

~~SECRET (25660)~~  
SC 2094 (CP)

Orig. page 1

~~Security Information~~

SANDIA SYSTEMATIC DECLASSIFICATION REVIEW		PACKAGING PROCEDURE
1 <sup>st</sup> Review Date: <u>1-02-97</u>	Authority: <input type="checkbox"/> ADC <input checked="" type="checkbox"/> ADP	Name: <u>W. Keyn</u>
2 <sup>nd</sup> Review Date: <u>2/20/97</u>	Authority: <u>ADP</u>	Name: <u>B.R. Green</u>
1. Classification Required: <u>U</u> 2. Classification Changed to: 3. Contains No. 100 Classified Information: 4. Contains With: 5. Contains UCAT: 6. Comments:		FOR
		B-61 TRAINING UNITS

INVENTORIED  
MAR 1 1966

3428-3

SANDIA SYSTEMATIC DECLASSIFICATION REVIEW DOWNGRADING OR DECLASSIFICATION STAMP	
CLASSIFICATION CHANGED TO: <u>U</u>	AUTHORITY: <u>Bruce Green</u>
PERSON CHANGING MARKING: <u>Emelda Selph 3/4/97</u>	RECORD ID: <u>925N258</u>
PERSON VERIFYING MARKING & DATE: <u>Carmel M. Delligos 3/11/97</u>	DATED: <u>2-20-97</u>

Inventoried  
Septemb. 1960  
INVENTORIED

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AUG 1 1963

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SC-2094 (CP)  
Original page 2  
October 12, 1951  
PER 11,888

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SC-2094 (CP)  
Original page 4  
October 12, 1951  
PER 11,888

APPLICABLE SPECIFICATIONS

- GENERAL METHODS OF CLEANING AND PACKAGING.....SC-1665(CP)
- STANDARD OPERATION PROCEDURES FOR EXTERIOR IDENTIFICATION MARKING OF CONTAINERS..SC-1846(CP)

CONTAINERS USED

CONTAINER NO.	METHOD OF PACK	AAF OR NAVY STOCK NO.	STOCK NO. & D'G. NO.	APPLICABLE SPEC.	SIZE	PACKAGING PROCEDURE
B 1/3	II	-----	106187	-----		See Appendix I.
B 2/3	I		201859			Pkg. #1 & #2 strapped to pallet.
Package #1	I			200858		See Appendix III.
Package #2	I			106049		See Appendix III.
B 3/3	IIId	6700-210340	801458	AN-8024-1	14.69 H x 10.50 dia.	See Appendix II.

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UNCLASSIFIED

SC-2094 (CP)  
Original page 5  
October 12, 1951  
PER 11,888

MATERIALS USED  
FOR  
B 1/3 - B 3/3

NO.	ITEM	STK. NO.	APP. SPEC.	QTY.	USE
1*	Tape Aluminum Foil 2" wide	806361	Commercial	50 ft.	Used to seal Unit as specified in App. I.
2*	Wadding Creped Cellulose, Type V	802551	AN-V-18a	25 sq. ft.	Used for B 2/3 & B 3/3.
3	Dessicant (activated) Grade A, Type V	800153	JAN-D-169	50 lbs.	See Appendix I, para. 2.
		or 800155			
		800154	"	8 oz.	Place in B 3/3 Container.
4	Envelopes	809751	Commercial	4	As called for in packaging procedures.
5	Envelopes	809749	"	1	" " " " " " "
6*	Greaseproof paper Grade A, Type 1, Class 1	809875	JAN-B-121	7 sq. ft.	Used as called for.

\* These material amounts are approximations and should be adjusted in accordance with production findings. However, sufficient materials shall be used to insure proper packaging.

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SC-2094 (CP)  
Original page 6  
October 12, 1951  
PER 11,388

PACKAGING PROCEDURE

MAJOR MECHANICAL ASSEMBLY

B 1 of 3

CONTENTS

NO.	ITEM	STK. NO.	QTY.	METHOD OF PACK	METHOD OF CLEANING	PACKAGING PROCEDURE
1	Unit LK 6 Mod 1 Training Unit-----		1	II	Cl	See Appendix I.
	a. Type I	925372				
	b. Type II	925373				
	c. Type III	925374				
	d. Type IV	925377				

B 2/3 (REJECT SPARE CASTINGS)

CONTENTS

NO.	ITEM	STK. NO.	QTY.	METHOD OF PACK	METHOD OF CLEANING	PACKAGING PROCEDURE
PKG. #1	I.P. Block Assembly T.D.	925277	1	I	Cl	See Appendix III.
PKG. #2	O.P. Block Assembly T.D.	925278	1	I	Cl	See Appendix III.

