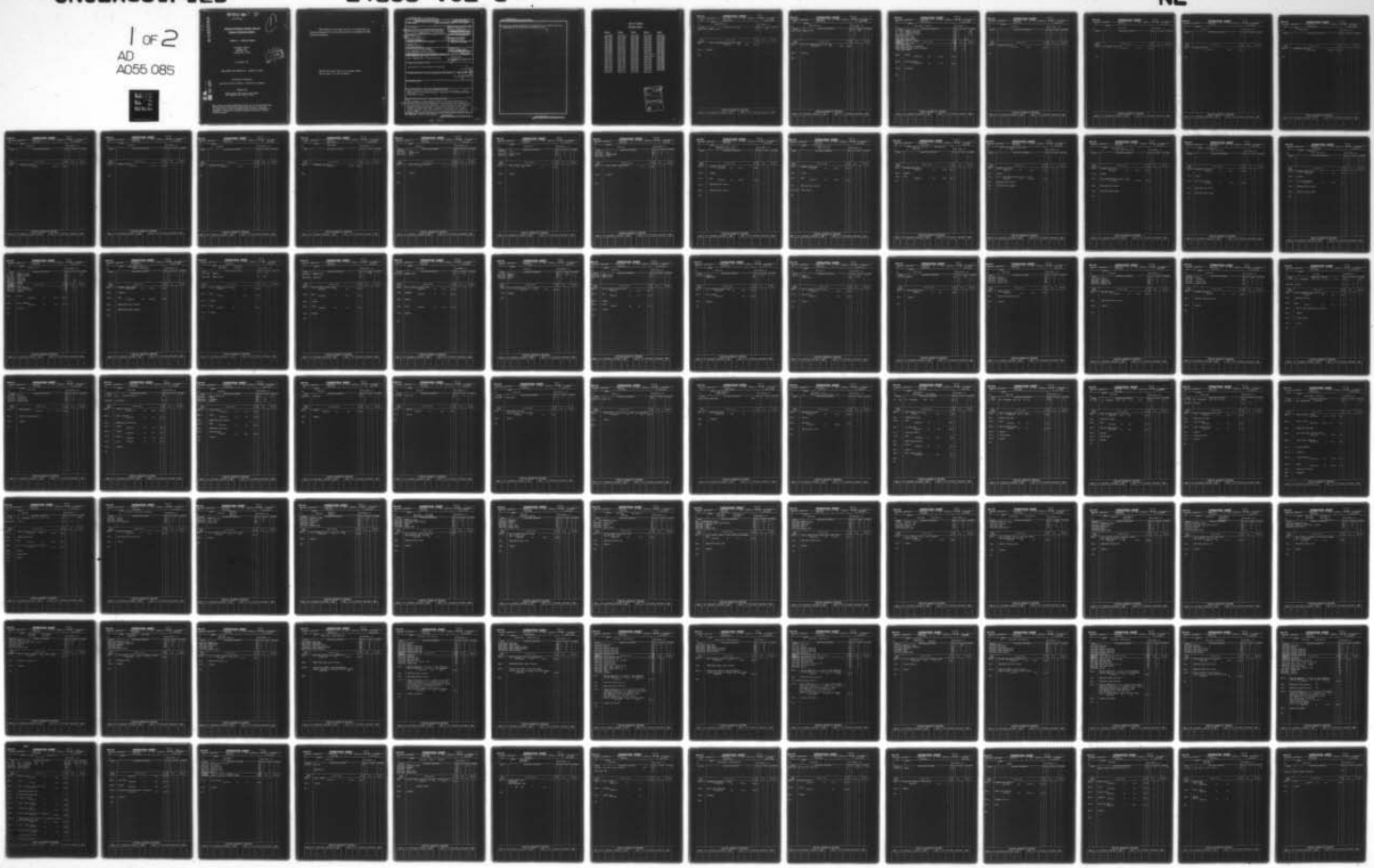
AD-A055 085 GENRAD INC CONCORD MA F/G 14/2
TRACKING SERVOBRIDGE DETECTORS. VOLUME III. OPERATION SHEETS.(U)
DEC 76 W J RILEY, W M TWADELL DAAB07-73-C-0609
UNCLASSIFIED 24655-VOL-3 NL

1 OF 2
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PRODUCTION ENGINEERING MEASURES (PEM) FOR TRACKING SERVOBRIDGE DETECTORS

VOLUME III - OPERATION SHEETS

William M. Twadell
GenRad, Inc.
300 Baker Ave.
Concord, Ma. 01742

DDC
JUN 13 1978

15 December 1976

FINAL REPORT FOR CONTRACT NO.: DAAB05-73-C-0609

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Fort Monmouth, New Jersey 07703

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Quartz resonators; measuring-devices (electrical-electronic); crystal measurements; Servobridge detector; detectors; synchronous-detection; heterodyne-receiver.

20. ABSTRACT (Continue on reverse side if necessary and identify by block number)

This report is in three volumes. - Volume I describes technically the Tracking Servobridge Detector in final configuration after passing all of the requirements of MIL-D-55361(EL). Volume II describes the Production Engineering Measures required for the pilot production of these units. Volume II includes flow charts, equipment and tooling lists, sample operation sheets, other data required for production and review of the program. Volume III contains all of the Operation Sheets required to

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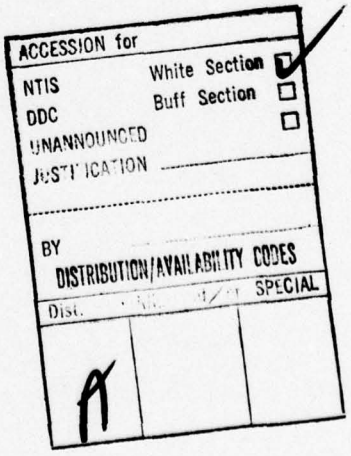
410 496

20. fabricate (GenRad manufactured) components and to assemble and test subassemblies and Tracking Servobridge Detectors.

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ORDER QUAN	DRAFTING NO.	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						0485-0290

→ PRINTS 0485-4073-1L OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
0030-1240	ESMW-2-2-24	Ft		80"	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B01 A	Cut to length and service ends 03-84-05 20 .05	Ea	S		
H20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						0485-0295

→ PRINTS 0485-4074-1L OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0030-1240	ESMW-5-2-24	Ft		80"	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B01 A	Cut to length and service ends				
	03-84-05 20 .05	Ea	S		
H20 B	Inspect				
P50					

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25		2995-4855						0485-4074

PRINTS: 0485-4074, 4074-1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
36 0285	ESMW-57-28-SNP	LB			.8
36 0185	ESMW-57-18-SNP	LB			.26
36 0195	ESMW-57-19-SNP	LB			.5
0485-0295	Lead Set	Ea		1	
0485-0730	Coil tube	Ea		1	
0485-0800	Lamination	Ea		100	
0485-8160	Trans. Clamps	Ea		2	
5310-9300	Nut, Hex	Ea		2	
7840-0650	Stud	Ea		2	
7930-1800	Terminal, Locking	Ea		2	
8040-2400	Washer, Split Locking	Ea		3	
7720-1100	Spacer	Ea		2	

-OPERATIONS-				UNIT		SET-UP	PIECE RATE
W15A	Wind						
	03-83-06	66	21.50	Ea	S		
W35-B	Asm Complete						
	03-81-04	32	5.75	Ea	S		
J50 C	Inspect						
P50							

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25		2994-4781						2994-0800

→	PRINTS	OFFICE ORDER →
	2994-0800	

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test				
	03-81-05 15.75	Ea	S		
P50					

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25		2994-4781						2994-0801

→	PRINTS	OFFICE ORDER →
	2994-0801	

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-		UNIT	SIDE	SET-UP	PIECE RATE
284-A	Assemble and Test					
	03-81-05	15.75	Ea	S		
P50						

