

SPECIAL PACKAGING INSTRUCTION (AMCCOM Suppl 1 to AR 706 ,5)

NATIONAL STOCK NUMBER

**NOMENCLATURE FILTER, GAS-PARTICULATE:
NBC, 100 CFM, M48A1 (ASZM-TEDA)**

UI
EA

CLEANING/DRYING
C1/ANY

SPI NUMBER (PN)
P5-19-7435

LEVEL A UNIT PACK REQUIREMENTS (MIL-P-116 METHOD N/A)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
SEE NOTE (B)							

LEVEL B (METHOD) NOT APPLICABLE SEE NOTE IAW MIL-STD-2073-1
 LEVEL C (METHOD) NOT APPLICABLE SEE NOTE IAW MIL-STD-2073-1
 COMMERCIAL PACKAGING NOT APPLICABLE SEE NOTE IAW ASTM D3951

UNIT PACK LOGISTICS DATA (Weights and Sizes Approximate)

LEVEL	UNIT PACK QUANTITY	UNIT PACK WEIGHT	UNIT PACK CUBE	UNIT PACK SIZE (EXTERIOR) FEET
A	1	30.00 lbs.	1.472 cu. ft.	1.06 x 1.06 x 1.31

Intermediate packaging and packing will be in accordance with specification MIL-STD-2073-1 or as otherwise specified hereon. (C) (D)

Marking will be in accordance with MIL-STD-129. (E)

Specifications, standards, and drawings listed hereon of the issue in effect on date of invitation for bid form a part of this data sheet. The applicable general and referenced requirements of specification MIL-STD-2073-1 form part of this data sheet. Unless otherwise specified, materials will be minimum size IAW MIL-STD-2073-1.

Tolerances shall be in accordance with material specifications. Quality performance and testing requirements shall be in conformance with MIL-STD-2073-1 or as specified hereon. (F) (G)

REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

- (A) - **Interplant shipment.** Packaging and marking for interplant shipment shall only be applied as indicated in EA-F-1284.~
- (B) - The gas filter shall be unit packed as shown on pages 3 and 4. **NO PRESERVATIVE COMPOUNDS SHALL BE APPLIED TO FILTER.** Prior to packaging, repair damaged painted surfaces of the filter in accordance with the "finish (touch-up)" requirement on drawing 5-19-7435.
- (C) - **Packing, Level A.** Two (2) unit pack containers (see pages 3 and 4) shall be enclosed in a container conforming to overseas type, style optional, type 2 load, grade A, weight of contents 0-100 pounds, of PPP-B-601, except that 3/8 inch plywood shall be used to construct the end and side panels; and 5/8

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Revised by: *J.D. Stallings/Contr DAA05-01-P1303*

ITEM DATA (APPROX) ITEM CODE - Z13, Z12, Z11, Z09 ITEM SIZE - 12 x 12 x 14 in. ITEM WEIGHT - 28.00 lbs.	AMCCOM 81361		JDS	Y21-0056 -003	Y21-053 B	2 JAN 02
	SMCCR-PET-P			S2H3213 -0002	Z13-025 A	25 JAN 93
	PAGE NUMBER	NUMBER OF PAGES		S2L9450 -0011	Z13-023 -	8 APR 92
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inch thick plywood for the top and bottom panels. The box shall have inside dimensions of 12 7/8 x 25 5/8 x 15 7/8 inches (length, width and depth respectively). Filler pads fabricated of weather - resistant fiberboard conforming to variety SW, grade W6c or W5c, of PPP-F-320 shall be included as necessary to make a tight pack. The box shall be closed in accordance with the Appendix to PPP-B-601. Two additional straps shall be applied around the sides and ends, centered over the edge filler cleats at the top and bottom of box.

(D) - Unitization. When specified in the contract or order, the level A pack shall be palletized in accordance with the requirements of MIL-STD-147.

(E) - Special markings. In addition to the standard interior and exterior identification and contract data markings required by MIL-STD-129, apply the following markings to each unit pack and shipping container. The special markings shall be in conformance with the applicable requirements of MIL-STD-129.

