

SPECIAL PACKAGING INSTRUCTION

Form Approved
OMB No. 0704-0188 -BK
MB

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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE VK-38244 (72643) ENGINE ASSEMBLY, DIESEL			2. CAGE 19207		3. SPI NO. AK15987019	
4. NATIONAL STOCK NO. 2815-01-598-7019			5. DATE 6/20/2012		6. REVISION A	
7. QUP 1 EACH	8. ICQ NONE	9. UNIT PACK WT (LB.) 1639.0	10. UNIT PACK CU (CU. FT.) 62.998		11. UNIT PACK SIZE (INCHES) 58.3 X 38.5 X 48.5	
12. MILITARY PRESERVATION MIL-STD-2073-1D, METHOD 53			18. STEPS	19. REQD	20. DESCRIPTION	
13. CLEANING MIL-STD-2073-1D			1 - B	A/R	SPECIAL EQUIPMENT FOR ENGINE PRESERVATION	
			2 - C	A/R	ENGINE PRESERVATION	
14. DRYING MIL-STD-2073-1D			3 - D	A/R	CAPS/PLUGS: NAS-847	
			4 - E	4	FABRICATED BRACKETS	
15. PACKING			5 - F	A/R	HARDWARE	
			6 - G	4	BLOCKING/BRACING: ASTM-D6199, CL 3	
a. LEVEL A MIL-STD-2073-1D & NOTE M			7 - H	1	WRAP: MIL-PRF-121, TY II, SIZE: 60 X 168	
			8 - I	1	CUSHIONING: A-A-59135, CL 1, GR A,	
b. LEVEL B NOT APPLICABLE					SIZE: 36 X 212 X ¼" THICKNESS	
			9 - J	96	DESICCANT: MIL-D-3464, TY II	
16. MARKING MIL-STD-129 & NOTE N			10 - K	1	BAG: MIL-DTL-6060E, SIZE: 80 X 132 (FLAT LAYOUT)	
			11 - L	1	CONTAINER: ASTM-D7478, TY II, CL 2, ST A,	
					SIZE: 55-1/2 X 36 X 38	

17. NOTES/DRAWING

- A. INSPECT THE PRESERVATION AND UNIT PACK IN ACCORDANCE WITH MIL-STD-2073-1. INSPECT THE PACKING IN ACCORDANCE WITH MIL-STD-1186 AND THE APPLICABLE CONTAINER SPECIFICATION.
- B. SPECIAL EQUIPMENT REQUIRED FOR ENGINE PRESERVATION (SEE PAGE 4):
 - 1. ONE (1) PRESERVATIVE SUPPLY HOSE, APPROXIMATELY 24" IN LENGTH, OF WHICH ONE END SHALL BE EQUIPPED WITH A FITTING THAT WILL MATE WITH THE FUEL INLET FITTING LOCATED ON THE FUEL PUMP.
 - 2. ONE (1) PRESERVATIVE RETURN HOSE, 3/8" I.D. AND APPROXIMATELY 24" IN LENGTH, OF WHICH ONE END SHALL BE EQUIPPED WITH A FITTING THAT WILL FIT THE FUEL RETURN LINE OUTLET.
 - 3. ONE (1) 24 VOLT D.C. POWER SUPPLY TO POWER THE STARTER MOTOR WITH SWITCH TO ENGAGE/DISENGAGE THE STARTER SOLENOID.
 - 4. ONE (1) SLAVE FUEL FILTER (PERKINS P/N 26560141).
 - 5. TWO (2) SLAVE OIL FILTERS (PERKINS P/N 2654403).
 - 6. ONE (1) FUEL FLOW CHECKING TOOL GROUP (CATERPILLAR P/N 331-3626) OR AN AIR COMPRESSOR (MAX 15 PSI) WITH A SPRAYER ATTACHMENT ABLE TO PROVIDE SPRAY AND FOG PATTERNS.
 - 7. ONE (1) 5 GALLON PAIL OR EQUIVALENT FOR PRESERVATIVE DRAINAGE.
- C. THE FOLLOWING PROCEDURE DESCRIBES THE APPROVED METHOD FOR PRESERVATION OF THIS ENGINE:
 - **ANY DEVIATIONS FROM THIS PROCEDURE SHALL BE PRE-APPROVED BY TACOM AND THE ENGINE MANUFACTURER.**

