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13. ABSTRACT (Maximum 200 words)

Technology Insertion (TI)/Industrial Process Improvement (IPI) Data Base Documentation Book Volume 9 for SA-ALC/AMTPSI (Starter Repair).
This document contains detailed information about layouts equipment and processes for this RCC (Resource Control Center).

This is the

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TECHNOLOGY INSERTION ENGINEERING SERVICES

PROCESS CHARACTERIZATION

TASK ORDER NO. 1

DATA DOCUMENTATION BOOK FOR RCC MATPSI

SA - ALC

1989

1.0 IDENTIFICATION OF RCC MATPSI

RCC MATPSI HAS BEEN IDENTIFIED BY STATEMENT OF WORK OF CONTRACT F33600-88-D-0567 FOR PROCESS CHARACTERIZATION.

TABLE OF CONTENTS

2.0 GENERAL INFORMATION

THE RESOURCE CONTROL CENTER (RCC) MATPSI AT SAN ANTONIO AIR LOGISTIC CENTER IS LOCATED IN BUILDING 329. THIS RCC HAS THREE DISTINCT FUNCTIONS. ONE IS THE DISASSEMBLY OF CERTAIN AIRCRAFT STARTERS AND F-15 AND F-16 END ITEMS, SECOND IS THE CLEANING OF THE PARTS FROM THESE END ITEMS AFTER THEY ARE DISASSEMBLED PLUS PARTS FROM [illegible] SIMILAR ENGINES) AND LASTLY, THE INSPECTION OF THE CLEANED PARTS. SOME PARTS ARE SENT DIRECT TO THE PARTS POOL WITHOUT CLEANING (NUTS, BOLTS, SPACERS, ETC.), SOME PARTS ARE SENT THROUGH FLORESCENT PENETRANT INSPECTION PRIOR TO INSPECTION AND OTHER PARTS GO DIRECT FROM CLEANING TO INSPECTION.

\+ THE INSPECTION FUNCTION IS LOCATED IN A FREE STANDING MODULE WHICH IS LOCATED INSIDE THE NORTH END OF BUILDING 329 AT KELLY AFB, TEXAS. THE MODULE IS AIR CONDITIONED WITH TEMPERATURE AND

HUMIDITY MAINTAINED AT APPROXIMATELY 72 DEGREES FAHRENHEIT AND 68 PER CENT RESPECTIVELY DUE TO THE PRECISSIONAL MEASUREMENT EQUIPMENT UTILIZED IN THE SHOP. ALL PARTS BROUGHT INTO THE SHOP FOR INSPECTION ARE HELD FOR 24 HOURS PRIOR TO COMMENCING ANY DIMENSIONAL INSPECTION. THE PURPOSE IS TO ENSURE THE TEMPERTURE OF THE PARTS HAS STABILIZED AT THE ROOM TEMPERATURE SO AS TO ENSURE ACCURATE DIMENSIONAL MEASUREMENTS. THE ROOM HAS ASPHALT TILE FLOOR COVERING AND IS KEPT NEAT AND CLEAN AT ALL TIMES. FLORSCENT CEILING FIXTURES PROVIDE EXCELLENT LIGHTING. THE WORK ENVIROMENT IS GOOD AND THE EQUIPMENT IS FIRST CLASS.

* THE CLEANING FUNCTION IS LOCATED IN THE NORTHEAST END OF BUILDING 329. THE PHYSICAL AREA IS APPROXIMATELY 18 FEET WIDE BY 300 FEET IN LENGTH AND IS NOT AN AIRCONDITIONED AREA. WORKING CONDITIONS ARE POOR AS THE OUTDOOR TEMPERATURE IN THE SUMMER IS AGGRAVATED BY [illegible] LIQUIDS IN THE CLEANING VATS AND THEIR ATTENDENT ODORS.

IN ADDITION, ALL WORKERS MUST WEAR RUBBER GLOVES AND BOOTS PLUS HEAVY A[illegible] [illegible] INCREASES THE DISCOMFORT.

PARTS REQUIRING CLEANING ARE BROUGHT IN TO THE CLEANING AREA IN PLASTIC [illegible] STACKED ON FLOOR. EACH BASKET [illegible] SPECIFIC TYPE METAL [illegible] AS THAT DICTATES THE [illegible] UTILIZED. WORK CONTROL DOCUMENTS (WCD'S) ARE NOT USED FOR THE BULK OF ITEMS REQUIRING CLEANING AS IT WOULD BE VERY DIFFICULT AND COSTLY IN MANHOURS TO KEEP EACH DOCUMENT WITH ITS SPECIFIC PARTS. WCD'S ARE ASSIGNED TO EACH ITEM WHEN IT PASSES THROUGH THE FLORESCENT PENETRANT INSPECTION (FPI) STATION AFTER CLEANING SO THE DOCUMENT CAN RECEIVE THE INSPECTOR'S STAMP.

* THE DISASSEMBLY FUNCTION IS LOCATED IN AN AIR CONDITIONED FREE STANDING FREE STANDING MODULE CONSTRUCTED INSIDE OF THE NORTHEAST CORNER OF BUILDING 329. THE NORTHERN END OF THIS MODULE IS WHERE GAS TURBINE ENGINES ARE DISASSEMBLED WHILE THE SOUTHERN SECTION HAS DISASSEMBLY FOR

STARTERS AND F-15 AND F-16 END STEMS.

THE AREA IS NOW BEING REMODELED SO A BASKET CONVEYOR SYSTEM CAN BE INSTALLED TO MOVE DISASSEMBLED PARTS FROM INDIVIDUAL WORK STATIONS TO THE CLEANING AREA WHICH IS LOCATED JUST OUTSIDE THE MODULE. WHEN THE RENOVATION IS COMPLETE, THERE WILL BE OVER THIRTY DISASSEMBLY WORKSTATIONS. THE FLOORING IS OF ASPHALT TILES WITH RECESSED FLUORESCENT OVERHEAD LIGHTING. THE WALL SURFACE ARE OF METAL WHICH CAN RESULT IN A NOISY ENVIRONMENT. ALL IN ALL, WORKING CONDITIONS ARE VERY GOOD.

A TYPICAL WORKSTATION IN DISASSEMBLY CONSISTS OF A WORKBENCH, A MOUNTING STAND OR FIXTURE FOR THE ITEM TO BE DISASSEMBLED, AND A NEARBY CABINET FOR STORED SPECIAL TOOLS.

2.1 FACILITY LAYOUT

BUILDING 329 IS OVER SIXTY YEARS OLD AND WAS ORIGINALLY BUILT FOR DEPOT MAINTENACE ON GASOLINE FUELED RADIAL AIRCRAFT ENGINES. THE BUILDING IS IN POOR PHYSICAL SHAPE AND FREE STANDING AIR CONDITIONED MODULES HAVE BEEN CONSTRUCTED WITHIN THE BUILDING FOR OPERATIONS SUCH AS OFFICES, DISASSEMBLY, ASSEMBLY, AND INSPECTION OF VARIOUS PARTS. DUE TO THESE FREE STANDING MODULES, WORKING CONDITIONS ARE EXCELLENT FOR ALL FUNCTIONS OF MATSSI EXCEPT FOR THE PARTS CLEANING FUNCTION. THIS EFFORT IS LOCATED IN AN OLD SECTION OF BUILDING 329 AND IS RATHER OPEN AND EXPOSED TO OUTDOORS TEMPERATURES.

