ASSEMBLE THE REMAINDER OF THE CONTAINER, ITEM 18.
- P. THE UNIT CONTAINER IS AN ACCEPTABLE LEVEL A AND LEVEL B SHIPPING CONTAINER.
- Q. INSPECT THE PRESERVATION, THE UNIT PACK AND THE PACKAGING IN ACCORDANCE WITH MIL-STD-2073-1D AND THE APPLICABLE CONTAINER SPECIFICATION.

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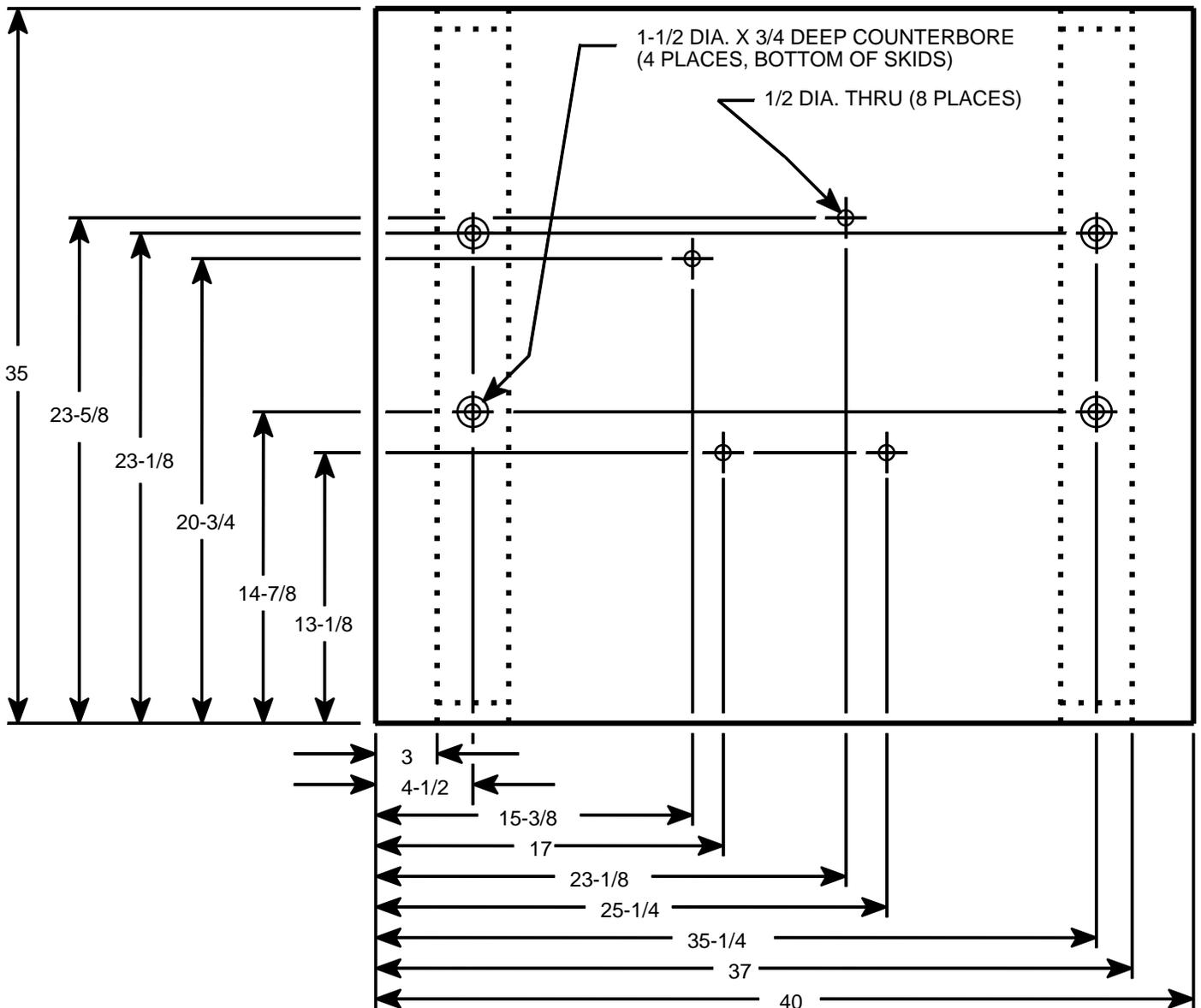
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BASE OF CONTAINER, ITEM 18