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- 17. NOTES/DRAWING**
1. REPLACE FUEL FILTER (P/N 26560141) AND OIL FILTERS (P/N 2654403) WITH SLAVE FILTERS. SET ORIGINAL FILTERS ASIDE TO BE RE-INSTALLED AFTER PRESERVATION PROCESS IS COMPLETE (SEE PAGE 5).
 2. FILL PRESERVATIVE PUMP WITH ONE (1) GALLON OF PRESERVATIVE CONFORMING TO MIL-PRF-21260E, TYPE PE-10. ATTACH PRESERVATIVE SUPPLY HOSE TO PRESERVATIVE PUMP OUTLET.
 3. REMOVE CAP FROM FUEL PUMP INLET HOUSING, INSTALL PRESERVATIVE SUPPLY HOSE FROM PRESERVATIVE PUMP TO FUEL INLET (SEE PAGE 6).
 4. REMOVE CAP FROM FUEL RETURN LINE, ATTACH PRESERVATIVE RETURN HOSE, POSITION HOSE OVER PRESERVATIVE DRAINAGE CONTAINER (SEE PAGE 7).
 5. PUMP ONE (1) GALLON OF PRESERVATIVE MIL-PRF-21260E, TYPE PE-10, THROUGH FUEL SYSTEM ALLOWING EXCESS TO DRAIN INTO CONTAINER.
 - **DO NOT REUSE PRESERVATIVE.**
 6. REMOVE SUPPLY LINES AND RE-CAP BOTH THE FUEL PUMP INLET AND THE FUEL RETURN LINES.
 7. FILL ENGINE CRANK CASE TO OPERATIONAL LEVELS USING A VCI OIL MIXTURE THAT CONSISTS OF 50% VCI OIL CONFORMING TO MIL-P-46002A AND 50% MANUFACTURER'S RECOMMENDED ENGINE OIL (SEE PAGE 5).
 8. CONNECT STARTER TO 24 VOLT POWER SUPPLY (SEE PAGE 6).
 9. REMOVE FLYWHEEL COVER AND FOG APPROXIMATELY 2ml OF A VCI OIL MIXTURE, CONSISTING OF 50% VCI OIL CONFORMING TO MIL-P-46002A AND 50% MANUFACTURER'S RECOMMENDED ENGINE OIL, ON THE FLYWHEEL AND RING GEAR TEETH (SEE PAGE 7).
 10. REMOVE CAP FROM TURBO CHARGER EXHAUST PORT, FOG WITH 1ml OF A VCI OIL MIXTURE, CONSISTING OF 50% VCI OIL CONFORMING TO MIL-P-46002A AND 50% MANUFACTURER'S RECOMMENDED ENGINE OIL. (SEE PAGE 6).
 11. REMOVE CAP FROM TURBO CHARGER INTAKE PORT, SPRAY OR FOG APPROXIMATELY 12-15 ml OF A VCI OIL MIXTURE, CONSISTING OF 50% VCI OIL CONFORMING TO MIL-P-46002A AND 50% MANUFACTURER'S RECOMMENDED ENGINE OIL (SEE PAGE 6).
 12. CYCLE THE ENGINE USING THE STARTER UNTIL 36 - 45 ml OF VCI OIL MIXTURE HAS BEEN FOGGED OR SPRAYED INTO THE TURBO CHARGER INTAKE PORT, 12 – 15 ml AT A TIME.
 - **DO NOT CYCLE FOR MORE THAN 5 SECONDS ALLOWING THE STARTER TO REST 30 SECONDS BETWEEN CYCLES.**
 13. REMOVE POWER SUPPLY.
 14. REPLACE SLAVE FUEL AND OIL FILTERS WITH THE ORIGINAL FILTERS.
 15. DRAIN OIL FROM CRANKCASE, REPLACE DRAIN PLUG, TORQUE TO 25LB/FT (SEE PAGE 6).
 16. REPLACE ANY REMOVED CAPS AND PLUGS.
 17. CAP BREATHER TUBE WITH 3 X 5 POLY BAG SECURE WITH TAPE ASTM-D6123 (SEE PAGE 5).

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18. COOLING SYSTEM: IT IS ASSUMED THIS ENGINE, IF NEW, HAS BEEN PREVIOUSLY RUN WITH COOLANT UTILIZING NON-CHROMATE INHIBITORS BY THE MANUFACTURER. THEREFORE, THE COOLING SYSTEM PRESERVATION IS NOT REQUIRED.

- **THIS COMPLETES THE STEPS FOR ENGINE PRESERVATION REQUIRED PRIOR TO PACKAGING.**

D. SEAL ALL OPENINGS TO ENGINE INTERIOR WITH CAPS/PLUGS OF APPROPRIATE SIZE.

E. BRACKETS SHALL BE FABRICATED FROM COMMERCIAL GRADE 1/2" THICK PLATE STEEL. BRACKETS SHALL BE FORMED BY BENDING, NOT WELDING AND SHALL BE PAINTED, PLATED OR PRESERVED USING MIL-PRF-16173, GR 4. SEE PAGES 8 - 10 FOR BRACKET DRAWINGS AND PLACEMENT.

F. ALL HARDWARE SHALL BE COMMERCIAL GRADE AND BE PAINTED, PLATED OR PRESERVED USING MIL-PRF-16173, GR 4. SEE PAGES 8 & 9 FOR SIZES AND LOCATION.

G. ALL LUMBER SIZES ARE NOMINAL UNLESS OTHERWISE SPECIFIED. SEE PAGES 10 & 11 FOR SIZES AND ORIENTATION.

H. WRAP ENGINE ENTIRELY IN GREASE PAPER, SECURE WITH TAPE ASTM-D6123.

I. APPLY CUSHIONING AROUND THE ENGINE TO PREVENT PUNCTURING THE FOIL ENVELOPE MATERIAL, SECURE WITH TAPE ASTM-D6123.

J. DESICCANT BAGS SHALL BE PLACED WITHIN FOIL ENVELOPE, BENEATH OIL PAN, BEFORE SEALING BAG.

K. ENVELOPE FABRICATION SHALL BE IN ACCORDANCE WITH SPECIFICATION MIL-DTL-6060. MATERIAL USED FOR FABRICATION OF GASKETS SHALL CONFORM TO SPECIFICATION ASTM F 104. GASKETS SHALL BE CEMENTED TO EACH SIDE OF THE BAG AT THE MOUNTING LOCATION USING MMM-A-260 ADHESIVE OR COMMERCIAL EQUIVALENT. AFTER POSITIONING BARRIER OVER BOLTS, A SUFFICIENT QUANTITY OF ADHESIVE SHALL BE APPLIED AROUND BOLT AND GASKET TO PROVIDE AN AIRTIGHT SEAL.