THE INSPECTION FUNCTION IS LOCATED IN A FREESTANDING MODULE WHICH LOCATED INSIDE THE NORTH END OF BUILDING 329.

THE ROOM HAS THREE INSPECTION PRODUCTION LINES BASED ON THE THREE BASIC TYPES OF ITEMS INSPECTED. ONE IS FOR GAS TURBINE ENGINES (GTE), ONE IS FOR AIRCRAFT STARTERS AND THIRD IS FOR F 15-16 PARTS.

PARTS ARE DELIVERED TO THE INSPECTION MODULE BY TWO METHODS. FIRST, A DOUBLE DECKER ROLLER CONVEYOR SYSTEM ENTERS THE MODULE FROM THE CLEANING AND FLORESCENT PENETRANT WORK AREA. THE CONVEYOR DIVIDES INTO THREE LINES INSIDE THE MODULE WITH EACH OF THE THREE CONVEYOR LINES PASSING THROUGH THE MIDDLE OF EACH OF THE THREE INSPECTION LINES, THEREBY CREATING A TOTAL OF SIX INSPECTION LINES. EACH OF THE SIX INSPECTION LINES HAS SIX TO EIGHT INSPECTION STATIONS.

* THE CLEANING FUNCTION IS LOCATED IN THE NORTHEAST END OF BUILDING 329. THE PHYSICAL AREA IS APPROXIMATELY 18 FEET WIDE BY 300 FEET IN LENGTH. THE CLEANING FUNCTION IS GOING TO BE COMPLETELY REDONE WITHIN THE NEXT FEW MONTHS. THE SAME AREA WILL BE UTILIZED BUT NEW EQUIPMENT WILL BE INSTALLED AND NEW FLOOR LAYOUT WILL BE IMPLEMENTED.

* . THE DISASSEMBLY FUNCTION IS LOCATED IN AN AIR CONDITIONED FREE STANDING MODULE CONSTRUCTED INSIDE OF THE NORTHEAST CORNER OF BUILDING [illegible]29.

THE AREA IS NOW BEING REMODELED SO A BASKET CONVEYOR SYSTEM CAN BE INSTALLED TO MOVE DISASSEMBLED PARTS FROM INDIVIDUAL WORK STATIONS TO THE CLEANING AREA WHICH IS LOCATED JUST OUTSIDE THE MODULE. WHEN THE RENOVATION IS COMPLETE, THERE WILL BE OVER THIRTY DISASSEMBLY WORKSTATIONS. A TYPICAL WORKSTATION IN DISASSEMBLY CONSISTS OF A WORKBENCH, A MOUNTING STAND OR FIXTURE FOR THE ITEMS TO BE DISASSEMBLED AND A NEARBY CABINET FOR STORED SPECIAL TOOLS.

2.2 EQUIPMENT

THE EQUIPMENT USED BY MATPSI FOR THE FUNCTIONS PERFORMED BY THEM IS LISTED ON THE FOLLOWING PAGES. THE CLEANING EQUIPMENT IS CODED "CLN". THE INSPECTION EQUIPMENT IS CODED "NDI". THE DISASSEMBLY EQUPMENT IS CODED AS FOLLOWS:

F15 AMAD = "A"

F15 JFS = "G"

F15 CGB = "L"

F16 JFS = "M"

F16 ADG = "J"

Conventional Starters = "AB"

NAME: EATON ALC:SA RCC:MATPS1

* EQUIPMENT CODE	EQUIPMENT TYPE DESCRIP.	QUANTITY SHIFT 1ST	2ND	3RD	DOWNTIME PREVENTIVE FREQ	S	D	MAIN TIME	BREAKDOWN MTBF	MTTR	% USED OTHER	ENVELOP MIN	MAX	ALTERNATE EQUIPMENT
CLN-1	CARRONREM	1	1	1	14	1		0.5	720	8				
CLN-2	CORROSION	2	2	2	1	1		1.5	180	8				
CLN-3	DEGREASER	9	9	9	30	1		2	360	8				
CLN-4	GRITBLAST	8	8	8	1	1		1	720	8				
CLN-5	MAGNACLEN	2	2	2	30	1		1	180	8				
CLN-6	WATERRINS	1	1	1	30	1		2	720	8				
CLN-7	SONICDEGR	1	1	1	30	1		4	180	8		1	300	

NAME: EATON ALC:SA RCC:MAFPST

* EQUIPMENT CODE	EQUIPMENT TYPE DESCRIP.	QUANTITY SHIFT 1ST	2ND	3RD	D O W N T I M E PREVENTIVE FREQ	S	D	MAIN TIME	BREAKDOWN MTBF	MTTR	% USED OTHER	ENVELOP MIN	MAX	ALTERNATE EQUIPMENT
NDI-1	APIS	20	20	20	365	1		48	30	1	2	1	1	NDI-2
NDI-2	MICRO-4	2	2	2	365	1		24	30	24	5	1	1	NDI-1
NDI-5	INDI-RON	1	1	1	365	1		24			0.5	1	1	NDI-1
NDI-14	FORMSCAN	1	1	1	365	1		48			25	1	1	NDI-2
NDI-16	OPTLCPTRS	1	1	1					365	168	25	1	1	NDI-5
NDI-17	OPTLCPIRS	1	1	1					365	168	2	1	1	NDI-1
NDI-22	HYDTSTSTD	1	1	1	365	1		192	60	24	20	1	1	
NDI-23	PENETINSP	1	1	1							5	1	1	
NDI-24	EDDYCURNT	1	1	1	365	1		192				1	1	
NDI-25	MAGPARTCL	1	1	1	365	1		192			5	1	1	

