

MIL-C-21215A (OS)  
 9 June 1976  
 SUPERSCEDING  
 MIL-C-21215(NOrd)  
 24 January 1958

## MILITARY SPECIFICATION

### CRATES, PALLETS, AMMUNITION

This specification is approved for use by the Naval Sea Systems Command (OS) Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

#### 1. SCOPE

1.1 Scope. This specification covers ammunition pallet crates intended for handling, stowing, and transporting of ordnance items in intradepot operations.

1.2 Classification. The pallet crates shall be of three sizes with inside dimensions for end, side, and height, respectively, as follows:

Size 1 - 48 by 48 1/2 by 40 inches

Size 2 - 40 by 46 1/2 by 40 inches

Size 3 - 34 by 44 1/2 by 28 inches

#### \*2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on the date of invitation for bids or request for proposal form a part of this specification to the extent specified herein.

#### SPECIFICATIONS

##### MILITARY

MIL-P-116

Preservation, Packaging; methods of

MIL-D-1000

Drawing, Engineering and Associated List

#### STANDARDS:

##### FEDERAL

FED-STD-66

Steel: Chemical Composition and Hardenability

FED-STD-101

Preservation, packaging and packing materials:  
 Test Procedures

#### MILITARY:

MIL-STD-22

Welding Joint Design

MIL-STD-105

Sampling procedures and tables for inspection  
 by attributes

FSC 8140

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MIL-STD-129	Marking for Shipment and Storage
MIL-STD-130	Identification marking of U. S. Military Property
MIL-STD-248	Welding and Brazing procedure and performance qualifications

DRAWINGS:

Naval Sea Systems Command (CODE IDENT. 10001)

DL 2644148                      Sling, Pallet Hoisting Mk 70 and Mod 2

(Copies of Specifications, Standards, Drawings, and Publications required by suppliers in connection with specific procurement functions, should be obtained from the procurement activity or as directed by the Contracting Officer.)

\*2.2 Other Publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated the issue in effect on the date of invitation for bids or request for proposal shall apply.

American Welding Society

AWS A2.0 Welding Society  
AWS A3.0 Welding Terms and Definitions

(Applications for copies should be addressed to the American Welding Society, 345 East 47th Street, New York, New York 10017.)

American Society for Testing Materials

ASTM A386 Zinc Coating (Hot-Dip) on Assembled Steel Products

(Applications for copies should be addressed to the American Society for Testing Materials, 1916 Race Street, Philadelphia, Pennsylvania 19103.)

Uniform Classification Committee

Uniform Freight Classification Rules and Regulations

(Application for copies of these uniform freight classification rules and regulations should be addressed to the Uniform Classification Committee, Room 1106, 222 S. Riverside Plaza, Chicago, Illinois 60606.)

3. REQUIREMENTS

3.1 Description. The pallet crate shall consist of a pallet to which are attached sides and ends. The sides, ends, and pallet deck shall be connected by hinges and locks to form an open top container. When not in service the sides and ends shall be capable of being folder onto the pallet deck making a compact unit suitable for efficient storage and safe tiering. All drawings shall be in accordance with MIL-D-1000 as specified in 6.2.2.

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\*3.2 Preproduction sample. In all respects not specifically covered by this specification, the pallet crates shall be equal to the preproduction sample. The design and structural characteristics of this sample will be evaluated for acceptability from a standpoint of safety, structural rigidity, and for conformance with the requirements specified herein. Unless otherwise specified, two preproduction samples of each size shall be submitted for examination, and test to determine compliance with all provisions of this specification. The first and second pallet crate of each size produced under the terms of a contract, following notice of award shall be submitted for approval as a preproduction sample, and approval shall be obtained prior to fabrication of subsequent items. Fabrication of additional items prior to approval of the preproduction pallet crates will be at the contractor's risk and such additional items are subject to rejection in the event they fail to meet the requirements of this specification. Examination and testing of preproduction samples will be accomplished by the facility designated by the procurement activity, and the delivery schedule under the terms of the contract will be automatically extended in an amount equal to, but not exceeding, the time required for such testing and examination.

\*3.3 Material. The material used shall be standard steel in accordance with approved Government specifications, where applicable, and shall be selected in accordance with FED-STD-66. Steel specifications and commercial designations referenced on respective drawings which have been furnished by the contractor and approved by the procuring activity shall be adhered to unless specific approval in writing covering departure therefrom is received from the procuring activity prior to manufacture or use. Materials which are not covered by applicable specifications shall be the best quality used in commercial practice and suitable for the intended purpose.

