

# **SPECIAL PACKAGING INSTRUCTION**

Form Approved -JLG/BT  
OMB No. 0704-0188 JS

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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE 1001097193 (1YHH8) TRANSMISSION		2. CAGE 19207		3. SPIN NO. AK15771841	
4. NATIONAL STOCK NO. 2520-01-577-1841		5. DATE 9/3/09		6. REVISION	
7. QUP 1 EA	8. ICQ NONE	9. UNIT PACK WT (LB.) 1282	10. UNIT PACK CU (CU. FT.) 38.4	11. UNIT PACK SIZE (INCHES) 53.75 X 38 X 32.5	
12. MILITARY PRESERVATION MIL-STD-2073-1D, METHOD 53 & NOTE A		18. STEPS	19. REQD	20. DESCRIPTION	
13. CLEANING MIL-STD-2073-1D & NOTE B		1-D		PRESERVATIVE: MIL-PRF-21260, GR 10 OR 30	
		2-D		CAPS/PLUGS: NAS 847	
14. DRYING MIL-STD-2073-1D & NOTE B		3-E		MIL-PRF-21260	
		4-G		CONTAINER: ASTM D6256, TY II, CL 2, ST A, TREAT A	
15. PACKING				SIZE: 51-1/4 X 35-1/2 X 24 ID	
		5-H		BLOCKING/BRACING: SEE NOTE H	
a. LEVEL A MIL-STD-2073-1D & NOTE C				ENVELOPE: MIL-DTL-6060, 130 X 60	
		6-I		WRAP: MIL-PRF-121, TY I, SIZE: 130 X 60	
b. LEVEL B NOT APPLICABLE		7-K		CUSHIONING: A-A-1051, TY 1, SIZE: 110 X 40	
		8-L		DESICCANT: MIL-D-3464, 64 UNITS	
16. MARKING MIL-STD-129 AND NOTES N					

## **17. NOTES/DRAWING**

- A. THE UNIT PACK METHOD OF PERSERVATION SHALL BE IN ACCORDANCE WITH MIL-STD-2073-1D FOR METHOD 53. UNIT PACK SHALL PROVIDE PHYSICAL AND MECHANICAL PROTECTION TOGETHER WITH A SEALED, FLOATING, WATERVAPORPROOF ENVELOPE CONTAINING DESICCANT.
- B. CLEAN AND DRY ITEM BY ANY SUITABLE PROCESS BEFORE APPLICATION OF PACKAGING MATERIALS.
- C. THE UNIT CONTAINER IS THE SHIPPING CONTAINER.
- D. TRANSMISSION PRESERVATION
  1. FILL TRANSMISSION TO OPERATING LEVEL. ROTATE MECHANISM TO ENSURE 100% COVERAGE OF PRESERVATIVE ON INTERNAL SURFACES. REMOVE DRAIN PLUG AND DRAIN EXCESS PRESERVATIVE. REPLACE DRAIN PLUG SECURELY.  
(NOTE: IF TRANSMISSION HAS BEEN PREVIOUSLY RUN BY THE MANUFACTURER AND ALL INTERIOR SUFACES HAVE BEEN COATED WITH THEIR APPROVED LUBRICANT, NO ADDITIONAL INTERNAL PRESERVATION IS REQUIRED)
  2. UPON COMPLETION OF PRESERVATION, ALL OPENINGS SHALL BE SEALED WITH CAPS OR PLUGS CONFORMING TO NAS 847, OR WITH TAPE CONFORMING TO SAE-AMS-T-22085. APPLY PRESERVATIVE TO ALL BARE METAL SURFACES.
- E. APPLY PRESERVATIVE TO UNPAINTED EXTERIOR METALLIC SURFACES.
- F. GASKETS, OR GASKET SHEET MATERIAL FOR USE WITH THE ENVELOPE SHALL BE CONSTRUCTED FROM ONE OF THE FOLLOWING TYPES OF MATERIALS: SYNTHETIC RUBBER, RECLAIMED RUBBER, NATURAL RUBBER, CORK AND RUBBER COMPOSITION, FIBER, AND OTHER MATERIALS APPROVED BY THE ACQUIRING ACTIVITY. THE GASKET MATERIAL SHALL HAVE A MINIMUM SHORE DUROMETER HARDNESS, TYPE A, OF 60. THE GASKET MATERIAL SHALL HAVE A NOMINAL THICKNESS OF 0.062 +/- 0.010 INCH. SHAPE AND SIZE OF GASKETS SHALL BE AS SPECIFIED IN THE CONTRACT OR ON APPLICABLE DRAWINGS. GASKET MATERIAL SHALL BE IN ACCORDANCE WITH ASTM F104 OR ASTM D2000. ADHERE GASKETS TO BOTH SIDES OF BARRIER ENVELOPE AT MOUNTING HOLE LOCATIONS USING WATER RESISTANT ADHESIVE. AFTER POSITIONING BARRIER OVER BOLTS, A SUFFICIENT QUANTITY OF WATER-RESISTANT ADHESIVE SHALL BE APPLIED AROUND THE BOLT AND GASKET TO PROVIDE AIR TIGHT SEAL. CLOSE AND HEAT SEAL THE SIDES OF THE TOP OF THE BARRIER ENVELOPE, ELIMINATE EXCESS AIR TO COMPLETE WATERVAPORPROOF METHOD 53.

