

SPECIAL PACKAGING INSTRUCTION				CODE ID 98752	SPI NO (TPD) F00-580-0493 SHEET 6 OF 13							
PART OR DRAWING NO. MULTIPLE		NATIONAL STOCK NO. MULTIPLE		CURR REV N	ILL D. BELFLOWER PS J. HOLMES CHK M. RAINES AUTH C. WILLIAMS							
ITEM NOMENCLATURE PROP ASSY				ORIG DATE 73241								
<b>PRESERVATION:</b> IAW MIL-STD 2073 SERVICEABLE METHOD: SEE NOTE 1 UNSERVICEABLE METHOD: SEE NOTE 1				<b>PACKING:</b> AS SPECIFIED BELOW AND BILL OF MATERIALS								
				LEVEL	SPEC	STYLE	TYPE	CL	VRTY	GR	TR	
				A	ASTM D 6256	A	I	2	(MOD)		SEE NOTE 2	
				B	ASTM D 6256	A	I	2	(MOD)			
QUP: 001 ICQ: 000												
						LEVEL A		LEVEL B				
<b>CLEANING &amp; DRYING:</b> IAW MIL-STD-2073				GROSS CU FT		102.95		102.95				
<b>PRESERVATIVE:</b> SEE NOTE 1				GROSS WT LBS		1880		1880				
<b>MARKING:</b> IAW MIL-STD-129				DESIGN FRAGILITY G		110		110				
<b>SPECIAL MARKINGS:</b> A) SPI NO. F00-580-0493 B) REUSABLE CONTAINER & DUNNAGE - DO NOT DESTROY. C) NOT FOR OUTSIDE STORAGE D) OUTSIDE DIMENSIONS IN INCHES REQUIRED				CNTNR I.D.				LENGTH		WIDTH		DEPTH
				LEVEL A		136 3/4		35 1/2		26		
				LEVEL B		136 3/4		35 1/2		26		
				CNTNR O.D.								
<b>CLOSURE:</b> LEVEL A: IAW ASTM D 6256 LEVEL B: IAW ASTM D 6256				LEVEL A		145		37 3/4		32 1/2		
				LEVEL B		145		37 3/4		32 1/2		
				ITEM DIM: N/A ITEM WT LBS: N/A								
				REVISIONS								
				LTR	DESCRIPTION						DATE	
				L	IAW W/O 003/14						14034	
				M	IAW W/O 008/14						14062	
				N	IAW W/O 236/17						17291	
11	2	TOP DIAGONAL BRACE	37 1/2 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>								
10	4	SIDE DIAGONAL BRACE	36 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>								
9	4	INSERT SUPPORTS	24 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>, DETAIL 7								
8	4	INSERT SUPPORTS	24 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>, DETAIL 7								
7	8	STRUTS	24 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>								
7A	2	STRUTS	23 3/4 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>								
6	7	CROSS MEMBERS	33 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>, <13>								
5	4	SIDE RAILS	132 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>								
4	8	RUBBING STRIP	2 X 6 (NOM) X 46	ASTM D 6199, <7>, DETAIL 1 & 8								
3A	2	HEADER	4 X 4 (NOM) X 35 1/2	ASTM D 6199, DETAIL 1								
3	1	FLOOR	136 X 35 1/2 X 1/2	A-A-55057, DETAIL 1 & 8, <13>								
2	2	SKIDS	2 X 6 (NOM) X 145	ASTM D 6199, DETAIL 1 & 8								
1	1	EXTERIOR CONTAINER		SEE PACKING, <14>								
PART NO.	QTY.	NOMENCLATURE OR DESCRIPTION		SIZE (INCHES UNLESS SPECIFIED) TOLERANCES ON FRAC. ± 1/8, DECIMAL ± .01, ANGLES ± 1°.			MATERIAL SPECIFICATION					