DATE 05-31-89

EQUIPMENT CROSS REFERENCE LIST

PCN NO. 08005A & 08004A

ALC SA

PART NAME AMAD

RCC MATPSI

OPERATION DISASSEMBLY LH & RH

EQUIPMENT CODE	TOOL/EQUIPMENT NUMBER	NAME	QUANTITY	COMMENTS
A-1	287951-1	SPLINED TORQUE WRENCH ADAPTER	2	
A-2	287959-1	SPLINED TORQUE WRENCH ADAPTER	2	
A-3	287961-1	SPLINED TORQUE WRENCH ADAPTER	2	
A-4	287963-1	TORQUE WRENCH ADAPTER	2	
A-6	287966-2	SPLINED TORQUE WRENCH ADAPTER	1	
A-7	289602-1	SEAL DRIVER	1	
A-8	289639-2	SHAFT ASSEMBLY HOLDING WRENCH	1	
A-10	291396-9	PULLER ADAPTER	1	
A-11	291397-5	BEARING REMOVAL PLATE	1	
A-12	291397-6	BEARING REMOVER	2	
A-14	291399-1	MAINTENANCE STAND ADAPTER	3	
A-15	291400-1	MAINTENANCE STAND	3	
A-16	291426-1	SHAFT REMOVAL	1	
A-22	291427-1	SHAFT REMOVAL	1	
A-23	291429-1	BEARING REMOVAL	1	
A-24	291433-2	FLANGE PULLER	1	
A-28	291869-1	TUBE PLIERS	1	
A-29	291911-1	SEAL PULLER	1	
A-30	291917-1	TORQUE WRENCH ADAPTER	1	
A-31	291918-1	SEAL WRENCH	2	
A-32	291919-1	SEAL DRIVER	2	
A-33	291959-1	SPANNER WRENCH	1	
A-34	293043-1	TORQUE WRENCH ADAPTER	2	
A-35	293428-1	LOADING FIXTURE	1	
A-37	293785-1	SEAL DRIVER	1	
A-38	296806-1	PULL SET	3	
A-40	8219970	PULLER	2	
A-41	8220010	HOLD DOWN	1	
A-42	8517914	VALVE REMOVER	2	
A-43	LP2059-10	ADAPTER	1	
A-44	LP2059-7	SNAP RING PLIERS	1	
A-45	LP2059-11	PULLER & HANDLER	1	
A-46	4020C	BEARING PULLER	1	

DATE 05-31-89

EQUIPMENT CROSS REFERENCE LIST

PCN NO. 08006A

ALC SA

PART NAME F15 JFS

RCC MATPSI

OPERATION DISASSEMBLY

PAGE 1 OF

EQUIPMENT CODE	TOOL/EQUIPMENT NUMBER	NAME	QUANTITY	COMMENTS
G-12	294549-1	PULLER SET	1	
G-14	289671-1	HOLDER, GEARSHAFT SPLINED	1	
G-15	289687-1	HOLDER, TURBINE WHEEL	1	
G-16	289689-1	HOLDER, WHEEL PRESS	1	
G-18	289691-1	ADAPTER, TORQUE WRENCH, SPLINED	1	
G-19	289704-1	HOLDER, TURBINE WHEEL REMOVAL	2	
G-20	289706-2	PULLER, MECHANICAL BEARING AND SEAL	1	
G-21	289707-1	HOLDER, ROTATING ASSEMBLY	1	
G-22	289708-2	FIXTURE, SHAFT STRETCHING	1	
G-23	289712-1	PULLER, MECHANICAL BEARING	1	
G-24	289714-1	ADAPTER, TORQUE WRENCH	1	
G-25	289719-1	PULLER, MECHANICAL COUPLING	1	
G-27	289727-1	HOLDER, NUT TORQUING	1	
G-28	289728-1	ADAPTER, NUT TORQUING	1	
G-30	289733-1	ADAPTER, TORQUE WRENCH, SPLINED	1	
G-32	291400-1	MAINTENANCE STAND	3	
G-33	291392-1	ADAPTER, MAINTENANCE STAND	3	
G-34	291461-1	DRIVER, BEARING	1	
G-35	291471-1	ADAPTER, TORQUE WRENCH	1	
G-38	291472-1	HOLDER, SPLINED, GEAR	1	
G-40	291482-1	DRIVER, BEARING AND GEAR	1	
G-44	291490-1	HOLDER, BEARING PRESSING	1	
G-54	293312-1	HOLDER, DIFFUSER, NUT TORQUING	1	
G-60	8221114-10	ADAPTER, TORQUE WRENCH	2	
G-64	8221170	DRIFT, WHEEL REMOVAL	1	
G-98	68D170008-100?	BORESCOPE	1	

DATE 06-03-89

EQUIPMENT CROSS REFERENCE LIST

PCN NO. 08007A | ALC SA

PART NAME CGB | RCC MATPSI

OPERATION DISASSEMBLY | PAGE 1 OF

EQUIPMENT CODE	TOOL/EQUIPMENT NUMBER	NAME	QUANTITY	COMMENTS
L-1	291400-1	ROLL OVER STAND	3	ASSEMBLY & DISASSEMB.
L-2	291392-1	STAND ADAPTER	3	ASSEMBLY & DISASSEMB.
L-3	293158-1	CLUTCH HOLDER	1	ASSEMBLY & DISASSEMB.
L-4	X8871138	TUBE PULLER	1	
L-5	291907-1	ADAPTER PULLER	1	
L-6	293157-1	HOLDER	1	ASSEMBLY & DISASSEMB
L-7	X720A	SPECIAL WRENCH	1	ASSEMBLY & DISASSEMB
L-8	291868-1	FAN PULLER	1	
L-9	291432-1	GEAR PULLER	1	
L-10	291656-1	PULLER	1	
L-11	291432-1	GEAR PULLER	2	
L-12	8319624	GEAR HOLDER	1	
L-13	291396-7	PULLER	1	
L-14	291446-1	PLATE PULLER	1	
L-15	4020C	BEARING PULLER	1	
L-16	291396-8	ADAPTER	1	
L-17	8140811	DRIFT	2	ASSEMBLY & DISASSEME
L-18	8140812	BEARING PULLER	1	
L-19	291440-1	HOLDER	2	
L-20	291439-1	ADAPTER	2	
L-21	8140810	DRIFT	1	
L-22	8140808	GEAR HOLDER	1	
L-23	8319608	HOLDER FIXTURE	1	ASSEMBLY & DISASSEME
L-24	289684-1	PULLER	2	
L-25	8140815	BEARING PULLER	2	
L-26	291397-3	PLATE	1	
L-27	291396-3	PLATE	1	
L-28	289607-1	SPANNER WRENCH	2	ASSEMBLY & DISASSEME
L-29	291691-1	PULLER	2	
L-30	291194-1	SEAL DRIVER	2	
L-31	291421-1	TORQUE WRENCH/ADAPTER	2	
L-32	289666-1	BUSHING DRIVER	2	
L-33	291418-1	GEAR SHAFT DRIVER	1	
L-34	291412-1	SHAFT HOLDER	2	
L-35	291413-1	SHAFT DRIVER	1	
L-36	289657	ADAPTER	2	
L-37	289031-1	WRENCH ADAPTER	2	ASSEMBLY & DISASSEME
L-38	8140813	BEARING PULLER	2	
L-39	289681-1	SPRING COMPRESSOR	2	
L-40	291868	BEARING PULLER	1	
L-41	291890-1	TUBE PULLER	2	
L-95	595A	COLOR CHART	1	
L-96	8140809	DRIFT BEARING	1	

DATE 05-31-89

EQUIPMENT CROSS REFERENCE LIST

PCN NO. 13096A ALC SA

PART NAME F16 JET FUEL STARTER RCC MATPSI

OPERATION DISASSEMBLY PAGE 1 OF

EQUIPMENT CODE	TOOL/EQUIPMENT NUMBER	NAME	QUANTITY	COMMENTS
M-1	ST91125	COMBUSTOR ASSY. PULLER	1	
M-2	ST93466	ADAPTER PULLER	1	
M-3	ST70137	HOLDING FIXTURE	1	
M-4	ST70230	SPANNER WRENCH	2	
M-5	ST70107	BEARING PULLER	2	
M-6	ST70109	BEARING PULLER	2	
M-7	ST92619	HOLDING FIXTURE	1	
M-8	ST90112	EXTRACTOR SUPPORT	1	
M-9	160005-100	SLAVE SHAFT	2	
M-10	ST90110	DRIVER	2	
M-11	8621514	STAND, WOODEN	1	
M-12	X8621139	ADAPTER	1	
X-8	ON ORDER	ICE BOX	1	
X-2	ON ORDER	OVEN	1	