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- G. CONTAINER SHELL IS CONSTRUCTED OF ALL 1-INCH THICK NOMINAL CLEATS AND 1/2-INCH THICK PLYWOOD.
- H. INSTALL BLOCKING/BRACING AS SHOWN ON PAGES 3 AND 4. BLOCKING AND BRACING SHALL BE ACCOMPLISHED IN ACCORDANCE WITH MIL-STD-1186. BLOCKING/BRACING SHALL BE CONSTRUCTED OF 3 X 4 HARDWOOD LUMBER. BLOCKING/BRACING LUMBER SHALL CONFORM TO ASTM D6199, CLASS 2, GROUP III.
- I. BEFORE SECURING THE TRANSMISSION TO THE SKID BASE, PLACE ONE (1) PIECE OF WRAP, SIZE: 130 X 60, BETWEEN THE ENVELOPE AND THE TRANSMISSION ASSEMBLY.
- J. THE TRANSMISSION ASSEMBLY SHALL BE SECURELY FASTENED TO THE SKID BASE WITH HARDWARE AS SHOWN. SEE PAGE 3 AND 4. BOLTS SHALL BE IN ACCORDANCE WITH ASME/ANSI B18.2.1 OR B18.8.1. FLAT WASHERS SHALL BE IN ACCORDANCE WITH ASME/ANSI B22.1. NUTS SHALL BE IN ACCORDANCE WITH ASME/ANSI B18.2.2. OPTIONAL METAL BANDING OR SIMILAR RETAINERS MAY BE USED BENEATH THE SKID TO HOLD THE CARRIAGE BOLTS IN POSITION.
- K. DRAPE TWO (2) PIECES OF CUSHIONING, 110 X 40, OVER THE TOP OF THE MOUNTED TRANSMISSION. ENSURE THAT ALL CORNERS AND SHARP PROTRUSIONS ARE ADEQUATELY CUSHIONED. SECURE WRAP WITH TAPE.
- L. DESICCANT SHALL BE PLACED WITHIN ENVELOPE, BUT OUTSIDE OF CUSHIONING.
- M. CONTAINER SHELL SHALL BE SECURED TO SIDES AND ENDS OF BASE WITH LAG SCREWS. LAG SCREWS SHALL BE IN ACCORDANCE WITH ASME/ANSI B18.2.1 OR B18.8.1. FLAT WASHERS SHALL BE IN ACCORDANCE WITH ASME/ANSI B22.1.
- N. SPECIAL MARKING SHALL BE APPLIED AS FOLLOWS:
1. IN ADDITION TO MIL-STD-129 MARKINGS, THE UNIT CONTAINER SHALL BE MARKED ON THE TOP AND SIDES WITH MINIMUM 1/2-INCH HIGH BLACK LETTERS "REUSABLE CONTAINER AND CUSHIONING, DO NOT DESTROY". IN ADDITION, THE TOP AND ENDS SHALL BE MARKED "REMOVE LAG SCREWS TO OPEN CONTAINER" USING 1/2-INCH HIGH BLACK LETTERS. CONTAINER SIDES AND ENDS SHALL ALSO BE MARKED NEAR THE TOP WITH MINIMUM 1/2-INCH HIGH BLACK LETTERS "CAUTION: LIFT BY BASE ONLY".