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2994-4785						2994-0802

PRINTS → 2994-0802 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-		UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test					
	03-81-05	15.75	Ea	S		
P50						

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2994-4765						2994-0803

→	PRINTS 2994-0803	OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test				
	03-81-05 20.15	Ea	S		
P50					

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2994-4766						2994-0804

→ PRINTS 2994-0804 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-		UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test					
	03-81-05	15.75	Ea	S		
P50						

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ORDER QUAN	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2994-4766						2994-0805

PRINTS → 2994-0805 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-		UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test					
	03-81-05	15.75	Ea	S		
P50						

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2994-4785						2994-0806

PRINTS → 2994-0806 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test 03-81-05 15.75	Ea	S		
P50					

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2994-4783						2994-0807

PRINTS 2994-0807 → OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-		UNIT	CODE	SET-UP	PIECE RATE
284-A	Assemble and Test 03-81-05	15.75	Ea	S		
P50						

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25		2994-4781						2994-2016

→ PRINTS 2994-2016 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
5000-4900	Core	ea		1	
5300-3200	Winding Form	ea		1	
6084-1039	Diode	ea		1	

WORK STATION	-OPERATIONS-		UNIT	CODE	SET-UP	PIECE RATE
A10 A	Wind, adjust, and assemble					
	45	1.5	Ea	S		
J15B	Inspect					
P50						

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25		2994-4781						2994-2017

PRINTS → 2994-2017 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
5300-4903	Core	ea		1	
5300-3200	Winding Form	ea		1	
6084-1039	Diode	ea		2	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A10 A	Wind, adjust, and assemble				
	45 1.5	Ea	S		
J15 B	Inspect				
P50					

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25		2994-4781						2994-2018

PRINTS → 2994-2018 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-0547	Core	ea		1	
5300-3200	Winding Form	ea		1	
6084-1038	Diode	ea		2	

WORK STATION	-OPERATIONS-		UNIT	CODE	SET-UP	PIECE RATE
A10 A	Wind, adjust, and assemble					
	45	1.5	Ea	S		
J15 B	Inspect					
P50						

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25		2995-4855						2994-4766

→ PRINTS 2994-4766-1L, 2L, 3L, 4L
2994-4766, 2D-SS, 4766

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder				
	03-81-06 50 126.0	ea	S		
J16 B	Inspect				
L01 C	Test				
	01-82-07 60 242.40	ea	S		
Tool	8986-8163 Test Fixture				
Tool	8986-8169 Power Supply				
P50					

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25		2995-4855						2994-4781

PRINTS: 2994-4781-1L, 2L-3L -4781, 2D, FM

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder						
	03-81-06	50	108.0	ea	S		
J16B	Inspect						
L01 C	Test						
	01-82-07	60	342.0	ea	S		
Tool	8986-8167 Test Fixture						
8986-8170	Power Supply						
P50							

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25		2995-4860						2994-4783

PRINTS 2994-4783, 1L, 2L, 3L 2994-4783-2D
2994-4783

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder						
	03-81-06	50	105.0	Ea	S		
J16 B	Inspect						
L01 C	Test						
	01-82-07	60	203.0	Ea	S		
P50							

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25		2995-4855						2994-4784

PRINTS 2994-4784-1L-2L-3L-2DPS
-4784

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder				
	03-81-06 50 60.0	ea	S		
J16B	Inspect				
L01 C	Test. Match MEM-660 Return excess to P50				
	01-82-07 60 181.20	ea	S		
Tool	8986-8166 Test Fixture				
Tool	8986-8169 Power Supply				
P50					

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2994-4785

PRINTS 2994-4785-1L, 2L -4785, 2994-4785-2D-SD

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder				
	03-81-06 50 54.0	ea	S		
J16 B	Inspect				
L01 C	Match MEM-660 Return excess to P50				
	01-82-07 60 181.20	ea	S		
Tool	8986-8166 Test Fixture				
Tool	8986-8169 Power Supply				
P50					

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25		2995-4855						2994-4786

PRINTS 2994-4786-1L
-4786, 4786-2D-GI

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder						
	03-81-06	50	66.0	ea	S		
J16 B	Inspect						
L01 C	Test and calibrate						
	01-82-07	60	61.20	ea	S		
Tool	8986-8165 Test Fixture						
Tool	8986-8169 Power Supply						
P50							

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25		2995-4855						2994-4787

PRINTS 2994-4787-1L
-4787, 4787-2D-LI

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder						
	03-81-06	50	3.0	ea	S		
J16B	Inspect						
L01 C	Test and calibrate						
	01-82-07	60	61.20	ea	S		
Tool	8986-8165 Test Fixture						
Tool	8986-8169 Power Supply						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						0485-4073

PRINTS 0485-4073, & 1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
36 0285	ESMW-57-38-SNP	LB			.8
36 0205	ESMW-57-20-SNP	Ea			.7
0485-0290	Lead set	Ea		1	
0485-0730	Coil tube	Ea		1	
0485-0800	Lamination	Ea		100	
0485-8160	Clamp	Ea		2	
5810-0300	Hex Nut	Ea		2	
7840-0650	Stud	Ea		2	
7930-1800	Lkg. Terminal	Ea		1	
8040-2400	Split Lock Washer	Ea		3	
7270-1100	Spacer	Ea		2	

WORK STATION	-OPERATIONS-			UNIT	S/O	SET-UP	PIECE RATE
W15 A	Wind						
	03-83-06	66	21.50	Ea	S		
W35B	Asm. Complete						
	03-81-04	32	5.75	Ea	S		
J50 C	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2994-4788

PRINTS 2994-4788-1L-2L-3L -4788, 4788-2D-IF

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder				
	03-81-06 50 84.0	ea	S		
J16 B	Inspect				
L01 C	Test				
	01-82-07 60 241.20	ea	S		
Tool	8986-8168 Test Fixture				
Tool	8986-8168 Power Supply				
P50					

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ORDER QUAN	DRAFTING NO.	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0282

PRINTS 2995-0282-1L 2995-0375
2995-0282 2995-0377

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
0033 1700	ESMW-86	Ft		37.6"	
0030 3249	ESMW-5-2L-24	Ft		700"	

WORK STATION	OPERATIONS			UNIT	CODE	SET-UP	PIECE RATE
B01 A	Cut to length & service ends						
	03-84-05	35	5.0	Ea	S		
B73 B	Asm						
	03-81-04	5	15.0	Ea	S		
H20 C	Inspect						
B01 D	Braid						
	03-84-05	45	7.0	Ea	S		
J20 E	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0283

PRINTS →

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0030-3249	ESMW-5-2L-24	Ft		1000"	
4230-4024	Connector	Ea		1	

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B01 A	Cut to length & service ends						
	03-84-05	35	4.5	Ea	S		
B73 B	Asm						
	03-81-04	5	11.0	Ea	S		
H20 C	Inspect						
B01 D	Braid						
	03-84-05	65	9.0	Ea	S		
J20 E	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0284

PRINTS → 2995-0284 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0030-3240	ESMW-5-2L-24	Ft		17.2"	

WORK STATION	-OPERATIONS-				UNIT	CODE	SET-UP	PIECE RATE
B01A	Cut to length & service ends							
		03-84-05	20	3.0	Ea	S		
B73B	Assemble							
		03-81-04	5	2.5	Ea	S		
H20C	Inspect							
B01D	Braid							
		03-84-05	55	9.0	Ea	S		
J20E	Inspect							
P50								

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0370

→ PRINTS 2995-0370 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-2300	ESMW-93	Ft		11.5"	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73A	Cut to length service, Asm, & Solder				
	03-81-04 10 2.50	Ea	S		
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0371

→ PRINTS 2995-0371 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0032-5112	ESMW-31,3/16	Ft			
0030-3200	ESMW-5-22-20	Ft			