DATE 05-31-89

EQUIPMENT CROSS REFERENCE LIST

PCN NO. 12712 A

ALC SA

PART NAME ACCESSORY DRIVE GEARBOX

RCC MATPSI

OPERATION DISASSEMBLY

PAGE 1 OF

EQUIPMENT CODE	TOOL/EQUIPMENT NUMBER	NAME	QUANTITY	COMME
J-1	AKS-31466	ASSEMBLY TOOL	1	
J-2	AKS-31957	DRIVER	1	
J-3	BHS-28161	SPLIT BUSHING	2	
J-4	BHS-28163	SPLIT BUSHING	2	
J-5	BHS-28164	SPLIT BUSHING	2	
J-6	BHS-28165	SPLIT BUSHING	2	
J-7	BHS-28168	SPLIT BUSHING	2	
J-8	BHS-28169	SPLIT BUSHING	2	
J-9	BHS-28170	SPLIT BUSHING	2	
J-10	BHS-31243	SPLIT BUSHING	1	
J-11	BHS-33185	SPLIT BUSHING	2	
J-12	BHS-33187	SPLIT BUSHING	2	
J-13	BHS-33188	SPLIT BUSHING	3	
J-14	BHS-33189	SPLIT BUSHING	2	
J-15	DJS-27669	DRIVER	1	
J-16	DJS-28307	DRIVER	4	
J-17	DJS-29062	DRIVER	1	
J-18	DJS-30718	DRIVER	1	
J-19	DJS-33387	DRIVER	2	
J-20	DJS-33388	DRIVER	1	
J-21	DJS-33389	DRIVER	1	
J-22	DJS-33391	DRIVER	2	
J-23	FDS-27580	HOLDING FIXTURE	2	
J-24	FDS-28439	HOLDING FIXTURE	1	
J-25	FDS-28440	HOLDING FIXTURE	2	
J-27	PBS-27955	SHAFT PULLER	1	
J-29	PWS-27074	GEAR PULLER	2	
J-30	PWS-28167	GEAR PULLER	1	
J-31	PWS-29243	GEAR PULLER	2	
J-32	PWS-31845	BEARING PULLER	2	
J-33	PWS-31846	BEARING PULLER	2	
J-34	PWS-31847	BEARING PULLER	2	
J-35	PWS-34211	HOLDER	2	
J-36	PWS-35733	PULLER	2	
J-37	PXS-9210	BEARING PULLER	2	
J-38	WIS-27062	SPANNER WRENCH	3	
J-39	5401-30393	ROLL OVER STAND	3	
J-40	6SV-86275	HOLDER	1	
J-41	6SV-87457	HOLDER	2	
J-42	8621089	PULLER	2	
J-43	8621011	PULLER	2	
J-44	8620951	DRIVER	2	
J-45	851792-1	PULLER	2	
J-46	291869-1	INSERT PLIERS	1	
J-47	PBS-32301	PULLER	2	
J-48	8621136	PULLER	2	
J-49	8620953	BEARING NEST	2	
J-50	8620984	DRIVER	2	

J-51	8517881	SPLIT BUSHING	2		
J-52	8620965	HOLDER	2		
J-53	8620963	DRIVER	2		
J-54	8620962	DRIVER	2		
J-55	8621134	DRIVER	2		
J-56	AKS-29050	ASSY TOOL	1		
X-2		OVEN	1		ON ORDER"-DUE
J-26	PBS 27954	PULLER	2		

DATE 06-03-89

EQUIPMENT CROSS REFERENCE LIST

PCN NO. 04542A. 10598A. 10718A ALC SA

PART NAME STARTERS RCC MATPSI

OPERATION DISASSEMBLY PAGE 1 OF

EQUIPMENT CODE	TOOL/EQUIPMENT NUMBER	NAME	QUANTITY	COMMENTS
	B52G CPS-02 MOD			
AB-1	6PT-44066	DISASSEMBLY BLOCK	5	
AB-2	6PT-80063	SPANNER WRENCH	2	
AB-3	6PT-46232	COMPRESSION FIXTURE	2	
AB-4	6PT-47457	SEAL PULLER	2	
AB-5	6PT-47972	PULLER, RETAINER SET	2	
AB-6	6PT-43615	FAN PULLER	2	
AB-7	6PT-44070	SHAFT PULLER	2	
	100-87			
AB-8	8441968	BEARING PUSHER	1	
AB-9	64TM08309	SHAFT HOLDER	1	
AB-10	361175-05-06-07	SPECIAL WRENCH	3	
AB-11	65C24043	GEAR HOLDER	2	
AB-12	3472649	SPANNER WRENCH	1	
AB-13	284257-1-1	HOLDER	1	
	B52 C-100-97			
AB-8	8441968	BEARING PUSHER	1	
AB-14	331	PUSHER, SEAL	1	
AB-9	64TM08309	SHAFT HOLDER	1	
AB-15	281496-1	BEARING PULLER	4	
AB-16	65C2404	SHAFT HOLDER	1	
AB-17	346	GOVERNOR REMOVER	1	
AB-18	347	GOVERNOR REMOVER	1	

2.3 WORKFORCE

The WorkForce covers the skills needed to accomplish the disassembly, cleaning and inspection Functions accomplished by MATPSI. The experience level of some of theworkers in this RCC is very limited because many loan in/loan out's occur during the course of a year. The cleaning operations are generally the entry level jobs in this RCC.

The list of skill codes and number of people per shift is as follows:

MATPSI WORKFORCE

Skill Code	Description	Number/SHIFT 1st	2nd
4848 DB 07	Mechanical Repairer	3	0
5439 DB 05	Nondestructive Test Helper	1	0
5439 DB 09	Nondestructive Tester	12	1
5439 DB 10	Nondestructive Tester	4	1
5439 DD 05	Nondestructive Test Helper	1	0
5439 DD 06	Nondestructive Tester	2	2
5439 DD 09	Nondestructive Tester	14	6
5439 DD 10	Nondestructive Tester	6	1
5423 4D 05	Sand blast	3	0
7009 4D 05	Equipment Cleaner	10	0
8602 BA 05	Helper	1	0
8602 BA 08	Repairer	14	0

2.4 REPAIR PROCESS TECHNOLOGY

THE REPAIR PROCESS TECHNOLOGY WITHIN MATPS CONSIST OF THREE DISTINCT FUNCTIONS. ONE IS THE DISASSEMBLY OF CERTAIN AIRCRAFT STARTERS AND F-15 AND F-16 END ITEMS, SECOND IS THE CLEANING OF THE PARTS FROM THESE END ITEMS AFTER THEY ARE DISASSEMBLED (PLUS PARTS FROM GAS TURBINE ENGINES) AND LASTLY, THE INSPECTION OF THE CLEANED PARTS.

