

NOTICE OF INACTIVATION
FOR NEW DESIGN

INCH-POUND

MIL-R-28653C
NOTICE 1
22 April 1998

MILITARY SPECIFICATION

REVETMENT KIT, PREFABRICATED MODULAR TYPE; CORRUGATED STEEL PANELS

MIL-R-28653C, dated 14 March 1990, is inactive for new design and is no longer used, except for replacement purposes.

Custodians:

Navy - YD1
Air Force - 99

Preparing activity:

Navy - YD1

AMSC N/A

FSC 5450

DISTRIBUTION STATEMENT A: Approved for public release; distribution is unlimited.

* INCH-POUND *

MIL-R-28653C
14 March 1990
SUPERSEDING
MIL-R-28653C
22 March 1984

MILITARY SPECIFICATION

REVETMENT KIT, PREFABRICATED MODULAR TYPE;
CORRUGATED STEEL PANELS

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

1. SCOPE

1.1 Scope. This specification covers revetment kits, consisting of
prefabricated panels and connecting structures and hardware.

1.2 Classification. When specified, revetment kits will have the following
types and sizes identified by part identifying number (PIN) (see 6.2).

Type 1 - Bolted type.

Size A - 4 feet (ft) by 5.5 ft wide by 50 ft long.
Size B - 5.33 ft high by 9.9 ft wide by 30 ft long.

Type 2 - Pinned type.

Size C - 12 ft high by 5 ft wide by 252 ft long.
Size D - 16 ft high by 7 ft wide by 252 ft long.
Size E - 16 ft high by 7 ft wide by 132 ft long.
Size F - 12 ft high by 5 ft wide by 132 ft long.

* Beneficial comments (recommendations, additions, deletions) and any pertinent*
* data which may be of use in improving this document should be addressed to: *
* Commanding Officer (Code 156), Naval Construction Battalion Center, Port *
* Hueneme, CA 93043-5000, by using the self-addressed Standardization *
* Document Improvement Proposal (DD Form 1426) appearing at the end of this *
* document or by letter. *

AMSC N/A

FSC 5450

DISTRIBUTION STATEMENT A. Approved for public release; distribution is
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2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications and standards. The following specifications and standards form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

PPP-B-636 - Boxes, Shipping Fiberboard.
PPP-T-97 - Tape, Pressure-Sensitive Adhesive, Filament Reinforced.

MILITARY

MIL-P-116 - Preservation, Methods of.

STANDARDS

MILITARY

MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
MIL-STD-2073 - DoD Materiel, Procedures of Development and Application of Packaging Requirements.

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from Military Specifications and Standards, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.1.2 Government drawings. The following Government drawings form a part of this document to the extent specified herein. Unless otherwise specified, the issues are those cited in the solicitation.

DRAWINGS

NAVAL FACILITIES ENGINEERING COMMAND (NAVFAC)

Drawing No. 1109790 - Steel-Bin Type Revetment.
Drawing No. 1109830 - Revetment Kits 12 Foot Height, 16 Foot Height.
Drawing No. 6027505 - Retaining wall, Steel Bin Type.

(Copies of specifications, standards, drawings, publications, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the

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issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents which are current on the date of the solicitation (see 6.2).

ASTM

- ASTM A 108 - Steel Bars, Carbon, Cold Finished, Standard Quality.
- ASTM A 153 - Zinc Coating (Hot Dip) on Iron and Steel Hardware.
- ASTM A 307 - Low-Carbon Steel Externally and Internally Threaded Standard Fasteners.
- ASTM A 123 - Zinc (Hot Dip Galvanized) Coating on Iron and Steel Products.
- ASTM A 444 - Sheet Steel, Zinc Coated (Galvanized) by the Hot Dip Process for Culverts and Under Drains.
- ASTM D 2103 - Polyethylene Film and Sheeting.
- ASTM D 3951 - Commercial Packaging.

(Application for copies should be addressed to the ASTM, 1916 Race Street, Philadelphia, PA 19103.)

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this document and the references cited herein (except for associated detail specifications, specification sheets or MS standards), the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Description. Revetment kits shall consist of preformed structural elements as shown in the applicable figures and drawings. These elements shall interconnect to form vertical earth retaining walls. The bolted revetment kit comes in two sizes. The kit with 4 ft high walls is stackable to 12 ft high. The kit with 5.33 ft high walls is not stackable. The pinned revetment kit comes in four sizes of varying widths, heights, and lengths.