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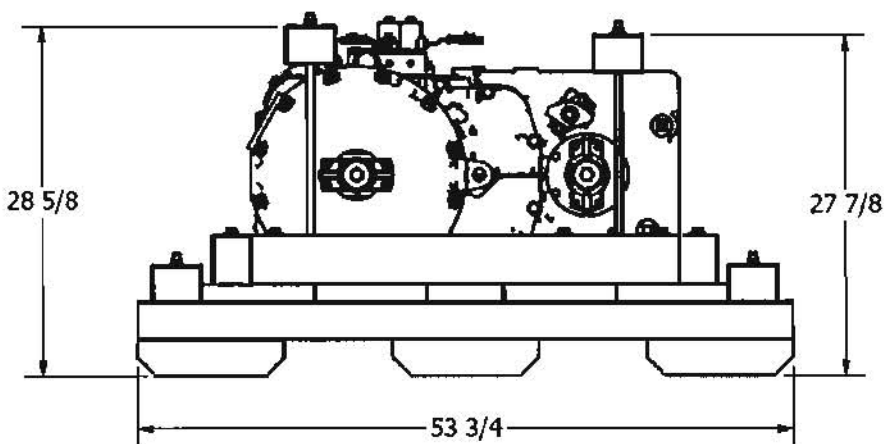
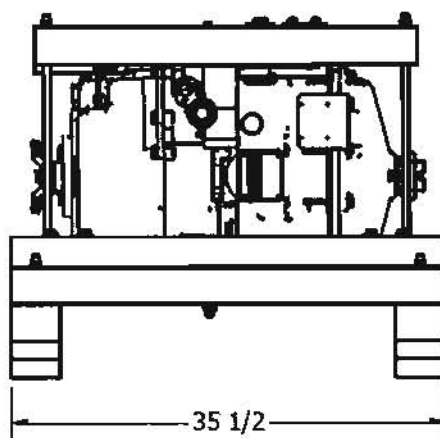
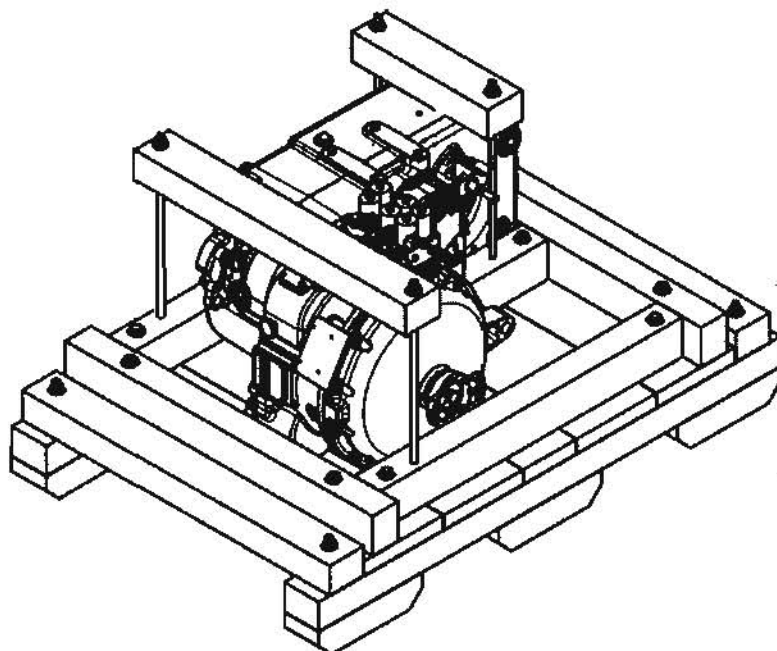
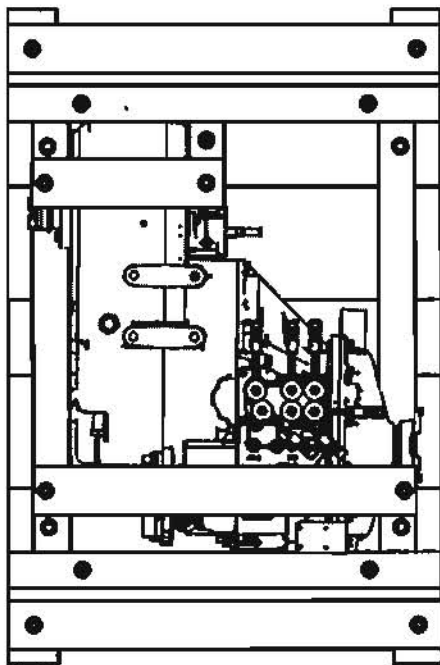
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## **ALL DIMENSIONS IN INCHES**