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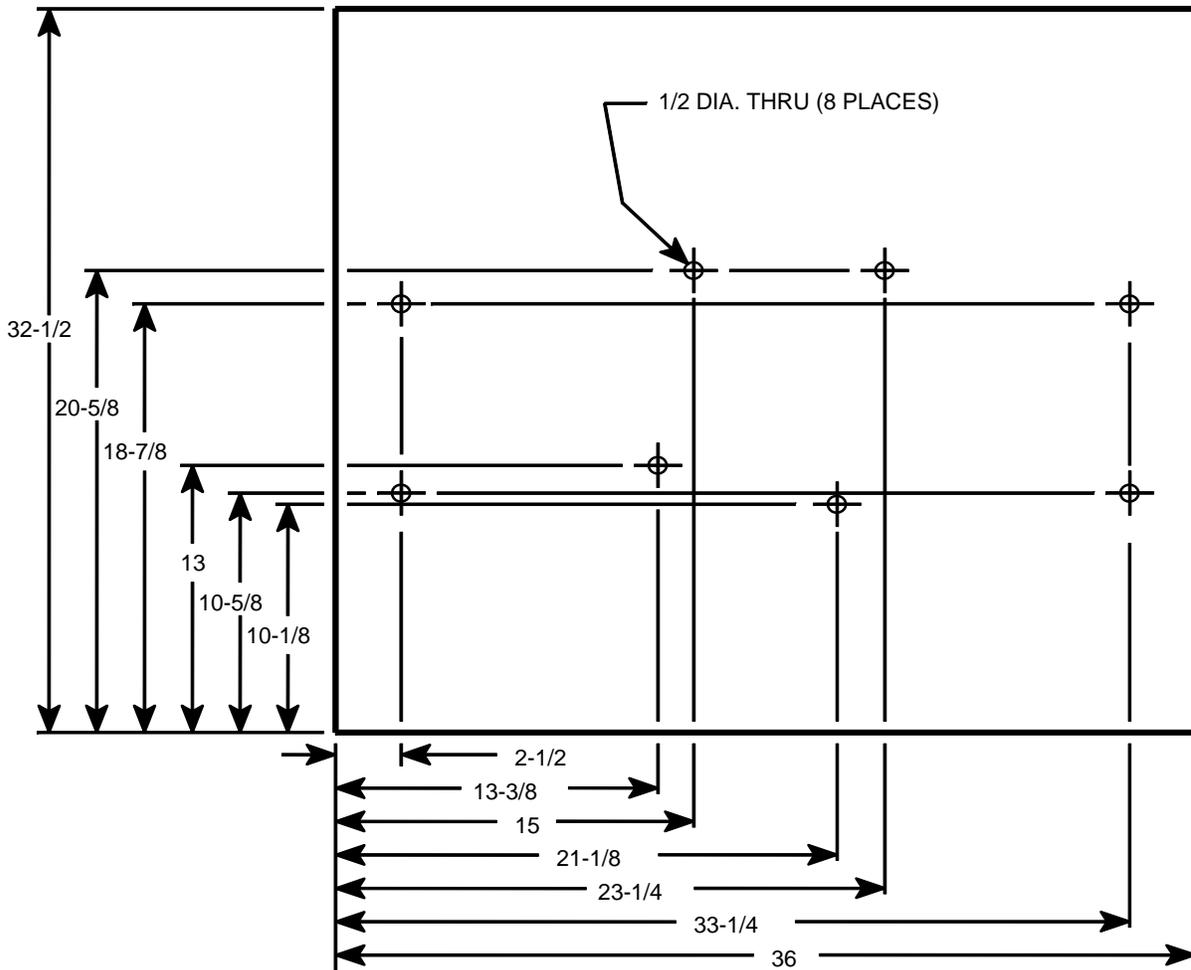
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4