B 2/3 (CONCRETE CASTINGS)

PKG. #1	I.P. Block Assembly T.D.	Y-6876 D13	1	I	Cl	See Appendix IV.
PKG. #2	O.P. Block Assembly T.D.	Y-6876 D12	1	I	Cl	" " "

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SC-2094 (CP)  
Original page 7  
October 12, 1951  
PER 11,888

PACKAGING PROCEDURE  
BOMB PARTS CONTAINER  
B 3 of 3  
CONTENTS

NO.	ITEM	STK. NO.	QTY.	METHOD OF PACK	METHOD OF CLEANING	PACKAGING PROCEDURE
1	Desiccator Assembly	575000	6	0	C1	See Appendix I, par. 4. Wrap in cushioning material.
2	Desiccator Mask Assembly	575765	6	0	C1	Place in envelope S/N 809751.
3	Puller Assembly	575592	2	0	C1	" " " S/N 809749.
4	Cable CF-609	200835	1	0	C1	Wrap in Grade A greaseproof paper
5	Safety Wire (24" long)	800135	2ea (24")	0	C5	Place in envelope S/N 809751,
6	Lift Lug Special	106892	1	0	C5	Wrap in Grade A greaseproof paper.
7	Strap Assembly	577302	1	0	C1	Place in container.
8	Vinyl Plastic Tape	800148	1	1A-8	C1	Place in moisture proof barrier sleeve, size 7" x 7" I.D.
9	Wire, safing 8"	800135	1	0	C1	Place in envelope, S/N 809751.
SPARES						
1	Desiccant Mask Assembly	575765	6	0	C1	Place in envelope S/N 809751
2	Desiccator Assembly	575000	6	0	C1	Wrap individually in cushioning material.

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DC-2094 (CP)  
Original page 8  
October 12, 1951  
PER 11,888

APPENDIX I

Procedure for Loading MK 6 Units in the Modified H/T Crate, Drawing No. 102408.

Assuming the crate is completely assembled:

- a. Remove the end panels and then remove the remaining panels from the skid by means of a sling and store aside.
- b. By utilizing the access obtained by (a), remove both Lug Guide Adapters, Drawing No. 101940, from the Lug Guides, Drawing No. 101537.
- c. Assemble the Lug Guide Adapter to the rear tie-down fitting of the unit.
- d. Align the longitudinal axis of the crate with the longitudinal axis of the unit.
- e. Install the Offset Hook Adapter, H-9, Drawing No. 101759, to permit the unit to be raised in a level attitude.
- f. Move the unit into the crate with the nose end entering first.
- g. When the nose of the unit is approximately 2" from the inside surface of the front panel, the shear pin cavity of the unit should be aligned with the shear pin in the crate base and the Lug Guide Adapter should be approximately in line with the Lug Guide which will guide the shear pin into the shear pin cavity.
- h. The unit should be lowered carefully with one person observing each Lug Guide Adapter to insure that it is properly entering the Lug Guide and to prevent the shear pin inadvertently damaging the unit.
- i. Again utilizing the access obtained by (c), insure that the Nut Retainer is in place on the clevis. Assemble the tie-down clevis, Drawing Nos. 101924, 101923, and 102435. To facilitate this assembly, it is suggested that the clevis be raised to engage the tie-down fitting to permit the assembly of the Toggle Pin, Drawing No. 102409. At this time,

UNCLASSIFIED

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SC-2094 (CP)  
Original page 9  
October 12, 1951  
PER 11,888

The nut should be tightened as much as possible by hand, the complete tightening will require the use of a wrench. This procedure will have to be repeated for all four Clevis Assemblies.

1. Replace all panels.

2. Tape shall be applied over all openings of the MK 6 Unit: this includes split band, pullout cable holes, manifold and desiccator holes. Cover assembly 100654 shall be used whenever available, and shall be installed over taping. 35 lbs. of Silica Gel shall be placed in the rear case, and 15 lbs. in the Nose. This may be either 1 lb. or 5 lb. bags, depending on which is available. Stenciling shall be in accordance with 108665.

APPENDIX II

1. The Bomb spares shall be packaged in the bottom of the container. The desiccators shall form a circle on the inside of the container and the other items shall be packaged in the center of this circle.

2. Cushioning material should be placed on the top of the Bomb spares prior to packaging the Bomb parts. The remaining components shall be packaged with the small items packaged as near the top as possible.