1. Marking for items 3 and 8 shall be as shown on page 3 and as follows:

a. All characters and spaces between lines on item 3, unless otherwise specified hereon, shall be 1/8 inch. Marking on one line shall not exceed 4 inches on the can circumference.

b. Item 8 shall be marked with the identification markings shown for item 3.

2. Lot numbers and shelf life markings shall be applied to unit packs, level A packs and unitized loads.

(F) - Unit pack container leakage. The unit pack container (can) shall show no sign of leakage when tested in accordance with EA-F-1284.

1. As an alternate to the leakage test in PPP-C-96 for the can assembly with one lid attached (closure lid supplied separately), each can assembly shall be tested in accordance with Method 5009 of Federal Test Method Std. No. 101, except test duration shall be 8 seconds ; 2 seconds, and gauge pressure shall be 8 PSI ; 2 PSI. Any loss of gauge pressure over 8 seconds ; 2 seconds, or leakage as evidenced by release of a continuous stream of bubbles, shall be cause for rejection. Rejected can assemblies may be repaired and retested.

(G) - The preproduction (first article) and quality conformance inspection and testing requirements for level A unit packing shall be in accordance with EA-F-1284; packing inspection shall be in accordance with EA-F-1284 and with the quality conformance inspection requirements of MIL-STD-2073-1.

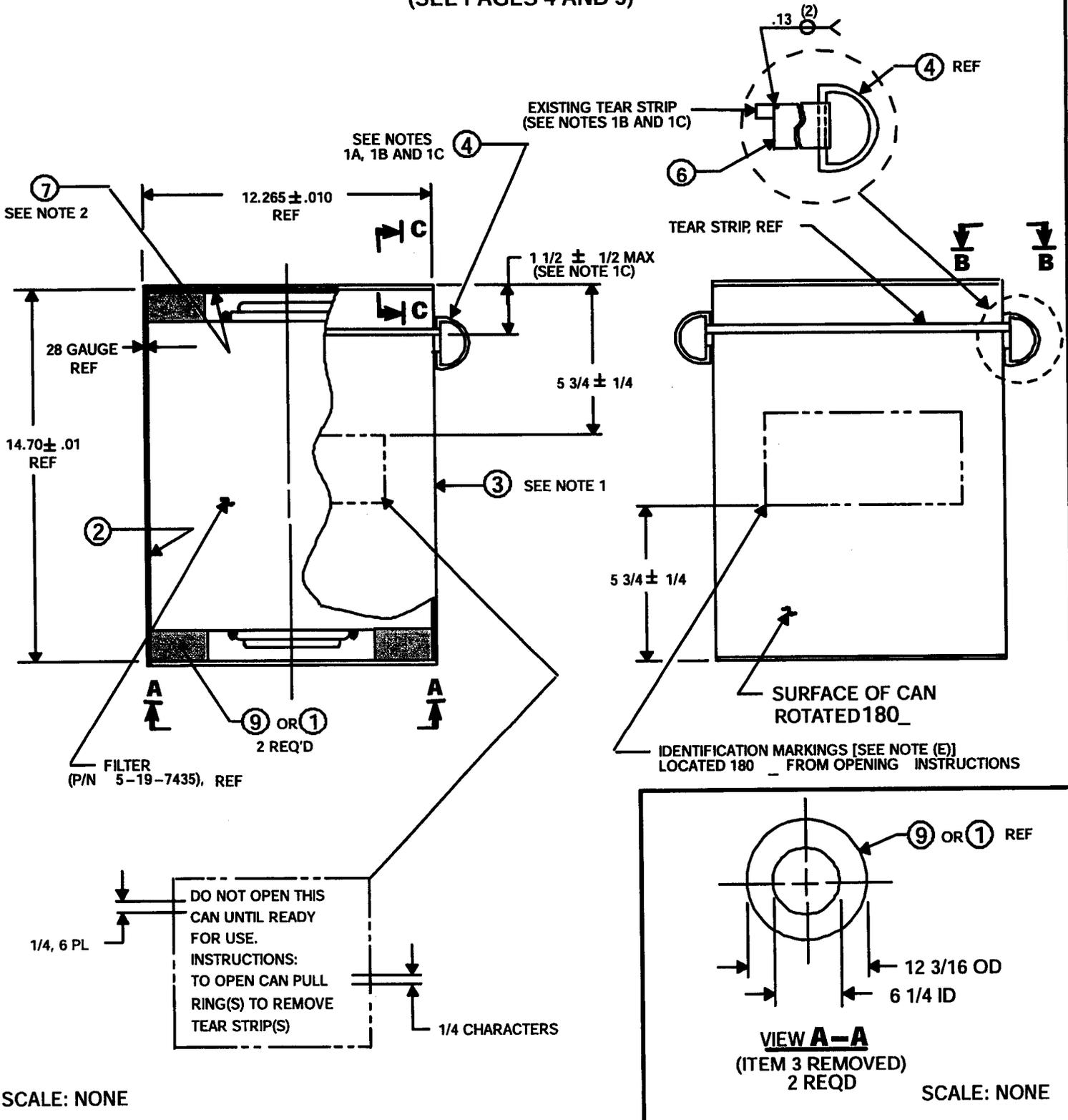
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SKETCH NO. 1 - UNIT PACK ASSEMBLY

