

MIL-B-8111E (USAF)
22 July 1983
SUPERSEDING
MIL-B-8111D (USAF)
28 June 1979

MILITARY SPECIFICATION

BOX SET, WOOD, NESTED, ORGANIZATION EQUIPMENT

TYPE MG-1A

This specification is approved for use by the Department of the Air Force and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers requirements for a wood box set for organizational equipment, consisting of four nested containers, and designated type MG-1A (see 6.1).

*1.2 Classification. The wood box sets shall be of the following classes (see 6.2):

Class 1 - Body and lid of each container shall be constructed from A-C plywood.

Class 2 - Body and lid of each container shall be constructed from overlaid plywood.

*1.3 Part Number. Specification part number for items described in this specification will be formulated as shown in Section 6.3.

2. APPLICABLE DOCUMENTS

*2.1 Government documents.

*2.1.1 Specifications and standards. Unless otherwise specified (see 6.2), the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation, form a part of this specification to the extent specified herein.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Air Force Packaging Evaluation Agency, AFALD/PTP, Wright-Patterson AFB OH 45433, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

FSC 8115

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SPECIFICATIONS

Federal

TT-C-490	Cleaning Methods and Pretreatment of Ferrous Surfaces for Organic Coatings
TT-E-529	Enamel, Alkyd, Semi-Gloss
TT-P-636	Primer Coating, Alkyd, Wood and Ferrous Metal

Military

DOD-D-1000	Drawings, Engineering and Associated Lists
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STANDARDS

Federal

FED-STD-595	Colors
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Military

MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129	Marking for Shipment and Storage
MIL-STD-130	Identification Marking of U.S. Military Property
MIL-STD-143	Standards and Specifications, Order of Precedence for the Selection of Environmental Test Methods
MIL-STD-810	Commercial Packaging of Supplies and Equipment
MIL-STD-1188	

DRAWING

Air Force

44B9598	Handle Assembly-Shipping Case
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(Copies of specifications and standards required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

*2.1.2 Other Government documents, drawings, and publications. The following other Government documents form a part of this specification to the extent specified herein.

U.S. Department of Commerce, National Bureau of Standards:

PS 1	Softwood Plywood, Construction and Industrial
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(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington DC 20402)

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* 2.1.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.3.1).

3.2 Components. The box set shall consist of four nested containers. Each container shall consist of a body assembly, lid assembly, and eight closure bolts.

3.3 Selection of specifications and standards. Specifications and standards for necessary commodities and services not specified herein shall be selected in accordance with MIL-STD-143 except as provided in 3.3.1 and 3.3.2.

3.3.1 Commercial parts. Commercial utility parts, such as screws, bolts, nuts, and cotter pins having suitable properties may be used provided:

- a. There are no suitable standard parts.
- b. They can be replaced by the standard parts (MS and AN) without alteration.
- c. The corresponding standard part numbers are referenced in the parts list and, if practical, on the contractor's drawings.

3.3.2 Standard parts. With the exception in 3.3.1, MS and AN standard parts shall be used. Standard parts shall be identified on the drawings by their part numbers.

* 3.4 Protective treatment of materials. Materials used in the construction of the box set shall have protective coatings that are resistant to extreme changes in natural environmental conditions.

3.5 Design and construction. The box set shall be designed and constructed so that no parts will work loose in service. The box set shall be built to withstand the strains, shocks, vibrations, and other conditions incidental to shipping, storage, and service of military organizational equipment weighing not more than 150 pounds (68 kilograms) per container.

3.6 Performance

* 3.6.1 Class 1 container. Each class 1 container of the box set shall be capable of withstanding the following conditions:

- a. One free fall from a height of 2 feet (60.96 centimeters) onto each of eight corners when solidly loaded with 150 pounds (68 kilograms) in each container.

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b. A static load of 150 pounds (68 kilograms) supported by each handle with the long dimension of the box set in a vertical position and the handle at right angles to the end of the container.

* 3.6.2 Class 2 container. Each class 2 container of the box set shall be capable of withstanding the following conditions:

a. A temperature range of -40°F to 160°F (-40°C to 71°C).

b. A relative humidity of 95 ± 5 percent at a temperature of $160^{\circ}\text{F} \pm 3^{\circ}\text{F}$ ($71^{\circ}\text{C} \pm 1^{\circ}\text{C}$).

c. Exposure to atmosphere containing salt laden moisture.

d. One free fall from a height of 2 feet (60.96 centimeters) onto each of eight corners when solidly loaded with 150 pounds (68 kilograms) in each container.

e. A static load of 150 pounds (68 kilograms) supported by each handle with the long dimension of the box set in a vertical position and the handle at right angles to the end of the container.