3.1.1 Bolted revetment kit. Unless otherwise specified (see 6.2), the bolted revetment kit shall contain the items listed in table IA or IB.

TABLE IA. Type 1 - size A bolted revetment kit.

* Item	* Figure No.	* Description	* Quantity
	3, 5	Column, 8 gage, 4 ft 0 inch	12
2	3, 4	Stringer, 9.5 ft, 16 gage	30
3	3, 4	Connecting channel, 8 gage	60
4	3, 6	Standard spacer, 5 ft	
		2-3/8 inches long, 16 gage	12

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*	5	*	3, 6	*	Bottom spacer, 5 ft 2-3/8	*		*
*		*		*	inches long, 16 gage	*	6	*
*	6	*	3, 4	*	Base plate, 22 inches by 16	*		*
*		*		*	inches, 1 gage	*	12	*
*	7	*	3	*	Machine bolts with hex nuts	*		*
*		*		*	galvanized 5/8 inch diameter	*		*
*		*		*	by 1-1/4 inch	*	580	*
*	8	*	3	*	Springs nuts 5/8 inch	*	24	*
*	9	*	5	*	Column splice plate, 2 ft	*		*
*		*		*	0 inch long, 10 gage	*	12	*

TABLE IB. Type 1 - size A bolted revetment kit.

* Item	* Figure No.	* Description	* Quantity
* 1	* 3, 5	* Column, 8 gage, 4 ft 4 inch	* 8
* 2	* 3, 4	* Stringer, 9.5 feet long, 16 gage	* 24
* 3	* 3, 4	* Channel, connecting, 9 ft	
		* 7-3/17 inches	* 48
* 4	* 3, 6	* Spacer, standard, 9 ft	
		* 7-3/16 inches, 14 gage	* 12
* 5	* 3, 6	* Spacer, bottom, 9 ft	
		* 7-3/16 inches, 14 gage	* 4
* 6	* 3, 4	* Base plate, 1 plate 16 by	* 8
		* 22 inches	
* 7	* 3	* Bolt machine, 5/8 by 1-1/4	
		* hexagon head	* 502
* 8	* 3	* Spring nuts, 5/8 inch	* 16
* 9	* 8	* Column cap	* 8
* 10	* 9	* Stiffeners, stringer, 9.5 ft	
		* long, 10 gage	* 6
* 11	*	* Nut, hexagon, steel, cadmium	
		* 5/8 - 11 UNC	*

3.1.2 Pinned revetment kit. Unless otherwise specified (see 6.2), the pinned revetment kits shall contain the items listed in table II.

TABLE II. Type 2 - pinned revetment kit.

* Item	* Figure No.	* Description	* Assy mark	* Size C	* Size D	* Size E	* Size F
* 1	* 11, 15	* Side panel 0.060 inch by					
		* 36 inches by 12 ft					
		* 1-1/2 inches	* SP123	* 168	* 168	* 88	* 88
* 2	* 11, 15	* Side panel 0.075 inch by					
		* 24 inch by 12 ft					
		* 1-1/2 inches	* SP122	* 84	* 44		
* 3	* 12, 15	* Cross panel 0.060 inch by*					

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*	*	* 36 inches by 5 ft	*	*	*	*	*	*
*	*	* 2-1/2 inches	* CP73A	* 264	*	*	* 122	*
*	4	* 12, 15 * Cross panel 0.060 inch	*	*	*	*	*	*
*	*	* by 36 inches by 5 ft	*	*	*	*	*	*
*	*	* 10-1/2 inches	* CP73B	*	* 216	* 108	*	*
*	5	* 12, 15 * Cross panel 0.075 inch	*	*	*	*	*	*
*	*	* by 24 inches by 6 ft	*	*	*	*	*	*
*	*	* 10-1/2 inches	* CP72	*	* 108	* 54	*	*
*	6	* 12, 15 * End cross panel 0.060	*	*	*	*	*	*
*	*	* inch by 36 inches by	*	*	*	*	*	*
*	*	* 6 feet 10-1/2 inches	* CP73C	*	* 48	* 32	*	*
*	7	* 12, 15 * End cross panel 0.075	*	*	*	*	*	*
*	*	* inch by 24 inches by	*	*	*	*	*	*
*	*	* 6 ft 10-1/2 inches	* CP72C	*	* 24	* 16	*	*
*	8	* 12, 15 * End Plate panel	*	*	*	*	*	*
*	*	* 0.060 inch by 36 inches	*	*	*	*	*	*
*	*	* by 4 feet 1-1/4 inches	* BP43	*	* 24	* 16	*	*
*	9	* 12, 15 * End brace panel	*	*	*	*	*	*
*	*	* 0.075 inch by 24 inches	*	*	*	*	*	*
*	*	* by 4 feet 1-1/4 inches	* BP42	*	* 12	* 8	*	*
*	10	* 14, 16 * Pin, connecting 36 inches*	*	*	*	*	*	*
*	*	* by 1/4-inch diameter	* P3	* 532	* 580	* 320	* 320	*
*	11	* 14, 16 * Pin, connecting 24 inches*	*	*	*	*	*	*
*	*	* by 1/4-inch diameter	* P2	*	* 292	* 160	*	*
*	12	* 14 * Tool, flaring, hand	*	*	* 3	* 3	* 3	* 3
*	*	* Film, polyethylene	*	*	*	*	*	*
*	*	* 4 ft by 150 feet by	*	*	*	*	*	*
*	*	* 0.006 inch	*	*	* 1	* 2	* 1	* 1