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B01 A	Cut to length & service ends						
	03-84-05	25	15.0	Ea	S		
B73 B	Asm						
	03-81-04	10	6.0	Ea	S		
H20 C	Inspect						
B01 D	Braid						
	03-84-05	50	4.5	Ea	S		
J20 E	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0373

→ PRINTS 2995-0373 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1700	ESMW-86	Ft		12.3"	
	ESMW-30-24	Ft			

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B01 A	Cut to length & Service Ends						
	03-84-05	10	3.00	Ea	S		
B73 B	Asm & Solder						
	03-81-04	5	6.00	Ea	S		
J20 C	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0379

PRINTS → 2995-0379 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1700	ESMW-86	Ft		13.8"	
	ESMW-30-24	Ft			

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B01A	Cut to length & service ends						
	03-84-05	10	3.00	Ea	S		
B73 B	Asm & Solder						
	03-81-04	5	6.00	Ea	S		
J20 C	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-0387

PRINTS → 2995-0387

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0034-5600	ESMW-53	Ft		19"	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B01 A	Asm & Service Ends				
	03-84-05 20 .50	Ea	S		
H20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1840

PRINTS → 2995-1840

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-0400	Eyelet	Ea		2	
1165-7000	Insulator	Ea		2	
1165-8000	Spring Clip	Ea		2	
1165-8010	Spring Clip	Ea		4	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B70 A	Asm and swage				
	02-82-04 10 2.00	Ea	S		
Tool	8986-2817 Punch and Anvil				
H20 B	Inspect				
P50					

PARTIAL QUANTITY RECORD

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1841

PRINTS → 2995-1840

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
1165-4000	Eyelet	Ea		2	
1165-7000	Insulator	Ea		2	
1165-8000	Spring Clip	Ea		2	
1165-8010	Spring Clip	Ea		2	

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B70 A	Asm and swage						
	02-82-04	10	2.00	Ea	S		
Tool	8986-2817 Punch and Anvil						
H20 B	Inspect						
P50							

PARTIAL QUANTITY RECORD

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-2872						2995-1842

PRINTS → 2995-1840

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-0400	Eyelet	ea		2	
1165-7000	Insulator	ea		2	
1165-8000	Spring Clip	ea		2	
1165-8010	Spring Clip	ea		4	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B70 A	Assemble and Swage				
	02-82-04 10 2.0	Ea	S		
Tool	8986-2817 Punch and Anvil				
M20 B	Inspect				
P50					

PARTIAL QUANTITY RECORD

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OPERATION SHEET

START DATE:
DUE DATE:

ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1843

PRINTS → 2995-1843 → OFFICE ORDER

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
10 1286	AL. 090X36X48 5052 H32 15 1/2# P55	LB	1		.09
5440-0600	Insert	Ea		3	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. and shear apart 120 pcs. off 02-82-07 31 .82	Ea	S		
Tool	8986-8178 NC Tape				
M76 B	Form 02-82-05 29 .50	Ea	S		
M49 C	Tap "A" Holes Asm and swage Inserts				
H82 D	Inspect				
011 E	Finish ESFC-2				
H30 F	Inspect				
P50					

PARTIAL QUANTITY RECORD

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OPERATION SHEET

START DATE
DUE DATE

ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1850

PRINTS 2995-1840

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-4000	Eyelet	Ea		2	
1165-7000	Insulator	Ea		2	
1165-8000	Spring Clip	Ea		2	
1165-8010	Spring Clip	Ea		2	

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B70 A	Asm and swage						
	02-82-04	10	2.00	Ea	S		
Tool	8986-2817 Punch and Anvil						
H20 B	Inspect						
P50							

PARTIAL QUANTITY RECORD

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DUE DATE: _____

ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1860

→ PRINTS 2995-1860 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 4210	AL. 1 5/16 Dia 2011 T3	LB			
7250-0554	Set Screw	Ea		1	

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M80 A	C'Bore & .250 Dia						
	02-83-06	40	2.20	Ea	S		
M02 B	Drill & Tap A77						
	02-83-04	17	.70	Ea	S		
Tool	8986-8177 Drill Fixture						
E12 C	Groove						
	04-83-05	30	.40	Ea	S		
M88 D	Clean						
	04-82-04	5	5.00	Ea	S		
N25 E	Finish						
	04-84-06	16	1.60	Ea	S		
E12 F	Fill 04-83-05	10	.25	Ea	S		
H82 G	Inspect						
P50							

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START DATE: _____

DUE DATE: _____

ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1865

PRINTS → 2995-1865

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
21 1117	Phen. .062 XXS BK	LB.			.01
1160-6016	Spacer	Ea		4	
7976-2200	Terminals	Ea		15	
5170-0750	Eyelet	Ea		15	

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Cut to size						
	02-83-06	16	.55	Ea	S		
M02 B	Drill						
	02-83-04	18	.61	Ea	S		
Tool	8986-8179 Drill Fixture						
E13 C	Mark						
	04-83-04	30	.21	Ea	S		
Tool	8986-8180 Silk Screen						
M49 D	Asm and Swage						
	02-82-05	30	3.05	Ea	S		
H82 E	Inspect						
P50							

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ORDER QUAN	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1866

PRINTS → 2995-1867

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-0543	Lens Cap	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
E12A	Engrave 04-83-06 30 .40	Ea	S		
H70 B	Inspect				
P50					

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START DATE:
DUE DATE:

ORDER QUAN	DRAFTING NO.	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1867

PRINTS → 2995-1867

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-0543	Lens Cap	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
E12 A	Engrave				
	04-83-06 30 .40	Ea	S		
H70 B	Inspect				
P50					

PARTIAL QUANTITY RECORD

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1870

→ PRINTS 2995-1871 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
2995-0540	Shell Asm	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
E12 A	Disassemble cap from switch, engrave, and reassemble 04-83-06 50 .60	Ea	S		
H70 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1871

PRINTS → 2995-1871

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-0540	Shell Asm	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
E12 A	Disassemble cap from switch, engrave and reassemble 04-83-06 50 .60	Ea	S		
H70 B	Inspect				
P50					

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
75		2995-4855						2995-1875

PRINTS 2995-4855-8L
2995-1875

→

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION		UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
1167-1100	Knob Asm	P50			1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
E12 A	Engrave & Fill 04-83-06 20 .9				
H70	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2994-4765

PRINTS

2994-4765-1L & 2L
2994-4765 & 2994-4765-2D-V, 1 & 2

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A25 A	Assemble and solder				
	03-81-06 50 96.0	ea	S		
J16 B	Inspect				
L01 C	Calibrate				
	01-82-07 60 302.40	ea	S		
Tool	8986-8164 Test Fixt.				
P50					

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1880

PRINTS
2995-4855-7L
2995-1880, 2995-8887/A

→ OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 1266	AL .063X36X48 5052 H#	LB	1		

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf & Shear 10 pcs off						
	02-82-07	21	2.8	Ea	S		
Tool	8986-8193 NC Tape						
M76 B	Form						
	02-82-05	24	.5	Ea	S		
M26 C	Osc Sand Face						
	02-83-04	12	.80	Ea	S		
011 D	Finish per ESFC-2						
E13 E	Mark						
	04-83-04	30	2.50	Ea	S		
Tool	8986-8194 Silkscreen						
N25F	Finish						
	04-84-05	10	1.5	Ea	S		
H82 G	Inspect						
M49 H	Asm, & Swage Inserts						
	02-82-05	5	1.80	Ea	S		
Tool							
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1888

PRINTS

→ 2995-1888 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 1266	AL. 063X36X48 5052 H32 11# P55	LB	1		.9

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. and shear apart 12 pcs. off 02-82-07 80 2.50	ea	S		
Tool	8986-8171 NC Tape				
M76 B	Form 02-82-05 36 .50	ea	S		
M49 C	Asm and swage inserts 02-82-04 18 1.20	ea	S		
H82 D	Inspect				
011 E	Finish ESFC-2				
H30 F	Inspect				
P50					