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41	A/R	WRAP		MIL-PRF-121	
40	4	CARR BOLTS W/NUTS & WASH	3/8 DIA X 9	COMMERCIAL, DETAIL 1	
39	1	FILLER UNDER BOX B	29 X 29 X 1/4	A-A-55057, TY. A, DETAIL 1	
38	1	FILLER UNDER BOX A	29 X 19 X 1/4	A-A-55057, TY. A, DETAIL 1	
37	A/R	WRAP		PPP-C-1797, TY. 1	
36	16	WOOD SCREWS	10/24 X 2 INCHES	COMMERCIAL, <5>	
35	4	STABILIZER	8 X 4 1/2 X 3/4	A-A-55057, TY. A, <5>, DETAIL 2	
34	A/R	TAPE		A-A-1689, DETAIL 9	
33	A/R	PRESERVATIVE		MIL-C-16173, GR. 3, <1>, DETAIL 9	
32	1	TOP PANEL	29 1/2 X 27 X 1/2	A-A-55057, TY. A, DETAIL 4	
32A	1	BOTTOM PANEL	29 1/2 X 27 X 3/4	A-A-55057, TY. A, DETAIL 4	
31	2	SIDE PANELS	27 X 23 X 1/2	A-A-55057, TY. A, DETAIL 4	
30	4	FILLER CLEATS	1 X 4 X 21 1/2	ASTM D 6199, DETAIL 4	
29	4	THROUGH CLEATS	1 X 4 X 23	ASTM D 6199, DETAIL 4	
28	2	END PANELS COMPONENT	28 1/2 X 23 1/2 X 1/2	A-A-55057, TY. A, DETAIL 3,	
				BOX B 32 1/2 X 27 X 23 1/2 OD	
27	1	TOP PANEL	29 1/2 X 19 X 1/2	A-A-55057, TY. A, DETAIL 3	
27A	1	BOTTOM PANEL	29 1/2 X 19 X 3/4	A-A-55057, TY. A, DETAIL 3	
26	2	SIDE PANELS	23 X 19 X 1/2	A-A-55057, TY. A, DETAIL 3	
25	4	FILLER CLEATS	1 X 4 X 21 1/2	ASTM D 6199, DETAIL 3	
24	4	THROUGH CLEATS	1 X 4 X 23	ASTM D 6199, DETAIL 3	
23	2	END PANELS COMPONENT	28 1/2 X 23 X 1/2	A-A-55057, TY. A, DETAIL 3,	
				BOX A 32 1/2 X 19 X 23 1/2 OD	
22	A/R	BOLTS W/NUTS	FOR CRATE ASSY	ASTM D 6255, <6>, <13>	
21	A/R	WRAP		MIL-PRF-131, CL. I, DETAIL 9, <3>	
20	A/R	FELT		C-F-206	
19	6	CARR BOLTS W/NUTS & WASH	3/8 DIA X 5	COMMERCIAL, DETAIL 1 & 8	
19A	12	LAG SCREWS	3/8 DIA X 5	COMMERCIAL	
18	16	CARR BOLTS W/NUTS & WASH	3/8 DIA X 2 1/2	COMMERCIAL	
17	2	BLADE HEADERS	2 X 6 (NOM) X 32 3/4	ASTM D 6199, DETAIL 1	
16	4	INSERT FILLER STRIPS	22 1/8 X 1 1/2 X 1 1/2	A-A-55057, TY. A OR MIL-STD 731, DETAIL 1 & 5	
15	2	INSERTS SETS	29 3/4 X 24 1/2 X 1 1/2	A-A-55057, TY. A, <9>, <10>, DETAIL 2	
14	2	PUSH PLATES	2 X 6 (NOM) X 33	ASTM D 6199, DETAIL 1	
13	4	BRACKETS	3 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>, DETAIL 6	
12	2	END BRACES	33 INCHES LONG	MIL-S-21041, UNIT A, TY. 4, CL. 2, FIN., <6>	
PART NO.	QTY.	NOMENCLATURE OR DESCRIPTION	SIZE (INCHES UNLESS SPECIFIED) TOLERANCES ON FRAC. ± 1/8, DECIMAL ± .01, ANGLES ± 1°.	MATERIAL SPECIFICATION	