3.7 Containers. Containers shall conform to figures 1 and 2. Numbers and dimensions of containers shall conform to table I. Dimensions A and B shall be measured between the outside faces of the container, excluding reinforcing and binding, and dimension C shall be measured from the bottom surface to the top edge of the container body (see figure 1).

TABLE I. Net outside dimensions of containers.

Container No.	A		B		C	
	Inches	Millimeters	Inches	Millimeters	Inches	Millimeters
I	36-3/4	933.450	20-3/4	527.050	17-3/4	450.850
II	34-3/4	882.630	19-1/4	488.950	16-5/8	422.275
III	32-3/4	831.850	17-3/4	450.850	15-1/2	393.700
IV	30-3/4	781.050	16-1/4	425.250	14-3/8	365.125

* 3.7.1 Plywood for class 1 containers. The body and lid of each class 1 container shall be constructed from plywood conforming to U.S. Product Standard PS-1, panel grade A-C.

* 3.7.2 Plywood for class 2 containers. The body and lid of each class 2 container shall be constructed from overlaid plywood conforming to U.S. Product Standard PS-1, or plywood surfaced on two sides with an equivalent surfacing material of plastic or fiber. Plywood shall be surfaced on two sides with a medium density overlay panel grade B-B. The thickness of plywood exclusive of the surfacing material shall be 3/8 inch (9.525 mm). The color of the facing shall be olive drab conforming to TT-E-529, color number 24087 of FED-STD-595.

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*3.7.3 Gaskets and sealing. The corners and edges of the class 1 and class 2 containers shall be tightly joined to resist entry of moisture. A gasket shall be provided on the under side of the lid. The gasket shall be flexible at -20°F (-29°C) and shall not disintegrate or separate from the lid at -40°F (-40°C).

*3.7.4 Handles. The handles shall fold down against the side of the container when not in use and shall stop open at approximately 90 degrees when extended. The handles shall be fabricated in accordance with U.S. Air Force drawing No. 44B9598 or equal (see Fig. 3). Each handle shall be capable of lifting the total gross weight by single-point suspension(see 4.6.2).

3.8 Interchangeability. All part numbers having the same manufacturer's part number shall be functionally and dimensionally interchangeable. The drawing number requirements of DOD-D-1000 shall govern changes in the manufacturer's part numbers.

3.9 Finishes and protective coatings.

*3.9.1 Plywood Edge Treatment. After cutting and prior to assembly, all sawed edges of both the class 1 and class 2 containers shall be sealed against the entry of moisture with one application of primer TT-P-636 and two coats of enamel conforming to TT-E-529, color number 24087 of FED-STD-595.

*3.9.2 Metal Parts. Prior to assembly of the containers, metal parts shall be covered with a phosphate coating conforming to TT-C-490, grade 1. Closure bolts, if otherwise protected against corrosion, shall be exempt from this requirement.

*3.9.3 Protective coating.

*3.9.3.1 Class 1 containers. For class 1 containers, one coat of primer conforming to TT-P-636 and two coats of enamel conforming to TT-E-529, color number 24087 of FED-STD-595, shall be applied to both the inside and the outside of the containers subsequent to assembly (see 3.9.1). Particular care shall be taken to assure complete coverage of handles, rivet heads, and similar areas.

*3.9.3.2 Class 2 containers. Plywood for class 2 containers surfaced with an overlay of the specified color need not be painted. However, if the facing of the plywood is not surfaced with the specified color, it shall be suitable for painting. Two coats of enamel conforming to TT-E-529, color number 24087 of FED-STD-595, shall be applied to both the inside and the outside of the class 2 containers subsequent to assembly (see 3.9.1). Particular care shall be taken to assure complete coverage of handles, rivet heads, and similar parts.

*3.10 Identification marking. Each box of a box set shall be marked on one end in accordance with MIL-STD-130. The following information shall be included:

BOX SET, WOOD, NESTED ORGANIZATION EQUIPMENT
TYPE MG-1A (CLASS 1 or 2 AS APPLICABLE)
CONTAINER SIZE (I, II, III OR IV AS APPLICABLE)

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MIL-B-8111E

MFG NAME OR CODE (AS APPLICABLE)

CONTRACT OR PURCHASE NUMBER (AS APPLICABLE)

THE DESIGNATION "U.S. PROPERTY"

"CAPACITY 150 POUNDS (68 KILOGRAMS)"