3.2 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.2.1 and 6.4).

3.3 Interchangeability. All units of the same classification furnished with similar options under a specific contract shall be identical to the extent necessary to insure interchangeability of component parts, assemblies, accessories, and spare parts.

3.4 Drawings and figures. Drawings and figures forming a part of this document are engineering design references. The contractor is responsible for preparing his own shop drawings. Where tolerances prescribed could cumulatively result in incorrect fits, the contractor shall provide tolerances within those prescribed on the drawings and figures to insure correct fit and assembly of the items. No deviation from the prescribed dimensions or tolerances is permissible without prior written approval of the contracting officer.

3.5 Materials. Materials used shall be free from defects which would adversely affect the performance or maintainability of individual components or of the overall assembly. Materials not specified herein shall be of the same quality used for the intended purpose in commercial practice. Unless otherwise specified herein, all equipment, material, and articles incorporated in the work covered by this specification are to be new and fabricated using materials produced from recovered materials to the maximum extent possible without

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jeopardizing the intended use. The term "recovered materials" means materials which have been collected or recovered from solid waste and reprocessed to become a source of raw materials, as opposed to virgin raw materials. Unless otherwise specified, none of the above shall be interpreted to mean that the use of used or rebuilt products are allowed under this specification.

3.5.1 Steel sheets and plates. Steel sheets and plates shall conform to ASTM A 444. The gage shall be as specified in the applicable figures or drawings or as specified herein.

3.5.2 Polyethylene sheeting. Polyethylene sheeting shall be 48 inches wide by 0.006 inch thick polyethylene conforming to ASTM D 2103.

3.6 Construction.

3.6.1 Bolted revetment kits. The bolted revetment kit shall consist of preformed stringers, columns, spacers, channels, and plates as described in tables IA and IB. The parts shall be fabricated and punched or drilled for field assembly as shown in figures 1 through 7 and NAVFAC Drawing No. 1109790 and 6027505, as applicable. Six stringers, four standard spacers, two bottom spacers, 12 connecting channels, four column and four base plates plus nuts and bolt shall form a basic section. Sections may be bolted together horizontally to form the desired configuration. Size A sections may be stacked vertically to heights of 8 ft or 12 feet using column splice plates (item 9) to fasten columns (item 1) together as shown in figures 1 and 7. The size A kit shall provide material for a section of revetment 50 ft long by 5.5 ft wide by 4 ft high (five sections 10 ft long). The size B kit shall provide material for a section of revetment 30 ft long by 9.9 ft wide by 5.33 ft high (three sections 10 ft long).

3.6.1.1 Bolts and nuts. Bolts and nuts shall be hexagon head 5/8 inch, conforming to ASTM A 307 and shall be hot-dip zinc coated in accordance with ASTM A 153. Lacquered spring nuts made of high tensile steel shall be furnished for all base plate bolts as shown in figure 3.

3.6.2 Pinned revetment kits. The pinned revetment kits shall consist of preformed steel side panels and cross panels, predrilled and notched for field assembly, with the connecting pins as described in table II and as shown in figures 10 through 16 and NAVFAC Drawing No. 1109830. Two side panels and four cross panels form a basic module which is pinned to adjoining sections or stacked on other sections to form various revetment configurations. A supply of polyethylene film shall be provided to prevent leakage of filler material at the end joints. Size C provides a revetment 5 ft wide by 252 ft long by 12 ft high (four tiers, 3 ft high each). Size D provides a revetment 7 ft wide by 252 ft long by 16 ft high (two tiers, 2 ft high each and four tiers, 3 ft high). Size E provides a revetment 7 ft wide by 132 ft long by 16 ft high. Size F provides a revetment 5 ft wide by 132 feet long by 12 ft high.