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NOTES:			
1.	Item	Cleaning / Drying	Preservative
	BLADE SHANK	CODE 1	MIL-C-16173, GR. 3
	DE-ICER CONTACT RING HOLDER ASSEMBLY	CODE 1	N/A
	DOME	CODE 1	MIL-C-16173, GR. 3
	BARREL	CODE 1	MIL-C-16173, GR. 3
	BLADE AIRFOIL	CODE 1	N/A
	Wrap		
			MIL-PRF-131
			MIL-PRF-131
			MIL-PRF-131
			MIL-PRF-131
			MIL-PRF-121
	UPON PROPELLER DISASSEMBLY FOR TURN IN OR STORAGE CLEAN AND PRESERVE IN ACCORDANCE WITH THIS SPI.		
2.	ALL WOODEN LUMBER, WOODEN PALLETS, AND WOODEN CONTAINERS PRODUCED ENTIRELY OR IN PART OF WOOD PACKING MATERIAL (WPM) SHALL BE CONSTRUCTED FROM DEBARKED WOOD IN ADDITION TO HEAT TREATED (HT) MATERIAL (HT 56 DEGREES CENTIGRADE OR 133 DEGREES FAHRENHEIT FOR 30 MINUTES) . CERTIFICATION/MARKING IS REQUIRED BY AN ACCREDITED AGENCY RECOGNIZED BY THE AMERICAN LUMBER STANDARDS COMMITTEE (ALSC) . FOR REFERENCE DOCUMENTATION, SEE "INTERNATIONAL STANDARDS FOR PHYTOSANITARY MEASURES LATEST REVISION OF ISPM) NO.15.AND DOD 4140.01-M-1 COMPLIANCE FOR DEFENSE PACKAGING: PHYTOSANITARY REQUIREMENTS FOR WOOD PACKAGING MATERIAL (WPM) OFFICE. THIS INFORMATION CAN BE FOUND AT WWW.IPPC.INT.		
3.	<b>BLADE SHANK:</b> USING P/N 33, PRESERVE ALL INTERNAL AND EXTERNAL METAL SURFACES OF THE BLADE SHANK INCLUDING THE TAPER BORE, THRUST WASHER AND BUSHING. THE TAPER BORE SURFACE SHOULD BE PRESERVED FROM THE BUTT OF THE BLADE TO THE BALANCE PLUG. WRAP THE BLADE SHANK BY SLIDING P/N 21 UNDER THE THRUST WASHER LEAVING THE THRUST WASHER EXPOSED. SLIDE THE THRUST WASHER BACK TOWARDS THE BUTT END (OVER THE WRAP, P/N 21) AND TIGHTLY WRAP SHANK OUTBOARD OF THE THRUST WASHER WITH TAPE, P/N 34. <b>CAUTION: DO NOT DAMAGE TEFLON STRIP WHILE POSITIONING THRUST WASHER.</b> PRESERVE THE THRUST WASHER WITH ADDITIONAL PRESERVATIVE, P/N 33. WRAP THE THRUST WASHER AND SHANK AREA WITH A SECOND LAYER OF WRAP, P/N 21. TIGHTLY SECURE WITH TAPE, P/N 34, SUCH THAT ALL WRAP IS COVERED TO PREVENT MOISTURE ENTRY. <b>BLADE AIRFOIL:</b> WRAP THE BLADE AIRFOIL FROM THE TIP TO THE BLADE CUFF (BLACK RUBBER) WITH P/N 41 AND SECURE WITH P/N 34. <b>BARREL:</b> USING P/N 33, PRESERVE ALL SURFACES PRIOR TO WRAPPING WITH P/N 21. HEAT SEAL AND VACUUM WRAP AS REQUIRED TO PREVENT MOISTURE INTRUSION. <b>DOME:</b> USING P/N 33, PRESERVE ALL BARE METAL SURFACES. WRAP DOME IN P/N 21. HEAT SEAL AND VACUUM WRAP AS REQUIRED TO PREVENT MOISTURE INTRUSION. <b>DE-ICER CONTACT RING HOLDER ASSEMBLY (NAVY ONLY):</b> WRAP IN P/N 21. HEAT SEAL AND VACUUM WRAP TO PREVENT MOISTURE INTRUSION. WRAP AND PLACE ALL OTHER LOOSE COMPONENTS IN P/N 21. HEAT SEAL AND VACUUM WRAP AS REQUIRED TO PREVENT MOISTURE INTRUSION.		
4.	REMOVE THE TOP INTERMEDIATE CROSS MEMBERS AND DIAGONALS FROM THE SHIPPING CONTAINER. PLACE THE FOUR PRESERVED AND PACKAGED BLADE ASSEMBLIES IN SHIPPING CONTAINER INSERTS, CUSHION AS REQUIRED TO PREVENT MOVEMENT. PLACE BARREL, DOME, DE-ICER CONTACT RING HOLDER ASSEMBLY AND ALL OTHER LOOSE COMPONENTS IN COMPARTMENT BOXES.		
5.	STABILIZER P/N 35 SHALL BE CUSHIONED SAME AS P/N 15. SECURE WITH 2 INCH WOOD SCREWS P/N 36, TO THE TOP OF V CUTS ON P/N 15 WHEN NEEDED TO TAKE OUT MOVEMENT OF BLADE ON THE BLADE END, ADJUST FIRMLY AGAINST BLADE.		
6.	CONSTRUCTION ASSEMBLY AND CLOSURE OF COMPONENT BOX WHEN APPLICABLE AND SHIPPING CONTAINER SHALL BE AS SHOWN IN THIS INSTRUCTION AND THE ADDITIONAL APPLICABLE REQUIREMENTS OF ASTM D 6251 AND ASTM D 6255. NUTS AND BOLTS USED IN SLOTTED ANGLE ASSEMBLIES SHALL CONFORM TO THE REQUIREMENTS OF ASTM D 6255.		
7.	NAILS FOR ATTACHING RUBBING STRIPS SHALL CONFORM TO TYPE II, STYLE 18, FF-N-105 3 1/4 INCHES LONG (MIN) IN STAGGERED ROWS SPACED 12 INCHES (MAX) IN EACH ROW. USE THREE NAILS (MIN) IN EACH ROW WITH PATTERN BEGINNING AND ENDING APPROXIMATELY 1 1/2 INCHES FROM EACH END.		
8.	ASSEMBLE BASE WOOD COMPONENTS BY NAILING.		
9.	MARK P/N 15 WITH SPI NUMBER. USE METHOD AND MATERIALS PRESCRIBED IN MIL-STD 129.		
10.	LAMINATE P/N 15 TO REQUIRED THICKNESS BY NAILING, USE ENOUGH NAILS TO ENSURE NO SEPARATION WILL OCCUR.		
11.	SPECIFICATION ORDERING DATA AND OPTIONS NOT SPECIFIED ( TYPE, CLASS, STYLE, GRADE, ETC) SHALL BE THE PACKERS OPTION.		
12.	USE 5/16 INCH X 1 1/2 LAG SCREW TO SECURE P/N 3 TO P/N 14.		
13.	WHEN FABRICATING A NEW CONTAINER, USE BOLTS P/N 22 TO SECURE P/N 6 CROSS MEMBERS TO P/N 3 FLOOR; SPACING OF BOLTS IN 6 INCH INCREMENTS.		
14.	CONTINUE TO USE ALTERNATE PACK FOR ALL FOREIGN MILITARY SALES (FMS) SHIPMENTS.		