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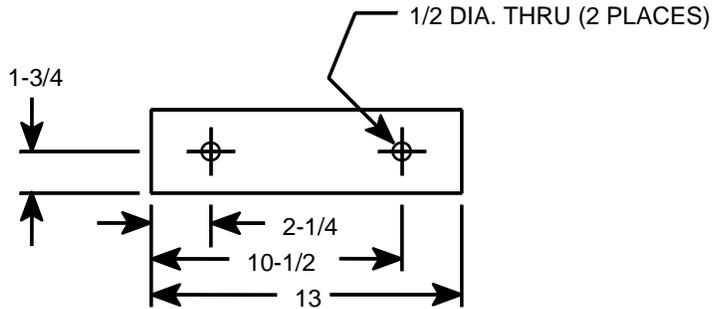
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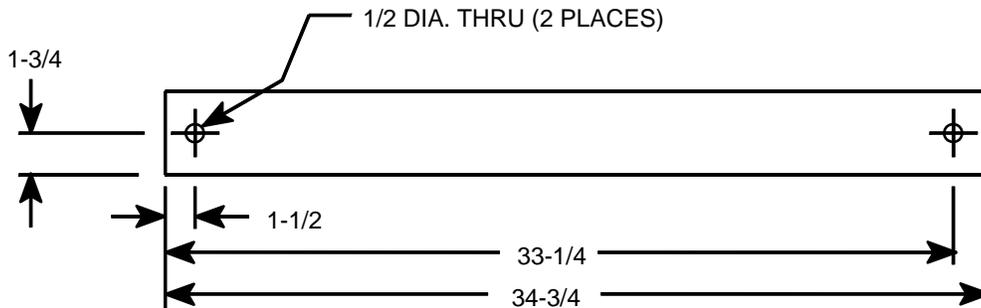
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9