PARTIAL QUANTITY RECORD

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1889

PRINTS 2995-1889

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 1266	AL. 063X36X48 5052 H32 #11 P55	LB	1		.9

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M31A	Perf. and shear apart 12 pcs. off				
	02-82-07 80 2.50	Ea.	S		
Tool	8986-8172 NC Tape				
M76 B	Form				
	02-82-05 36 .50	Ea.	S		
M49 C	Asm and swage Inserts				
	02-82-04 18 1.20	Ea.	S		
H82 D	Inspect				
011 E	Finish ESFC-2				
H30 F	Inspect				
P50					

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1890

→ PRINTS 2995-1890/1 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 1266	AL .063X36X48 5052 H32 11# P55	LB	1		.6
5440-0600	Inserts	Ea		10	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. & Shear apart 18 pcs. off				
	02-82-07 31 3.60	Ea	S		
Tool	8986-9414 NC Tapes				
M76 B	Form, Extrude				
	02-82-05 29 2.4	Ea	S		
M49 C	Asm. & Swage Inserts				
	02-82-04 15 2.4	Ea	S		
H82 D	Inspect				
011 E	Finish per ESFC-2				
H30 F	Inspect				
P50					

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1891

PRINTS → 2995-1891 & 1891/A → OFFICE ORDER

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
10 1430	AL .250X24X48 2024-T4	LB			2.97

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Cut to size ± .005						
	02-83-06	16	2.55	ea			
M42 B	Perf & Mill						
	02-82-04	130	44.	ea			
Tool	8986-8174 NC Tape						
M21 C	Osc Sand Face and Bev Edges						
	02-83-04	12	2.78	ea			
M88 D	Ultrasonic Degrease						
	04-82-04	5	5.0	ea			
011 E	Finish ESFC-2						
H30 F	Inspect						
N25 G	Finish ESFO-7						
	04-84-06	25	3.59	ea			
E13 H	Mark						
	04-84-04	35	4.40	ea			
Tool	8986 Silk Screen						
H82 I	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1893

→ PRINTS 2995-1893 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 1286	AL. 090X36X48 5052 H32 15/12 P55	LB			1.84
5440-0600	Insert	Ea		15	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. and shear apart 6 pieces off 02-82-07 129 3.570	Ea	S		
Tool	8986-8176 NC Tape				
M76 B	Form 02-82-05 58 1.00	Ea	S		
M49 C	Tap "J" Holes, Asm. and swage Inserts 02-82-05 15 3.15	Ea	S		
H82 D	Inspect				
011 E	Finish ESFC-2				
H30 F	Inspect				
P50					

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ORDER QUAN	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2887						2995-1903

PRINTS
2995-1903, 2995-1904, 2995-8904

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
2995-8903	Septum	Ea		1	
2995-8904	Bracket	Ea		1	
1165-1000	End Plate Asm	Ea		2	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B70 A	Asm and spot weld 02-82-07 15 .30	Ea	S		
Tool	8986-2855 spot weld fixture				
H20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1982

PRINTS 2995-1982 ESPM-200 ESPM-229 ESPM-243

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		1.4"	
2995-6875	Plug, Coax.	Ea		1	
4220-0210	Plug, Coax.	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service, form, asm, & mark 03-81-04 15 1.5	Ea	S		
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-1983

→	PRINTS		OFFICE ORDER →
	2995-1983	ESPM-243 ESPM-229	

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		4.5"	
4220-0220	Plug, Coax.	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service, form, Asm, & Mark 03-81-04 20 2.5	Ea	S		
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2856

PRINTS

→ 2995-2856 0874-280L
2995-4855-3L 0874-280D

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		7.5"	
0874-4493	Conn. Asm. Panel Locking	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73A	Cut to length, service form, Asm, Asm cables per dwg. and mark 03-81-04 45 5.5	EA	S		
Tool	8986-8181 Form & Fixt.				
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4860						2995-2857

→ PRINTS 2995-2857, ESPM-243, ESPM-200 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2	Ft		.9'	
1165-6035	Bushing	Ea		2	
1165-6040	Cone	Ea		2	
4220-0210	Coax. Plug	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service & form				
	Asm. & solder mark				
	03-81-04 10 2.40	Ea	S		
Tool	8986-5950 Forming Fixt.				
J20B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2858

PRINTS 2995-2858 2995-4855-3L

→ ESPM-182 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
33 1210	ESMW-46-2 Cable	Ft		1.5"	
4220-0220	Plug, Coax.	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service and form				
	Asm and Solder Mark				
	03-81-04 45 5.70	Ea	S		
Tool	8986-5946 Forming Fixt				
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2859

PRINTS 2995-2859, 2995-4855-3L
0874-280L 0874-280D

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033 1210	ESMW-46-2 Cable	Ft.		5.5"	
0874-4493	Connector Asm, Locking Panel	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service, form, solder and assemble, mark				
	03-81-04 45 5.5	Ea	S		
Tool	8986-8182 Forming Fixt.				
J16 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4860						2995-2861

PRINTS → 2995-2861

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Wire	Ft		.4'	
4220-0220	Plug, Coax.	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length service form Asm & solder mark				
	03-81-04 10 2.00	Ea	S		
Tool	8986-5955 Forming Fixt.				
J20 B	Inspect				
P50					

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DUE DATE: _____

ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2862

PRINTS → 2995-2862, 2995-4855-1L → OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
33-1210	ESMW-46-2 Cable	Ft		1.5'	
2995-8892	Connect, BNC	ea		1	
1165-6240	Bushing	ea		1	
4220-0220	Plug, Coax.	ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service, form, assemble, solder and mark				
	03-81-04 34 15.38	Ea	S		
J20 B	Inspect				
P50					

PARTIAL QUANTITY RECORD

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ORDER QUAN	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2864

PRINTS → 2995-2864, 2995-4855-3L → OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		4.25"	
1165-6035	Bushing	Ea		2	
1165-6040	Cone	Ea		2	
5305-0138	Solder Form	Ea		2	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service, form Asm, solder, Asm cables per dwg. and mark				
	03-81-04 45 5.4	Ea	S		
Tool	8986-8183 Forming Fixt.				
J16B	Inspect				
P50					

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ORDER QUAN	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2865

PRINTS
2995-2865 2995-4855-4L
ESMP-182

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		2.5'	
4220-0220	Plug, Coax	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service, form ass. solder, Asm. cables per dwg. and mark 03-81-04 60 7.50	Ea	S		
Tool	8986-8184 Forming fixt.				
J20 B	Inspect				
P50					

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2866

PRINTS 2995-2866 2995-4855-4L 0874-280-D 0874-280-L

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		7.25"	
0874-4493	Connector Asm, Panel Locking	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	S D E	SET-UP	PIECE RATE
B73 A	Cut to length, service, form solder, Asm cables per dwg. and mark 03-81-04 55 7.0	Ea	S		
Tool	8986-8185 Forming Fixt.				
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2867

PRINTS 2995-2867, 2995-4855-4L
0874-280D, 0874-280L
ESPM-182

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		9.5"	
0874-4493	Connector Asm, Panel, Locking	Ea		1	
4220-0220	Plug, Coax.	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, assemble, 0874-6523 and solder form, and assemble				
	03-81-04 60 7.50	Ea	S		
Tool	8986-8186 Forming Fixt.				
J16 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2868

→ PRINTS 2995-2868, 2995-4855-4L
0874-280L 0874-280D
OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		11.5"	
0874-4493	Connector Asm, Panel Locking	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, assemble, form, solder & mark				
	03-81-04 55 6.75	Ea	S		
Tool	8986-8185 Forming Fixt.				
J16 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2869

→ PRINTS 2995-4855-4L, 2995-2869 ESMP-169 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		8.0"	
4260-1190	Connector, Bulkhead	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form				