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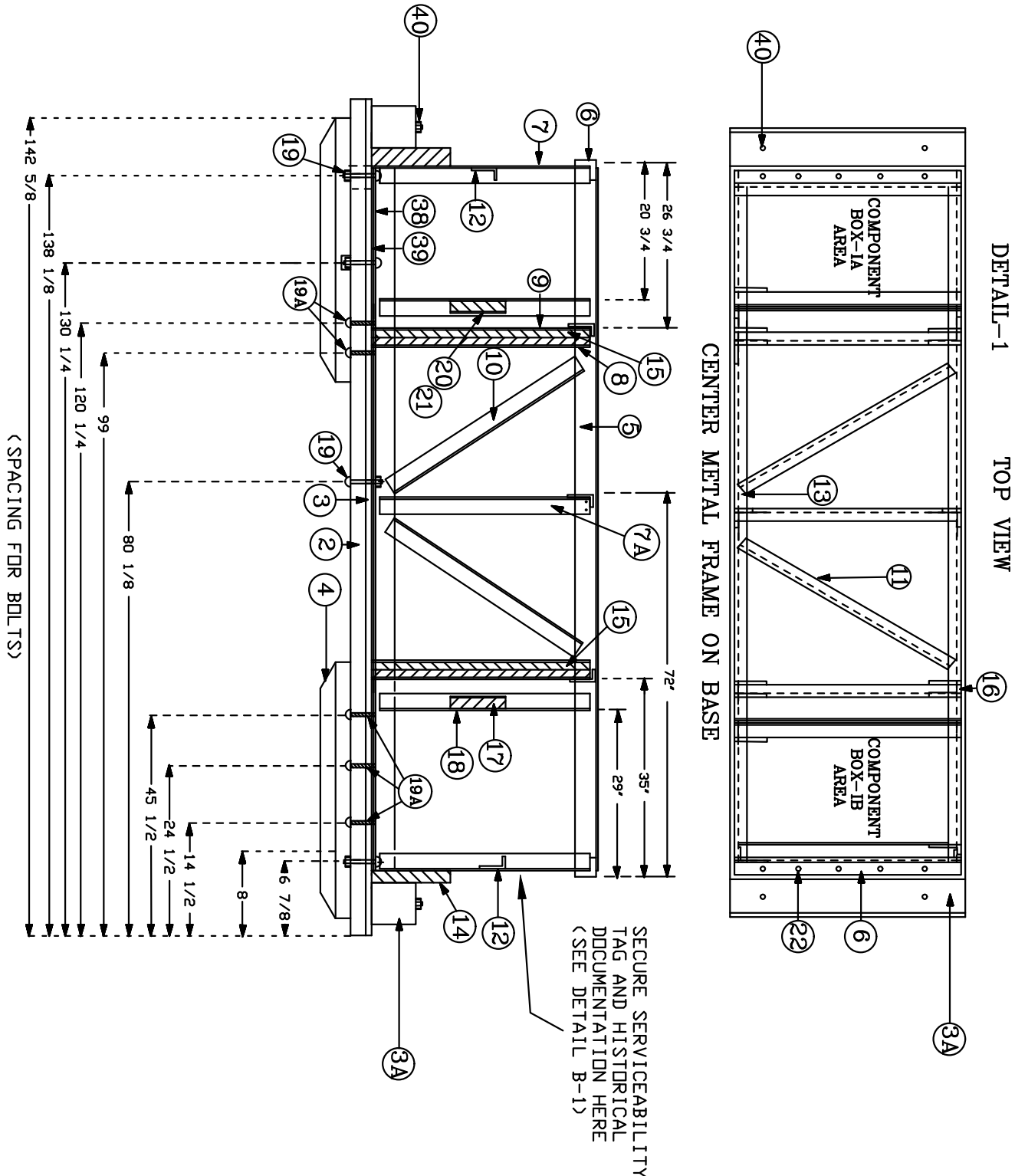
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ITEM NOMENCLATURE  
PROP ASSY