3.10.1 Other markings. On the opposite end of the identification marking (see 3.10), a 4 x 6 inch (102 x 152 millimeter) space shall be stenciled as follows:

"PLACE SHIPPING TICKET HERE"

3.11 Workmanship. The box sets shall be constructed and finished in a thoroughly workmanlike manner. The box sets shall be clean, free of burrs, sharp edges, and foreign material.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.2 Classification of tests. The inspection and testing of boxes shall be classified as follows:

- a. First article tests (see 3.1 and 4.3.1)
- b. Quality conformance tests (see 4.4)

4.3 First article tests.

*4.3.1 First article test samples. First article test samples shall consist of one box set upon which approval is desired. Samples shall be appropriately identified. The box set shall be examined as specified in paragraphs 4.4.3 through 4.4.5. Class 1 containers shall be tested in accordance with paragraph 4.6.1 and 4.6.2. Class 2 containers shall be tested in accordance with table II and paragraphs 4.6.1 through 4.6.3.4.1. The test results shall be approved by the procuring activity before production is commenced.

4.3.2 First article retest. First article tests shall be repeated in the event a change in the manufacturing process or a change in material is made.

*4.4 Quality conformance tests. These tests shall consist of the examination as specified in 4.4.3, 4.4.4 and 4.4.5 (using the levels as specified in 4.4.6).

4.4.1 Sampling for inspection and acceptance. Sampling for inspection and acceptance shall be performed in accordance with the provisions set forth in MIL-STD-105, except where otherwise indicated. For purposes of sampling, an inspection lot for examination and test shall consist of all boxes submitted for delivery at one time. The acceptance quality level (AQL) shall be applicable to the entire lot regardless of defects as they may occur in any one size of box.

4.4.2 In-process inspection. In-process inspection shall be made to determine that surface treatment of metal parts complies with 3.9.2; that after cutting and prior to assembly, plywood edges and exposed openings are sealed against the entry of moisture (see 3.9.1); specified type rivets are used as indicated in figure 2; and that utility parts such as screws, nuts, bolts, cotter pins, etc., are as specified in 3.3 and subparagraphs thereto. Failure to take immediate corrective action of any noncompliance shall be cause for rejection of lots.

4.4.3 Examination of the end item. Examination of the end item shall be made in accordance with the classification of defects, inspection levels, and acceptable quality levels (AQLs) set forth below. The lot size for the purpose of determining the sample size in accordance with MIL-STD-105 for examination in 4.4.4 shall be expressed in containers of one size only. Separate examinations shall be performed for each container, I, II, III, and IV. The inspection level and AQL shall apply to each of the separate examinations. For examination in 4.4.5, the lot size shall be expressed in units of box sets fully prepared for delivery.

4.4.4 Examination of individual containers for defects in material, construction, appearance, workmanship, dimensions, and marking. The sample unit for this examination shall be one size I, II, III, or IV unit container with lids and closure bolts, as applicable. Separate examinations shall be performed for each size container. The inspection level and AQLs shall apply to each of the separate examinations.

Examine	Defect	Classification	
		Major	Minor
Finish	Not color specified		X
	Rust on metal surfaces	X	
	Peeling or blistered	X	
	Not smooth and uniform	X	
	Touchup not neat		X
	Not completely dry (tacky)		X
	Dirt, grit, or foreign matter imbedded in the enamel		X
	Color separation or discoloration affecting appearance		X
Plywood	Void in core showing on any edge not filled, overlaid plywood only		X
	Veneer blistered, wrinkled, buckled, warped, split, chipped, or delaminated	X	
Quality of components (except rivets and tacks)	Not fabricated of material specified	X	
	Not type or size specified	X	
	Component damaged, malformed, dented, or bent affecting usability	X	
	Component damaged, malformed, dented, or bent not affecting usability		X
	Sharp edge or projection that may cause injury	X	
	Component bruised, chipped, or nicked to an extent affecting appearance		X