L. CLOSE CONTAINER IN ACCORDANCE WITH CONTAINER SPECIFICATION ASTM-D7478.

M. THE UNIT CONTAINER IS THE SHIPPING CONTAINER.

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, 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.
2. SECURE WARNING TAG (S) IN A CONSPICUOUS LOCATION ON THE ENGINE TO STATE, "**ENGINE OIL SYSTEM PRESERVED. ENGINE FUEL SYSTEM AND CYLINDERS PRESERVED. BEFORE CRANKING, REMOVE ALL CAP/PLUGS AND TAPE AND ADD PROPER OPERATIONAL LUBRICANT TO CRANKCASE**".

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17. NOTES/DRAWING

ENGINE PRESERVATION SPECIAL EQUIPMENT



FILTERS AND PAIL ARE NOT SHOWN

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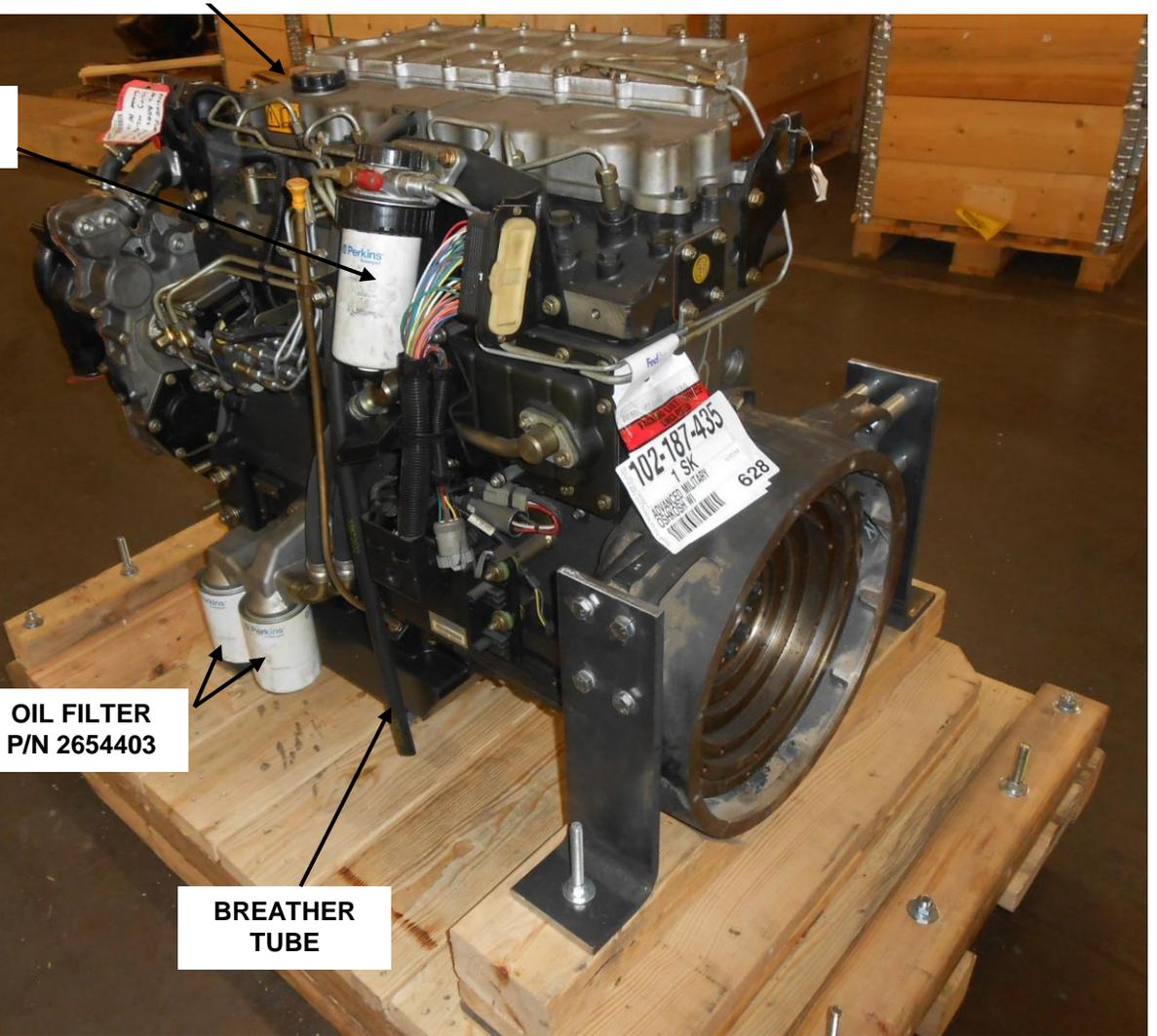
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ENGINE PRESERVATION LOCATIONS