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73A	Cut to length, service, form, assemble, and mark				
	03-81-04 45 5.4	Ea	S		
Tool	Forming Fixture				
J16 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4860						2995-2855

PRINTS
2995-2855
ESPM-200, ESPM-243

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	~~ESMW-46-2~~	Ft		2"	
4220-0210	Plug, Coax.	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Cut to length, service ends & mark				
	03-81-04 10 2.50	Ea	S		
Tool	8986-5949 Forming Fixt.				
J20 B	Inspect				
P50					

PARTIAL QUANTITY RECORD

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2872						2995-2870

PRINTS 2995-2871, 2995-2872-1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-8006	End Rail	Ea		2	
1165-8103	Side Rail	Ea		2	
1165-8113	Contact Strip	Ea		2	
1165-8116	End Contact Strip	Ea		2	
2995-8875	Tray Pierced	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M70 A	Asm and spot-weld per ESPM-151-1				
	02-82-04 24 5.79	Ea	S		
Tool	8986-2743 Spot weld fixture				
N20 B	Finish per WSPF-1 and ultrasonic clean 1 minute to remove plating fluids				
	04-81-06 5 .89				
P50					

PARTIAL QUANTITY RECORD

FROM	TO	NO. OF PCS.	INSP. & DATE	CLOSE SHORT

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START DATE:
DUE DATE:

ORDER QUAN.	DRAFTING NO	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2872

PRINTS 2995-2872, 2995-2872-1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-2871	Tray Asm	ea		1	
1165-0401	Eyelet	ea		12	
1165-1811	Contact Strip Asm	ea		1	
1165-1820	Contact Strip Asm	ea		1	
1165-1826	Contact Strip Asm	ea		2	
1165-1830	Contact Strip Asm	ea		1	
1165-1842	Contact Strip Asm	ea		1	
1165-6020	RF Insert	ea		2	
1165-8770	Capacitor	ea		7	
1165-1020	End Place Asm	ea		1	
1165-1021	End Plate Asm	ea		1	
7110-1495	Screw, cap. .138-32 x .312	ea		2	
5000-1267	Toroid core	ea		7	

STATION	-OPERATIONS-	UNIT	C/S/D	SET-UP	PIECE RATE
B70 A	Asm per ESPM-151-1, 1.0 and 1.1 less soldering and per ESPM-151-2, 5.0 and 5.1 less soldering 02-82-04 45 2.05	Ea	S		
Tool	8986-2830 Punch and Anvil				
Tool	8986-2815 Punch and Anvil				
B73 B	Asm per ESPM-151-2, 6.0, 6.1, and 6.4 less solder Solder per ESPM-151-1, 1.1, ESPM-151-2, and 5.1 and 6.1 when above operations are complete, solder per ESPM-151-2, 6.2, and ESPM-151-3, 9.3 Asm per ESPM-151-4, 11.0, 11.1, 11.2 Pack to prevent damage, freon clean and repack 02-82-04 35 4.50	Ea	S		
H20 C	Inspect and Repack				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2875						2995-2873

PRINTS
2995-2874, 2995-2875-1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-8006	End Rail	Ea		2	
1165-8103	Side Rail	Ea		2	
1165-8113	Side Contact Strip	Ea		2	
1165-8116	End Contact Strip	Ea		2	
2995-8876	Tray Pierced	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M70 A	Asm and spot weld per ESPM-151-1 02-82-04 24 5.79	Ea	S		
Tool	8986-2843 Spot weld fixture				
N20 B	Finish per ESPF-1 and ultrasonic Clean 1 minute to remove plating fluids 04-81-06 5 .89	Ea	S		
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2875

PRINTS: 2995-2872, 2995-2875-1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-2874	Tray Asm	ea		1	
1165-0401	Eyelet	ea		8	
1165-1811	Contact Strip Asm	ea		1	
1165-1830	Contact Strip Asm	ea		1	
1165-1831	Contact Strip Asm	ea		1	
1165-1835	Contact Strip Asm	ea		1	
1165-6020	RF Insert	ea		2	
4500-7556	Choke, molded 200 µf	ea		2	
4450-6531	Cap, Tant, 4.7 µf	ea		4	
5280-1253	Filter, Elec. L.P. 100 MHz	ea		8	
1165-1020	End Plate Asm	ea		1	
1165-1021	End Plate Asm.	ea		1	
7110-1495	Screw, Cap. .138-32 X .312	ea		2	
6250-1140	RSTF, film, 1.40K ± 1% 1/8	ea		1	
6250-1221	RSTF, film 2.21K ± 1/8	ea		1	
2995-6880	Insert	ea		8	
7940-0200	Terminal	ea		1	

WORK STATION	-OPERATIONS-	UNIT	C D	SET-UP	PIECE RATE
B70 A	Asm per ESPM-151-1, 1.0 and 1.1 less soldering and per ESPM-151-2, 5.0 and 5.1 less soldering 02-82-04 45 2.05	Ea	S		
Tool	8986-2830 Punch and Anvil				
Tool	8986-2815 Punch and Anvil				
B73 B	Asm per ESPM-151-2, 6.0, 6.1 and 6.4 less solder solder per ESPM-151-1, 1.1, ESPM-151-2, 5.1 and 6.1 when above operations are complete, solder per ESPM-151-2, 6.2, and ESPM-151-3, 9.3 Asm per ESPM-151-4, 11.0, 11.1, 11.2 Pack to prevent damage, freon clean and repack 02-82-04 35 4.50	Ea	S		
H20 C	Inspect and repack				
P50					

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-2878						2995-2876

PRINTS → 2995-2877, 2995-2878-1L → OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-8006	End Rail	Ea		2	
1165-8101	Side Rail	Ea		2	
1165-8111	Side Contact Strip	Ea		2	
1165-8116	End Contact Strip	Ea		2	
2995-8877	Tray Pierced	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M70 A	Asm and spot weld per ESPM-151-1 02-82-04 24 5.79	Ea	S		
Tool	8986-2834 Spot weld fixture				
N20 B	Finish per ESFP-1 and ultrasonic clean 1 minute to remove plating fluids 04-81-06 5 .89	Ea	S		
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2878

PRINTS 2995-2872, 2995-2878-1L

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
2995-2877	Tray Asm	ea		1	
1165-0401	Eyelet	ea		6	
1165-1813	Contact Strip Asm	ea		1	
1165-1828	Contact Strip Asm	ea		1	
1165-1829	Contact Strip Asm	ea		1	
1165-6020	RF Insert	ea		3	
4300-7556	Choke, molded 220 µH	ea		2	
4150-6531	Cap. Tant. 4.7 µf	ea		2	
5280-1253	Filter, Elec. L.P. 100 MHz	ea		2	
1165-1020	End Plate Asm.	ea		2	
1165-1021	End Plate Asm.	ea		1	
7110-1495	Screw, Cap. 138-32 X .312	ea		2	
5810-3100	Nut, Hex. 164-32	ea		2	
2995-6880	Insert	ea		2	

OPERATION	OPERATIONS	C D E	UNIT	SET-UP	PIECE RATE
B70 A	Asm per ESPM-151-1, 1.0 and 1.1 less soldering and per ESPM-151-2, 5.0 and 5.1 less soldering 02-82-04 45 2.05		Ea S		
Tool	8986-2830 Punch and Anvil				
Tool	8986-2815 Punch and Anvil				
B73 B	Asm per ESPM-151-2, 6.0, 6.1 and 6.4 less solder Solder per ESPM-151-1, 1.1, ESPM-151-2, 5.1 and 6.1 When above operations are complete, solder Per ESPM-151-2, 6.2, and ESPM-151-3, 9.3 Asm per ESPM-151-4, 11.0, 11.1, 11.2 Pack to prevent damage, freon clean and repack 02-82-04 35 4.50		Ea S		
H20 C	Inspect and repack				
P50					

