



Designation: E1977 – 18

Standard Specification for Shelter, Tactical, Expandable, One-Side¹

This standard is issued under the fixed designation E1977; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers a rigid wall, one-side expandable shelter constructed of aluminum-faced, nonmetallic honeycomb sandwich panels, and meeting the International Organization for Standardization (ISO) Cargo Container specification in the transport mode. Nominal dimensions when closed (container mode) are: height 8 ft, width 8 ft, and length 20 ft (2.4 by 2.4 by 6.1 m) Approximate dimensions, when expanded (shelter mode) are: height 8 ft, width 15 ft, and length 20 ft (2.4 by 4.6 by 6.1 m).

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 The following precautionary statement pertains to the test method portion only. Section 7, of this specification; *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determines the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

E864 Practice for Surface Preparation of Aluminum Alloys to Be Adhesively Bonded in Honeycomb Shelter Panels

¹ This specification is under the jurisdiction of ASTM Committee E06 on Performance of Buildings and is the direct responsibility of Subcommittee E06.53 on Materials and Processes for Durable Rigidwall Relocatable Structures.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

E865 Specification for Structural Film Adhesives for Honeycomb Sandwich Panels

E866 Specification for Corrosion-Inhibiting Adhesive Primer for Aluminum Alloys to Be Adhesively Bonded in Honeycomb Shelter Panels

E874 Practice for Adhesive Bonding of Aluminum Facings to Nonmetallic Honeycomb Core for Shelter Panels

E990 Specification for Core-Splice Adhesive for Honeycomb Sandwich Structural Panels

E1091 Specification for Nonmetallic Honeycomb Core for Use in Shelter Panels

E1749 Terminology Relating to Rigid Wall Relocatable Shelters

E1773 Practice for Sealing Rigid Wall Tactical Shelters with Polysulfide Based Sealants

E1826 Specification for Low Volatile Organic Compound (VOC) Corrosion-Inhibiting Adhesive Primer for Aluminum Alloys to Be Adhesively Bonded

E1925 Specification for Engineering and Design Criteria for Rigid Wall Relocatable Structures

2.2 *ANSI/ASQ Standard:*³

ANSI/ASQ Z1.4-2003 (R2013) Sampling Procedures and Tables for Inspection by Attributes

2.3 *AWS Standard:*⁴

AWS D17.1/D17.1M Specification for Fusion Welding of Aerospace Applications

2.4 *ISO Standards:*⁵

ISO 1161-1980 Series 1-Freight Containers-Corner Fittings, Specification

ISO 1496/I Series 1-Freight Containers-Specification and Testing Part I-General Cargo Containers

ISO 9001 Quality Systems—Model for Quality Assurance in Design, Development, Production, Installation, and Servicing

³ Available from American Society for Quality (ASQ), 600 N. Plankinton Ave., Milwaukee, WI 53203, <https://www.asq.org>.

⁴ Available from American Welding Society (AWS), 8669 NW 36 St., #130, Miami, FL 33166-6672, <http://www.aws.org>.

⁵ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

2.5 *Military Standards:*⁶

MIL-STD-129 Marking for Shipping and Storage

MIL-STD-810G Environmental Engineering Considerations and Laboratory Tests

2.6 *Drawings:*⁷

5-4-2828 Shelter, Assembly, One-Side Expandable-60 amp

5-4-3200 Shelter, Assembly, One-Side Expandable-100 amp

3. General Requirements

3.1 *Alternate Components*—When this specification or the referenced drawings specify use of a specific component “or equal,” the contractor may substitute a component equal to the specified component provided that the contractor complies with the following requirements. Prior to manufacture of the first article, or if none is required, prior to commencing production, the contractor shall submit for the purchaser’s approval a list identifying each proposed “or equal” component together with proof that each listed component is functionally equal to the specified component and is compatible with the end item covered by this specification. The purchaser, at his option, may require a physical sample of any “or equal” component. Approval of the submitted listing and supporting data authorizes the commencement of fabrication of the first article or of production, as applicable, but does not relieve the contractor of the responsibility that the “or equal” components perform in accordance with specified requirements when incorporated into the end item.

3.2 *Materials and Components*—Materials and components shall conform to the documents listed in Section 2 and as specified herein. Any change to the proposed materials or processes must be approved by the purchaser. It is encouraged that recycled material be used when practical as long as it meets the requirements of this specification.

