STANDARD PLANS
FOR
HIGH SECURITY HASPS
AND
PHYSICAL SECURITY EQUIPMENT ASHORE

by
Naval Weapons Support Center
(NAVWPNSUPPCCEN)
Crane, Indiana 47522
ACTIVITY REQUESTS FOR HIGH SECURITY HASPS, LOCKS, SAFES, ETC

Background: NAVWPNSUPPWCEN Crane (Code-208) is in the business of furnishing physical security hardware to activities and ships for the Arms, Ammunition and Explosives (AA&E) and Nuclear Weapons Security Programs. However, recent requests from the above type units for this hardware and the fact that over 50 percent of the ammunition and weapons in storage do not qualify for the level of protection we can provide, make it necessary that a policy be established regarding validation of requests.

Policy: Henceforth, an activity wishing hardware should forward a message or letter to NAVWPNSUPPWCEN Crane (Code 208) stating the following:

a. Requesting Activity
b. Building Number or Magazine Number (where hasps is to be installed)
c. Risk Category being stored
d. Style* of Hasp or type of Door (correlate to building number)
e. Complete Shipping Address (include ATTN: name and code)
f. Desired Delivery Date (normal shipping time: 2-3 weeks)
g. A Point of Contact, with phone number

Discussion: the above information will allow us to validate a request, prioritize its filling, and initiate shipment as quickly as possible to meet security requirements.

Forward Requests to:

Commander
Code 3046
NAVSURFWARCENDIV
300 Highway 361
Crane, IN 47522-5001

For Additional Assistance, Contact Code 208 Representative:

Mr. Bob Price
Mr. Jeff Sollliday

Telephone: Commercial (812) 854-8560/5840
DSN 482-5860/5840

*There are two styles of Landbase hasps. See Hasp Style Determination for correlation of style to door type.
4 OF NAPCO Dwg NO. 0358

NAME: BOTTOM ATTACK SHEILD
MANUFACTURE: CAST/STEEL MIL-810F/16810K-28
STAINLESS STEEL CASING
HEAT TREAT: 776-28
SURF. RESID: 833 CAD
SPCL NAPCO LINEAR TOLERANCES
UP TO 1/2 1.003
- 2 1.013
- 3 1.016
- 4 1.019
- 5 1.022
- 6 1.025

INGP ZIGLO PER MIL-5209-14864
LIST OF MATERIALS

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NOTES:
1. HIGH SECURITY HASP INSTALLATION HEIGHT IS INTENDED TO BE OPERATOR ADJUSTABLE. THE HASP SHOULD BE MOUNTED TO THE TOP OF THE DOOR IN A LOCATION THAT WILL LEAVE TWO OF HOLES ABOVE THE CANOPY. THE CENTER OF THE HASP SHOULD BE MOUNTED TO THE CENTER OF THE DOOR OR WINCH IN LID OF THE BOTTOM OF THE DOOR.

2. USE WELDING ROD E7016, E7018.

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STEP 1
CUT PART 13-5/8 INCHES AXIAL FROM MOUNTING HOLE. LOCATE HOLE FOR LOCKER PIN HOLE FOR DRAWER. LOCATE HOLE FOR LOCKER PIN HOLE FOR DRAWER.

STEP 2
USE LASER LEVEL TO MOUNT PART 13-5/8 INCHES AXIAL FROM MOUNTING HOLE. LOCATE HOLE FOR LOCKER PIN HOLE FOR DRAWER. LOCATE HOLE FOR LOCKER PIN HOLE FOR DRAWER.

STEP 3
ASSEMBLE ASSEMBLY AS H6. ATTACH ALL HARDWARE AS SHOWN. LOCATE HOLE FOR LOCKER PIN HOLE FOR DRAWER. LOCATE HOLE FOR LOCKER PIN HOLE FOR DRAWER.

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INSTALLATION PROCEDURE

[Diagram showing installation procedures]
LIST OF MATERIALS

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<tr>
<th>PART#</th>
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NOTES:
1. HIGH SECURITY FLAG INSTALLATION H thugs: ASSEMBLY IS INTENDED TO BE OPERATED
   WITHOUT any provision for a GREAT DEGREE OF SECURITY. TAKING CARE IF THE STAPLEHEADS ARE NOT
   SECURELY MOUNTED AND THE LOCKING MECHANISM REMOVED, THE KNOCK-OUT HOLE IS
   USED FOR THE HANDLE OF THE DOOR, OR THE FACE OF THE DOOR IN
   2. USE SLEEVE NO. 60, 70, 80, 90, 100.