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ORDER QUAN	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2879

PRINTS → 2995-2879, 2995-4855-4L ESPM-169

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		12,5"	
4260-1190	Connector, Bulkhead	Ea		1	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73A	Cut to length, service, form, assemble & mark				
	03-81-04 50 6.0	Ea	S		
Tool	Forming Fixture				
J16 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2881						2995-2880

PRINTS 2995-2880, 2995-2881-1L

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-8006	End Rail	Ea		2	
1165-8101	Side Rail	Ea		2	
1165-8111	Side Contact Strip	Ea		2	
1165-8116	End Contact Strip	Ea		2	
2995-8878	Tray pierced	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M70 A	Asm and spot weld per ESPM-151-1				
	02-82-04 24 5.79	Ea	S		
Tool	8986-2834 spot weld fixture				
N20 B	Finish per ESFP-1 and ultrasonic				
	Clean 1 minute to remove plating fluids				
	04-81-06 5 .89	Ea	S		
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2881

PRINTS 2995-2872, 2995-2881-1L

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-2880	Tray Asm	Ea		1	
1165-0401	Eyelet	ea		6	
1165-1813	Contact Strip Asm	ea		1	
1165-1828	Contact Strip Asm	ea		1	
1165-1830	Contact Strip Asm	ea		1	
1165-6020	RF Insert	ea		4	
4300-7556	Choke, molded 220 µf	ea	C	2	
4450-6531	Cap. Tant. 4.7 µf	ea	D	2	
5280-1253	Filter, Elec. L.P. 100 MHz	ea		2	
1165-1020	End Plate Asm.	ea		1	
1165-1021	End Plate Asm.	ea		1	
7110-1495	Screw, Cap. 138-32 X .312	ea		2	
5810-3100	Nut, Hex .164-32	ea		2	
2995-6880	Insert	ea		2	

STATION	OPERATIONS	UNIT		SET-UP	PIECE RATE
B70 A	Asm per ESPM-151-1, 1.0 and 1.1 less soldering and per ESPM-151-2, 5.0 and 5.1 less soldering 02-82-04 45 2.05	Ea	S		
Tool	8986-2830 Punch and Anvil				
Tool	8986-2815 Punch and Anvil				
B73 B	Asm per ESPM-151-2, 6.0, 6.1, and 6.4 less solder Solder per ESPM-151-1, 1.1, ESPM-151-2, 5.1, and 6.1 When above operations are complete, solder per ESPM-151-2, 6.2, and ESPM-151-3, 9.3 Asm per ESPM-151-4, 11.0, 11.1, 11.2 Pack to prevent damage, freon clean and repack 02-82-04 35 4.50	Ea	S		
H20 C	Inspect and repack				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2886						2995-2885

→ PRINTS 2995-2886, 2995-2887-1L OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
1165-8006	End Rail	Ea		2	
1165-8103	Side Rail	Ea		2	
1165-8113	Side Contact Strip	Ea		2	
1165-8115	End Contact Strip	Ea		2	
2995-8879	Tray Pierced	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M70 A	Asm and spot weld per ESPM-151-1				
	02-82-04 24 5.79	Ea	S		
Tool	8986-2814 Spot Weld Fixture				
Tool	8986-5563 Spot Weld Fixture				
N20 B	Finish per ESFP-1 and ultrasonic clean 1 minute to remove plating fluids				
	04-81-06 5 .89	Ea	S		
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2887

PRINTS 2995-2887, 2995-2887-1L → OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
2995-2886	Tray Asm	ea		1	
1165-0401	Eyelet	ea		12	
1165-1849	Contact Strip Asm	ea		1	
1165-1852	Contact Strip Asm	ea		1	
2995-1840	Contact Strip Asm	ea		2	
2995-1841	Contact Strip Asm	ea		1	
2995-1850	Contact Strip Asm	ea		1	
1165-8020	RF Insert	ea		2	
1165-8770	Capacitor	ea		6	
4300-7556	Choke, molded 220 µH ± 10%	ea		2	
4450-6531	Cap., Tant. 4.7µG, ± 20%, 25V	ea		2	
5280-1253	Filter, Elec, L.P. 100MHz	ea		2	
5810-3100	Nut, Hex. 164-32	ea		2	
7110-1495	Screw, Cap .138-32 X .312	ea		2	
2995-1903	Septum Asm	ea		1	
2995-6880	Insert	ea		2	
7940-0600	Terminal	ea		2	

-OPERATIONS-				UNIT		SET-UP	PIECE RATE
B70 A	Asm per ESPM-151-1, 1.0 and 1.1 less soldering and per ESPM-151-2, 5.0 and 5.1 less soldering						
	02-82-04	45	2.05	Ea	S		
Tool	8986-2830 Punch and Anvil	B70					
Tool	8986-2815 Punch and Anvil	B70					
B73 B	Asm per ESPM-151-2, 6.0, 6.1, and 6.4 less solder						
	Solder per ESPM-151-1, 1.1, ESPM-151-2, 5.1 and 6.1						
	When above operations are complete, solder						
	per ESPM-151-2, 6.2, and ESPM-151-3, 9.3						
	Asm chokes, caps, and filters						
	Asm per ESPM-151-4, 11.0, 11.1, 11.2						
	Pack to prevent damage						
	Freon clean and repack						
	02-82-04	35	4.50	Ea	S		
H20 C	Inspect and repack						
P50							

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
		2995-4855						2995-2890

PRINTS 2995-2890-1L 2995-4855-5L
2995-2890

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
10 1315	AL .125X36X48 3003 H14	$/50	IN	1561 lbs	11.2000
10 1286	AL .090X36X48 5052 H32	$/50	IN	16	1.15
5440-4430	Insert Tapped	Ea		4	
5860-0503	Pad, Tapping	Ea		4	

WORK STATION	-OPERATIONS-			UNIT	S O E	SET-UP	PIECE RATE
M25 A	Shear to size						
	02-82-05	36	.328	Ea	S		
M01 B	Slot						
	02-83-06	16	.550	Ea	S		
M31 C	Perf. & Shear - 8895, 8896, 8897						
	02-82-07	21	.150	Ea	S		
Tool	8986-5943 NC TAPE 8895						
Tool	8986-5993 NC TAPE 8896						
M02 D	C'Bore "E" holes						
	02-83-04	10	2.0	Ea	S		
M76 E	Form - 8895, & 8896						
	02-82-05	15	.25	Ea	S		
M88 F	Clean per ESPM-40						
	04-82-04	5	3.00	Ea	S		
M90 G	Asm. & weld 2995-2890 and square up						
	02-82-05	50	20.00	Ea	S		
M26 H	Blend corner weld, grind, & file inside & outside edge and gage open end						
	02-83-07	20	15.00	Ea	S		
M49 I	Asm. & Swage Insert						
	02-82-04	10	.10	Ea	S		
M02 J	Drill & Tap "C" holes						
	02-83-04	5	.25	Ea	S		
Tool	8986-5944 Drill Fixt.						
M88 K	Ultrasonic Degrease						

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25		2995-4855						2995-2890

PRINTS →

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
	04-82-04	5	3.00	Ea	S		
M26 L	Osc. Sand						
	02-83-04	5	7.50	Ea	S		
N25 M	Finish						
	04-84-05	15	4.50	Ea	S		
M26 N	Sand paint from front edge if necessary						
	02-83-04	2	.55	Ea	S		
H82 0	Inspect						
P50							

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2891

→ PRINTS 2995-4855-5L, 2995-2891 OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
7890-6202	Switch, wafer Rotary	Ea		1	
6010-2200	Pot 500Kr	Ea		1	
6250-0287	Resistor 287r	Ea		1	
6250-0499	Resistor 499r	Ea		1	
6250-1158	Resistor 1.58r	Ea		1	
ESMW-30-20	Wire	Ft		1	
5810-1000	Nut, Hex .375-32, 500 Br	Ea	C	1	
8050-0400	Washer, Lock Int'l tooth, .375 Np	Ea	D	1	