**ENGINE OIL
FILL**

**FUEL FILTER
P/N 26560141**



**OIL FILTER
P/N 2654403**

**BREATHING
TUBE**

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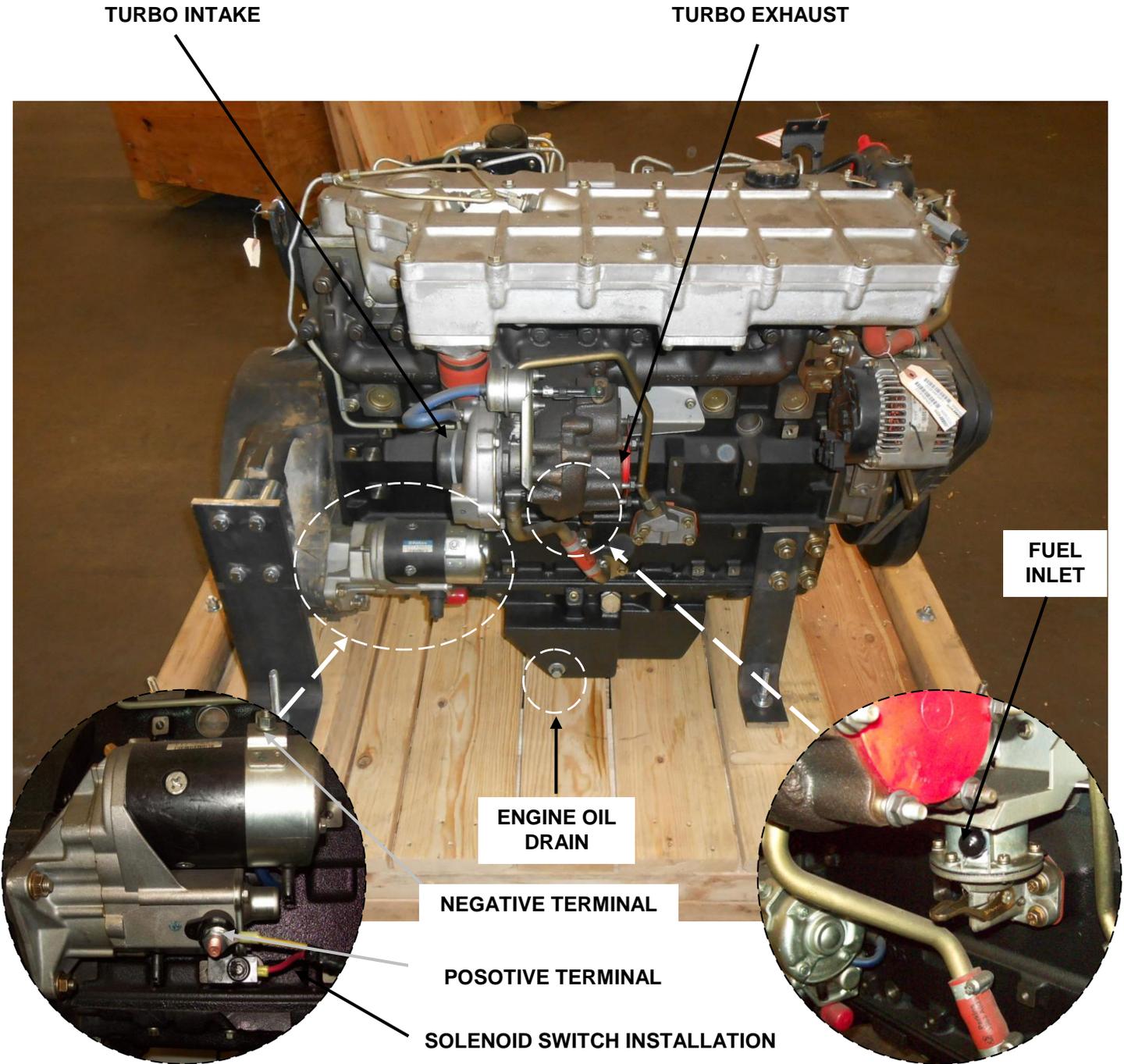
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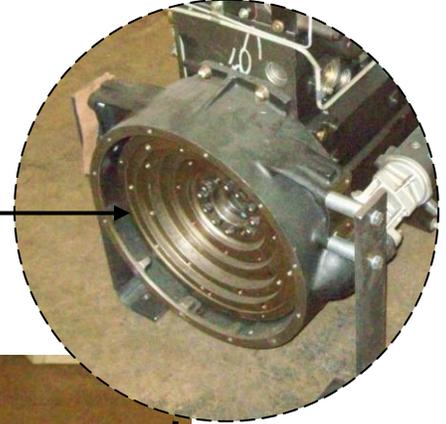
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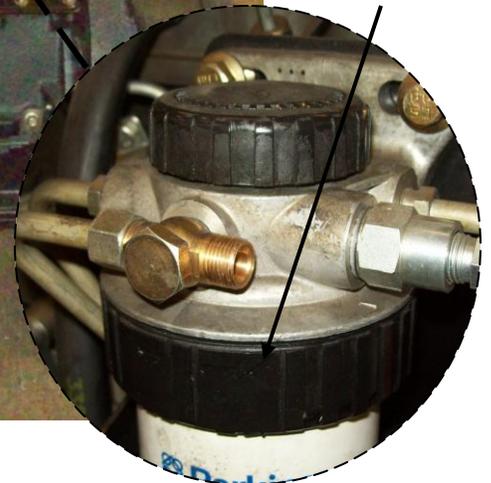
17. NOTES/DRAWING

ENGINE PRESERVATION LOCATIONS

**FLYWHEEL &
RING GEAR**



**FUEL
RETURN
LINE**



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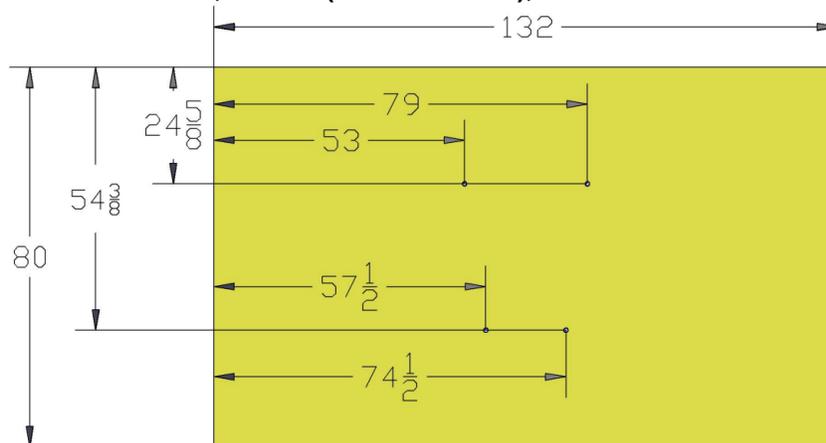
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PACKAGING BILL OF MATERIAL