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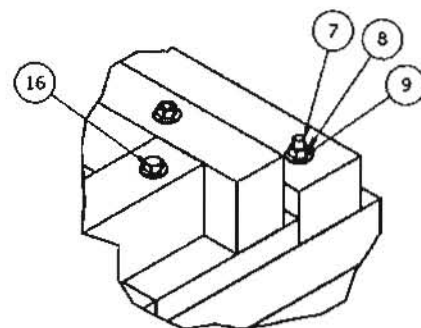
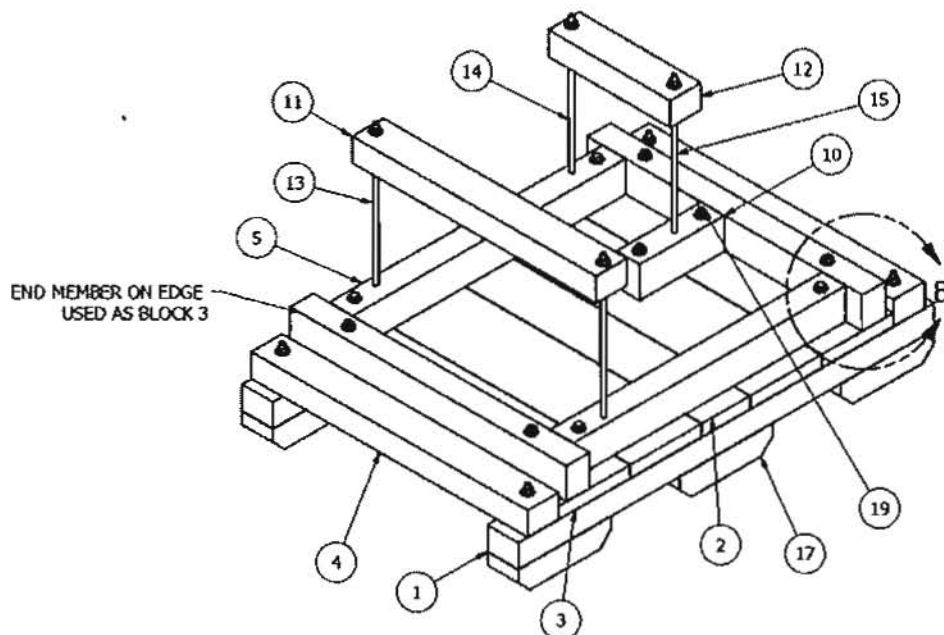
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DETAIL B  
SCALE 1:5