2.5 WORKLOAD MIX AND VOLUME

THE WORKLOAD FOR MATPSI CONSISTS PRIMARILY OF THE ITEMS ON THE MISTR FILES FOR MATPG AND MATPS WHICH ARE FOUND IN THE 80/20 WORKLOAD SECTION OF THIS BOOK.

THE NUMBER INDUCTED IN FY88 FOR THE 80 PERCENT OF THE ITEM LIST WAS AS FOLLOWS:

PCN	NOUN	1ST Q	2ND Q	3RD Q	4TH Q	TOTAL
08004A	F15 LH AMAD	56	47	40	47	190
08005A	F15 RH AMAD	27	15	30	36	108
08006A	F15 JFS	82	68	85	90	325
08007A	F15 CGB	120	73	72	134	399
12712A	F16 ADG	35	34	36	39	144
13096A	F16 JFS	20	40	58	90	208
04542A	CPS-02 MOD	110	107	80	128	425
10598A	ATSC 100-87	50	80	43	62	235
10718A	ATSC 100-97	44	78	77	59	258
13081A	GTE 85-70	34	34	20	19	107
13094A	GTE 85-397	54	59	38	34	185
13095A	GTE 85-180	49	63	53	47	212
	TOTAL	681	698	632	785	2796

2.5.1 INSPECTION WORKLOAD

IN ORDER TO REDUCE THE LARGE NUMBER OF ITEMS TO BE PROFILED IN THE INSPECTION AREA TO A MANAGEABLE NUMBER, THE FOLLOWING PROCEDURE WAS FOLLOWED:

(a) A LISTING OF THE PARTS TO BE INSPECTED FOR EACH PCN WAS GENERATED.

(b) THIS LIST WAS PURGED OF PARTS WHICH ARE ONLY SUBJECTED TO VISUAL INSPECTION.

(c) FOUR CRITICAL PARTS WERE SELECTED FOR EACH PCN AND THEIR WCD'S WERE SUBJECTED TO INDIVIDUAL PROCESS CHARACTERIZATION.

(d) A "GENERIC" PROCESS CHARACTERIZATION WCD WAS CREATED FOR THE REMAINING PARTS ON EACH PCN'S LIST.

(cont)

2.5.1 (d) Cont.

THE MANPOWER AND EQUIPMENT NEEDED FOR EACH OF THESE GENERIC PROCESS PROFILES WAS ADJUSTED TO REFLECT THE TOTAL NUMBER OF DIFFERENT PARTS FOR EACN PCN, MINUS THE FOUR PREVIOUSLY SELECTED.

(e) THIS RESULTS IN A TOTAL OF 60 PROFILES BEING ACCOMPLISHED (IE; 5 PER PCN x 12 PCN'S) INSTEAD OF THE TOTAL OF 589 PARTS ON THE 12 LISTS BY PCN WHICH FOLLOW.

2.5.2 CLEANING WORKLOAD

WCD's FOR CLEANING THE INDIVIDUAL PARTS GENERALLY DO NOT EXIST. WCD'S WERE CREATED FOR THE 60 PARTS BEING STUDIED. THESE WERE IDENTIFIED BY ADDING A "C" AHEAD OF THE INSPECTION WCD NUMBER ON THEIR DATA SHEETS. SHOP PERSONNEL WERE INTERVIEWED TO CHARACTERIZE THE CLEANING PROCESS.

SA-ALC -- INSPECTION

PCN NO. 08004A   END ITEM: F15 L/H AMAD

WCD: TA071K   DATED: 89107   NOUN: FLANGE, GEN MOUNTING   PART NO. 365428-5
WCD: TA072K   DATED: 89086   NOUN: GEARSHAFT, IDG SPUR   PART NO. 366858-1
WCD: TA074K   DATED: 89086   NOUN: GEAR, 2ND IDL SPUR ASSY   PART NO. 365357-1
WCD: TA092K   DATED: 89039   NOUN: LH/RH AMAD GEARBOX   PART NO. 367042-1
WCD: 6121   DATED: 89152   NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	365429-1	DECOUPLER RINS	TA002K	87037	08005A
2	367145-1	STEPPED, SPACER	TA009K	86276	08005A
3	365432-2	SPRING	TA025K	85127	08005A
4	365515-1	MOUNT, SWIVEL GEARBOX	TA030K	89088	08005A
5	366997-1	MOUNT, UPPER	TA032K	88111	08005A
6	366558-1	SPRING, HEL. COMP.	TA040K	84143	
7	367334-1	SPRING	TA048K	84259	
8	365377-1	PLATE (RETAINER)	TA051K	89082	08005A
9	367306-1	GEARSHAFT ASSY, PTO SPUR	TA053K	89086	
10	367424-1	SEAL, ROTOR	TA055K	89080	
11	367426-2	SHAFT, PTO SPLINED	TA056K	84129	
12	367427-1	CARRIER, L/H	TA059K	89086	
13	365859-5	ISOL. DECOUPLER PAWL CARRIER	TA065K	89020	08005A
14	365488-4	VENTURI, CAVITATION	TA068K	84129	
15	367562-1	COVER	TA070K	88110	08005A
16	365428-5	FLANGE GEN MOUNTING	TA071K	86211	08005A
17	366858-1	GEARSHAFT I.D.G. SPUR	TA072K	89086	08005A
18	365501-3	SECOND IDLER SHAFT INSPECTION	TA073K	89086	08005A
19	365357-1	GEAR, 2ND IDLER SPUR	TA074K	89086	08005A
20	365500-3	SHAFT, 1ST IDLER STATIONARY	TA075K	89086	08005A
21	365498-1	COVER	TA077K	84136	
22	365441-1	RETAINER, UTIL & PWR CNTRL	TA078K	89039	08005A
23	367064-1	GEARSHAFT	TA079K	88179	08005A
24	365358-1	SPUR GEAR	TA080K	89089	
25	365496-2	COVER ASSY	TA081K	85210	08005A
26	365353-1	SPUR GEAR	TA082K	84298	
27	367063-1	GEARSHAFT	TA083K	86022	08005A
28	365354-1	POWER CONTROL SPUR GEAR	TA084K	84129	
29	367195-1	SHROUD, L/H INSPECTION	TA085K	88131	08005A
30	365350-1	GEAR, POWER TAKEOFF BEVEL	TA086K	85094	
31	367042-1	LH/RH AMAD HOUSING ASSY	TA092K	89039	08005A
32	366526-2	HOUSING ISOLATION	TA095K	87023	08005A
33	367134-1	HSG, BRG ISOL. DECOUP.	TA097K	87024	08005A
34	367423-1	ROTOR SEAL	TA099K	87024	08005A
35	365513-2	SHAFT	TA100K	87056	08005A
36	367479-1	SPACER, L/H	TA105K	86247	
37	365960-4	PLATE, ISOL. DECOUP. DAMPING	TA111K	85210	08005A
38	366882-1	GEAR ASSY, 1ST IDLER	TA309K	88131	08005A

