

<b>NAVY SHIPS PARTS CONTROL CENTER</b>				<b>CODE IDENT</b>		<b>SPI NO.</b>	
<b>SPECIAL PACKAGING INSTRUCTION(SPI)</b>				03950		10083	
<b>NOMENCLATURE</b> BALL AND SEAT ASSEMBLIES			<b>NATIONAL STOCK NO.</b> VARIOUS		<b>DATE</b> 29 MAR 1995		<b>REV</b> B
<b>QUP</b>	<b>MAX. UNIT PACKAGE WT.</b>	<b>MAX. UNIT PACKAGE CUBE</b>	<b>MAX. UNIT PACKAGE DIMS.</b>		<b>DWN BY</b> <b>APP BY</b> <i>[Signature]</i>		
1	40+ LBS	VARIOUS	VARIOUS		SHEET <u>1</u> OF <u>4</u>		

THE PACKAGING DATA SHALL BE IN ACCORDANCE WITH MIL-STD-2073 AS FOLLOWS:

H	M	QUP	ICQ	PRES METH	C D	PRES MTL	WRAP MTL	CUSH DUNN	C T	UNIT CONT	L P	INT CTR	U C L	SPEC MKG	PACK-ING	UNIT PACK WGT	UNIT PACK CUBE	O P I
N		001	000	ZZ	1	00	XX	XX	X	XX	A	00	A	XX	FFF	40+		A

This special packaging is for straight valve ball and seat assemblies weighing over 40 pounds, and less than 16 feet in length.

The special method of packaging shall be accomplished by Method III of MIL-P-116, and in accordance with Steps 1 through 14 using enclosed drawing as follows:

Step 1. Wrap Ball Assembly (Item 1) in MIL-P-130F laminated and creped paper.

Step 2. Wrap and cushion Seat Assembly (Item 2) in PPP-C-1120C, Class A, Grade 3, type to be determined by weight of Seat Assembly for appropriate thickness to provide adequate protection from damage. Tape type used to close container shall be PPP-T-60.

Step 3. Place the wrapped/cushioned Seat Assembly in a shallow ASTM-D-5118D/5118M (formerly PPP-B-636), Type CF, weather resistant fiberboard container (A). Exterior dimensions of the fiberboard box shall allow sufficient clearance for bolts (F) to protrude through the edges of hold-down cover (B).

Step 4. Fiberboard box ASTM-D-5118D/5118M shall have closure in accordance with ASTM-D-1974.

Step 5. Secure disc (C) with square headed bolts, washers and nuts (E) to center of base (G). Fasteners shall be equally spaced. The disc shall be fabricated of 3/4" plywood and its diameter shall be 1/8" smaller than the diameter of the ball cavity. Square headed bolts shall be 2 1/2" long.

Step 6. Place wrapped Ball Assembly (Item 1) on disc (C). Make sure that disc (C) fits snugly and evenly in ball cavity.

Step 7. Install the four long tie rod bolts (F) to extend through the skids in accordance with paragraph 3.6.7 of MIL-P-116. Select the length of the long bolts to allow for skid, floor and hold-down cover thickness plus a minimum two thread protrusions after tightening.

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Step 8. Secure disc (C) with square headed bolts, washers and nuts (E) to center of base (G). Fasteners shall be equally spaced. The disc shall be fabricated of 3/4" plywood and its diameter shall be 1/8" smaller than the diameter of the ball cavity. Square headed bolts shall be 2 1/2" long.

Step 9. Install hold-down cover (B) and disc (C) over the four tie rod bolts (F) and the wrapped Ball Assembly. Assure that disc is properly seated in the center of the Ball Assembly. Install flat washers, lock washers and nuts (D). Tighten to prevent free movement of the Ball Assembly. The hold-down cover (B) shall be fabricated of 3/4" plywood, with four holes drilled equally spaced on the corners to align with long bolts (F). Hold-down cover exterior dimensions shall be 1/2" less than the inside dimensions of the MIL-B-26195C box (H), cleated plywood overseas type II, Grade 1, style "A" (regular cleating arrangement).