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Examine	Defect	Classification	
		Major	Minor
Quality of rivets and trunk tacks	Forming or machine mark affecting appearance		X
	Component mispositioned or misaligned affecting serviceability	X	
	Missing or loose component	X	
	Handle does not operate freely	X	
Workmanship of attachment of rivets or tacks	Wrong type or size is used	X	
	More than one rivet or tack missing	X	
	One rivet or tack missing		X
	Spacing and alignment of rivets or tacks not as shown in drawing		X
	Five or less rivets or tacks not securely and properly clinched or peened (as applicable)		X
	Six or more rivets or tacks not securely and properly clinched or peened (as applicable)	X	
	Any combination of ten or more rivets or tacks cocked or not flush	X	
	Three or more rivets visibly loose or insecure		X
	Five or more rivet heads popped on binding, lid or channels	X	
	Body and lid assembly (exterior)	Force fit of lid on body	X
Lid loose on body with closure bolts in locked position		X	
Panel warped more than 1/8 inch (3.175 mm) length or width			X
Any hole through container		X	
Construction details not as specified in figures 1 and 2		X	
Body and lid assembly (interior)	Gasket deformed, torn, or loose	X	
	Open joint at gasket ends more than 1/8 inch (3.175 mm)	X	
	Open joint over 1/32 inch (0.794 mm) at juncture of adjoining panels		X
Markings	Omitted, incomplete, incorrect, not legible	X	
Dimensions	Not within tolerances specified in table I and figures 1 and 2	X	

4.4.5 Inspection and examination of the end item for defects in assembly and nesting. The sample unit for this examination shall be one complete box set.

Examine	Defect
Assembly	Boxes not completely assembled and nested. Any component member, including bolts, missing from assembly.

4.4.6 Inspection levels and acceptable quality levels (AQLs) for examination. The inspection level and acceptable quality levels (AQLs) based on defects per 100 units shall be as follows:

Examination Paragraph	Inspection Level	AQL	
		Major	Minor
4.4.4	II	2.5	10.0
4.4.5	S-2	---	4.0

*4.5 Testing of the end item. One sample unit consisting of one complete set of boxes, Class 1 or Class 2 from each lot presented for acceptance, shall be tested as indicated in Table II. Failure to comply with any characteristic requirement shall be cause for rejection of the lot.

TABLE II. Instructions for testing (sample unit)

Characteristic	Specification Requirement	Reference Test Method	Rqmts Appl to Indiv Unit	Number Determinations per Sample	Results Reported as Pass or Fail ^{1/}
Drop test (1 of each size container)	3.6	4.6.1	X	1 on each of the 8 corners	X
Handle test (1 of each size container)	3.6	4.6.2	X	1 on each handle	X
Low Temperature Test	3.6	4.6.3.1	X	1 on each size container	X
High Temperature Test	3.6	4.6.3.2	X	1 on each size container	X
Humidity Test	3.6	4.6.3.3	X	1 on each size container	X

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Characteristic	Specification Requirement	Reference Test Method	Rqmts Appl to Indiv Unit	Number Determinations per Sample	Results Reported as Pass or Fail ^{1/}
Gasket and Sealing	3.7.3	4.6.3.3	X	1 on each size gasket	X
Salt Fog Test	3.6	4.6.3.4	X	1 on each size container	X

1/ In case of failure, report degree of failure.

4.6 Test methods.

4.6.1 Drop test. One of each size container shall be subjected to a drop test at ambient conditions. The containers shall be prepared for testing with a dummy load. The dummy load shall be firmly braced against each wall of the container at four or more symmetrical points. No internal or external reinforcements shall be used. The test load for each size container shall be 150 pounds (68 kilograms). Each container shall be subjected to one free fall on each of its eight corners from a height of 24 inches (60.96 centimeters). The container shall be positioned for the drop test with two diametrically opposite corners in a vertical line and shall be dropped on any unyielding surface. The container or fastenings shall not show signs of failure as a result of this test. The lid shall be opened and closed and shall be functional after the drop test.

4.6.2 Handle test. One container of each size shall be subjected to a handle test. The load of 150 pounds (68 kilograms) shall be retained in the container, the long dimension of the container shall be vertical, and the handle shall be at right angles to the end of the container. The handles on both ends of the container shall not fail or pull loose from the container when the container is lifted vertically by the handle while in the position indicated.

4.6.3 Environmental tests. The containers of one box set shall be subjected to tests in accordance with the applicable procedures of MIL-STD-810. The lids of the containers shall be closed when subjected to all tests. A different container shall be subjected for each environmental test. In the event that test facilities are inadequate for the testing of the larger containers, additional smaller containers may be submitted for the environmental testing. Following each test, the containers shall be capable of being opened and closed with ease and shall show no signs of mechanical failure, loss of protective coatings, or separation or disintegration of gasket material.

*4.6.3.1 Low temperature. One container shall be subjected to a low temperature test in accordance with MIL-STD-810, Method 502.1, Procedure 1, except that a -40°F (-40°C) temperature will be substituted. A dummy test load of 150 pounds (68 kilograms) shall be placed in the container (see 4.6.1) prior to insertion of the container in a test chamber. At the end of the exposure period, the container shall be inspected to determine compliance with 4.6.3 and shall be drop tested in compliance with 4.6.1. The drop test shall be performed within 20 minutes of removal of the container from the test chamber. No failure shall result to the container or to the fastenings.