SA-ALC -- INSPECTION

PCN NO. 08005A END ITEM: F15 R/H AMAD

WCD: TA071K DATED: 89107 NOUN: FLANGE, GEN MOUNTING PART NO. 365428-6
WCD: TA072K DATED: 89086 NOUN: GEARSHAFT, IDG SPUR PART NO. 366858-1
WCD: TA074K DATED: 89086 NOUN: GEAR, 2ND IDL SPUR ASSY PART NO. 365357-1
WCD: TA092K DATED: 89039 NOUN: LH/RH AMAD GEARBOX PART NO. 367041-1
WCD: 61I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	365429-1	DECOUPLER RING	TA002K	87037	08004A
2	367145-1	STEPPED, SPACER	TA009K	86276	08004A
3	365432-2	SPRING	TA025K	85127	08004A
4	365515-1	MOUNT, SWIVEL GEARBOX	TA030K	89088	08004A
5	366997-1	MOUNT, UPPER	TA032K	88111	08004A
6	365897-1	PLATE (RETAINER)	TA051K	89082	08004A
7	365859-5	ISOL, DECOUPLER PAWL CARRIER	TA065K	89020	08004A
8	367561-1	COVER	TA070K	88110	08004A
9	367561-1	COVER	TA070K	88110	08004A
10	365428-6	FLANGE GEN MOUNTING	TA071K	86211	08004A
11	366858-1	GEARSHAFT I.D.G. SPUR	TA072K	89086	08004A
12	365501-3	SECOND IDLER SHAFT INSPECTION	TA073K	89086	08004A
13	365357-1	GEAR, 2ND IDLER SPUR	TA074K	89086	08004A
14	365500-3	SHAFT, 1ST IDLER STATIONARY	TA075K	89086	08004A
15	365441-1	RETAINER, UTIL & PWR CNTRL	TA078K	89039	08004A
16	367064-1	GEARSHAFT	TA079K	88179	08004A
17	365496-1	COVER ASSY	TA081K	85210	08004A
18	367063-1	GEARSHAFT	TA083K	86022	08004A
19	367195-2	SHROUD, L/H INSPECTION	TA085K	88131	08004A
20	367195-2	SHROUD	TA085K	88131	08004A
21	367041-1	LH/RH AMAD HOUSING ASSY	TA092K	89039	08004A
22	366525-2	HOUSING ISOLATION	TA095K	87023	08004A
23	367134-1	HSG, BRG ISOL. DECOUP.	TA097K	87024	08004A
24	367423-1	ROTOR SEAL	TA099K	87024	08004A
25	365513-2	SHAFT	TA100K	87056	08004A
26	365960-4	PLATE, ISOL. DECOUP. DAMPING	TA111K	85210	08004A
27	365559-2	COVER BEARING INSPECTION	TA289K	84146	
28	367227-2	GEARSHAFT ASSY, PTO SPUR	TA291K	84026	
29	367217-2	CARRIER, R/H	TA293K	86128	
30	366882-1	GEAR ASSY, 1ST IDLER	TA309K	88131	08004A
31	365898-1	GEAR	TA314K	84131	
32	365378-2	RETAINER	TA326K	84083	

SA-ALC -- INSPECTION

PCN NO. 08006A END ITEM: F15 JET FUEL STARTER

WCD: TA032H DATED: 89075 NOUN: ANULAR COMBUSTION CHAMBER PART NO. 364923-5
WCD: TA056H DATED: 89075 NOUN: INLET GEAR BOX HSG. ASSY PART NO. 367140-3
WCD: TA077H DATED: 89019 NOUN: POWER TURBINE WHEEL PART NO. 366975-1
WCD: TA088H DATED: 88350 NOUN: POWER TURBINE BEARING HSG. ASSY PART NO. 366820-2
WCD: 621 DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	366993-1	TRANSFER TUBE	TA001H	88078	
2	367540-1	FUEL DRAIN SUPPORT ASSY	TA002H	88075	
3	365077-1	SPEC. OIL DRAIN TEE	TA004H	88075	
4	367256-1	COMPR. INLET SCREEN	TA005H	88071	
5	367545-1	TRANSFER TUBE	TA006H	88075	
6	366451-1	SPLINED, SHAFT	TA007H	88075	
7	ASM1375S025	CLIP	TA009H	88075	
8	367542-1	FUEL TUBE ASSY	TA010H	87362	
9	367241-1	FUEL TUBE ASSY	TA010H	87362	
10	367543-1	FUEL TUBE ASSY	TA010H	87362	
11	ASM1375S025-01	CLIP	TA011H	88075	
12	366108-1	F/MANIFOLD TUBE	TA012H	88075	
13	366109-1	F/MANIFOLD TUBE	TA012H	88075	
14	367263-1	COMPR. INLET DUCT	TA015H	88075	
15	367244-1	BRACKET ASSY	TA016H	88075	
16	367245-1	BRACKET ASSY	TA016H	88075	
17	367248-1	COMPR. INLET DUCT	TA017H	88075	
18	367292-1	MOUNT BRACKET	TA021H	88061	
19	367159-1	R. ENG. MT. BRKT.	TA022H	88075	
20	367159-2	R. ENG. MT. BRKT.	TA022H	88075	
21	367157-1	AX. COM. TURB. WHEEL	TA023H	89089	
22	364955-13	TURBINE PLENUM	TA027H	89048	
23	S8809024	WASHER, SPRING TENSION	TA030H	88075	
24	364984-1	THRUST WASHER	TA031H	88075	
25	364923-5	COMBUST. CHAMBER	TA032H	88075	
26	367520-1	TUBE, RETAINER	TA034H	88075	
27	364950-2	IMPELLER SHROUD	TA037H	89103	
28	366590-1	SHAFT, TURBINE	TA039H	88075	
29	352723-35	WASHER, SPR. COMP.	TA043H	88095	
30	366992-1	SHAFT DRIVE	TA045H	88271	
31	367539-1	RETAINING ASSY	TA047H	88097	
32	366486-1	PINION, SHAFT	TA050H	88097	
33	365005-2	SPUR GEAR	TA051H	88097	
34	365083-1	FACE, GR/SHAFT	TA052H	88097	
35	365004-1	SPRING COMPRESSION	TA053H	88097	
36	3671979-1	SPUR GEAR, BEARING	TA055H	87275	
37	365914-1	SPUR GEAR, BEARING	TA055H	87275	
38	367140-3	INLET GR. BOX HOUS. ASSY	TA056H	89095	