(SEE PAGES 4 AND 5)



SCALE: NONE

SCALE: NONE

NOMENCLATURE
FILTER, GAS-PARTICULATE: NBC, 100 CFM, M48A1 (ASZM-TEDA)

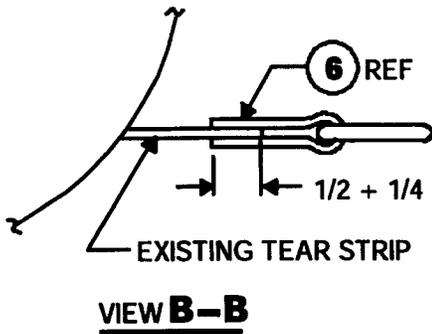
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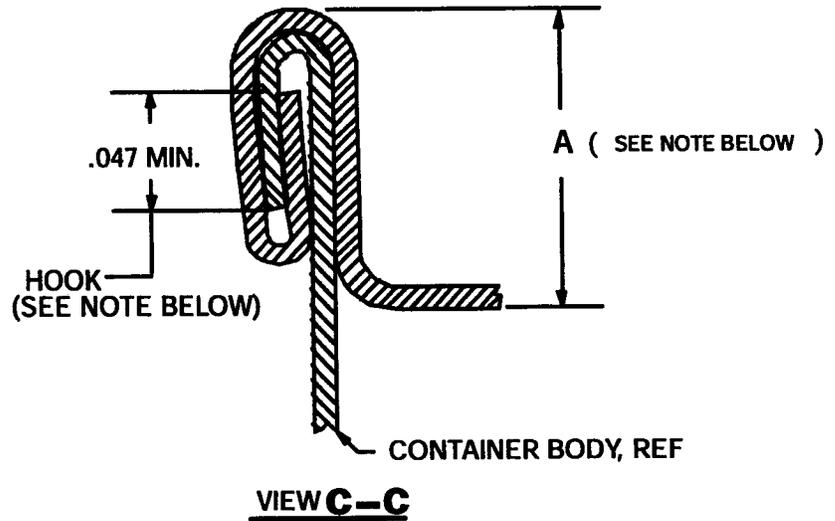
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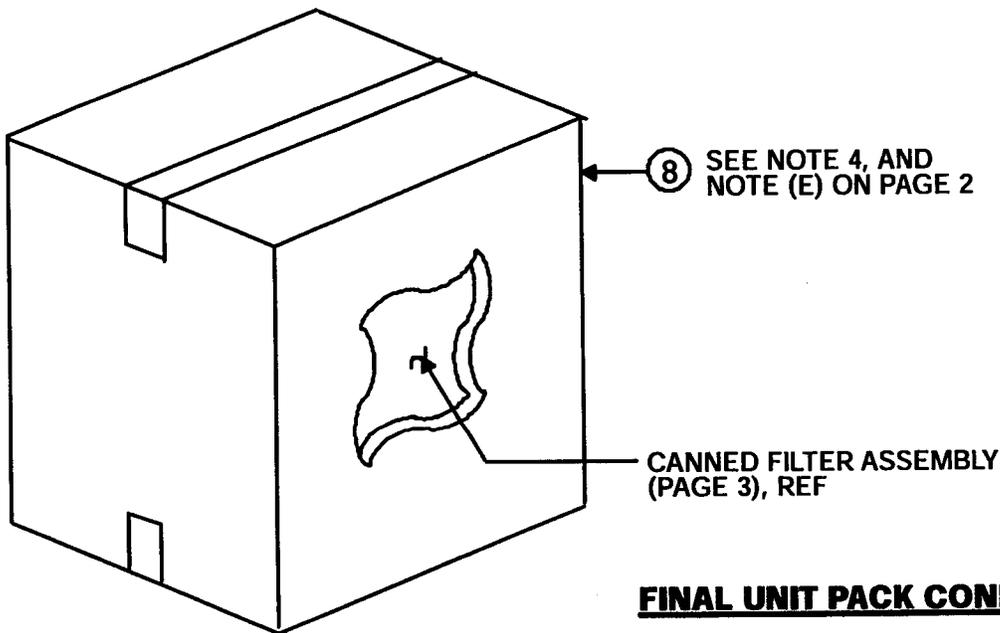