3.4 Capacity. Pallet crates of Sizes 1, 2, and 3 shall have a working load capacity of 4,000 pounds with a safety factor of 5-1.

3.5 Weight. Minimum weight of the pallet crate is required without impairing its function, operation, or durability. The crates shall not exceed the following weights when tested as specified in 4.4.1 and 4.5.4.1:

Size 1 - 360 pounds  
Size 2 - 325 pounds  
Size 3 - 245 pounds

3.6 Provision for handling.

3.6.1 Fork and pallet truck. The pallet shall permit entry of fork truck, electric pallet truck, and hand pallet truck on any side or end. Criteria for entry shall be based on electric pallet truck fork width of 9 inches, overall width of 27 inches, and collapsed height of 3-5/8 inches. There shall be no interference with pallet deck supports or base runner in proper entry or withdrawal of forks.

3.6.2 Slings. The pallet crate shall be capable of being hoisted by four hooks on slings attached to a suitable strongback or spreader. The deck supports of the pallet crate shall permit entry and use of Sling, Pallet Hoisting, Mk 70 Mod 2, NAVSEA Drawing DL 2644148.

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\*3.7 Tiering. The pallet crate shall be constructed to permit tiering of one crate on another of the same size. This shall be accomplished by recesses or notches in the outer deck supports which engage the tops of the sides of the pallet crate below. The notches or recesses shall be of sufficient depth so that the superimposed pallet crate is safely secured in position under the 8 degree slope test specified in 4.4.5.4. Tiering of up to four units shall be readily accomplished with normal fork truck "inching" action and shall not require excessive time-consuming accuracy on the part of the fork truck operator. During, and after being subjected to the test specified in 4.4.5.3 and 4.4.5.4, the crate shall not collapse or show component distortions that affect tiering stability.

3.8 Folding. The pallet crates shall be constructed to permit folding to a compact unit for efficient stowage when not in use or when shipping empty by rail or highway vehicle. Flat folding without interference may be accomplished by hinging one side directly to the deck and the other side to an extension above the deck. It shall be possible to strap the folded units into a compact and secure load suitable for tiering without damage to the pallet crates.

3.9 Component parts. The pallet crate components shall incorporate the features specified herein which are dictated by service requirements.

\*3.9.1 Deck supports, outer. The pallet crate shall have four main deck supports, two to each side, which, in addition to the primary function of supporting the deck, shall provide for tiering (see 3.7). The support shall permit bar member entry of the Sling, Pallet Hoisting Mk 70 Mod in the longitudinal direction of the pallet crate.

\*3.9.2 Deck supports, intermediate. There shall be an intermediate support at the center of each side and end secured to the base runner and deck. Provision shall be made for entry of the bar member of Sling, Pallet Hoisting Mk 70 Mod 2 in the longitudinal direction of the pallet crate.

3.9.3 Base runner. There shall be a runner on the base perimeter of the pallet crate secured to the bases of the main deck supports and passing under and secured to the intermediate deck supports. The runner shall be 3/16 inches thick and formed for strength. This forming shall not introduce interference with hand and electric pallet trucks. The runners and main deck supports shall provide a flush bottom surface for stability with superimposed loads. The base runners shall serve to prevent overturning of pallet crates from forks during operations due to the possibility of unbalanced loads.

3.9.4 Deck. The pallet crate shall be of rigid construction and shall have two sides attached through a hinging arrangement. In order to permit flat folding of the sides and ends, one hinged end of the deck may be extended vertically to provide flat folding of the side above the deck. The deck shall be adequately supported by subdecking structural members. If wire fabric is used for the deck, spacing between wires shall not exceed 2 inches.

3.9.5 Sides. The sides shall be structurally capable of supporting superimposed loads (see 4.4.5.3). If wire fabric is used, spacing between wires shall not exceed 2 inches. Each side shall have two hook eye plates, 4 by 6-1/2 by 1/4 inches thick with centrally located 1-3/4 inch hole, welded securely to the top of the side. The spacing between plates shall be adequate

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to insure longitudinal stability during hoisting. The sides shall be adequately hinged to the deck to permit folding onto the deck with no interference with each other or the ends.

3.9.6 Ends. The pallet crate shall be provided with one removable end and one end hinged to a side. If wire fabric is used, maximum spacing between wires shall be 2 inches. The bottoms shall have provision for interlocking with the pallet deck to prevent bulging under load. The removable end shall be hinged at the center to permit the top half to be folded down upon the lower half to facilitate loading and unloading. The top half of the removable end shall be provided with an open type card holder for 5 inch by 8 inch cards, which will permit entries to be read without removal of the card.