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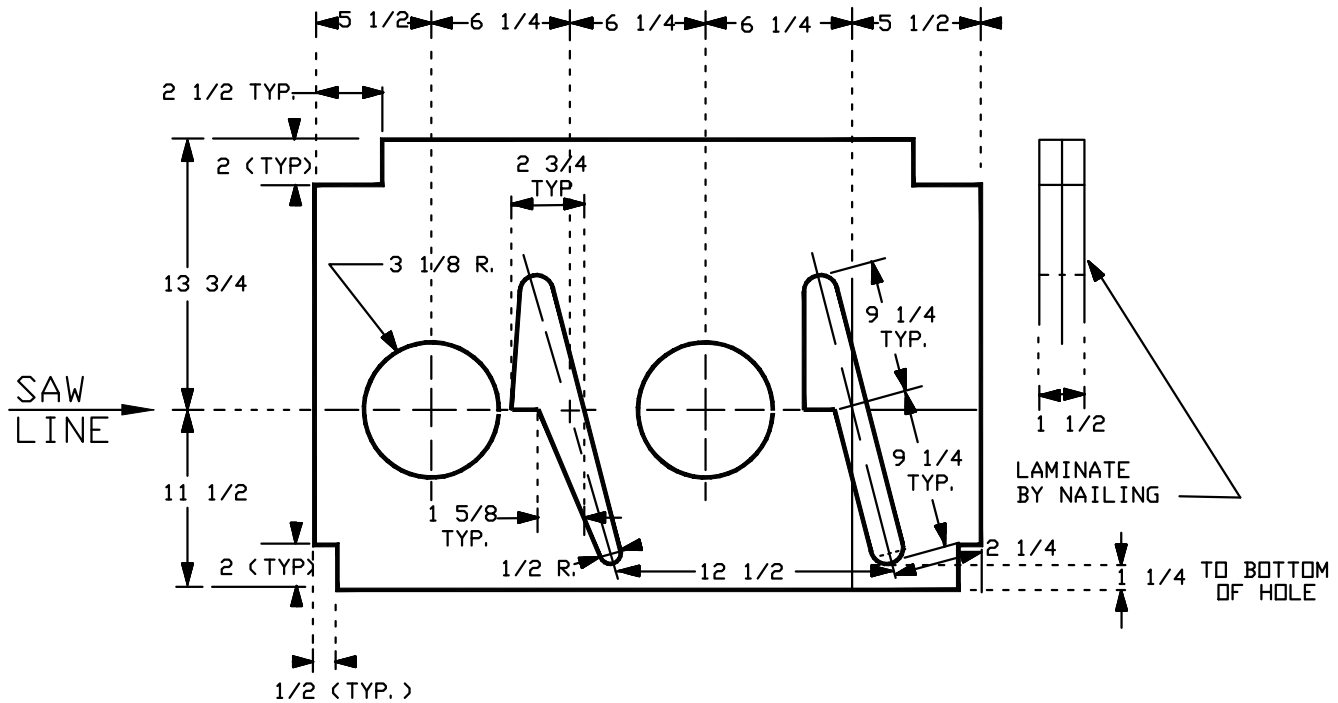
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F00-580-0493

ITEM NOMENCLATURE

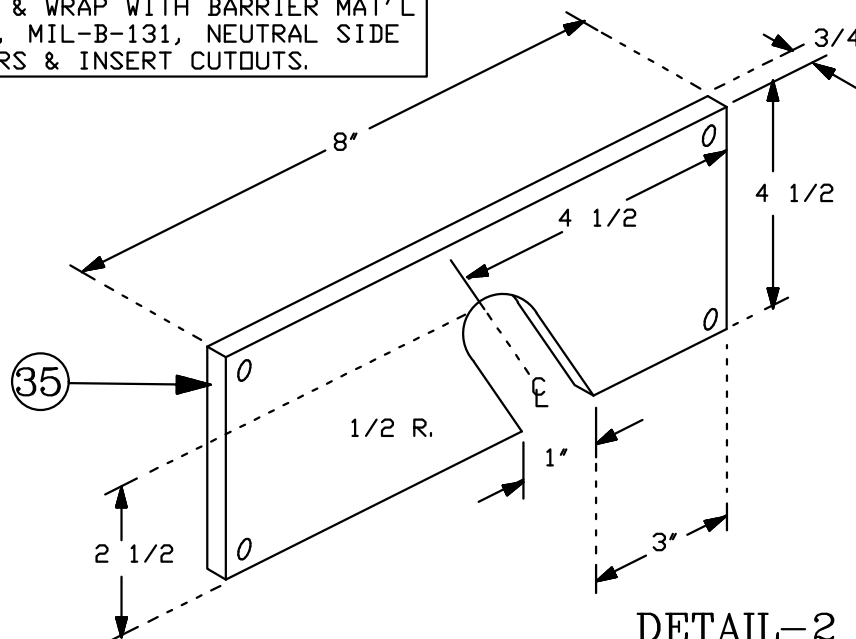
PROP ASSY

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DETAIL-2, P/N-15 INSERTS (2 SETS REQ'D)