SCALE: NONE



SCALE: NONE

NOTE: MINIMUM OVERLAP (HOOK) OF DOUBLE SEAM TO BE OBTAINED WITH A NOMINAL 1/8 INCH PANEL DEPTH (A) OR GREATER, AS SHOWN ABOVE.



SCALE: NONE

FINAL UNIT PACK CONFIGURATION

NOTES:

1. CONSTRUCTION REQUIREMENTS FOR ITEM 3 (CAN) - OPTIONS AND EXCEPTIONS.

A. ITEM 3 SHALL HAVE TWO SIDE SEAMS. TWO D-RINGS (ITEM 4) SHALL REPLACE THE METAL KEY FOR OPENING CAN. AS AN OPTION, ITEM 3 MAY BE FABRICATED WITH ONE SIDE SEAM AND ONE D-RING.

B. THE D-RING(S) SHALL BE SPOT WELDED TO TEAR STRIP IN ACCORDANCE WITH MIL-W-12332. FASTEN D-RING(S) FLAT TO THE SIDE OF ITEM 3 USING TAPE (ITEM 5). TAPE SHALL NOT OBSCURE ANY MARKINGS.

C. TEAR STRIP(S) [SCORED OPENING BAND] WITH ATTACHED D-RING(S) SHALL BE LOCATED AS SHOWN. THE EXACT LOCATION SHALL BE AT THE OPTION OF CAN SUPPLIER. THE TEAR STRIP SHALL BE FORMED BY TWO OR MORE SCORES ON THE INSIDE

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SURFACE OF ITEM 3. THE TONGUE END OF THE TEAR STRIP SHALL BE FREE OF SOLDER FOR A MINIMUM LENGTH OF 1/2 INCH TO PERMIT ATTACHMENT OF D-RING(S) ASSEMBLY (ITEMS 4 AND 6). THE TEAR STRIP SCORE DEPTH SHALL BE $60\% \pm 3\%$ OF CAN BODY MATERIAL THICKNESS.

D. AS AN OPTION, CAN (ITEM 3) MAY BE SUPPLIED WITH TEAR STRIP END (LID) SEAMED ON AND THE OPPOSITE END LOOSE, AND THE TEAR STRIP LOCATED AT THE OPTION OF CAN SUPPLIER.

E. THE CLOSURE END (LID) SHALL BE ATTACHED TO THE CAN BODY BY MEANS OF A DOUBLE SEAM WITH A MINIMUM OVERLAP (HOOK) AS SHOWN ON **VIEW C-C**. ATTACHMENT OF LID TO CAN BODY SHALL BE ACCOMPLISHED ON A SPIN HEAD CAN DOUBLE SEAM MACHINE (CAN STANDSTILL TYPE).