3.3 *Workmanship*—The shelter, including all parts and accessories, shall be constructed and finished in a workmanlike manner with particular attention given to removal of burrs and sharp edges, accuracy of dimensions, thoroughness of soldering, welding, painting, alignment of parts of assemblies, and the tightness of screws, bolts, and so forth. Gaskets shall not be torn or split and shall be free of finish. Cloth components shall be clean and free of holes, cuts, or tears. All latches utilized for erection and closing of the shelter shall be properly adjusted before the shelter is prepared for delivery to the purchaser.

3.4 *Riveting*—Riveting joints shall be tight. The joined parts shall be undamaged, and the rivet heads shall be properly seated and tight against the bearing surfaces. All the rivets, except those used in panel bonding, shall be dipped in polysulfide sealant just prior to insertion, however, a dab of polysulfide sealant shall be applied to the head of each rivet.

3.5 *Cleaning*—After fabrication, parts shall be cleaned in accordance with the drawings.

3.6 *Welding*—Welded joints shall be such that grinding of the finished weld shall not be a requirement, except when specified on the drawing. Spot, stitch, and seam welds shall be as indicated on the drawings. All surfaces to be welded shall be cleaned and free from scale, paint, grease, and other foreign materials. Welds shall have thorough penetration, good fusion and shall be free from scabs, blisters, abnormal pock marks, cracks, voids, slag inclusions, and other harmful defects. Welded assemblies shall be cleaned to remove any scale, oxidation products, and excess flux. Any acid used in cleaning shall be completely neutralized and removed. Welders shall be certified in accordance with AWS D17.1/D17.1M. Welding equipment and procedures shall conform to AWS D17.1/D17.1M.

3.7 *Finish*—Coatings shall level out to an adherent, continuous and uniform film without runs, wrinkles, streaks, or areas of no film. Any coating damaged during assembly or examination shall be touched up. There shall be no areas of rust. Finish shall be free of blistering, peeling and chips.

3.7.1 *Adhesion of Paint*—The shelter shall be capable of withstanding, without degradation to the finish, the tests as specified in 7.37. After top coat application, the shelter in the deployed mode shall be stored for a minimum of 168 h at a minimum of 70 °F (21 °C) prior to performing this test.

3.7.2 *Color*—The color of the paint film shall be compared with an appropriate color chip for the paint specified.

3.7.3 *Thickness*—Thickness of the paint film shall be checked as specified in 7.39.

3.8 *Finish and Color*—Surfaces shall be of the color, treatment, and finish as shown on the drawings. Top coat painting shall be performed on the fully assembled shelter so as to prevent mismatch of color shading, unless other control techniques are approved by the purchaser. After top coat application, the shelter in the deployed mode (that is, expanded) shall be stored in a 70 °F (21 °C) minimum temperature indoor facility for a minimum of 36 h to ensure adequate coating(s) cure. During this storage period the shelter doors and vents shall be opened to permit air circulation within the shelter.

3.9 *Manuals*—Unless otherwise specified (see 13.2), technical manuals shall be provided with each shelter. Stowage provision for the manuals shall be located as shown on the applicable drawings.

3.10 Terminology related to this specification is defined in Terminology E1749.

4. Design and Construction Requirements

4.1 *Design and Construction*—Design and construction of the expandable shelter shall conform to the requirements specified on the drawings, all subsidiary drawings and parts lists and hereinafter. The shelter shall be free of panel delaminations and shall meet all physical and environmental requirements specified herein.

4.2 *Container Mode*—The shelter in the closed or transport mode shall be referred to as a container, hereinafter, for the purpose of definition. The shelter, in the container mode, shall be an article of transport equipment meeting ISO freight

⁶ Available from DLA Document Services, Building 4/D, 700 Robbins Ave., Philadelphia, PA 19111-5094, <http://quicksearch.dla.mil>.

⁷ Copies of drawings are available from U.S. Army Natick Soldier Research, Development, and Engineering Center, ATTN: RDNS-SEE-T, 15 General Greene Avenue, Natick, MA 01760-5018, <https://www.army.mil/info/organization/natick>.