NOTE: ADD FELT (A/R) & WRAP WITH BARRIER MAT'L CONFORMING TO CL. I, MIL-B-131, NEUTRAL SIDE OUT FOR BLADE HEADERS & INSERT CUTOUTS.



DETAIL-2

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CODE ID

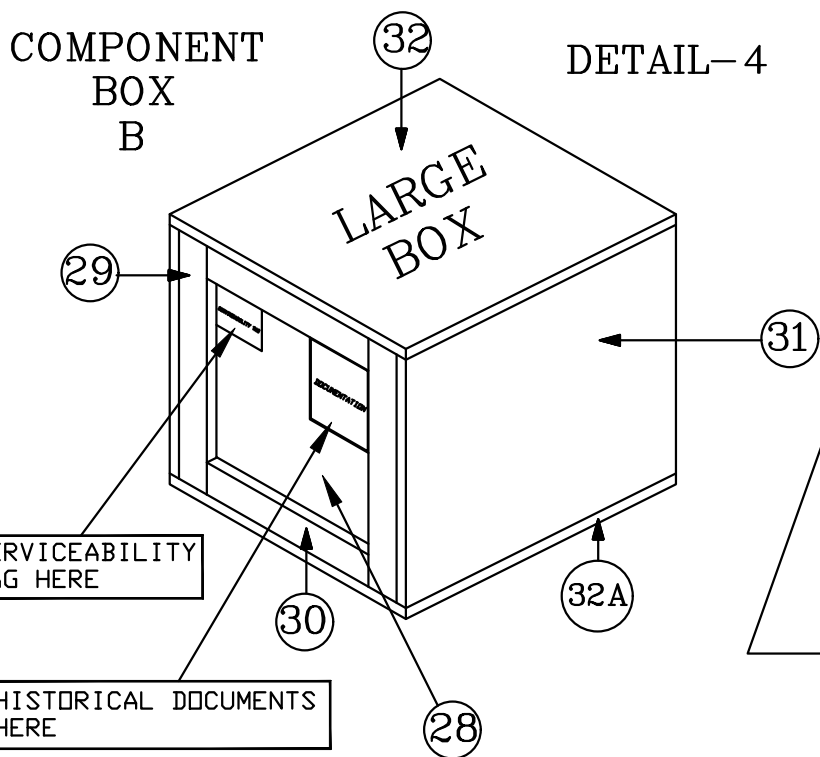
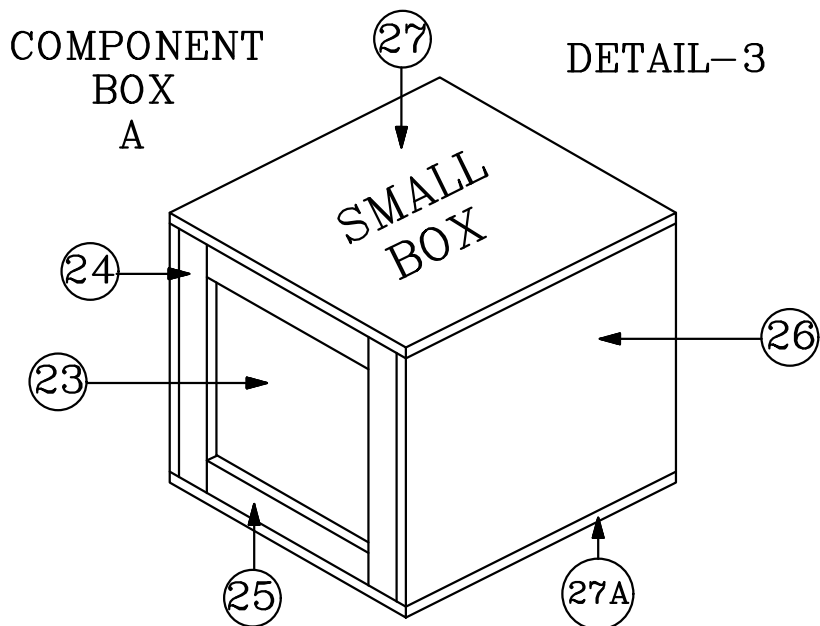
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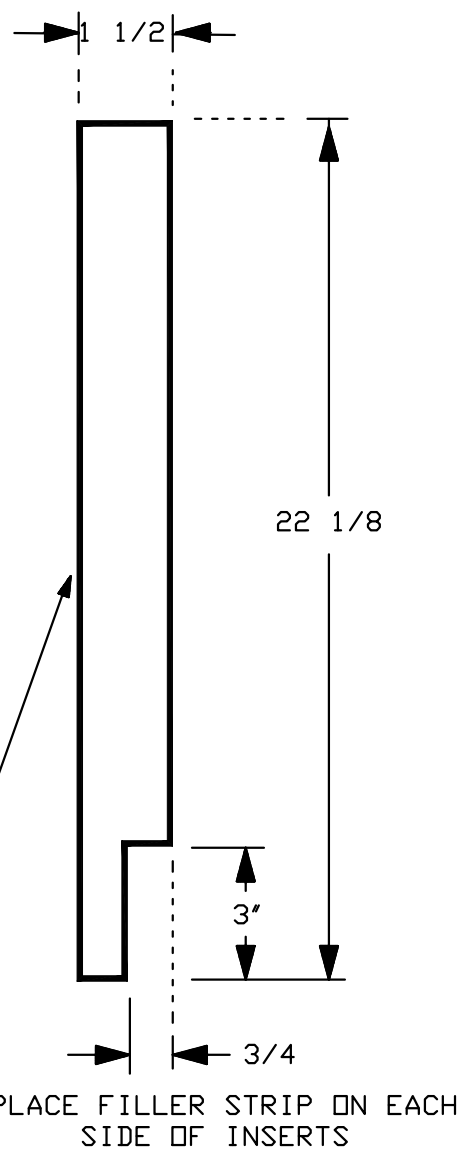
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PROP ASSY