11



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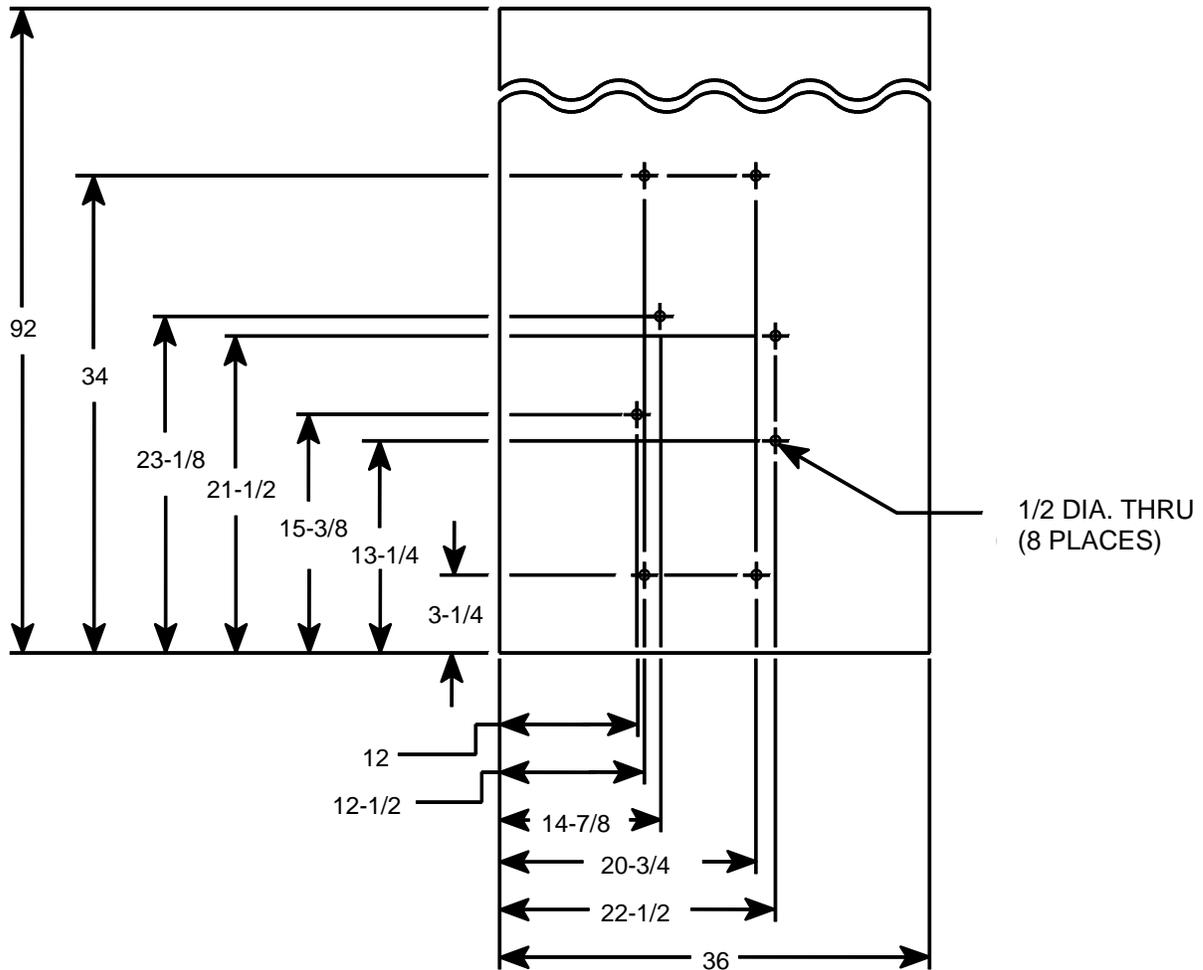
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SPECIAL PACKAGING INSTRUCTION (Continuation Sheet)