### **PARTS LIST**

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	Skid	3 x 4 x 53-3/4 HW
2	1	Deck 2x10 Ripped	2 (Nominal) x 6-1/4 x 35-1/2
3	4	Deck 2x10	2 x 10 (Nominal) x 35-1/2
4	4	End Member	3 x 4 x 35-1-2 HW (ALSO USED AS BLOCK 3 ON EDGE)
5	2	Block 1	3 x 4 x 35-1/4 HW ON EDGE
7	4	ANSI B18.5 - 1/2-13 UNC - 10	Round Head Bolt 10 inch
8	24	ANSI B18.22.1 - 1/2 - Regular - Type B	Plain Washer (Inch )Type A and B
9	18	ANSI B18.2.2 - 1/2 - 13	Hex Nuts (Inch Series) Hex Nut
10	1	Block 2	3 x 4 x 11 HW ON EDGE
11	1	Top Blocking 1	3 x 4 x 31-3/8 HW
12	1	Top Blocking 2	3 x 4 x 15-3/4 HW
13	2	Threaded Rod- 26.5	26-1/2 INCH THREADED ROD
14	1	Threaded Rod- 26	26 INCH THREADED ROD
15	1	Threaded Rod- 24	24 INCH THREADED ROD
16	4	ANSI B18.6.4 - 1/2-13 UNC - 6	6 inch Lag Bolt
17	6	Rubbing Strip	2 - 2 x 4 (Nominal) x 10 (NAILED TOGETHER WITH BOTTOM BOARD BEVELED)
19	6	ANSI B18.5 - 1/2-13 UNC - 6.5	Round Head Bolt 6-1/2 inch

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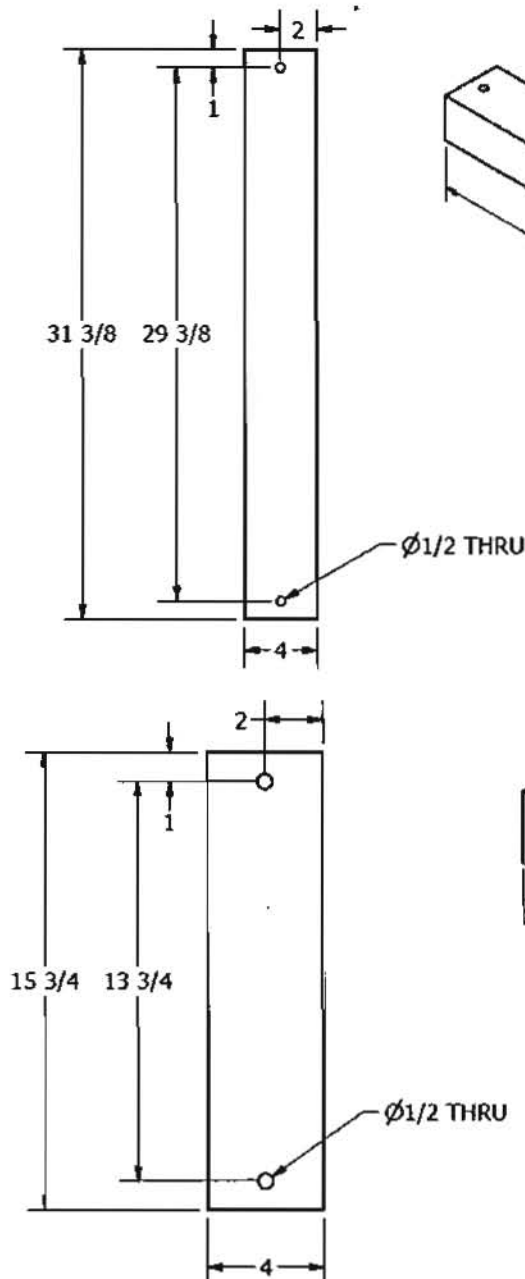
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ITEM 11  
TOP BLOCKING 1