3.9.7 Locks. The pallet crate shall be provided with locks to secure the sides and ends in a vertical position. The locking feature shall be positive and shall not disengage under the vibrations and shocks encountered in handling and transportation. The location, spacing, and number of locks shall be adequate to assure that there are no failures, deformations, or permanent sets in any part of the pallet crate evidenced from the pressure of the contained items. It shall be possible to release the lock under the pressure of shifted loads when necessary, but it is not intended to disengage locks under full load since item fall out will result (see 4.4.4 and 4.4.5).

3.9.8 Interchangeability. All parts shall be capable of interchangeable assembly without interference, binding, or misaligning. All parts comprising a permanently joined unit (as by welding) and the unit thus formed shall be capable of interchangeable joining in the assembled unit and assembly.

\*3.10 Protective coating. The Pallet Crate shall be hot-dipped galvanized in accordance with ASTM A386.

\*3.11 Name plate. All pallet crates shall be provided with a name plate securely fastened between the hook eye plates on the side which is on top when the unit is folded. The name plate shall be of metallic material protected against corrosion to assure permanency and legibility during the service life of the pallet crate. It shall meet requirements of MIL-STD-130 and shall include the following information:

PALLET CRATE, AMMUNITION  
SIZE (INCHES)

capacity: "MFR: (Initials or Code Identification)

3.12 Strength, rigidity, stability.

3.12.1 Pushing and towing. The crates after being tested as specified in 4.4.2 shall show no weld failures or distortions of the deck or deck supports.

\*3.12.2 Drop test. After being tested as specified in 4.4.4 the crates shall show no weld failures, or distortions of the deck or deck supports.

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\*3.12.3 Impact test. When tested as specified in 4.4.4, the pallet crate shall show no weld failures or damage which would affect the usability and folding of the pallet crate. The interlock between the ends and pallet deck should not be disengaged. The locks which secure the sides and ends in a vertical position should not disengage during this test.

\*3.12.4 Vibration. When tested as specified in 4.4.5, the crates shall still be capable of containing or supporting the intended contents, and shall not interfere with handling equipment. Further, there shall be no evidence of weld failures or component failures. After this test the locks shall still be capable of being disengaged with load shift against the ends. After testing as specified in 4.4.5.1, there shall be no component failures or distortions that prevent ready assembly or usability.

\*3.12.5 Hoisting. The crate shall contain a load of 20,000 pounds for at least 5 minutes without complete failure or parting of component parts what would permit loss of intended contents when tested as specified in 4.4.5.2.

3.12.6 Proof loading. After testing as specified in 4.5.4.2, the crates shall show no weld failures or component distortions evidenced by visual examinations.

3.13 Workmanship. All surfaces and edges shall be smooth and free from sharp edges, rough spots, and similar defects that could possibly damage the contents of the pallet crates, interfere with loading or unloading, or be a hazard to operating personnel.

3.13.1 Steel fabrication. Steel used in the fabrication of equipment shall be free from breaks and sharp bends. Shearing and clipping shall be done neatly and accurately. Corners shall be squared and true. All bends of a major character shall be made with metal dies or fixtures to insure uniformity of size and shape. Holes shall be accurately punched or drilled and have the burrs removed.

3.13.2 Welders and welding.

3.13.2.1 Welders. Before assigning any welder to work covered by this specification, the contractor shall provide the contracting officer with the names of welders to be employed on the work together with certification (see 6.2.2) that each of these welders has passed qualification tests as prescribed by MIL-STD-248 for the type of welding operation to be performed and that such qualification is effective as defined by the standard. The contractor shall require any welder to retake the tests when in the opinion of the Government inspector the work of the welder creates a reasonable doubt as to his proficiency. Recertification of the welder shall be made to the contracting office only after the welder has taken and passed the required tests.

3.13.2.2 Welding. The surfaces of parts to be welded shall be free from rust, scale, paint, grease, or other foreign matter. Welds shall develop adequate strength in the parts connected to satisfy testing requirements. Welded joint design shall be in accordance with MIL-STD-22.

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#### 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 or order, 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 Inspections. The inspection requirements specified herein are classified as follows:

1. Preproduction Inspection (see 4.3)
2. Production Inspection (see 4.5.1)

4.3 Preproduction Inspection. Preproduction inspection shall consist of the visual inspection of 4.3.2 and the preproduction tests of 4.4. Examination and testing of preproduction samples will be accomplished by the facility designated by the procuring activity and the delivery schedule under the terms of the contract will be automatically extended in an amount equal to, but not exceeding, the time required for such testing and examination.