*4.6.3.2 High temperature. One container shall be subjected to a high temperature test in accordance with MIL-STD-810, Method 501.1, Procedure I. At the conclusion of this test, the container shall be inspected to determine compliance with 4.6.3.

*4.6.3.3 Humidity. One container shall be subjected to a humidity test in accordance with MIL-STD-810, Method 507.1, Procedure I for 10 cycles (240 hours). Only minor corrosion shall result. The container shall be weighed prior to the test and shall be wiped dry of exterior moisture at the conclusion of the test. The container shall be reweighed prior to opening. The gain in weight shall be less than five percent of the initial weight of the container. The container shall then be inspected to determine compliance with 4.6.3.

*4.6.3.4 Salt fog test. One container shall be subjected to a salt fog test in accordance with MIL-STD-810, Method 509.1, Procedure I. At the conclusion of this test, the container shall be inspected to determine compliance with 4.6.3.

4.6.3.4.1 Minor corrosion. "Minor corrosion" shall be construed to mean minor streaking or staining which would in no way interfere with the operation of the container lid or with normal utility of the container and shall not be present on the interior of the container.

5. PACKAGING

*5.1 Preservation. Not applicable.

*5.2 Packing. Packing shall be level A or industrial as specified (see 6.2).

5.2.1 Level A. Containers shall be assembled and nested prior to shipment. Unless otherwise specified, no boxing, crating, or preservation packaging shall be used when shipping the box sets.

*5.2.2 Industrial packing. Packing shall be in accordance with MIL-STD-1188.

5.3 Marking.

5.3.1 Military marking. In addition to any special marking required by the contract or order, marking of the exterior container shall be in accordance with MIL-STD-129.

*5.3.2 Industrial marking. Marking shall be in accordance with MIL-STD-1188.

6. NOTES

6.1 Intended use. The Type MG-1A box set covered by this specification is intended for use by military organizations for shipping and storage of organizational equipment not to exceed 150 pounds (68 kilograms) per box.

*6.2 Ordering data. Procurement documents should specify the following:

- a. Title, number, and date of this specification.
- b. Class and size required (see 1.2 and Table I).

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- c. Specify level A or industrial packing (see 5.2).
- d. Specify military or industrial marking (see 5.3.1 and 5.3.2).
- e. When first article test sample is required (see 3.1, 4.3.1, and 6.2.2).

6.2.1 Moisture resistance. Where a high degree of moisture resistance is required, the user should specify a class 2 (overlaid plywood) box. For all normal uses, however, a class 1 (A-C plywood) box will generally be suitable.

6.2.2 First article test sample. One box set shall be required as a first article sample to be subjected to the first article tests to determine compliance with the requirements of this specification. The point of inspection for these tests shall be specified.

6.2.3 Environmental. Refer to material specifications or preparing activity for recommended disposability methods.

*6.3 Definitive specification part number. The specification part number is a definitive part number which will be formulated to identify each item covered by this specification. The part number will be formulated by selecting from the requirement options available in this specification as follows:

Definitive Specification Part Number M8111 - X - X

Military Specification Number _____

Class Designator (see 6.3.1) _____

Size Designator (see 6.3.2) _____

6.3.1 Class designator. A one position field used to designate the required class of box (see Table III):

TABLE III

Class Designator	Remarks
1	Constructed from A-C plywood
2	Constructed from overlaid plywood

6.3.2 Size designator. A one position field used to designate the required size of box (see Table IV & Figure 1):

TABLE IV

Size Designator	Dimensions in Inches		
	A	B	C
A	36 3/4	20 3/4	17 3/4
B	34 3/4	19 1/4	16 5/8
C	32 3/4	17 3/4	15 1/2
D	30 3/4	16 1/4	14 3/8
E	All of the above - one set		

Sample Part Number M8111 - 1 - B
 Military Specification Number _____
 Class 1 (A-C plywood) _____
 Size (34 3/4 x 19 1/4 x 16 5/8) _____

*6.4 Cross-classification. Revision to MIL-B-8111 (USAF) has resulted in a change from grades to classes. The following table (Table V) may be used as a cross-reference for the boxes.

TABLE V. Conversion from "D" to "E" classification

<u>MIL-B-8111D (USAF)</u>	<u>MIL-B-8111E (USAF)</u>
Grade A	Class 1
Grade B	Class 2

*6.5 Changes from previous issue. The margins of this specification are marked with asterisks to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

*6.6 Ordering information. At the time of this revision, NSN 8115-00-290-6016 was assigned to the Class 1 plywood box set. Using activities should verify this stock number before ordering.