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DETAIL B-1



DETAIL-5, P/N 16

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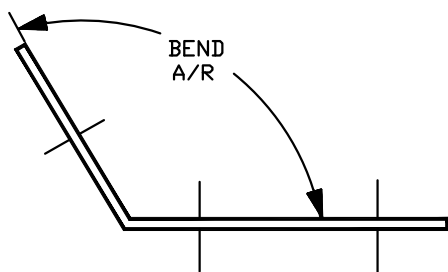
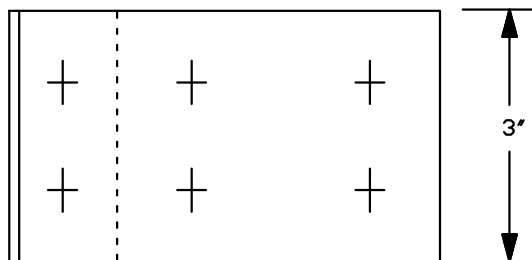
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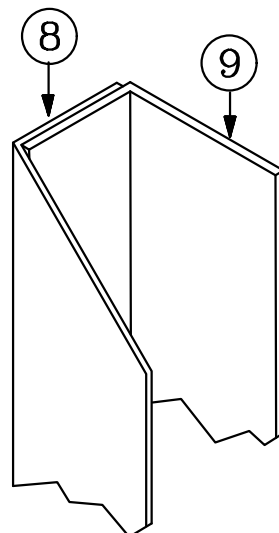
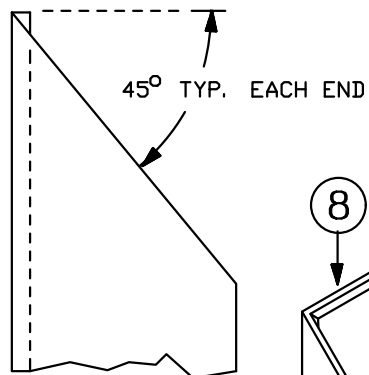
ITEM NOMENCLATURE

PROP ASSY

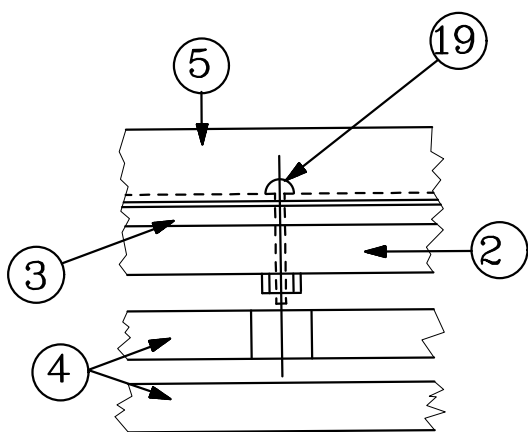
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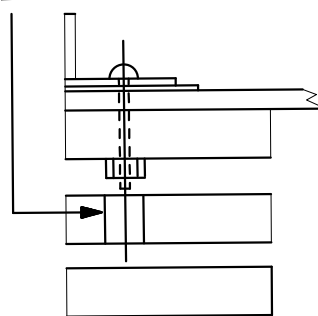
DETAIL-6, P/N 13