TABLE 1 Container Overall Dimensions

Type	Height				Width				Length			
	ft	in.	Tol.	in.	ft	in.	Tol.	in.	ft	in.	Tol.	in.
IC	8	0	+0	-0.1875	8	0	+0	-0.1875	19	10.5	+0	-0.25
	(2.438 m)		+0	(-5 mm)	(2.438 m)		+0	(-5 mm)	(6.058 m)		+0	(-6 mm)

container requirements related to cargo containers. The shelter shall show no structural damage when tested as specified in 7.20, 7.22, 7.23, and 7.28 – 7.35 and shall show no leakage when tested as specified in 7.24, and 7.24.1 – 7.24.3. The contractor shall ensure that the shelter receives Coast Guard Certification for ISO Containers. The container overall dimensions shall be in accordance with ISO freight container designated IC and are as shown in Table 1.

4.3 *Panels*—The panels used as structural members in the container configuration shall meet structurally all transportation and environmental requirements specified herein. Each panel shall be fabricated as a net panel with aluminum extrusions bonded about the panel perimeter during panel bonding. The inner and outer skins on all joints shall be sealed to provide a water barrier against the entrance of moisture to the core material and to the interior of the shelter. The water barrier is to be maintained intact at all panel cross-sectional openings. All joints and edges shall be assembled and sealed in a manner to prevent collection and retention of moisture. Particular emphasis shall be placed on the sealing of all mitered corners.

All of the above sealing procedures shall be accomplished in accordance with Practice E1773.

Rivet shafts shall be coated with sealing compound before insertion. The sealer shall be as indicated on the drawings. The contractor shall have the appropriate equipment and facilities, use the correct procedures in accordance with Practices E874 and E864, and use qualified panel components (that is, structural film and core splice adhesives, corrosion-inhibiting adhesive primer, structural nonmetallic honeycomb core, and as specified 5052-H34 or 6061-T6 aluminum skins, FRP barrier strips, 6061-T6 panel extrusions). Prior to use, all critical panel component materials must be qualified in accordance with Specifications E865, E866, E990, E1091, and E1826. There shall be no skin splices in the panels except where noted on the drawings. Unless otherwise specified (see 13.2), prior to award of contract, the contractor shall submit to the purchaser a certified copy of a laboratory test report and a copy of their process specification covering fabrication of the metallic-faced, nonmetallic honeycomb core sandwich panels they propose to use in the construction of the end item. Using their process specification, the contractor shall fabricate qualification test sandwich panels and structural film adhesive floating roller peel test specimens, and shall perform tests in accordance with Specification E865 and Practice E874 (see 13.2).

4.3.1 *Panel Processing*—The shelter panels shall be processed and inspected as specified in Practice E864 and Specifications E865, E866, or E1826 depending upon which primer is being used, Specifications E990 and E1091, and Practices E874 and E1773. The shelter panels shall be inspected for

dimensions and flatness in accordance with the “Dimensional and Flatness Inspection of Panel” Section of Practice E874 (see 10.2).

4.3.2 *Panel Watertightness*—Panel assemblies shall not permit the entry of water (see 10.3.1) when tested as specified in 7.18.

4.3.3 *Resistance to Thermal Shock*—Panels shall be resistant to thermal shock, when tested as specified in 7.6.

4.3.4 *Panel Interchangeability*—All panels and panel assemblies bearing same part numbers shall be functionally and dimensionally interchangeable without modification or rework. Individual assemblies shall not be hand picked for fit or performance, when tested as specified in 7.7.

4.3.5 *Delaminations*—Delaminations in shelter panels shall be tested as specified in 10.3.4.

4.3.6 *Panel Frame Airtightness*—Welded panel frames shall be air tight when tested as specified in 7.41.

4.4 *Inserts*—When tested as specified in 7.8, the following sized inserts, where used, shall withstand the torque and pullout loads as specified in Table 2, without failure of the inserts, panel, or potting compound.

4.5 *Payload*—The unit is designed to carry a maximum payload of 9480 lb (4300 kg) during transport.

4.6 *Corner Fittings*—The container shall be equipped with corner fittings at the top and bottom corners in accordance with the dimensional requirements for corner fittings for series-1 freight containers as stipulated in ISO 1161 requirements for commercial containers. The upper faces of the top corner fittings shall protrude above the top of the rest of the container by a minimum of ¼ in. (6 mm) The lower faces of bottom corner fittings shall protrude below the bottom of the container by a minimum of 7/16 in. (11 mm).