-OPERATIONS-

		UNIT	CODE	SET-UP	PIECE RATE
B73 A	Asm & Solder				
	03-81-04 10 25	Ea	S		
J20 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2892

PRINTS → 2995-2892

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
7890-6203	Switch	Ea		1	
	ESMW-30-24				

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
B73 A	Asm & Solder						
	03-81-04	5	15.38	Ea	S		
J20 B	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2893

PRINTS → 2995-2893, -4855-3L ESPM-182 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0033-1210	ESMW-46-2 Cable	Ft		3.5"	
1165-6035	Bushing	Ea		1	
1165-6040	Cone	Ea		1	
4220-0220	Plug, Coax.	Ea		1	
5305-0138	Solder Form	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73A	Cut to length, service, form, Asm, & Solder, mark				
	03-81-04 45 5.40	Ea	S		
Tool	Forming Fixture				
J16B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2894

PRINTS 2995-4855-7L
2995-2894

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
B73 A	Disasm. Rear Plate				
	Reassemble				
	with 2995-6870, 7884				
	02- -04 5 4.5				
P50					

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-2897

PRINTS
2995-2897

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
10-1266	AL .063 ± .006, 5052-H32 P55	LB			.02
5167-4045	PAD	Ea		1	

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M49 A	Perf & Form						
	02-82-05	30	3.2				
M88 B	Degrease						
	04-82-04	5	.70				
M49 C	Cement Pad						
	02-82-04	5	.72				
P50							

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-4850

PRINTS → 2995-4850, 2995-4855-6L

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
A75 A	Assemble complete & mark						
	03-81-06	15	29.0	Ea	S		
L01 B	Test and calibrate						
	01-82-08	15	15.0	Ea	S		
J20 C	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4860						2995-6850

PRINTS → 2995-6850 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0014-4110	Cut 3/8 dia. round rod	In		2.750"	110

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M85 A	Machine OD & ID						
	02-83-05	35	.77	Ea	S		
N20 B	Finish						
	04-81-06	5	.89	Ea	S		
H82 C	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-6852

PRINTS →

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
5360-2017	Handle	Ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
011 A	Finish per GenRad Co. ESFO-16, BK				
	04-81-06 5 2.5				
H30 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25								2995-9503

→ PRINTS DRAWN OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
A75 A	Assemble and Complete				
	03-81-08 120 2200.00	Ea	S		
L01 B	Check and Calibrate				
	01-82-09 60 2400.00	Ea	S		
Y10 C	Assemble parts OL				
Y11 D	Wrap				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2994-4765						2995-6855

→ PRINTS 2995-6855 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
	ESMM-1 Leaded Commercial Bronze 1/2 H	LB		.4	.00

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size						
	02-83-06	10	.20	Ea	S		
M02 B	Drill						
	02-83-04	5	.15	Ea	S		
M37 C	Turn to size						
	02-83-06	12	.30	Ea	S		
M88 D	Degrease						
	04-82-04	5	.01	Ea	S		
N20 E	Plate per ESFP-1						
	04-81-06	5	8.00	Ea	S		
H82 F	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
		2995-2899						2995-6870

→ PRINTS 2995-4855-7L
2995-6870
OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
12-1380	BRS .091 x 12 x 72 260 ½ H	LB			.18

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size						
	Finish edges						
	02-83-06	16	1.3				
M02 B	Drill & Burr						
	02-82-05	15	1.8				
N20 C	Finish						
	ESFP-24						
	04-81-06	10	10				
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-7860

→ PRINTS 2995-7860 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
4320-1100	Cable Holder, Quadruple	Ea.			

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M02 A	Drill				
	02-83-04 10 .55	Ea.			
H82 B	Inspect				
P50					

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AD-A055 085 GENRAD INC CONCORD MA F/G 14/2
TRACKING SERVOBRIDGE DETECTORS. VOLUME III. OPERATION SHEETS.(U)
DEC 76 W J RILEY, W M TWADELL DAAB07-73-C-0609
UNCLASSIFIED 24655-VOL-3 NL

2 OF 2
AD
A055 085



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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
		2995-2894						2995-7884

PRINTS 2995-7884

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
0067-9020	Silver/Silicone sheet	SI			6.6

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31 A	Shear						
	02-82-07	15	.8				
M02 B	Drill						
	02-83-05	15	1.8				
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4855						2995-8840

PRINTS 2995-8840

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 4460	AL 3" Dia 2011-73	LB			.2

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size						
	02-83-06	16	.55	Ea	S		
M80 B	Perf. & C'Bore (spot face)						
	02-83-06	90	2.10	Ea	S		
M88 C	Ultrasonic Degrease						
	04-82-04	5	5.00	Ea	S		
N25 D	Finish						
	04-84-05	11	.25	Ea	S		
E12 E	Engrave & Fill						
	04-83-04	30	1.50	Ea	S		
H82 F	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2872						2995-8875

→ PRINTS 2995-8875 & 2995-8875A OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
12 1016	Brs .016X24X36 CDA 260 1/2H	LB			1 .25

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. Osc Snd						
	Remove Burrs and shear apart						
	02-82-07	30	.250	Ea	S		
Tool	8986-8187 NC TAPE						
M49 B	Stamp O						
	02-82-04	15	.20	Ea	S		
M88 C	Ultrasonic Degrease						
	04-82-04	5	2.00	Ea	S		
M30 D	Form						
	02-82-05	30	.22	Ea	S		
Tool	8986-2186 Die Set						
Tool	8986-2844 Punch & die						
M88 E	Clean per ESPM-40						
	04-82-04	5	2.00	Ea	S		
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2875-1L						2995-8876

PRINTS 2995-8876
2995-8876A 2995-8875

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
12 1016	BRS .016X24X36 CDA 260 1/2H	LB			1 25

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31A	Perf, Osc sand, Remove Burr & Shear apart						
	02-82-07	30	.250	Ea	S		
Tool	8986-8188 NC TAPE						
M49 B	Stamp O						
	02-82-04	15	.20	Ea	S		
M88 C	Ultrasonic Degrease						
	04-82-04	5	2.00	Ea	S		
M30 D	Form						
	02-82-05	30	.22	Ea	S		
Tool	8986-2186 Die Set						
Tool	8986-2844 Punch & Die						
M88 E	Clean per ESPM-40						
	04-82-04	5	2.00	Ea	S		
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-2878						2995-8877

PRINTS → 2995-8887A 2995-8875 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
12 1016	Brs. .016X24X36 CDA 260 1/2 H	LB			1 25

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf, Osc sand, Remove burrs & shear apart				
	02-82-07 30 .25	Ea	S		
Tool	8986-8189 NC TAPE				
M49 B	Stamp O				
	02-82-04 15 .20	Ea	S		
M02 C	Open .172 holes to .196				
	02-83-05 3 .06	Ea	S		
M88 D	Ultrasonic Degrease				
M30 E	Form				
	02-82-05 5 2.00	Ea	S		
Tool	8986-2186 Die Set				
Tool	8986-2842 Panel D				
M88 F	Clean per ESPM-40				
	04-82-04 5 2.00	Ea	S		
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2881						2995-8878

PRINTS 2995-8878A 2995-8875

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
12 1016	Brs. .016X24X36 CDA 260 1/2H	LB			1 25

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. Osc Sand, Remove burrs, & Shear apart						
	02-82-07	30	.25	Ea	S		
Tool	8986-8190 NC TAPE						
M49 B	Stamp 0						
	02-82-04	15	.20	Ea	S		
M02 C	Open .172 Holes to .196						
M88 D	Ultrasonic Degrease						
	04-82-04	5	2.00	Ea	S		
M30 E	Form						
	02-82-05	30	.22	Ea	S		
Tool	8986-2186						
Tool	8986-2842						
M88 F	Clean per ESPM-40						
	04-82-04	5	2.00	Ea	S		
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2887						2995-8879