Custodian:
Air Force - 69

Preparing activity:
Air Force - 69

Reviewer activity:
Air Force - 99

Project number: 8115-F451

User activity:
Air Force - 99

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NOTE: DIMENSIONS SHOWN APPLY TO ALL FOUR BOX SIZES. DIMENSIONS IN MILLIMETRE/INCH UNLESS OTHERWISE SPECIFIED TOLERANCES + .159/286

254.02/10.20 TYP, TAKEN FROM BODY WITHOUT ANY HARDWARE (WOOD OF BODY)

NOTE: ALL RIVETS APPROX 63.20/2.50 APART, 6.35/25 FROM EDGE OF BINDING, SEE FIGURE 2.

76.20/3.00 TYP TAKEN FROM BODY WITHOUT ANY HARDWARE (WOOD OF BODY)

BIFURCATED RIVETS IN LID BINDING
TUBULAR OR SOLID RIVETS IN WRAP-AROUND TOP EDGE BINDING

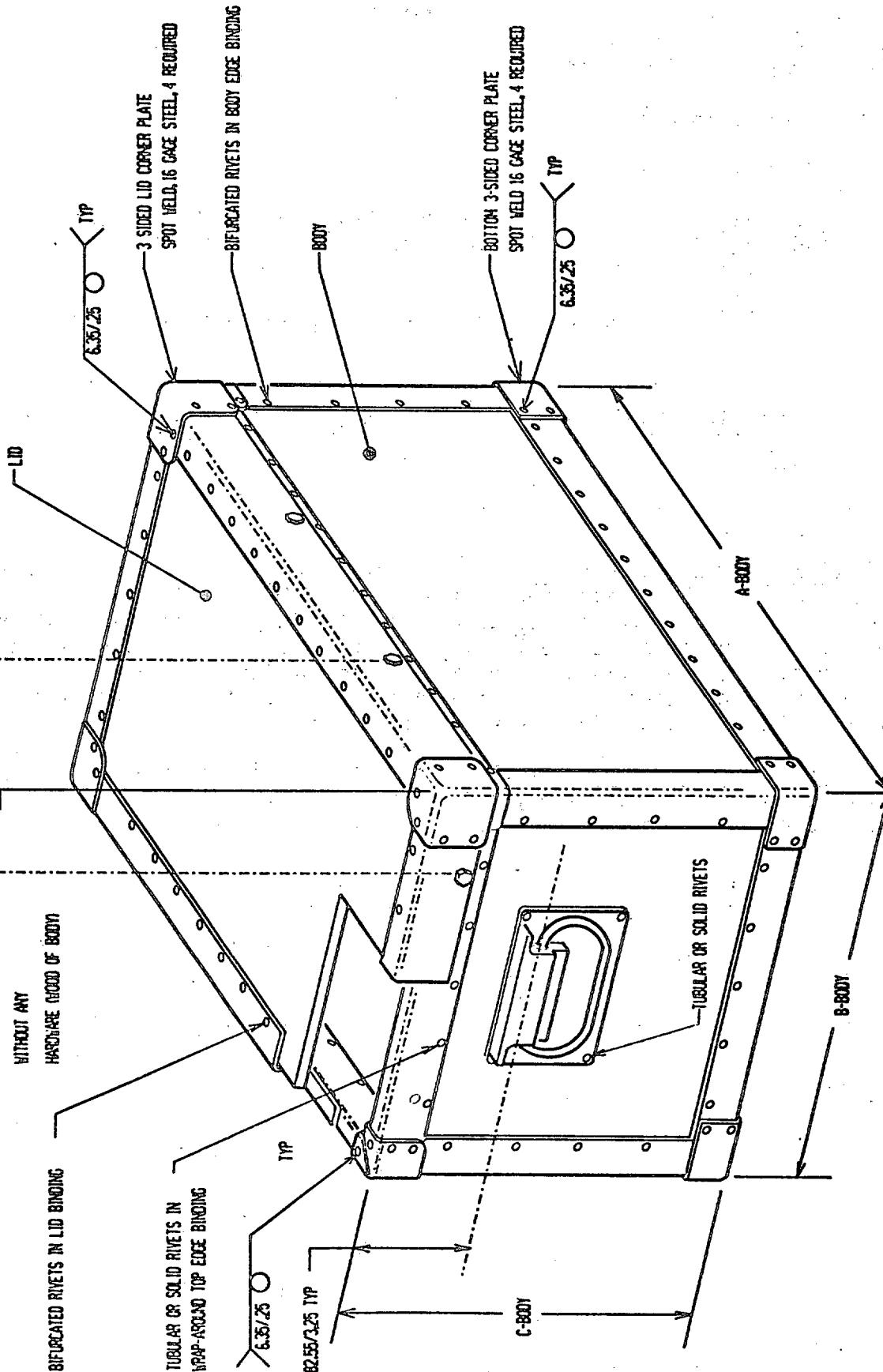
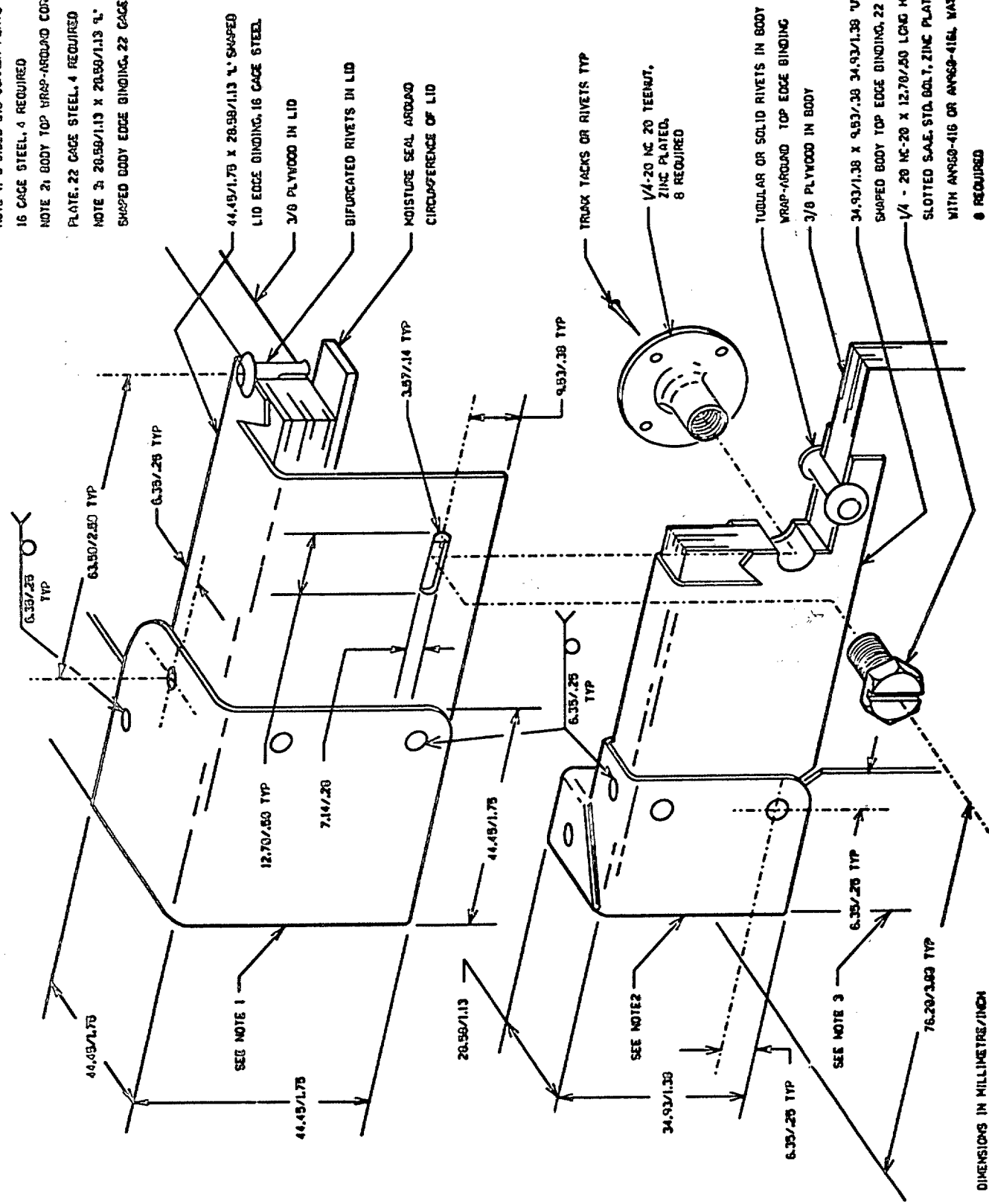