4.7 *Shelter Mode*—The shelter in the erected mode shall be referred to as a shelter herein for the purpose of definition. Hinged shelter panels shall be attached in a manner to ensure compliance with the environmental test requirements as specified in 7.6, 7.13 – 7.17, 7.24, and 7.26.

4.8 *Exterior Lighting*—One area lighting fixture, as shown on the drawings, shall be provided with each shelter.

TABLE 2 Insert Strength (Proof Loads)

Insert (Diameter Thread Size)	Pull-out, lb (kN)	Torque, ft-lb (N-m)
10-32	1000 (4.5)	10 (13.6)
¼ -28	1000 (4.5)	20 (27.2)
5/16 -24	2000 (9.0)	20 (27.2)
¾ -24	2000 (9.0)	40 (54.2)

4.9 Shelter Electrical System:

4.9.1 *General*—The system shall have all equipment, cabling and other hardware necessary to receive three phase 120/208 V, 60 Hz power from the base electrical distribution systems, and distribute it to lighting fixtures and receptacles as indicated on the drawings. The 60 A shelters shall be in accordance with Drawing 5-4-2828 and all subsidiary drawings and parts lists. The 100 A shelters shall be in accordance with Drawing 5-4-3200 and all subsidiary drawings and parts lists. All parts of the electrical system shall operate when tested for electrical continuity as specified in 7.40.

4.9.2 *Operating Temperature*—The wiring system and all individual hardware items shall be capable of operating at their required capacity within an ambient temperature range of -60 to 125 °F (-51 to 52 °C), except that the fluorescent lights shall operate from 0 to 125 °F (-18 to 52 °C), when tested as specified in 7.14 and 7.15.

4.9.3 *Current Rating*—All conductors and appropriate hardware shall be rated for current carrying in accordance with the applicable industry standards as specified on the drawings. Derating of components may be necessary for an operating ambient temperature of 125 °F (52 °C).

4.9.4 *Finish*—Panel boards and all other exposed metallic items shall have finishes as indicated on the drawings (see 3.7).

4.9.5 *Panel Board*—The panel board used shall be as indicated on the drawings. It shall be of dead front construction and have a solid neutral bus, a ground bus, and a 60 A or 100 A three phase main breaker as specified (see 13.2). The panel will have a NEMA-1 enclosure with conduit hubs as necessary and at least 18 breaker spaces excluding the main breaker. The panel board bus feed shall be by rigid conduit and conductors; the conductors having a current carrying capacity of at least 100 A at 125 °F (52 °C) ambient temperature. The bus feed cables shall terminate in a connector mounted on the exterior of the shelter. Conductors running from panel board circuits to fixtures or receptacles shall be enclosed in rigid conduit or shall be specified flexible cable for the expandable portion of the shelter. The current carrying capacity of the conductors shall be 20 A minimum, based upon an ambient temperature of 125 °F (52 °C) and NEC rating procedures. All circuit breakers used in the system shall be bolt-on type and have a minimum interrupting capacity of 10 000 A RMS symmetrical.

4.9.6 *Cabling*—Flexible cables shall be used to feed all relocatable lighting fixtures and receptacles. These cables shall be as indicated on the drawings.

4.9.7 *Switches*—Switches used shall be as indicated on the drawings.

4.9.8 *Grounding*—All noncurrent carrying metal components shall be solidly grounded using the green ground wire within the wiring system, as indicated on the drawings.

4.9.9 Receptacles:

4.9.9.1 *Electrical Power Service Entrance*—The electrical power service entrance shall be as shown on the drawings.

4.9.9.2 *Convenience Outlets*—The shelter shall contain duplex convenience outlets as indicated on the drawings. All outlets shall be electrically grounded.

4.9.9.3 *Air Conditioning*—Power for heating and cooling equipment shall be provided from the distribution panel in the

shelter to an electrical connector mounted in the service entrance recessed pan on the outside of the shelter as indicated on the drawings.

4.9.9.4 *External Outlets*—Power distribution shall be provided from the distribution panel box in the shelter to outlets mounted in the service entrance recessed pan on the outside of the shelter as indicated on the drawings.

4.9.10 *Communications*—The shelter shall have four (two pairs) circuits through the wall telephone and intercom utility connections terminating in four protected terminals inside and outside the shelter, as indicated on the drawings.

4.9.11 *Tools*—Tools provided with the shelter shall be readily accessible to personnel when the shelter is in both the container and shelter configuration.