39	364925-1	SPUR GEAR	TA060H	88075
40	365049-5	COMPRESSOR BEARING CARRIER	TA061H	88075
41	366930-1	AIR ROTATING SEAL NUT	TA062H	88075
42	366929-1	COUPLING HALF	TA063H	89019
43	364920-6	COMPRESSOR IMPELLER	TA064H	89066
44	364960-1	SHAFT-COUPLING	TA065H	88061
45	364956-2	HOUSING SEAL.	TA067H	87202
46	364967-2	STAT/CONT. RING	TA068H	89048
47	364921-1	COMPRESSOR, DIFFUSER ASSY	TA070H	89094
48	365127-3	GAS GENERATOR WHEEL ASSY	TA071H	89019
49	366931-1	TIE-ROD SHAFT	TA072H	88061
50	366945-2	LABYRINTH SEAL	TA076H	88075
51	366975-1	POWER TURBINE WHEEL	TA077H	89019
52	366944-1	SEAL, COVER	TA078H	89089
53	366856-1	SEAL ROTOR	TA080H	88075
54	S8164-240	PRECISION WASHER	TA082H	88075
55	366140-1	SPRING, COMP.	TA083H	88075
56	364919-1	PWR. TUB. STATOR	TA087H	89048
57	366820-2	TURB. BEAR. HOUS. ASSY	TA088H	88350
58	367490-1	SPACER	TA095H	88075
59	384238-4-1	VISUAL INSPECTED PARTS	TA500H	88263

SA-ALC -- INSPECTION

PCN NO. 08007A END ITEM: F15 CENTRAL GEAR BOX

WCD: TA004R DATED: 88181 NOUN: FAN OIL COOLER INLET HSG. PART NO. 367393-1
WCD: TA046R DATED: 89082 NOUN: GEAR BOX MATCHED SET HSG. PART NO. 367040-3
WCD: TA092R DATED: 89005 NOUN: DRIVEN BEVEL GEAR PART NO. 366265-2
WCD: TA098R DATED: 89082 NOUN: DECOUPLER ASSY., PISTON PART NO. 366125-2
WCD: G3I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	367613-1	CLUTCH & BRAKE ASSY.	TA001R	88174	
2	367621-1	FAN DUCT, INLET-REV/FLOW	TA002R	88181	
3	367393-1	FAN OIL COOLER INLET HSG.	TA004R	88181	
4	A75	MAGNETIC PLUG	TA005R	87266	
5	367027-2	BRAKE ADAPTER	TA008R	89082	
6	367614-1	FAN & ADAPTER	TA017R	88335	
7	367261-2	FAN STATOR	TA019R	87252	
8	367056-2	VALVE ASSY	TA023R	87266	
9	367060-1	OIL CHECK VALVE	TA030R	87266	
10	159490-3-1	AIR-OIL COOLER	TA033R	88165	
11	159490-3-3	AIR-OIL COOLER	TA033R	88165	
12	159490-3-2	AIR-OIL COOLER	TA033R	88165	
13	366258-2	ROTOR SEAL	TA042R	89095	
14	367040-3	GEAR BOX MATCHED SET HSG	TA046R	89082	
15	367444-1	CLUTCH SEAL	TA049R	89005	
16	365145-1	OIL JET TUBE	TA050R	87266	
17	367443-1	SEAL HOUSING	TA055R	87267	
18	367455-1	GEAR, SPUR	TA056R	88337	
19	366221-1	BEARING SHAFT	TA059R	87267	
20	365997-1	IDLER SPUR GEAR	TA062R	89082	
21	366718-2	PUMP HOUSING	TA064R	89005	
22	366020-4	ROTOR, MATCHED SET	TA066R	87267	
23	367272-1	SPUR GEAR	TA069R	87267	
24	352723-33	WASHER, SPRING	TA070R	87252	
25	352723-43	WASHER, SPRING	TA070R	87252	
26	366420-2	PUMP LINER	TA071R	87281	
27	366452-2	OIL DISTRIBUTION TUBE	TA076R	87281	
28	367215-1	SPUR GEAR	TA077R	87281	
29	367321-1	RATCHET WHEEL ASSEMBLY	TA080R	87281	
30	366949-1	L/H DECOUPLER HOUS. ASSY	TA083R	89082	
31	365196-3	SEAL CARRIER	TA084R	87281	
32	366145-4	SEAL CARRIER	TA085R	87287	
33	366266-1	SPRING RETAINING NUT	TA086R	88356	
34	366318-1	HELICAL COMPRESSION SPRING	TA087R	89024	
35	366118-1	GUIDE BUSHING	TA088R	89082	
36	366267-3	OIL TRANSFER TUBE	TA090R	87281	
37	366265-2	DRIVEN BEVEL GEAR	TA092R	89005	
38	367171-1	R/H DECOUPLER HOUSING ASSY.	TA095R	89082	

39	366125-2	DECOUPLER ASSY, PISTON	TA098R	89082	
40	367160-3	BEARING HOUSING ASSEMBLY	TA102R	89082	
41	367440-1	ROTOR SEAL	TA104R	89005	
42	367431-1	BAFFLE RING	TA105R	87287	
43	367538-1	PISTON, ACTUATOR	TA107R	88337	
44	367161-1	BEARING HOUSING ASSEMBLY	TA110R	89082	
45	365151-1	BEVEL GEAR	TA112R	87287	
46	367484-1	HELICAL COMPRESSION SPRING	TA115R	87292	
47	367448-1	SHAFT, CLUTCH	TA118R	89005	
48	367497-1	SHAFT	TA119R	87292	
49	367502-1	RETAINER ASSEMBLY	TA121R	87292	
50	367216-1	SHAFT, SPLINED	TA122R	87292	
51	366016-2	BEARING CARRIER	TA124R	89082	
52	367449-1	PUMP INLET, TUBE ASSEMBLY	TA127R	87293	
53	367137-1	GEARSHAFT ASSY.	TA154R	88153	

SA-ALC -- INSPECTION

PCN NO. 12712A END ITEM: F16 ACCESSORY DRIVE GEAR

WCD: TA014L DATED: 89081 NOUN: CARBON FACE SEAL PART NO. 3803-21
WCD: TA076L DATED: 89075 NOUN: IMPELLER ASSY. PART NO. 5004952-1
WCD: TA077L DATED: 89075 NOUN: TURBINE HOUSING PART NO. 5003714
WCD: TA080L DATED: 89060 NOUN: TURBINE PART NO. 503715
WCD: 671 DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	5002706	PUMP SHAFT	TA002L	88281	
2	5005574	LINK SUPPORT	TA003L	89030	
3	5005572-1	SEAL RETAINER HSG ASSY	TA013L	89081	
4	3803-21	CARB FACE SEAL	TA014L	89081	
5	5005112	INPUT HOUSING	TA015L	89081	
6	5005119	SPLINED SHAFT	TA016L	89081	
7	5002699B	COVER HSG ASSY	TA017L	89034	
8	5004054	CLUTCH HSG	TA018L	89034	
9	5002671	PUMP MOUNTING HSG	TA021L	89060	
10	5002664	SPUR GEAR SHAFT	TA022L	89081	
11	5002674	START MOTOR MOUNTING HOUSING	TA023L	89081	
12	5004469	SPLINED CLUTCH SHAFT	TA024L	89081	
13	5004466	SPUR GEAR	TA025L	89081	
14	5004891	IDG MOUNTING HSG	TA027L	89087	
15	5002638	SPUR GEAR SHAFT	TA028L	89087	
16	5002673A	JFS MOUNTING HSG	TA029L	89087	
17	5004968	SEAL RETAINER HSG ASSY	TA030L	89087	
18	5005236	PISTON	TA033L	89087	
19	5004818	SPUR GEAR SHAFT	TA034L	89087	
20	5002722	BEARING RETAINER	TA035L	89087	
21	5005253	BEARING SHAFT	TA036L	89087	
22	5002724	RETAINER HSG	TA037L	89087	
23	5002704	COVER ASSY	TA038L	89075	
24	5002696	COVER ASSY	TA039L	89075	
25	5005027	SPUR GEAR	TA040L	89087	
26	5002641	SPUR GEAR	TA041L	89075	
27	5002647	CLUSTER SPUR GEAR	TA042L	89075	
28	5004459	SPUR GEAR SHFT	TA043L	89107	
29	5002658	PUMP GEAR SHAFT	TA044L	89107	
30	5002657	SPUR GEAR	TA045L	89107	
31	5004464	SPUR GEAR SHAFT	TA046L	89075	
32	5004463	SPUR GEAR & CARBON BRG	TA047L	89075	
33	5902167	OVERRUNNING CLUTCH SPRAG	TA048L	89075	
34	5002709	SPUR GEAR	TA049L	89107	
35	5005252	BEARING SHAFT	TA050L	89074	
36	5002655	SPUR GEAR	TA052L	89107	
37	5004339	SPUR GEAR SHAFT	TA053L	89075	
38	5002712	SPUR GEAR	TA055L	89107	