ITEM 12  
TOP BLOCKING 2

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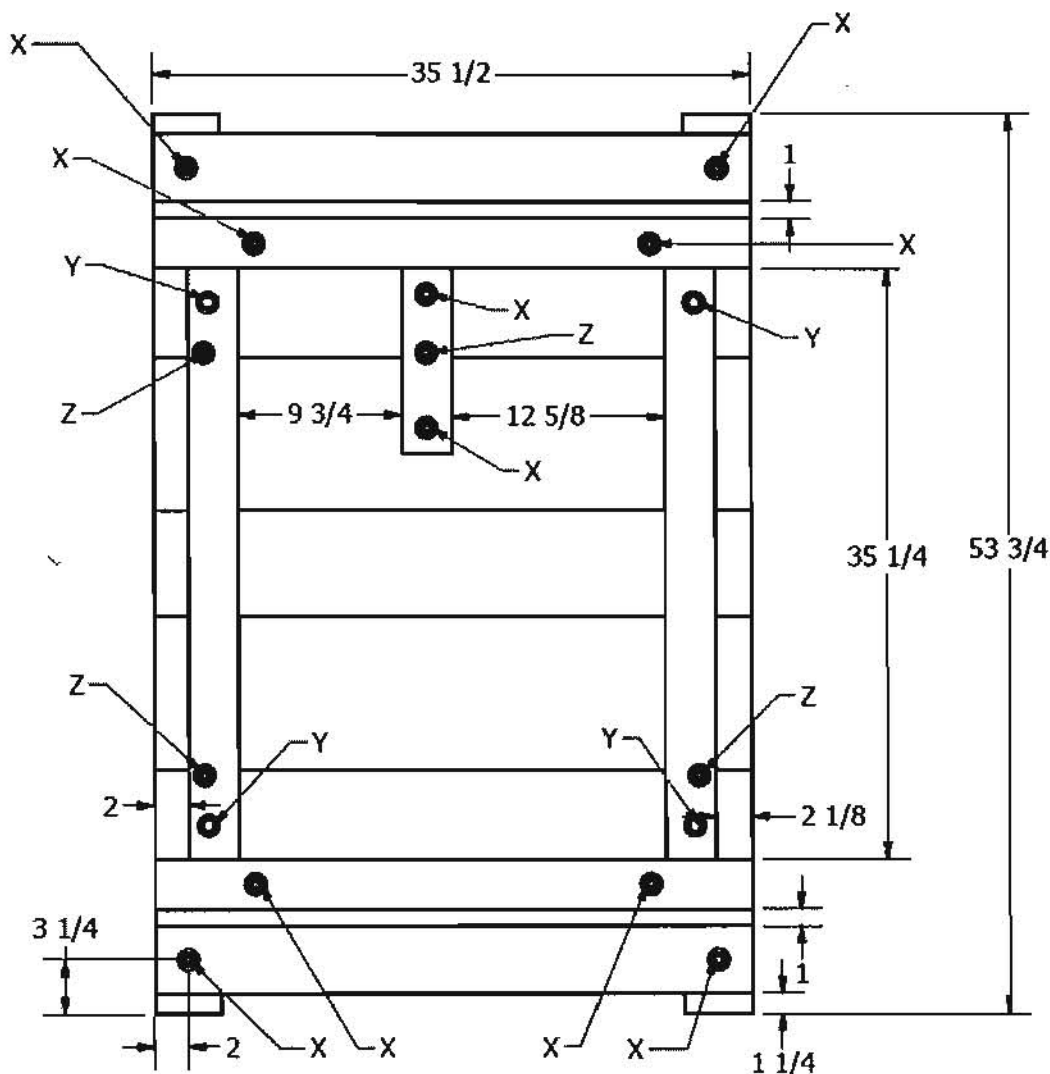
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X = DENOTES HOLES FOR CARRIAGE BOLTS ( 10 LOCATIONS)

Y = DENOTES HOLES FOR LAG BOLTS (4 LOCATIONS)

Z = DENOTES HOLES FOR THREADED RODS (4 LOCATIONS)

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