3.6.2.1 Joint connecting pins. Joint connecting pins shall be cold-finished steel bars conforming to ASTM A 108, grade 1020, and shall be zinc coated in accordance with ASTM A 123 (see figure 12).

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3.6.2.2 Flaring tool. The flaring tools shall be either cast steel with a steel rod handle, or formed steel with a pipe handle (see figure 12).

3.7 Identification marking. Identification shall be permanently and legibly marked directly on the side panel or on a corrosion-resisting metal plate securely attached to the side panel at the source of manufacturer. Identification shall include the manufacturer's model and serial number, name and trademark to be readily identifiable to the manufacturer.

3.8 Workmanship.

3.8.1 Steel fabrication. The steel used in fabrication shall be free from kinks, sharp bends, and other conditions which would be deleterious to the finished product. Manufacturing processes shall not reduce the strength of the steel to a value less than intended by the design. Manufacturing processes shall be done neatly and accurately. All bends shall be made by controlled means to insure uniformity of size and shape.

3.8.2 Bolted holes. Bolt holes shall be accurately punched or drilled and shall have the burrs removed. Washers or lockwashers shall be provided in accordance with good commercial practice, and all bolts, nuts, and screws shall be tight.

3.8.3 Castings. All castings shall be sound and free from patching, misplaced coring, warping, or any other defect which reduces the castings ability to perform its intended function.

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 (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase 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 this document where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items must meet all requirements of sections 3 and 5. The inspection set forth in this document shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the document shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.1.2 Component and material inspection. Components and materials shall be inspected in accordance with all the requirements specified herein and in applicable referenced documents.

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4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.2.1).
- b. Quality conformance inspection (see 4.2.2).

4.2.1 First article inspection. The first article inspection shall be performed on revetment kits when a first article is required (see 3.2 and 6.2). This inspection shall include the examination of 4.4 and the tests of 4.5. The first article may be either a first production item or a standard production item from the supplier's current inventory provided the item meets the requirements of this document and is representative of the design, construction, and manufacturing technique applicable to the remaining items to be furnished under the contract.

4.2.2 Quality conformance inspection. The quality conformance inspection shall include the examination of 4.4, the tests of 4.5, and the packaging inspection of 4.6. This inspection shall be performed on the samples selected in accordance with 4.3.

4.3 Sampling. Sampling and inspection procedures (see 6.5).

4.4 Examination. Each sample selected shall be examined for compliance with section 3 of this document. Examination shall be conducted as specified in table III.

TABLE III. Classification of defects.

* Classification *	* Defects	* Paragraph	* *
* 101	* Design and construction not as	* 3.1, 3.1.1,	* *
* *	* specified; dimensions not as shown in	* and 3.1.2	* *
* *	* figures 1 through 16.	* 3.3	* *
* *	* *	* 3.5, 3.5.1,	* *
* 102	* Parts not functionally and dimensionally	* 3.5.2	* *
* *	* interchangeable.	* 3.6.1, 3.6.1.1,	* *
* 103	* Materials not as specified.	* 3.6.2, 3.6.2.1,	* *
* *	* *	* 3.6.2.2	* *
* 104	* Construction not as specified.	* 3.7	* *
* *	* *	* 3.8	* *
* 105	* Marking not as specified.	* 3.9.1, 3.9.2,	* *
* 106	* Technical manuals not in accordance with	* 3.9.3	* *
* *	* requirements.		
* 107	* Workmanship not as specified.		
* *	* *		

4.5 Tests. Unless otherwise specified (see 6.2), tests shall be performed only on the first article, when a first article is required. This test shall be as follows: A test section shall be constructed to test the structural strength and general performance of the wall. An assembled basic section or module of the kit being offered for delivery shall be filled with sand and

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saturated with water. The test section shall then be dismantled and inspected for any damage. Buckling of the walls, tearing of any holes, or inability to assemble or disassemble the section without modification or damage shall be cause for rejection.

4.6 Packaging inspection. The preservation, packing, and marking of the item shall be inspected to verify conformance to the requirements of section 5.

5. PACKAGING

5.1 Preservation. Preservation shall be level A or commercial, as specified (see 6.2).

5.1.1 Level A.

5.1.1.1 Cleaning and drying. Prior to the application of preservative compounds or paint, surfaces shall be cleaned by process C-1 and dried by any applicable procedure of MIL-P-116.

