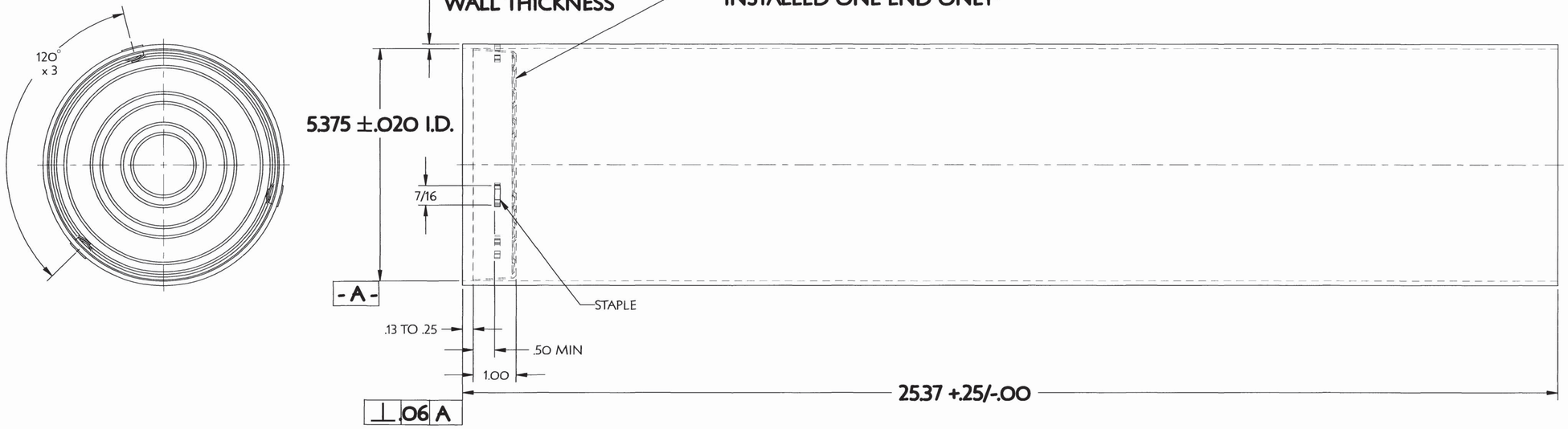
REVISIONS				
LTR	DESCRIPTION		DATE	DAT
A	MATERIAL TOL. SPECIFIED	D. BADE	10/20/2011	



*-STAPLE THE INSTALLED END PLUG IN 3 PLACES APPROXIMATLY 120° APART. STAPLE FROM THE OUTSIDE IN. STAPLE TO BE WELL CLINCHED ON THE INSIDE OF THE METAL END PLUG.

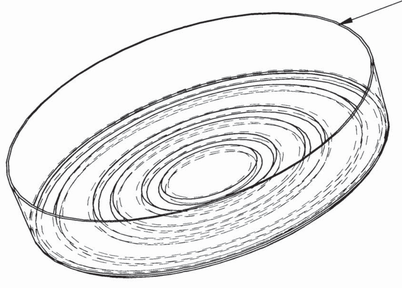
- STAPLES: No. 8, 7/16" CROWN, 1/2" LEG

- STAPLES WILL BE PLACED AS DEEP AS POSSIBLE UP INTO THE PLUG. THEY WILL BE LOCATED AT LEAST 1/2" IN FROM THE EDGE OF THE METAL PLUG AS SHOWN (NOT FROM THE END OF THE TUBE).

- THE CROWN OF THE STAPLE ON THE OUTSIDE OF THE TUBE WILL PRESS SECURELY AGAINST THE OUTSIDE OF THE TUBE SO THAT IT IS A MAXIMUM THICKNESS OF THE STAPLE WIRE ABOVE THE OUTSIDE CIRCUMFERENCE OF THE TUBE.

- THE STAPLE CROWN MAY INDENT THE TUBE BUT IT WILL NOT CUT INTO THE TUBE EXTERIOR.

1. APPLY A 0.005" THICK MOISTURE RESISTANT SILVER FOIL WRAP TO THE EXTERNAL OF THE TUBE.
2. BOTH END PLUGS SHOULD BE METAL AND FIT TIGHTLY
3. THE TUBE SHOULD BE CONSTRUCTED OUT OF 0.095" WALL THICKNESS CHIPBOARD.
4. INTERIOR SHALL BE LINED WITH A 0.005" THICK SILICONE COATED KRAFT.
5. TUBES WILL WITHSTAND A LONGITUDINAL CRUSH FORCE OF AT LEAST 1,400 LBS WHEN TESTED ON A COMPRESSION FORCE TEST MACHINE USING AN APPROACH VELOCITY OF 20" PER MINUTE. THE FORCE IS CENTERED OVER THE TUBE ENDS AND APPLIED THROUGH METAL PLATES PLACED OVER EACH TUBE END..
6. ENDS OF TUBE WILL BE SQUARE CUT.



METAL SERATED END PLUG PROVIDED.
2 EA. REQ'D. 1 INSTALLED AS SHOWN AND 1 SEPERATE FOR FIELD INSTALLATION

SERRATED METAL PLUG TO BE:

A. 5.375" DIA.

B. 5.445" FLARE

C. 1.000" DEPTH

D. MADE 126 GAUGE COLD ROLLED STEEL (INDUSTRY STANDARD .0159 TO .0199 THICK)

ONE SUPPLIER IS AMCLO GROUP, INC.

Shipping Notes:
- Tubes to be packed and shipped 192 total per pallet with 64 per row at three rows tall (max).
- All four vertical corners having 3"x3" - 0.120" thick fiberboard/ laminated Edge Protectors. Each horizontal row, bottom and top must be covered and protected with single wall 200lb test corrugated cardboard sheet or equivalent. Secure all as required to pallet with shrink wrap.
- Pallet to be 40"x48"

FIRST USED IN BUILDING 2728 AS GRENADE TUBE FOR D563, 155mm PROJECTILE DEMIL. THE 88 EACH GRENADES ARE PUSHED INTO THIS TUBE. DRAWING TAKEN FROM SKETCH #SO359.

Verify that this is the most current version of document prior to use.

Distribution Statement: "A"
Approved for public release: distribution unlimited

ITEM NO.	NOMENCLATURE	NO. REQD	MATERIAL
BREAK ALL SHARP EDGES	UNLESS OTHERWISE NOTED, TOLERANCES ARE DECIMALS: .XXX ± .005, XX ± .01, X ± .1 ANGLES ±30'		

FOR DRAWING NO.

TITLE **GRENADE TUBE FOR D563 155mm PROJECTILE DEMIL**

CRANE ARMY AMMUNITION ACTIVITY
ENGINEERING DIVISION

CHECKED BY		DATE	4/20/05
FABRICATION		DATE	4-28-05
SAFETY		DATE	5-13-05
APPROVAL		DATE	5/16/05
DRAWN BY	RJ WILSON	SCALE	D
DATE	19 APR 2005	DWG. NO.	9829
		SHEET	1 OF