ITEM	SIZE	QTY	REFERENCE
A	2 X 10 X 57-3/4	2	ASTM-D6199
B	2 X 6 X 24	1	ASTM-D6199
C	9-1/4 X 34 X 1/2 PLYWOOD	1	ASTM-D6199
D	1 X 10 X 34	1	ASTM-D6199
E	2 X 10 X 34	1	ASTM-D6199
F	4 X 6 X 14 ONE BEVELED EDGE 45°	1	ASTM-D6199
G	4 X 6 X 16 ONE BEVELED EDGE 45°	1	ASTM-D6199
H	8 X 26 GASKET MATERIAL	2	ASTM F 104
I	12 X 36 GASKET MATERIAL	2	ASTM F 104
J	18-3/4 "L" BRACKET	2	SEE DRAWING ON PAGE 12
K	13 "L" BRACKET	2	SEE DRAWING ON PAGE 12
L	M12 – 1.75 X 45 MM HARDWARE SET	4	HARDWARE SET CONSISTS OF: 1PC M12 – 1.75 X 45MM HEX BOLT & 1PC M12 LOCK WASHER.
M	M16 – 2.00 HARDWARE SET	4	HARDWARE SET CONSISTS OF: 1PC M16 – 2.00 NUT & 1PC M16 LOCK WASHER.
N	M12 – 1.75 X 110MM HARDWARE SET	4	HARDWARE SET CONSISTS OF: 1PC M12 – 1.75 X 90MM HEX BOLT & 1PC M12 LOCK WASHER.
O	1/2 X 1-1/2 STEEL SPACER	4	MCMASTER-CARR P/N 92415A156
P	1/2 HARDWARE SET	12	HARDWARE SET CONSISTS OF 1PC 1/2" FLAT WASHER
Q	1/2 X 8 HARDWARE SET	2	HARDWARE SET CONSISTS OF: 1PC 1/2 X 8" CARRIAGE BOLT, 1PC 1/2 FLAT WASHER, 1PC 1/2 LOCK WASHER & 1PC 1/2 NUT.
R	1/2 X 12 HARDWARE SET	2	HARDWARE SET CONSISTS OF: 1PC 1/2 X 12" CARRIAGE BOLT, 1PC 1/2 FLAT WASHER, 1PC 1/2 LOCK WASHER & 1PC 1/2 NUT.
S	80 X 132 ENVELOPE (FLAT LAYOUT)	1	MIL-DTL-6060E

ENVELOPE, ITEM S (FLAT LAYOUT), HOLE LOCATIONS



ALL HOLES PICTURED ON THIS PAGE ARE 1/2" DIAMETER

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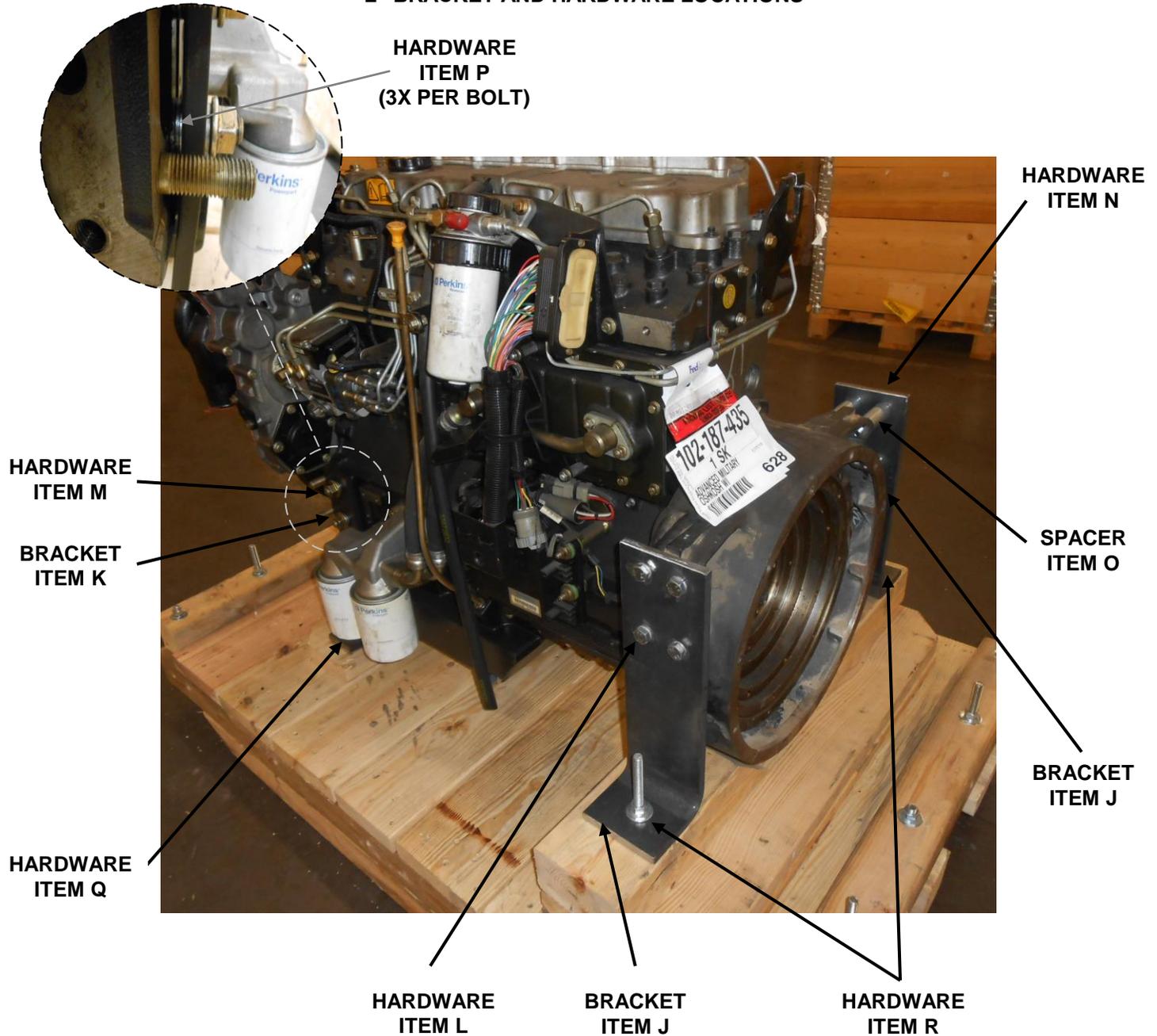
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"L" BRACKET AND HARDWARE LOCATIONS