4.10 *Nameplates and Product Marking*—All markings shall conform to the drawings. Each shelter shall be serially numbered and provided with a nameplate in accordance with applicable drawings (see 13.2).

4.10.1 *Interior Markings*—Interior markings shall be as shown and in the locations shown on the applicable drawings.

4.10.2 *Exterior Markings*—The shelter shall be provided with specific exterior markings as shown on the applicable drawings.

5. Performance Requirements

5.1 *Floor Loads*—The shelter floor shall be capable of supporting a uniform load of 65 lb/ft² (320 kg/m²). The shelter floor shall be capable of supporting a concentrated load of 2000 lb (910 kg) over a 4 ft² (0.4 m²) are at the center of the floor. The floor shall also be capable of supporting a point load of 125 lb/in.² (9 kg/cm²). Loads shall not cause any permanent deformation of the floors or cause any deflection that interferes with proper shelter operation, when tested as specified in 7.9.

5.2 *Roof Loads*—The roof assembly of the shelter shall withstand a snow load of 40 lb/ft² (200 kg/m²) and a personnel load of 660 lb (300 kg) static over 2 ft² (0.2 m²) when tested as specified in 7.10.

5.3 *Door Loads*—Container doors shall be tested to withstand the following loads without deformation or impairment of function:

5.3.1 *Static Door (Hinge) Load*—The doors, frames, and hardware shall be capable of supporting 200 lb (90 kg) applied to the door at the edge opposite the hinge pivot line with the door open to approximately 90 when tested as specified 7.11.

5.3.2 *Wind Gust Door (Stop) Load*—The doors, frames, and hardware shall withstand a wind gust of 60 mph (100 km/h) in any direction when the door is secured in its open position by its door stop device when tested as specified in 7.11.

5.4 *Step Assembly*—The completely mounted step assembly shall withstand a vertical load of 500 lb (225 kg) applied to the outer section without deformation of the assembly of supporting structure when tested as specified in 7.12.

5.5 *Airtightness*—The shelter shall not permit air leakage beyond specified limits in either container or shelter configuration when tested as specified in 7.13.

5.6 *Temperature Range:*

5.6.1 *Non-operating Temperature*—The container mode configuration shall withstand exposure to a temperature range of –60 to 160 °F (–51 to 71 °C).

5.6.2 *Operational Temperature*—The shelter shall be dependable and operable in an ambient temperature range of –60 to 125 °F (–51 to 52 °C) plus a solar load such that the outer skin reaches a temperature of 200 °F (93 °C), when tested as specified in 7.14, 7.15, and 7.26.

5.7 *Humidity and Temperature Aging (Components)*—The shelter components shall be capable of withstanding the conditions of a minimum 95 % relative humidity at 200 °F (93 °C). There shall be no evidence of delamination, cracking, corrosion, or deterioration when tested as specified in 7.16.

5.8 *Blackout*—There shall be no internal light visible from outside of the unit in the shelter mode when tested as specified in 7.17.

5.9 *Insert Strength*—When tested as specified in 7.19, the inserts indicated in Table 2 shall withstand loads equal to 80 % of the applicable strengths shown in Table 2 without failure and as indicated in Table 3.

5.10 *Rail Transportability*—The shelter when tested as specified (see 7.20) shall be capable of withstanding, without damage, the shocks normally induced by rail transport.

5.11 *Impact Resistance*—The shelter panel shall be impact resistant when tested as specified in 7.21.

5.12 *Drop Test*—The shelter when tested as specified in 7.22 shall show no evidence of damage as a result of the drop test.

5.13 *Towing*—The shelter shall show no evidence of damage when tested as specified in 7.23.

5.14 *Water Leakage*—The shelter shall show no evidence of leakage when tested as specified in 7.24.

5.15 *Fluorescent Light Temperature*—Shelter fluorescent light assemblies shall show no failure when tested as specified in 7.25.

5.16 *Solar Load*—The shelter shall withstand a solar load test when tested as specified in 7.26.

5.17 *Operational Fitness*—The shelter shall prove functional when tested as specified in 7.27.

5.18 *Heat Transfer*—The overall coefficient of heat transfer of the shelter shall not exceed 0.35 BTU per hour per square foot per degree Fahrenheit (2.0 watts per square metre per degree Kelvin) (see 7.36).