5.1.1.2 Structural members. Structural members, of like description, such as pins, connecting channels, base plates, spacers, and stringers shall be either bundled or boxed. When bundling, the items shall be secured with tape conforming to PPP-T-97 or soft annealed wire. Boxed items shall be packaged in close-fitting boxes conforming to PPP-B-636, class weather-resistant and cushioned, blocked, or braced to prevent movement.

5.1.1.3 Bolts with nuts and spring nuts. Bolts with nuts and spring nuts of like description shall be package in close-fitting boxes conforming to PPP-B-636, class weather-resistant. The items shall be cushioned to prevent movement.

5.1.1.4 Polyethylene sheeting. Each roll of polyethylene sheeting shall be packaged in a close-fitting box conforming to PPP-B-636, class weather-resistant.

5.1.1.5 Tools. Unprotected metal surfaces of the tools shall be coated with type P-1 preservative in accordance with MIL-P-116. Tools shall be packaged in close-fitting boxes conforming to PPP-B-636, class weather-resistant.

5.1.1.6 Technical publications. Technical publications shall be preserved in accordance with MIL-P-116, method IC-1.

5.1.2 Commercial. The equipment shall be preserved in accordance with ASTM D 3951.

5.2 Packing. Packing shall be level A or commercial, as specified (see 6.2.1).

5.2.1 Level A. Packing shall be in accordance with the level A requirements of MIL-STD-2073. Container shall be selected from table VII of MIL-STD-2073.

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5.2.2 Commercial. The complete revetment kit shall be packed in accordance with ASTM D 3951.

6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. Modular type corrugated steel bin revetment kits provide a means of containing vertical walls of earth for protection of personnel and combat equipment against enemy attack.

6.2 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this document.
- b. Type and size required identified by PIN (see 1.2).
- c. Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- d. When kits should contain items other than as listed in tables (see 3.1.1 and 3.1.2).
- e. When first article is required for inspection and approval (see 4.2.1).
- f. When test are required for other than the first article (see 4.5).

6.3 Data requirements. When this document is used in an acquisition and data are required to be delivered, the data requirements should be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the approved Contract Data Requirements List (CDRL), incorporated into the contract. When the provisions of DOD FAR Supplement, Part 27, Sub-Part 27.475-1 (DD Form 1423) are invoked and the DD Form 1423 is not used, the data should be delivered by the contractor in accordance with the contract or purchase order requirements.

6.4 First article. When a first article inspection is required, the item should be tested and should be a first production item or it may be a standard production item from the contractor's current inventory as specified in 4.2.1. The first article should consist of one unit. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, test, and approval of the first article.

6.5 Sampling. Sampling and inspection procedures should be in accordance with MIL-STD-105. All revetment kits of the same type and size offered for delivery at one time should be considered a lot for the purpose of inspection. The inspection level should be level II and the Acceptable Quality Level (AQL) should be 4.0 percent defective. If an inspection lot is rejected, the contractor may rework it to correct the defects, or screen out the defective units, and resubmit for complete reinspection. Resubmitted lots should be reinspected using tightened inspection. If the rejected lot was screened, reinspection should be limited to the defect causing rejection. If the lot was reprocessed, reinspection should be preformed for all defects. Rejected lots

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should be separate form new lots, and should be clearly identified as reinspected lots.

6.6 Reference data. The figures and bill of materials in this document are based on NAVFAC Drawings 1109790, 1109830, and 0027505.

6.7 Pin or identifying number (PIN). Revetment kits shall have the following types and sizes identified by PIN.

- MIL-R-28653-1A - Bolted type, 4 ft high by 5.5 ft wide by 50 ft long.
- MIL-R-28653-1B - Bolted type, 5.33 ft high by 9.9 ft wide by 30 ft long.
- MIL-R-28653-2C - Pinned type, 12 ft high by 5 ft wide by 252 ft long.
- MIL-R-28653-2D - Pinned type, 16 ft high by 7 ft wide by 252 ft long.
- MIL-R-28653-2E - Pinned type, 16 ft high by 7 ft wide by 132 ft long.
- MIL-R-28653-2F - Pinned type, 12 ft high by 5 ft wide by 132 ft long.

6.8 Subject term (key word) listing.

- Retaining Walls
- Revetment Shelters
- Embankment Walls
- Prefabricated Steel Panels

6.9 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue, due to the extensiveness of the changes.

Custodians:
Navy - YD
Air Force - 99

Preparing activity:
Navy - YD

(Project 5450-0023)

Review activity:
Air Force - 84