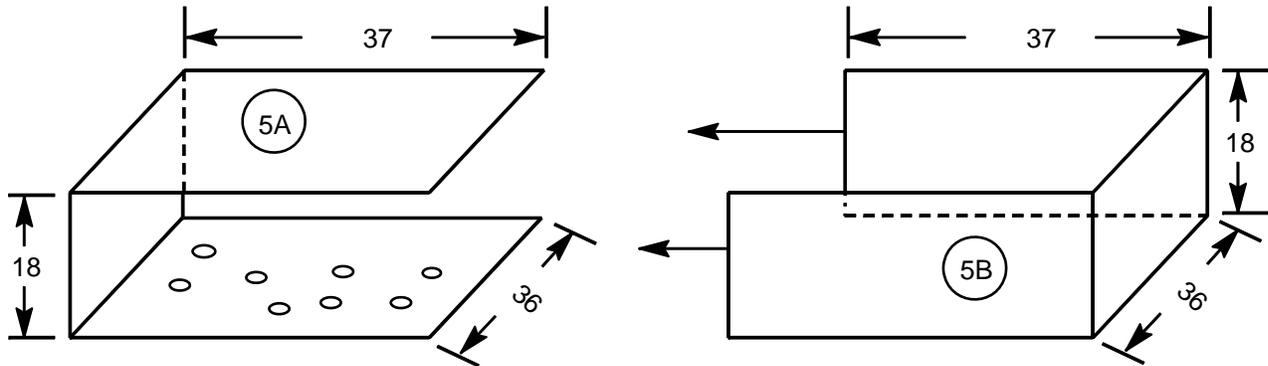
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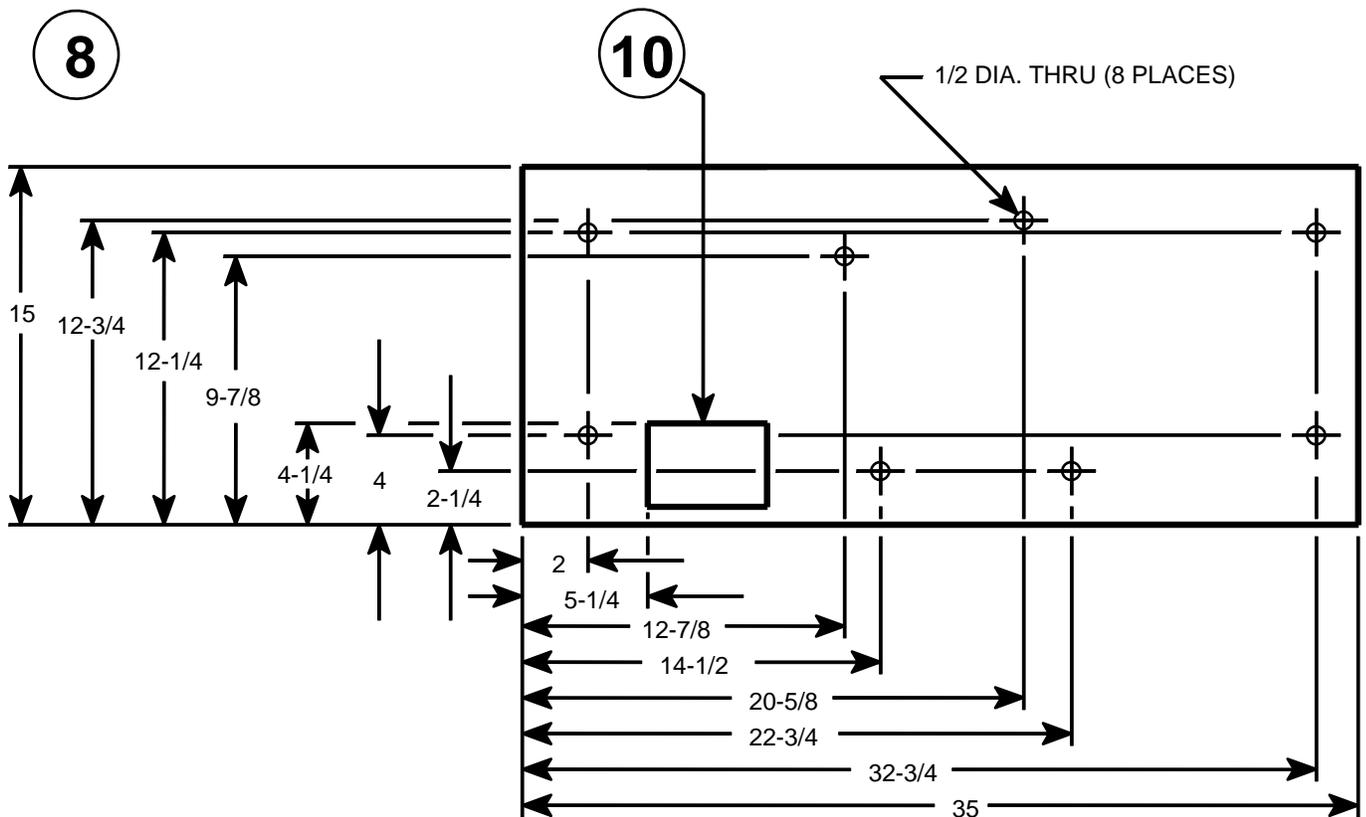
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BARRIER ENVELOPE MATERIAL AND ASSEMBLY