Step 10. Fasten packaged Seat Assembly (A) to top of cover (B) with non-metallic strapping or connectors conforming, to ASTM-D-3950 (formerly PPP-S-760).

Step 11. Mark top of packaged Seat Assembly (A):

"SEAT ASSEMBLY INSIDE"

Step 12. Mount MIL-B-26195C box (H) to base (G). CAUTION: Ensure that the fabrication of load bearing base (G) and box (H) allows for minimum of 2" clearance around the sides and ends of the wrapped Ball Assembly and the top of the packaged Seat Assembly (A). Load bearing base (G) shall be fabricated from class 2 lumber, with load condition "C" configuration, in accordance with MIL-B-26195C.

Step 13. Secure box (H) to base (G) using 3" long lag bolts in accordance with the instructions in the appendix of MIL-B-26195C.

Step 14. Additional marking to be placed on the exterior of the completed MIL-B-26195C box:

- a. "REUSABLE CONTAINER DO NOT DESTROY" marked on one side and one end of the container, with minimum 2" high black lettering.
- b. "TO OPEN REMOVE BOLTS" marked on one side and one end of the container, with minimum 2" high black lettering.
- c. "ARROW" indicating "UP" placed in appropriate locations along top of container sides and ends, in accordance with MIL-STD-129.

Step 15. All other markings shall be in accordance with MIL-STD-129.

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BILL OF MATERIALS:

<u>ITEM</u>	<u>NOMENCLATURE</u>	<u>QUANTITY REQUIRED</u>
A	ASTM-D-5118D/5118M (formerly PPP-B-636) fiberboard box, type CF, weather resistant	1 each
B	Plywood hold-down cover 3/4" thick	1 each
C	Plywood disc 3/4" thick	2 each
D	Flatwashers	4 each
	Lockwashers	4 each
	Nuts, square	4 each
E	Bolts, square headed	6 each
	Flatwashers	6 each
	Nuts, square	6 each
F	Long bolts	4 each
G/H	Loadbearing base and box, MIL-B-26195C, style "A", overseas Type II	1 each
L	Lag bolts in accordance with appendix of MIL-B-26195C	

NOTE: The above listed hardware shall meet the performance characteristics for the intended weight load. Hardware shall be corrosion resistant or coated with preservative compound conforming to Type P-19 of MIL-P-116.

UNPACKING INSTRUCTIONS FOR BALL VALVE ASSEMBLY

Step 1. Remove lag bolts which fasten the bottom of the MIL-B-26195 box (H) to base (G). Retain the lag bolts for reuse.

Step 2. Carefully remove (by lifting) the MIL-B-26195 box (H) from base (G). CAUTION: Be careful not to damage contents of container.

Step 3. Remove straps securing packaged seat assembly box (A) and remove from hold-down cover (B).

Step 4. Carefully open taped end of boxed seat assembly (A), and remove wrapped seat assembly (Item 2). Remove cushioning material. Retain fiberboard box and cushioning material for reuse.