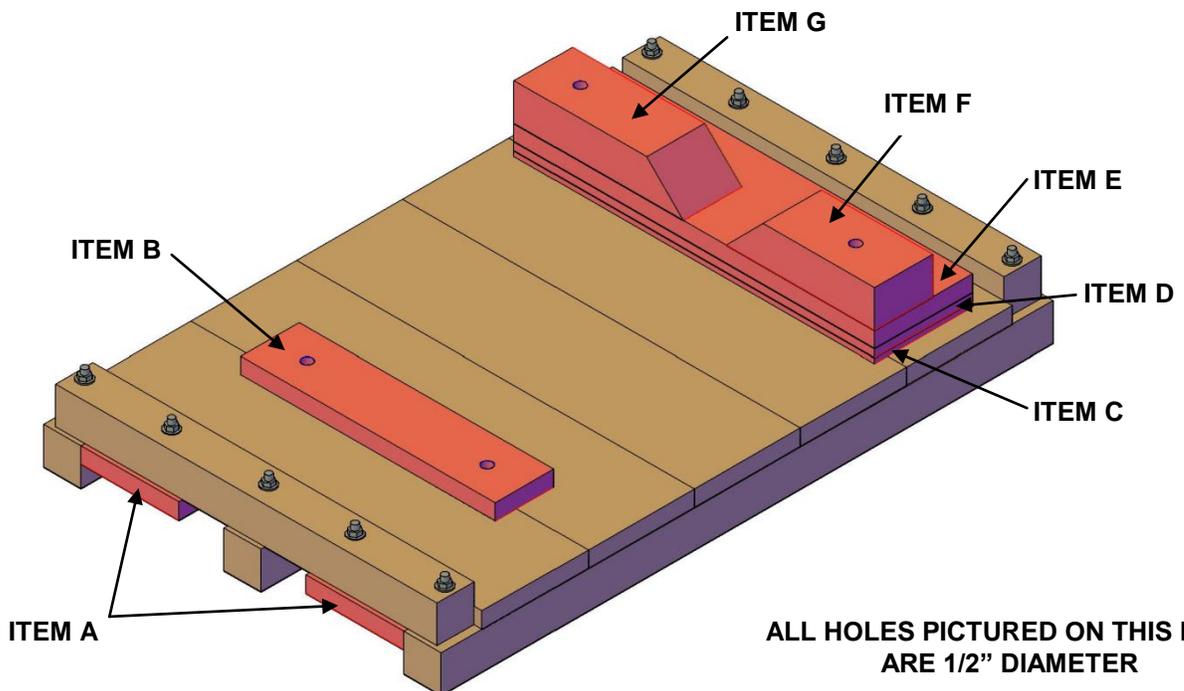
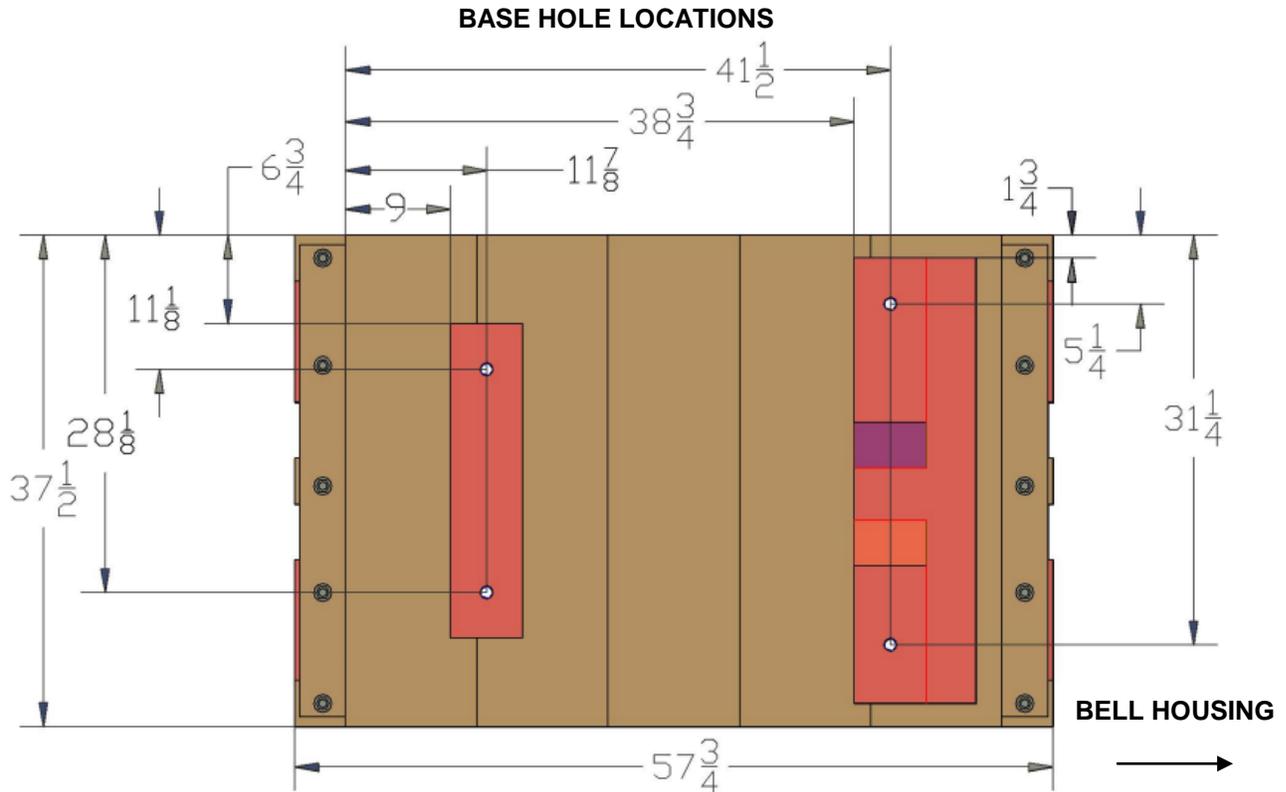
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