PRINTS → 2995-8879, 2995-8879A → OFFICE ORDER

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
12 1016	Brs. .016X24X36 CDA 260 1/2H	LB			1 25

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. Osc Sand Remove Burrs, shear apart						
	02-82-07	30	.25	Ea	S		
Tool	8986-8191 NC TAPE						
M49 B	Stamp O						
	02-82-04	15	.20	Ea	S		
M02C	Open .172 holes to .196						
M88 D	Ultrasonic Degrease						
	04-82-04	5	2.00	Ea	S		
M30 E	Form						
	02-82-05	30	.22	Ea	S		
Tool	8986-2133 Die Set						
Tool	8986-2156 Panel D						
M88 F	Clean per ESPM-40						
	04-82-04	5	2.00	Ea	S		
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4860						2995-8880

PRINTS 2995-8880

→ OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
0012-1500	.125 Brass 260 1/2 H	LB		3LBS	.73

WORK STATION	-OPERATIONS-				UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size	02-83-06	16	.55	Ea	S		
M02 B	Drill & Burr	02-83-04	37	1.65	Ea	S		
Tool	8986-8199 Drill Fixture							
M40 C	Mill skim cut to flatten	02-83-06	60	4.50	Ea	S		
N20 D	Finish	04-81-06	5	14.89	Ea	S		
H82 E	Inspect							
P50								

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4860						2995-8881

PRINTS → 2995-8880

OFFICE ORDER →

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
0012-1500	.125 Brass 260 1/2H	LB		3 lbs.	.73

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size						
	02-83-06	16	.55	Ea	S		
M02 B	Drill and Burr						
	02-83-04	37	1.50	Ea	S		
Tool	8986-8199 Drill Fixture						
M40 C	Mill skim cut to flatten						
	02-83-06	60	4.50	Ea	S		
N20 D	Finish						
	04-81-06	5	14.89	Ea	S		
H82 E	Inspect						
P50							

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4860						2995-8882

PRINTS → 2995-8882 → OFFICE ORDER

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
	.75 X 3.0 Brass, 260, 1/2H	LB			

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size 3.0 X 6.0						
	02-83-06	16	3.50	Ea	S		
M89 B	Stress relieve at 850° for 1 hr						
	04-82-04	15	60.00	Ea	S		
M40 C	Mill to dimensions 5.980± 015X2.830±.015 X.690±.010 .000						
	02-83-06	10	6.50	Ea	S		
M42 D	Mill						
	02-83-07	390	7.00	Ea	S		
Tool	8986-8200 NC TAPE						
Tool	8986-2836 ID Form Tool						
Tool	8986-2881 ID Form Tool						
N20 E	Finish						
	04-81-06	5	14.89	Ea	S		
H82 F	Inspect						
P50							

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ORDER QUAN	DRAFTING NO	WHERE USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-8885

PRINTS → 2995-8885 → OFFICE ORDER

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT QUANTITY	UNIT WEIGHT
10 3335	.312 ALX2.0 2024 T4	LB			.25

WORK STATION	-OPERATIONS-				UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size							
		02-83-06	16	1.2	Ea	S		
M40 B	Notch							
		02-83-06	12	.70	Ea	S		
M02 C	Drill & Burr							
		02-83-05	15	.20	Ea	S		
Tool	8986-8795 Drill Fixt.							
M88 D	Finish							
		04-82-04	9	.6	Ea	S		
H82 E	Inspect							
P50								

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ORDER QUAN	DRAFTING NO	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-8891

PRINTS → 2995-8891 → OFFICE ORDER

R/M NO	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
10 0503	ESMM-103	LB			.28

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw to size, Burr edges						
	02-83-06	16	.8	Ea	S		
M40 B	Slot						
	02-83-06	12	.15	Ea	S		
M02 C	Drill & C'Sink						
	02-83-04	18	1.61	Ea	S		
Tool	8986-8196 Drill Fix't						
M88 D	Ultrasonic Degrease						
	04-82-04	10	.3	Ea	S		
N25 E	Finish						
	04-84-05	11	1.4	Ea	S		
H82 F	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2862						2995-8892

PRINTS

→ 2995-4855-1L
2995-8892

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
4230-2350	connector	Ea.		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M02 A	Drill 4 Holes (.125 Dia.)				
	02-83-04 10 .55	ea	S		
H82 B	Inspect				
P50					

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO	L	PAGE	ITEM NUMBER
25		2995-4855						2995-8894

PRINTS → 2995-8894 → OFFICE ORDER

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
13 1230	.012X64 Nos H Prosphor Braze	LB			.006

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M25 A	Shear to size 3.522X.312						
	02-82-05	20	.30	Ea	S		
M49 B	Perf. & Form						
	02-82-05	30	1.32	Ea	S		
Tool	8986-8197 Forming Fixt.						
N20 C	Finish per ESFC-10						
	04-81-06	5	.89	Ea	S		
H82 D	Inspect						
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-4781						2995-8900

PRINTS → 2995-8900/1 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
	Brass 260 1/2 .020±.002	LB			002

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M31 A	Perf. & shear apart						
	02-82-07	80	2.50	ea	S		
M76 B	Form						
	02-82-05	36	.50	ea	S		
M88 C	Cold Ultrasonic degrease						
N20 D	Plate per dwg.						
	04-81-06	5	9.00	ea	S		
P50							

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ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2995-2887						2995-8904

→ PRINTS 2995-8904 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
I2 1006	.012 Brass, 1/2 H RL	LB			.0024

WORK STATION	-OPERATIONS-				UNIT	CODE	SET-UP	PIECE RATE
M25 A	Shear to size							
		02-82-05	36	.328	Ea	S		
M76 B	Form							
		02-82-05	24	.160	Ea	S		
M88 C	Degrease							
		04-82-04	10	.150	Ea	S		
N20 D	Finish per GR spec ESFP-1							
		04-81-06	5	.894	Ea	S		
H82 E	Inspect							
P50								

PARTIAL QUANTITY RECORD

FROM	TO	NO. OF PCS.	INSP. & DATE	CLOSE SHORT

FROM	TO	NO. OF PCS.	INSP. & DATE	CLOSE SHORT

SHOP COPY

OPERATION SHEET

START DATE: _____

DUE DATE: _____

ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
25		2994-4781						2995-8906

→ PRINTS 2995-8906 OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
6070-0410	Heat Sink	ea		1	

WORK STATION	-OPERATIONS-	UNIT	CODE	SET-UP	PIECE RATE
M01 A	Saw, Burr				
	02-83-06 16 .55	ea	S		
H82 B	Inspect				
P50					

PARTIAL QUANTITY RECORD

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FROM	TO	NO. OF PCS.	INSP. & DATE	CLOSE SHORT

SHOP COPY

OPERATION SHEET

START DATE: _____

DUE DATE: _____

ORDER QUAN.	DRAFTING NO.	WHERE-USED		DATE	FILE NO.	L	PAGE	ITEM NUMBER
		2995-4855						2995-8909

PRINTS 2995-8909 →

OFFICE ORDER →

R/M NO.	RAW MATERIAL DESCRIPTION	UNIT	I/D	TOT. QUANTITY	UNIT WEIGHT
16-1455	.312 CR Steel	LB			.03

WORK STATION	-OPERATIONS-			UNIT	CODE	SET-UP	PIECE RATE
M01 A	Cut to length						
	02-83-06	12	.75				
M49 B	Form						
	02-82-05	18	2.4				
M40 C	Mill						
	02-82-07	25	3.5				
N20 D	Finish ESFP-5						
	04-81-06	12	.75				
P50							

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