3. The bomb should be stenciled in 1 inch high letters "Training Unit, Type No." on two sides of the rear case in the center. The sphere should also be stenciled in one inch high letters "Training Unit, Type No." in two places readily visible.

UNCLASSIFIED

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4. Stencil the weight of the unit and weight of T.D. Castings in B 2/3 (minus the weight of silica gel and split cover on the M.F.) on the rear case as follows:

Stencil to read in 1" high letters:

WT. BOMB  
LESS FUZE

This stencil is to appear on both sides of the unit 1" aft of the chocking area band and 1" above the stencil reading "Chock Area".

5. Place the B Inspection Record sheet in an 8 - 3/4" x 12" manila envelope and tape in the R.C. between the second and third rib on the bottom, using a grade A, B or C tape.

UNCLASSIFIED

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UNCLASSIFIED

SC-2094 (CP)  
Original page 11  
October 12, 1951  
PER 11,888

APPENDIX III

1. Spare reject castings shall be packed in box 200858 (or 205537 Navy Bureau of Ordnance box) for the small inner casting and box 106049 (or 200539 Navy Bureau of Ordnance box) for the large outer casting. Both boxes shall then be strapped to the skid, dwg. 201859.
2. The castings shall be packed in the boxes with sufficient cushioning material to allow no movement or rattle.
3. The following stenciling shall appear on both containers.  
B - 2/3 Pkg. No. \_\_\_\_\_  
S/N \_\_\_\_\_  
The letters shall be 1/2" high and appear in the upper left hand corner on the top and two sides.
4. Stenciling Paint shall be in accordance with that specified in SC-1846 (CP).

APPENDIX IV

1. Concrete castings shall be packed in box 200858 (or 205537 Navy Bureau of Ordnance box) for the small inner casting and box 106049 (or 200539 Navy Bureau of Ordnance box) for the large outer casting. Optional boxes may be used constructed as a Style A Box, inside dimensions approximately the same as 200858 and 106049, and containing chocks cushioned with felt to support the casting. These boxes are not to be strapped to the skid.
2. The castings shall be packed in the boxes with sufficient cushioning material to allow no movement or rattle.
3. The following stenciling shall appear on both containers.  
S/N \_\_\_\_\_  
UNIT NO. \_\_\_\_\_  
The letters shall be 1/2" high and appear in the upper left hand corner on the top and two sides.
4. Stenciling Paint shall be in accordance with that specified in SC-1846 (CP).

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GC 6512 (0-51)

SHEET 1 OF 1 SHEETS

PECR OR

PER No. 11,888

ENG. RELEASE NO.

SANDIA CORPORATION

DATE 26 December 1951

PRODUCTION ENGINEERING RELEASE

TITLE Packaging Procedure for B61 Training Units			UNIT CODE B 61D		NEW DESIGN	OTHER (SPECIFY)
NO.	ISSUE	REPLACES	ISSUE	NEXT ASSEMBLY	REV. DESIGN	Publication
	SC-2094 (CP)	Orig				QUAN.

CLASS OF CHANGE	EFFECTIVE DATE	TYPE OF CHANGE	DISPOSITION OF REPLACED MATERIALS	ESTIMATED COST CHANGE		REQ'D FOR QUAN.
				UNIT	NEW ITEM	
A	X X X X	MARK		\$	<input type="checkbox"/>	KIT
B		MOD	USE	\$	<input type="checkbox"/>	LOT
C		ALT	REWORK	\$	<input type="checkbox"/>	GROUP
D	X X X X	SERIES	SCRAP	\$	<input type="checkbox"/>	SPARES

This PER releases SC-2094 (CP) Packaging Procedure for the B-61 Training Units.

Reason for Issue: To provide Packaging Specifications for B-61 Training Units.

AFFECTED		ITEM	TARGET DATE	PER NO.	INITIALS	AFFECTED		ITEM	TARGET DATE	PER NO.	INITIALS
YES	NO					YES	NO				
	X	Parts List (Basic)			PEP		X	Testing Equipment			PEP
		Alteration Order						Spares			
		Mester Sched. List						Tools or Gages		XX	
		IMI'S				X		Inspection		XX	
		TIS's					X	Interchangeability		XX	
		Data Books						Stock Numbers		XX	
		Specifications						"C" Retroactive		XX	
		Catalogs									
		Packaging									
		Next Assembly									

APPROVALS

PRELIMINARY APPROVALS				DATE		PER NO.	
PEP	<i>P.E. Pearson</i>					11,888	
<i>ABJ</i>	2112-3 AFF	ORG. 2112 2113	DISTRIBUTION 2110 #4 less Sugar & Orange				

*L. J. Biskner*  
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