STEP 1
1. CUT A HOLE IN THE DOOR, AS INDICATED.
2. INSERT THE KNOCK-OUT HOLE IN THE DESIGNATED LOCATION.
3. SECURE THE Hinge WITH SCREWS AS INDICATED.

STEP 2
1. INSERT THE Hinge INTO THE HOLE IN THE DOOR AS INDICATED.
2. SECURE THE HINGE WITH SCREWS AS INDICATED.
3. LEVEL THE DOOR AND FASTEN WITH SCREWS AS INDICATED.

STEP 3
1. INSERT THE Hinge INTO THE HOLE IN THE DOOR.
2. SECURE THE HINGE WITH SCREWS AS INDICATED.
3. LEVEL THE DOOR AND FASTEN WITH SCREWS AS INDICATED.

STEP 4
1. ASSEMBLE THE Hinge AND THE DOOR.
2. SECURE THE HINGE WITH SCREWS AS INDICATED.
3. LEVEL THE DOOR AND FASTEN WITH SCREWS AS INDICATED.
4. LEVEL THE DOOR AND FASTEN WITH SCREWS AS INDICATED.

FINISH HOLE MOUNTING HOLE TO DOOR.
Step 1
Open and close magazine door several times. Adjust limit or position switches so that door stops consistently against bumper stops.

Remove any obstructions from the magazine basket and turn over a lift of the door on closed position and get weight on lift above the magazine basket.

Close the door completely against the stops.

Step 2

MAPC Eng. 1054. Shown 6-7-95. A few items have been made to be used as a reference template. According to the template sheets enclosed at the bottom of this sheet. Please place the template on the first wall and all of the "T" marks in order that the end of the door may correspond with the same red marks on wall and door as indicated. Remove the template and drill the correct in location anchors. Drill hole in door and for "T" hole after installation of Place 6 see Step 7.

Step 3
Cut out 5"x5" panel in end of door.

Step 4
Fix projection on both lock and sensor housing. Place 1, any portion of main housing, Place 6. Weld assembly unit.

Step 5
Bolt the housing subassembly to the back of the housing using 1/2" nuts and bolts having a minimum thread strength of 120 ksi. Use 1/2", 15 concrete anchors.
Step 11
Slide cover to the right.
Place adapter Plate 6 until it is fully seated in the sensor body. If replacement sen-
ors are used, install adhesive back to panel. Install sensor in position. Install sensor body, 14. Install-
ner Tape into body. Tape will secure body to housing.
Back plate now out and slide cover to the left. Finish sealing sensor body to housing.

Step 12
Install lever arm sensor Plate 27x sensor body. Plate 29.
Install sensor wiring.
Note: Cover not shown in this illustration for clarity.

Step 13
Install door controls and supporting electrical equipment.
Note: Cover removed in this illustration for clarity.

Step 14
The locking mechanism used in the Trident range consists of a flanged end.
Balancer Plate 35, a pin body, and a shear catch that is returned to the sensor.

Step 15
Install reflective sight on long Plate 6, as shown to allow for alignment check of sensor.
Drill a 3/4" diameter hole in shroud, Plate 6. As shown to facilitate opening of type when
cover is moved and sensor repositioned.
NOTE: INSTALLATION OF LOCK ANTI-ROTATION BLOCKS ALLOWS NAPEC DOOR SECURITY HASP SYSTEM TO BE CERTIFIED HIGH SECURITY WITH 3-3/4 RING LOCK.

LOCK ANTI-ROTATION BLOCKS INSTALLED IN DOOR HASP

LOCK ANTI-ROTATION BLOCKS INSTALLED IN DOOR HASP
INSTALLATION INSTRUCTIONS

STEP 1
Cut away ½ inch of material from natural door if natural is present.

STEP 2
Note: Locator buttons have been cast onto the hinge to aid in locating. Position hinge on doors using the locator buttons to ensure proper alignment. Tighten hinge onto doors.

STEP 3
Open door and finish welding. Note: Do not weld on door edges. Remove locator buttons prior to welding.