F. A SKIP IS PERMITTED IN THE LAP WELDED SIDE SEAM AT THE TEAR STRIP AND THE SEAM COMPLETED BY SOLDERING IN ACCORDANCE WITH THE SOLDERING REQUIREMENTS OF PPP-C-96.

2. ADD DUNNAGE (ITEM 7) TO CAN (ITEM 3), AS REQUIRED, TO MAKE A TIGHT ASSEMBLY, BUT STILL ALLOW FOR A FULL DOUBLE SEAM.
3. MODIFY PLAN B PROTECTIVE COATING REQUIREMENT TO INCLUDE TT-E-516, COLOR 34087, OR MIL-E-19603, COLOR 24084 OR 24087 OF FED-STD-595. SIDE SEAM STRIPE(S) SHALL BE COATED IN ACCORDANCE WITH PLAN B PROTECTIVE COATING, EXCEPT PAINT USED TO COAT CAN (ITEM 3) SHALL BE USED. DAMAGED PAINTED SURFACES SHALL BE REPAINTED AS REQUIRED USING THE SAME PAINTING REQUIREMENT.
4. ADD FILLER PADS (ITEM 7) TO UNIT PACK BOX (ITEM 8), AS REQUIRED, TO MAKE A TIGHT ASSEMBLY. CLOSURE OF ITEM 8 SHALL BE IN ACCORDANCE WITH THE METHOD IV CLOSURE REQUIREMENT FOR CLASS WEATHER RESISTANT BOXES IN THE APPENDIX TO PPP-B-636.

PARTS LIST

QTY REQD	DRAWING OR PART NO.	NOMENCLATURE	SPECIFICATION	ITEM NO.
* 2		FOAM, POLYSTYRENE, TYPE 1, GR R, EXCEPT DENSITY = $2\ 1/2 (+ 1/2)$ LBS PER CU. FT. AND THICKNESS = $1 (- 1/16)$ IN.	PPP-C-850	1
1		PAPERBOARD, WRAPPING AND CUSHIONING, TYPE III, STYLE 1. $37\ 1/4 (\ 1/4)$ X $12\ 1/2 (\ 1/4)$ IN.	PPP-P-291	2
1		CAN, METAL, 28 GAUGE OR LIGHTER, TYPE I, CLASS 1 (MODIFIED), 135 LB. BASE WT., ELECTROLYTIC TIN PLATE NO. 100 (TYPE, GRADE AND CLASS AT OPTION OF CAN MANUFACTURER), SIZE $12.265 (\ .010)$ DIA X $14.70 (\ .01)$ IN. (INSIDE DIMENSION)	PPP-C-96	3
2	MS51925-5	D-RING		4
2		TAPE STRIP, $2\ 1/2 (\ 1/2)$ X $1\ 1/2$ IN. WIDE	PPP-T-60	5
2		STEEL STRIP, 28 GAUGE X $3/4 (\ 1/16)$ X 4 IN. LONG	ASTM A366	6
A/R		FIBERBOARD, VARIETY SW, TYPE CF, GRADE W5c OR W6c, CLASS WR	PPP-F-320	7
1		BOX, FIBERBOARD, VARIETY SW, STYLE RSC, GRADE V3c OR W5c, TYPE CF, SIZE $12\ 3/8 (+ 1/8)$ X $12\ 3/8 (+ 1/8)$ X $15\ 1/8 (+ 1/8)$ IN.	PPP-B-636	8
* 2		PLASTIC MOLDING MATERIAL, TYPE 1, CLASS 1, DENSITY $2\ 1/2 (+ 1/2)$ LBS PER CU. FT., THICKNESS $1 (- 1/16)$ IN.	MIL-P-19644	9

*ALTERNATE

NOMENCLATURE
 FILTER, GAS - PARTICULATE: NBC, 100 CFM, M48A1 (ASZM - TEDA)

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