DETAIL-7



NOTCH 1 1/2 X 1 1/2  
FOR P/N 19



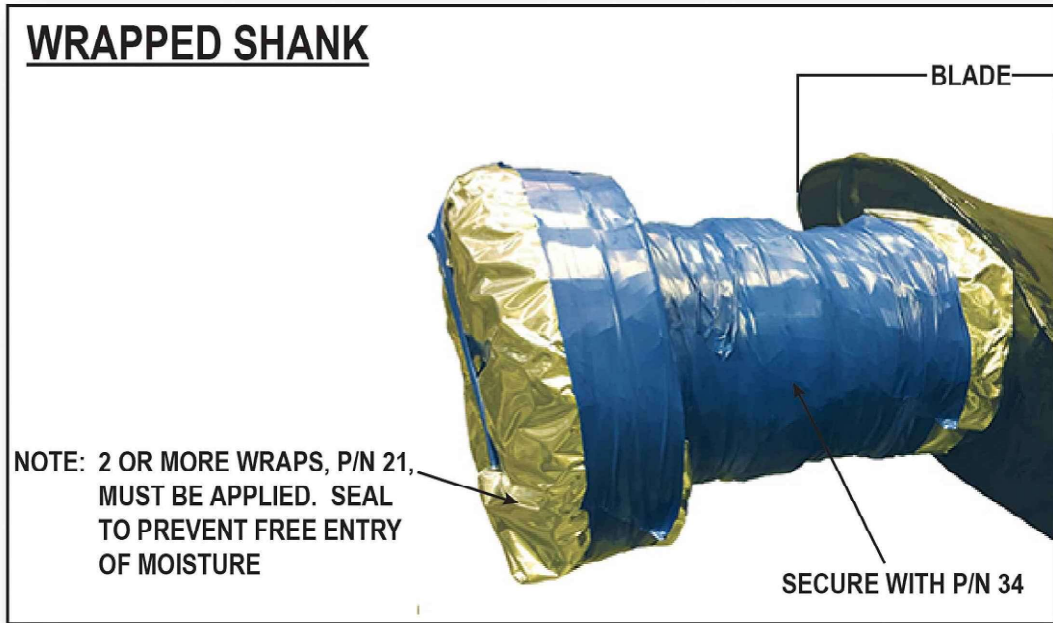
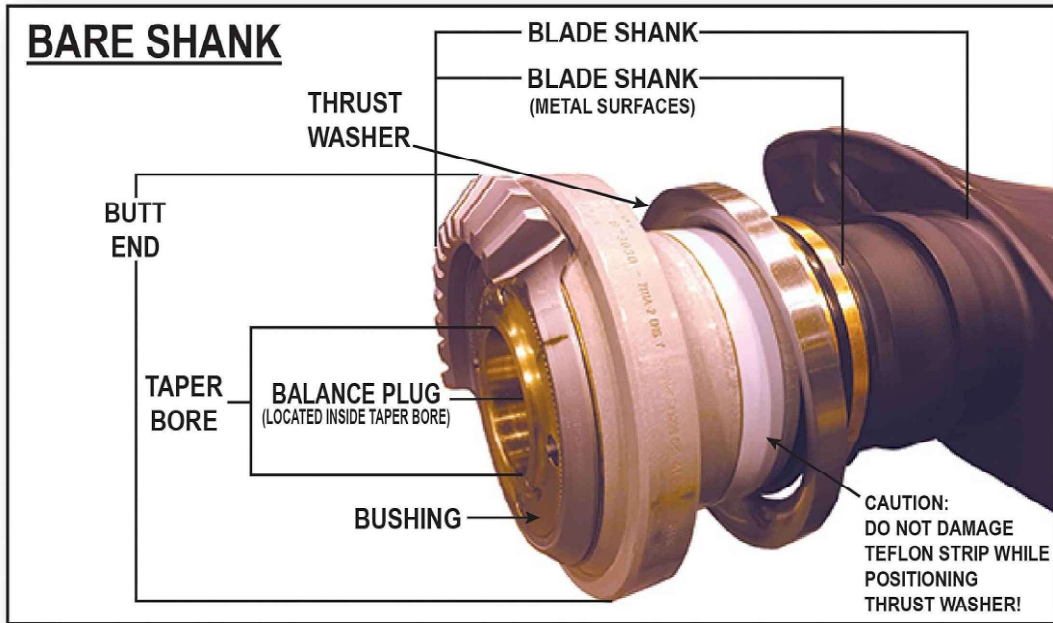
DETAIL-8

PLACE CARR. BOLTS DOWN, UNDER COMPONENT BOXES  
PLACE CARR. BOLTS UP, IN OTHER PLACES.

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## SHANK PRESERVATION DETAIL 9



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