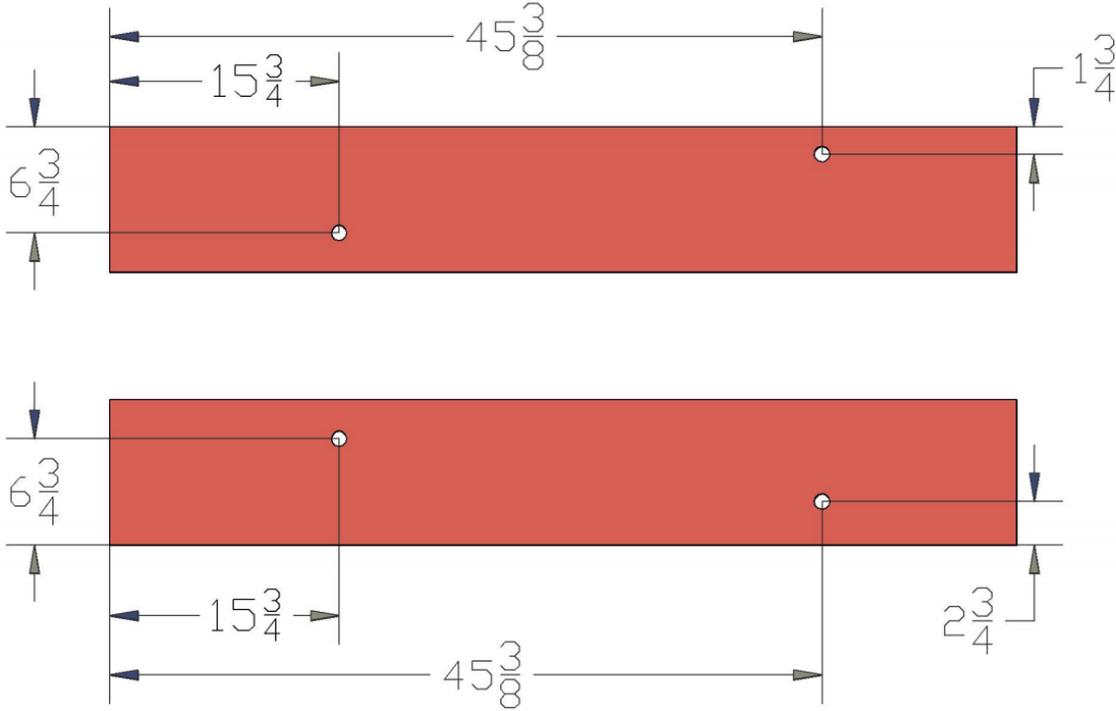
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ITEM A HOLE LOCATIONS