6. Other Requirements

6.1 Requirements and testing for lifting, six-high stacking, longitudinal restraint, racking, lashing, endwall strength, side-

wall strength, and lifting from fork lift pockets shall conform to ISO 1496-1 when tested as specified in 7.28 – 7.35.

6.2 *First Article*—When specified, a sample shall be subjected to first article inspection (see 8.1, 13.1, and 13.3).

6.3 *Inspection Comparison Testing Sample*—When specified (see 13.2), the contractor shall furnish a sample for comparison inspection and approval (see 8.1 and 13.4).

6.4 *Manuals*—Unless otherwise specified (see 13.2), technical manuals shall be provided with each shelter. Stowage provisions for the manuals shall be located as shown on the applicable drawings.

7. Test Methods

7.1 *Electrical Continuity Testing*—Test every end item as specified in 7.40. Any test failure shall be cause for rejection of the end item.

7.2 *Water Leakage and Operational Testing*—Test the first ten production units as specified in 7.24, 7.24.1 and 7.24.3. If no failures are experienced, five of the next ten production units shall be tested. If no failures are experienced on the 50 % sample, one of each 25 production units shall be tested thereafter. Any failure on sampled units shall be cause for rejection of the lot and return to 1008 testing; repeat the above procedure (starting with the units of that lot).

7.2.1 *Water Leakage (Fully Loaded)*—Test one out of every 50 production units as specified in 7.24.2 and 7.24.3. Notify the purchaser of any test failure within 72 h. Prepare a failure analysis report with corrective action defined, and test one out of the next ten production units followed by one out of the next fifty if no failures occur.

7.3 *Performance Testing*—Test one end item from each inspection lot as specified in 7.13 (shelter mode only) and 7.26. After successful completion of these tests, test the end item sample as specified in 7.17. The size of the inspection lot shall not exceed 25 shelters. Any test failure shall be cause for rejection of the lot.

7.4 *Paint Adhesion Testing*—Test one of every forty production units as specified in 7.37. Test this unit in the deployed mode only after storage in a 70 °F (21 °C) minimum temperature indoor environment for 168 h minimum, after topcoat painting. Notify the purchaser of any test failure within 72 h. Prepare a failure analysis report with corrective action defined, and test one out of the next ten production units, followed by one out of the next forty if no failures occur.

7.5 *Packaging Examination*—Make an examination to determine that preservation and packing comply with the Performance Requirements section. Score defects in accordance with Table 4. The sample unit shall be one shelter fully packaged except the mechanical seals on the doors may be omitted to facilitate inspection. When omitted for internal inspection, after acceptance of the lot for preservation, apply mechanical door seals to the shelters and then inspect the lot of shelters subsequently for sealing. The lot shall be the number of shelters offered for inspection at one time. The inspection level shall be II and the AQL, expressed in terms of defects per hundred units, shall be 2.6.

TABLE 3 Insert Strength (Working Loads)

Insert (Diameter Thread Size)	Pull-out, lb (kg)	Torque, ft-lb (J)
10–32	800 (360)	8 (11)
1/4 –28	800 (360)	16 (22)
5/16 –24	1600 (725)	16 (22)
3/8 –24	1600 (725)	32 (43)

TABLE 4 Packaging Defects

Examine	Defect	
Workmanship Exterior	Doors are not closed, latched, and mechanically sealed	
	Exterior electrical connections are not covered and covers are not secure (hand pressure)	
	Expandable wall corner post cam latch handles are not in locked position with pin in retaining hole	
	Puncture in exterior skin	
	Damage (such as bending, gouging, or denting) to frame ends or to fork lift opening	
	Steps are not folded closed	
	Any other protruding or not stowed part	
	Workmanship Interior	Equipment container is not secured in place
		Parts in the equipment container are not in accordance with the list of the parts
		The four lift jacks are not secured on the doors
The two leveling jacks are not secured on the cargo door		
The support struts are not secured with lock pin in place		
The removable light fixtures are not secured to the fixed ceiling by four captive studs with stowage bracket plunger locked		
The movable utility outlets are not secured to the hinged endwalls by their captive screws		
The area light and cable are not secured to the interior of the personnel end panel with the retaining wing nuts secured (hand pressure)		
The area light does contain a bulb (bulb should be packaged and packed in the equipment container)		
Any circuit breaker not in the OFF position		
The circuit breaker box keys are not inside the box		
Air vents are not secured closed		
Environmental control units (ECU), panels are not stowed securely on the fixed ceiling		
Any other loose or not stowed part		

7.6 Thermal Shock Test—Within 30 min after the exposure cycling of 7.16 has been completed, subject the panel specimens to a -65°F (-54°C) environment for 4 h to evaluate the effects of thermal shock. After thermal shock, inspect the panel specimens for delamination (see 7.38), corrosion, and material degradation. Any delamination, corrosion, or material degradation shall constitute a failure of the test.