FIGURE 1

NOTE 1: 3-SIDED LID CORNER PLATE
 16 GAGE STEEL, 4 REQUIRED

NOTE 2: BODY TOP WRAP-AROUND CORNER
 PLATE, 22 GAGE STEEL, 4 REQUIRED

NOTE 3: 20.98/1.13 X 20.98/1.13 "L"
 SHAPED BODY EDGE BINDING, 22 GAGE STEEL

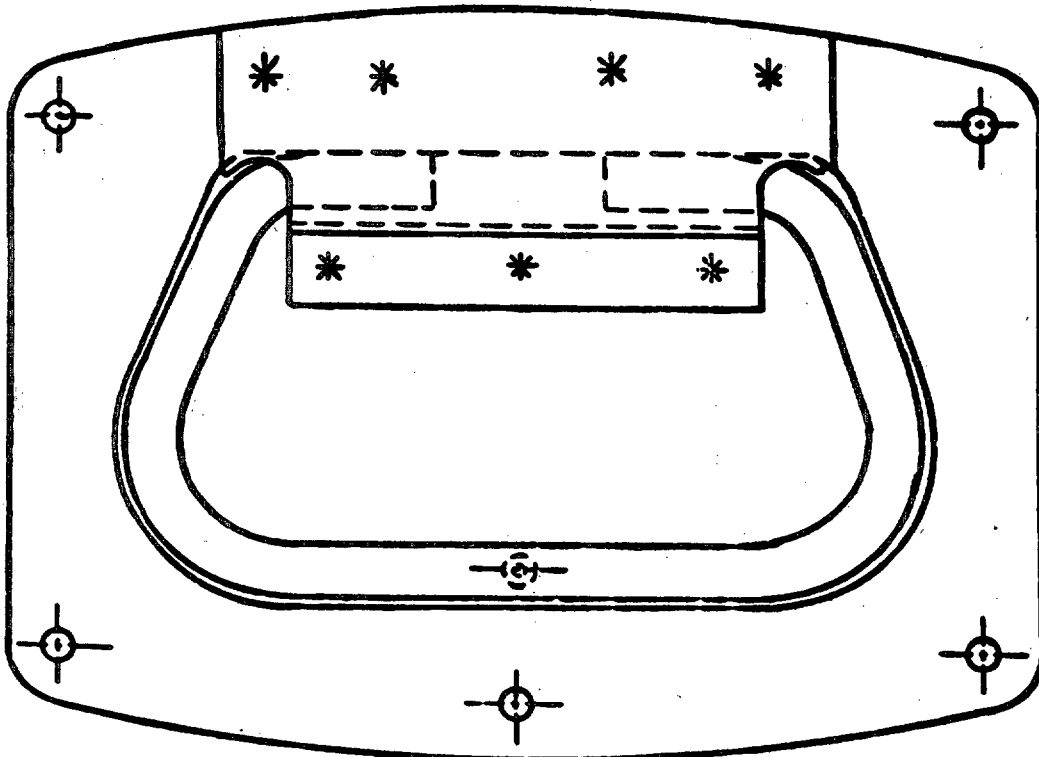


DIMENSIONS IN MILLIMETRE/INCH
 UNLESS OTHERWISE SPECIFIED.
 TOLERANCES: ±0.50/0.06

FIGURE 2

MIL-B-8111E (USAF)

DRAWING
OF
HANDLE ASSEMBLY SHIPPING CASE (Dwg 44B9598 or equal)



NOTE; HANDLE CHARACTERISTICS:

- a. Handle shall fold down against the side of the container when not in use and stop open at approximately 90° when extended.
- b. The grip diameter shall be not less than $1/2$ inch, the clear inside dimension shall be not less than $4 \frac{1}{4}$ inches in length and 2 inches in depth.
- c. Each handle shall be capable of supporting a static load of 150 pounds (68 kilograms) by single-point suspension (see 3.6.1b and 3.6.2e).

FIGURE 3

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER

2. DOCUMENT TITLE

3a. NAME OF SUBMITTING ORGANIZATION

4. TYPE OF ORGANIZATION *(Mark one)* VENDOR USER MANUFACTURER OTHER *(Specify):* _____b. ADDRESS *(Street, City, State, ZIP Code)*

5. PROBLEM AREAS

a. Paragraph Number and Wording:

d. Recommended Wording:

c. Reason/Rationale for Recommendation:

6. REMARKS

7a. NAME OF SUBMITTER *(Last, First, MI) - Optional*b. WORK TELEPHONE NUMBER *(Include Area Code) - Optional*c. MAILING ADDRESS *(Street, City, State, ZIP Code) - Optional*8. DATE OF SUBMISSION *(YYMMDD)*