\*4.3.1 Preproduction Sampling. The first and second pallet crate of each size produced under the terms of the contract shall be submitted as the preproduction sample. The failure of the pallet crate to comply with any of the visual inspections or test requirements shall result in the rejection of the preproduction sample. Rejection shall require submission of the first and second pallet crates of subsequent production corrected to comply with inspection requirements. All pallet crates submitted for inspection purposes shall be provided at the expense of the contractor. Further production of the pallet crates by the contractor, prior to approval of the preproduction sample, shall be at the contractor's risk.

4.3.2 Visual Inspection. Pallet crates shall be inspected visually for conformance with this specification and approved engineering drawings with respect to size, material, provision for handling, tiering, folding, component characteristics, protective coating, name plate, and workmanship.

#### 4.4 Preproduction Tests.

4.4.1 Weight. The pallet crates shall be weighed and shall not exceed the maximum weight for each size specified in 3.5.

\*4.4.2 Pushing and Towing. The pallet crate with a uniformly distributed load of 4000 pounds shall be tested in accordance with the mechanical handling test method 5011 of FED-STD-101. A pallet crate which does not meet the requirements of 3.12.1 shall be rejected.

\*4.4.3 Drop Test. The pallet crate with a uniformly distributed load of 4000 pounds shall be tested in accordance with the edge-wise-drop (rotational) test method 5008, Level A, of FED-STD-101. A pallet crate which does not meet the requirements of 3.12.2 shall be rejected.

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\*4.4.4 Impact test. The pallet crate with a uniformly distributed load of 4000 pounds shall be tested in accordance with the pendulum-impact test method 5012 of FED-STD-101. An alternate test shall be the incline-impact test Method 5023 of FED-STD-101. In either test the speed of impact shall be 10 feet per second. A pallet crate which does not meet the requirements of 3.12.3 shall be rejected.

\*4.4.5 Loaded. The pallet crate with a uniformly distributed load of 4000 pounds shall be tested in accordance with the vibration (repetitive shock) test Method 5019 of FED-STD-101. A pallet crate which does not meet the requirements of 3.12.4 shall be rejected.

\*4.4.5.1 Folded. The folded and bundled crates as shipped when empty (see 5.1.3) shall be tested in accordance with the vibration (repetitive shock) test method 5019 of FED-STD-101. Due to the small number of pallet crates of each size available for testing, this shipping condition may be simulated by filling an open crate with the equivalent weight of four additional empty pallet crates and strapping it onto the folded pallet crate being tested. A pallet crate which does not meet the requirements of 3.12.4 shall be rejected.

\*4.4.5.2 Hoisting. The pallet crate shall be uniformly loaded to 20,000 pounds hoisted from the floor and suspended for 5 minutes. Hoisting shall be accomplished with a suitable strongback or spreader to which are attached four slings with hooks for engaging the pallet crate at the hook eyes. A pallet crate which does not meet the requirements of 3.12.5 shall be rejected.

\*4.4.5.3 Tiering. The pallet crate shall have another crate uniformly loaded to 20,000 pounds superimposed on it for 5 minutes. A pallet crate which does not meet the requirements of 3.7 shall be rejected.

\*4.4.5.4 Tiering Stability The pallet crate shall be placed on an 8 degree slope and another uniformly loaded to 4000 pounds superimposed up it. There shall be no evidence of tier instability such as shifting of the tiered pallet crate. The test shall be repeated with the crates turned 90 degrees from the original position. A pallet crate which does not meet the requirements of 3.7 shall be rejected.

\*4.5 Quality Conformance.

\*4.5.1 Production Inspection. Production inspection shall consist of the visual inspection of 4.5.3 and the acceptance test of 4.5.4.

\*4.5.2 Production Sampling. Unless otherwise specified, sampling shall conform to MIL-STD-105, Level II, acceptance quality level (AQL) 1.0 percent defective. The minimum sample size shall consist of 75 units or the entire lot, whichever is smaller. The failure of an assembly to comply with any of the visual inspection and acceptance test requirements, shall result in the rejection of the lot represented. Unless otherwise specified in the contract or order, all pallet crates submitted for inspection purposes shall be provided at the expense of the contractor.