7.7 Panel Interchange Test—Interchange the folding walls with the same part number and two fixed walls with the same part number randomly selected from the first article or production lot of completed shelters, as applicable. Accomplish the interchange by removing the hinge pins or bolts, as applicable, interchanging walls, and reinstalling the hinge pins or bolts (see 4.3.4). Any wall that cannot be fully interchanged shall constitute a failure of the test.

7.8 Insert Proof Load Test—The test fixtures shall be fashioned by the contractor and approved by the purchaser prior to use, to evaluate the inserts using bolts of the applicable thread size. Apply loads to the insert in a tightening and loosening direction and hold at the specified torque for a minimum of 5 s. Fashion the test fixtures to induce only a twisting load to the insert for the torque test and, primarily, only on axial tensile load through the centerline of the insert for the pull-out test. Apply the reaction load from the insert pull-out fixture onto the test specimen panel, to the panel outside of a 3 in. (75 mm) radius measured from the centerline of the insert.

7.8.1 Insert Torque—To determine compliance with the torque requirements of 4.4, apply a torque load equal to the torque strength cited in Table 2 to the two identical inserts of

each size (1-H, 1-V) potted in the test specimen panel cited in 8.1.1 and 9.2. Torque load applied shall be equal to torque strength cited in Table 2 for applicable size. Inability of any insert to meet specification requirement shall constitute a failure of the test.

7.8.2 Insert Pull-Out—To determine compliance with the pull-out requirements of 4.4, a tensile pull load equal to pull-out strength cited in Table 2 shall be applied to two identical inserts of each size (1-H, 1-V) potted into the test specimen cited in 8.1.1 and 9.2. Failure of the potting compound to hold the insert firmly in panel shall constitute failure of the test.

7.9 Floor Loads Test-Static Load—The floor loads test-static load shall be as specified in Specification E1925.

7.10 Roof Load Test—The roof load test shall be as specified in Specification E1925.

7.11 Door Load Test—The door load test shall be as specified in Specification E1925.

7.12 Step Test—Suspend a 500 lb (225 kg) weight from the outer end of a step assembly for 5 min and remove the load. Any permanent deformation or local delamination (see 7.38), shall constitute failure of this test.

7.13 Airtightness Test—The shelter airtightness test shall be as specified in Specification E1925.

7.14 Low Temperature Test—Cold soak the shelter in its container mode, with shelter components and maximum payload packaged within, first at -60°F (-51°C) temperature for a minimum of 24 h in a mechanically refrigerated cold chamber. At the end of the 24 h period and while at -60°F (-51°C), erect the shelter. Operate all hardware (for example, latches, doors, knockout panels, and so forth) and examine the shelter and its components for any damage. Do not move lights or electrical receptacles into position at this time. Return the shelter to the closed/container mode and then raise the chamber temperature to -25°F (-32°C). Allow the chamber to stabilize at -25°F (-32°C) for 4 h. Next, erect the shelter and hook up power source to shelter. Position the ceiling fluorescent lights and electrical receptacles on expanded shelter section. Operate circuit breakers, blackout emergency switch, and emergency incandescent lights. The fluorescent ceiling lights shall not be operated at -25°F (-32°C), since they are rated for a minimum of 0°F (-18°C) operation. Next, return the shelter to normal operating conditions and cycle all doors, electrical components, and hardware. After operation and inspection of all components, close the shelter for shipment and re-examine for component damage and material degradation. The finding of any material or panel degradation or the inability of any hardware to function properly during this test shall constitute failure of the low temperature test.

7.15 High Temperature Test—Subject the shelter, in its container mode, with shelter components and maximum payload packaged within, to a 160°F (71°C) storage test cycle and a 125°F (52°C) operational test cycle. Soak the shelter in a chamber for at least 6 h at the storage test temperature and for 24 h at the operational test temperature prior to initiation of the operation phase of the operational test cycle. At 125°F