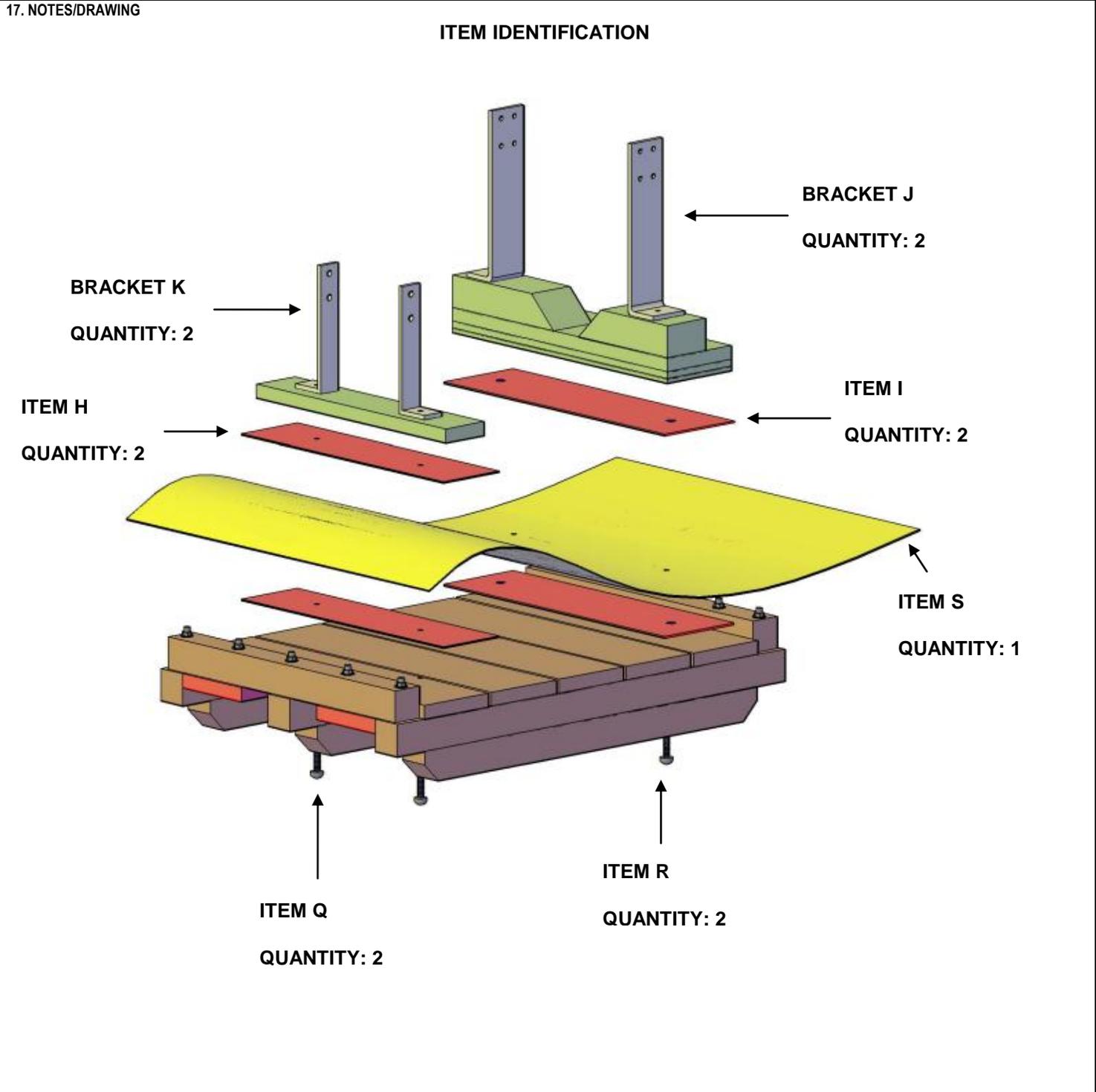
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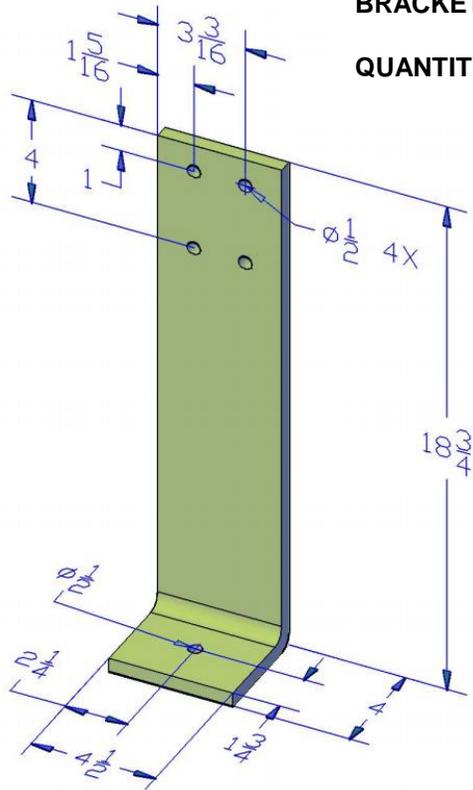
1. PART OR DRAWING NO. (CAGE) NOMENCLATURE VK-38244 (72643) ENGINE ASSEMBLY, DIESEL	2. CAGE 19207	3. SPI NO. AK15987019
4. NATIONAL STOCK NO. 2815-01-598-7019	5. DATE 6/20/2012	6. REVISION

17. NOTES/DRAWING

BRACKET DIMENSIONS

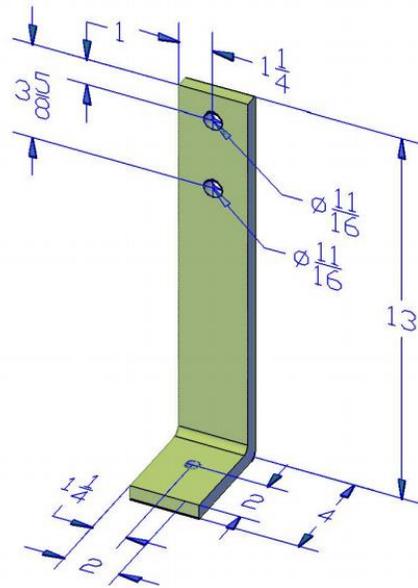
BRACKET J

QUANTITY: 2



BRACKET K

QUANTITY: 2



NOTE: ALL BRACKETS ARE MADE OF 1/2" THICK COMMERCIAL GRADE PLATE STEEL AND FORMED BY BENDING, NOT WELDED.