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4.5.3 Visual Inspection. Pallet crates selected in accordance with 4.5.2 shall be visually inspected for conformance with this specification and approved engineering drawings with respect to size, material, provision for handling, tiering, folding, component characteristics, protective coating, nameplate and workmanship.

4.5.4 Acceptance Tests.

4.5.4.1 Weight. The pallet crates shall be weighed and shall not exceed the maximum weights specified in 3.5.

\*4.5.4.2 Proof Loading. The pallet crate shall be uniformly loaded to 12,000 pounds, hoisted from floor, and suspended for 5 minutes. Hoisting shall be accomplished with a suitable strongback or spreader to which are attached four slings with hooks for engaging the pallet crate at the hook eyes. The pallet crate shall meet the requirements of 3.12.6.

\*5. PACKAGING.

\*5.1 Preservation - Packaging and Packing (See 6.2)

\*5.1.1 Level A. Not applicable.

\*5.1.2 Level B. Not applicable.

\*5.1.3 Level C. The pallet crates shall be prepared for shipment by Method III of MIL-P-116 as follows:

a. The pallet crates shall be shipped with sides and ends folded onto the pallet deck. The crates shall be stacked into bundles with appropriate dunnaging, not exceeding 2,000 pounds, and secured with steel straps.

5.2 Marking.

\*5.2.1 Special Marking. None, unless otherwise specified.

\*5.2.2 Normal Marking. In addition to the marking required by the contract or order, the pallet crates shall be marked in accordance with the requirements of MIL-STD-129.

\*6. NOTES AND CONCLUDING MATERIAL

6.1 Intended use. The pallet crates shall be used in intradepot operations. They will be suitable for containing the following:

- (a) Projectiles, up to and including 6 inches
- (b) Cartridge and powder tanks, up to and including 6 inches
- (c) Boxed Ammunition and components
- (d) Inert items

The size crate selected for each item shall be governed by maximum utilization of crate cube and capacity. The specific ordnance items to be carried by these crates and the manner of loading require prior approval by the cognizant bureau or activity.

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\* 6.2 Ordering data. DD Form 1423 and other related procurement documents should specify the following:

\* 6.2.1 Procurement requirements.

- (a) Title, number and date of this specification
- (b) Size required (see 1.2)
- (c) Preproduction sample (see 4.3.1)
- (d) Activity designated to perform preproduction testing (see 4.1)
- (e) Quantity required (if procuring activity is satisfied with preproduction test)
- (f) Desired level of preservation and packaging (see section 5)

\* 6.2.2 Contract data requirements. The item of deliverable data required by this specification is cited in the following paragraphs:

<u>Paragraph</u>	<u>Data requirement</u>	<u>Applicable DID</u>
3.1, 7.1, 7.2, 7.3 10.1, 10.2	Drawing, Engineering and Associated Lists, Level I, (Conceptual and Developmental Design)	DI-E-7013A
3.1, 7.1, 7.2, 7.3, 10.1, 10.2, 10.3, 10.4	Drawings, Engineering and Associated Lists, Level 2, (Production Prototype and Limited Production)	DI-E-7014A
4.4	Report, Test	DI-T-2072

The DID (Data Item Description/DD Form 1664) for the above data requirement is in the DoD Authorized data list (TD-3). Such data will be delivered as identified on the above cited DID when specified on DD Form 1423 (Contract Data Requirements Lists) and incorporated into applicable contracts.

(Copies of data item descriptions required by the contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

\*6.3 Terms.

\*6.3.1 Inside dimensions. The dimensions of the "basket" or interior stowage space provided by the crate

\*6.3.2 Height (inside). The distance from top of pallet crate deck to top of side or end.

\*6.3.3 Deck support. The vertical members between the runners and pallet deck which support the crate, provide access for materials handling equipment, and whose outer members have tiering capability.

\*6.4 The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the

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Government assumes no liability whatsoever for any inaccuracies in the 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.

\*Note: Information or changes related to this document should be directed to the technical field activity, Naval Weapons Handling Laboratory, Code 806, Earle, Colts Neck, NJ 07722, with a copy to Naval Ordnance Station, Code 611, Indian Head, MD 20640.

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<b>DOCUMENT IDENTIFIER AND TITLE</b>			
MIL-C-21215A (OS) " Crates, Pallet, Ammunition "			
<b>NAME OF ORGANIZATION AND ADDRESS</b>		<b>CONTRACT NUMBER</b>	
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<input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT			
<p>1 HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?</p> <p>A GIVE PARAGRAPH NUMBER AND WORDING</p>    <p>B RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES</p>			
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