*Note: Use MIG/ERF/Electrode #420. Standard is 1/8 in. 16 ga.
STEP 6
FABRICATE SLEEVE ITEM 48 INCLUDING CLOSING TO LENGTH AND DRILLING RETAINING PIN HOLE ACCORDING TO SHEET E.

STEP 7
FABRICATE RETAINING PIN ACCORDING TO SHEET E.

STEP 8
INSERT SLEEVE ITEM 48 THROUGH HOLE IN SLEEVE ITEM 46 AND WELD ACCORDING TO SHEET E.

STEP 9
INSERT TANG ITEM 44 INTO SLEEVE ITEM 46 AS SHOWN IN SHEET E. THEN INSERT RETAINING PIN LOOSE AS SHOWN IN SHEET F.

STEP 10
INSERT RETAINING PIN 43 THROUGH HOLE IN SLEEVE ITEM 42 AND THROUGH SLOT IN TANG ITEM 44 AS SHOWN ON SHEET E. WELD PIN TO SLEEVE AT BOTH ENDS.
STEP 7
Close door until the slide tube moves the door into the wall as shown.

STEP 8
Open door and cut out the marked panel.

STEP 9
Close the door until the projections from the back fitting project through the slide tube. Place the 3" length of #3 channel provided behind the wall to the right of the channel in Figure 1. Insert the end fitting 90° in the edge of the channel, and the door 90° and the slide.

STEP 10
Open the angled cover releasing the slide and channel as a component of the locking system by completing the angled assembly installation. Conducting the hole between the 81/2" channel and the 3/4" channel, the flat plate should then be placed inside the channel. To complete the system and be full-weld.

STEP 11
The angle should then be placed to the slide end. The 3" is placed inside the top and bottom of the slide and tube.

STEP 12
Install sensor wiring to locking system.
STEP 1
Open door and close magazine door several times noting position of door each time it stops in closed position. Mark this position on headwall in area approximately 3/4 to 1 foot of door in closed position and at a height 7½ to 8 above magazine apron.

STEP 2
Harp should be positioned on headwall plate even with mark established in step 1. Harp should be welded all around. Welding rod should be 30-35 rod.

STEP 3
Tang and shroud assembly should then be inserted into lock housing and tack welded in center of lock housing.

STEP 4
Close cover and fasten securely using two jack-caps. Insert wooden shim between should and center shroud assembly.

STEP 5
Close door until slide tube rides on door and mark welded items as shown.

STEP 6
Open door and cut out marked panel.
STEP 7
CLOSE DOOR UNTIL PROTRUDING TUBE PASSES SMOOTHLY THROUGH HOLE CUT IN STEP 6. TACK WELD SHROUD TO DOOR END. OPEN HINGED COVER RELEASING SHIMS AND CHECK ALIGNMENT OF SYSTEM BY OPENING DOOR.
COMPLETE WELD BETWEEN SHROUD AND DOOR END.

STEP 8
INSTALL SENSOR WIRING
STEP 1
Open and close magazine door several times setting it in the closed position mark this position on the headwall. Remove any obstructions in the magazine area. Approximate location of the coat closet position mark at a height above the magazine or head of stock.

STEP 2
Harp should be positioned on the headwall plate, even with the mark established in step 1, and leveled. Harp should then be welded all around to the base plate using a 1/8" flat weld. Welding rod should be 309-16, 40A.

MARK ESTABLISHED IN STEP 1

STEP 3
Tang and shroud assembly should then be inserted into lock housing and tang chamfered in center of lock housing.

STEP 4
Close cover and fasten securely using two jackscrews. Insert wooden shim between shroud and cover as shown to center shroud assembly.

SHIMS
STEP 5
CLOSE DOOR UNTIL SLIDE TUBE TOUCHES DOOR END. MARK AROUND TANG AS SHOWN.

STEP 6
OPEN DOOR AND CUT OUT MARKED PANEL.

STEP 7
CLOSE DOOR UNTIL PROTRUDING TUBE PASSES SMOOTHLY THROUGH HOLE CUT IN STEP 6. TACK WELD SHROUD TO DOOR END. OPEN HINGED COVER, RELEASING SHROUD AND CHECK ALIGNMENT OF SYSTEM W/ OPENING DOOR
COMPLETE WELD BETWEEN SHROUD AND DOOR END.

STEP 8
INSTALL SENSOR WIRING