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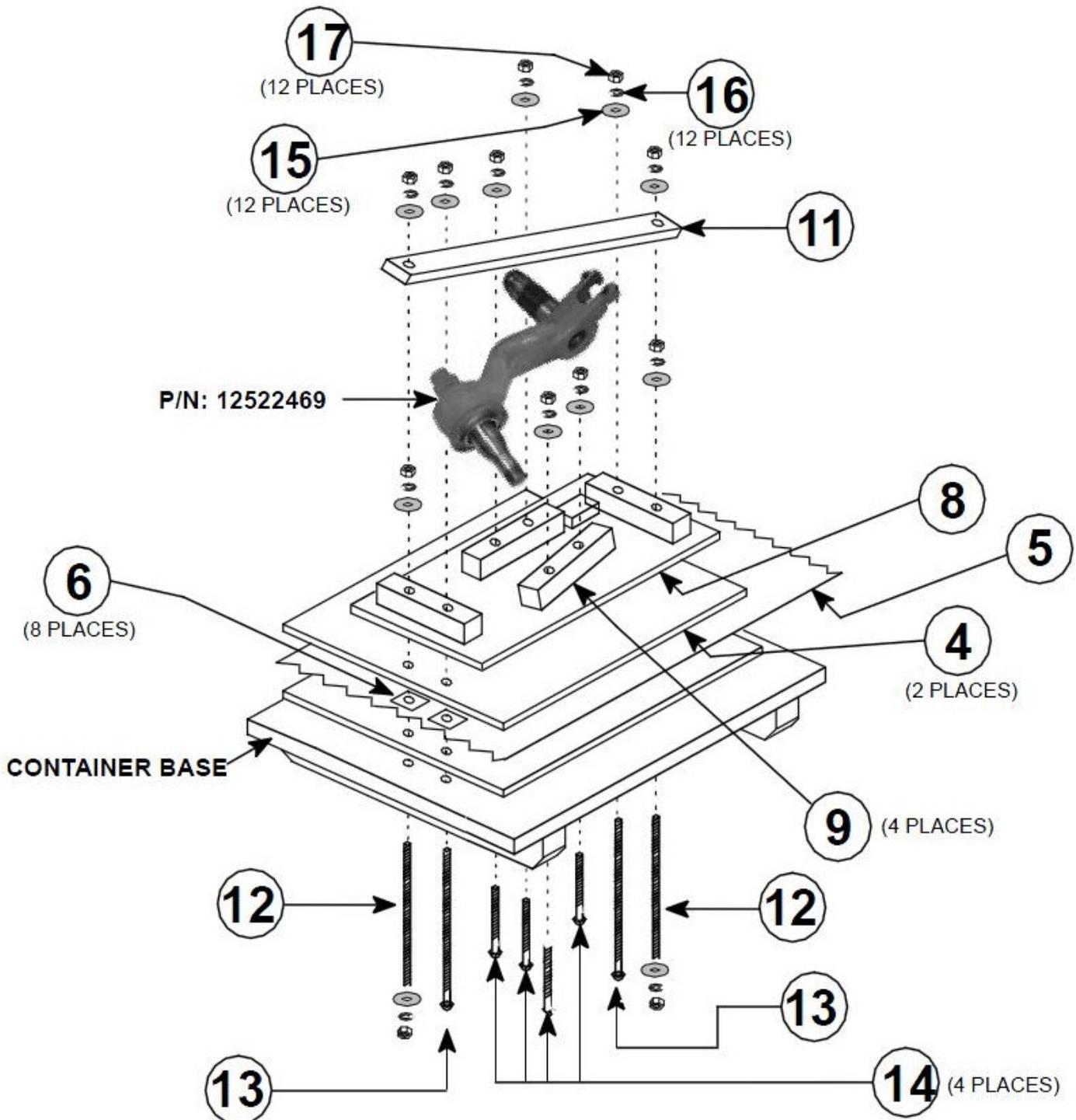
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BILL OF MATERIALS

ITEM NUMBER	DESCRIPTION	SIZE	SPECIFICATION DATA	QTY.
1	PRESERVATIVE		MIL-PRF-2104, GRADE 40.	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	WRAP	75 X 36	MIL-PRF-121, TYPE I.	1
4	CORRUGATED PAD	SEE PAGE 4	ASTM-D4727, TYPE CF, CLASS WR, VARIETY SW, GRADE W5c.	2
5	BARRIER ENVELOPE		MIL-DTL-6060.	
5A		92 X 36		1
		(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, CLASS 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

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ITEM NUMBER	DESCRIPTION	SIZE	SPECIFICATION DATA	QTY.
16*	LOCK WASHER	1/2	COMMERCIAL GRADE.	12
17*	HEX NUT	1/2	COMMERCIAL GRADE.	12
18**	CONTAINER	37 X 33-1/2 X 15	ASTM-D6880, CLASS 2, STYLE 2, MODIFIED.	1

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

**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.