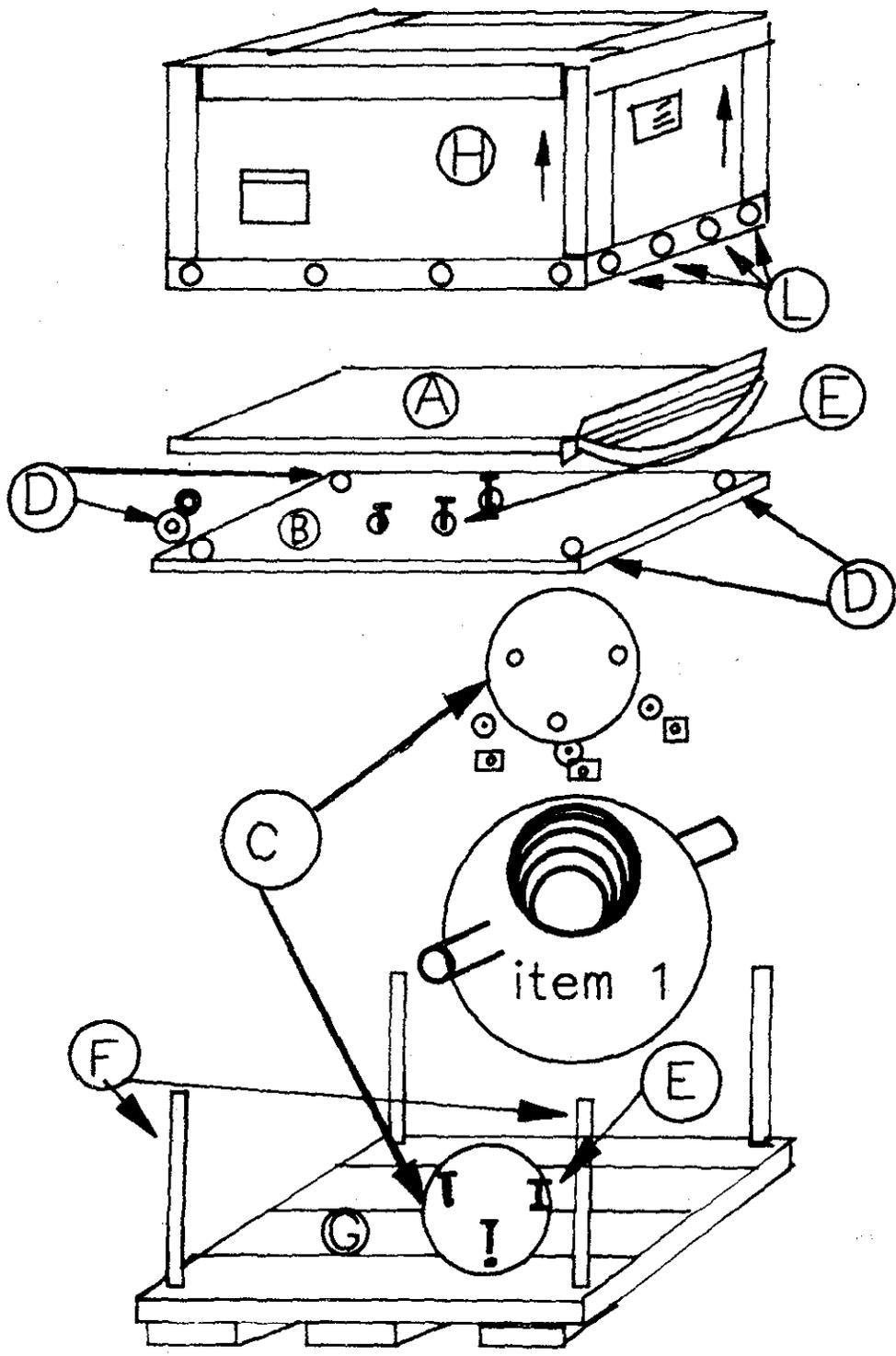
Step 5. Remove flatwashers, lockwashers and nuts (D) retaining hold-down cover assembly (B), which secures ball assembly (Item 1) to base (G). Remove hold-down cover. Retain cover and hardware for reuse.

Step 6. If unpacking is required for inspection purposes only, skip to step 7. Remove ball assembly (Item 1) from skidded base (G). CAUTION: If the ball assembly is extremely heavy to lift manually, use a fabric sling assembly.

Step 7. Carefully unwrap the ball assembly (Item 1). Retain all wrapping, packaging, and cushioning material for reuse on repairable ball assemblies of the same configuration.

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SEE:  
 BILL OF  
 MATERIALS ON  
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 INSTRUCTION  
 FOR ITEM  
 DESCRIPTION  
 AND QUANTITY  
 REQUIRED