39	5002775	LUBE NOZZLE FITTING	TA056L	89075	
40	5002739	VALVE PISTON	TA058L	89076	
41	5002738	VALVE SLEEVE	TA059L	89075	
42	5002735	VALVE SLEEVE	TA061L	89107	
43	5003518	VALVE PISTON	TA062L	89107	
44	99-4428	SPRING	TA063L	89075	
45	02-15054	VALVE PISTON	TA064L	89107	
46	02-15053	VALVE SLEEVE	TA065L	89107	
47	5005249	BEARING SHAFT	TA066L	89075	
48	5005250	BEARING SHAFT	TA067L	89075	
49	5005251	BEARING SHAFT	TA068L	89075	
50	5002653	SPUR GEAR	TA069L	89107	
51	5004819	CLUSTER GEAR	TA070L	89107	
52	5004020	BUSHING HSG	TA071L	89107	
53	5003921	IMPELLER	TA072L	89004	
54	5002706	PUMP SHAFT	TA073L	89107	
55	5002637	SPUR GEAR	TA074L	88342	
56	5002694D	GEAR BOX HSG	TA075L	89033	
57	5004052-1	IMPELLER ASSY	TA076L	89075	
58	5003714	TURBINE HSG	TA077L	89075	
59	5002706	PUMP SHAFT	TA078L	89109	
60	5002624	GEAR	TA079L	88342	
61	5003715	TURBINE	TA080L	89060	
62	3803-13	CARBON FACE SEAL	TA081L	99335	
63	5003969	TRANSFER TUBE SLEEVE	TA089L	88342	
64	5003973	VALVE SLEEVE	TA090L	88342	
65	5003972	FLOW PISTON	TA092L	88342	
66	5003974	CONTROL PISTON	TA093L	88342	
67	5004475	END PLATE	TA094L	89074	
68	5005231	PISTON & SLEEVE	TA095L	89075	
69	3803-14	CARB FACE SEAL	TA096L	89075	
70	3803-25	CARB FACE SEAL	TA096L	89075	
71	5002748-1	SEAL RETAIN. HSG ASSY	TA097L	88342	
72	5006449	SEAL ASSY	TA098L	88342	
73	5006450	RING	TA099L	89074	
74	5002611	END HSG	TA100L	89075	
75	5002610	PISTON HSG	TA101L	89058	
76	5003986	PISTON	TA102L	89074	
77	5004742	OUTPUT GEAR	TA103L	89074	
78	5004474	END PLATE	TA104L	89058	
79	5002601	INPUT GEAR	TA105L	89074	
80	5004475	END PLATE	TA106L	89058	
81	5002747-1	SEAL RETAINER HSG	TA109L	88334	
82	5002702-1	SEAL RETAINER HSG	TA111L	88334	
83	5002720-1	SEAL RETAINER HSG	TA112L	88334	
84	5005069	ADG GEARBOX HSG	TA115L	88334	
85	5002694D	ADG GEARBOX HSG	TA115L	88334	
86	5002659	CLUTCH SPLINED SHAFT	TA116L	89074	
87	5005215	REACTOR	TA117L	88334	
88	5003866	OUTER CLUTCH PLATES	TA120L	89074	
89	5003867	INNER CLUTCH PLATES	TA121L	89074	
90	5005252	BEARING SHAFT	TA130L	89023	

SA-ALC -- INSPECTION

PCN NO. 13096A   END ITEM: F16 JET FUEL STARTER

WCD: TA109U   DATED: 89089   NOUN: COMBUSTOR HOUSING ASSY.   PART NO. 160007-100
WCD: TA113U   DATED: 89089   NOUN: FUEL MANIFOLD   PART NO. 5901086
160012-100
WCD: TA115U   DATED: 89089   NOUN: START FUEL NOZZLE   PART NO. 5901085
WCD: TA130U   DATED: 89089   NOUN: COMP ROTOR/SHAFT   PART NO. 160006-300
WCD: GBI   DATED: 89152   NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	160005-100	QUILL SHAFT	TA108U		
2	160007-100	COMBUSTOR HOUSING ASSY	TA109U	89089	
3	160012-100	FUEL MANIFOLD	TA113U	89089	
4	5901086	FUEL MANIFOLD	TA113U	89089	
5	5901085	START FUEL NOZZLE	TA115U	89089	
6	111931-200	LINER ASSY	TA117U	89089	
7	160004-200	TURBINE NOZZLE ASSY	TA118U	89089	
8	103754-1	BRG RETAIN/OIL SLINGER NUT	TA119U		
9	101284-101	BEARING RETAINER PLATE	TA120U		
10	160008-2	AIR INLET HOUSING	TA121U	89089	
11	160009-1	DIFFUSER	TA123U	89089	
12	162689-1	COMPRESSOR ROTOR	TA124U	89089	
13	36373-100	ROTOR SHAFT ASSY	TA125U		
14	42806-0	SEAL PLATE ASSY	TA126U	89089	
15	160006-300	COMP ROTOR/SHAFT	TA130U		

SA-ALC -- INSPECTION

PCN NO. 04542A END ITEM: CPS02 MOD STARTER

WCD: TA2150 DATED: 88340 NOUN: TURBINE HOUSING ASSY. PART NO. 693040B
WCD: TA2180 DATED: 89040 NOUN: GEAR HOUSING SUBASSEMBLY PART NO. 693041B
WCD: TA2300 DATED: 89038 NOUN: EXHAUST HOUSING PART NO. 703985
WCD: TA2320 DATED: 89095 NOUN: TURBINE ROTOR PART NO. 692217
WCD: G4I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	692563	GEARSHAFT, SPUR	TA2070	87308	
2	687446	OUTPUT SPUR GEAR SHAFT	TA2080	87308	
3	693039A	SPLINE SHAFT ASSY	TA2100	87308	
4	690271	BAND, MOUNTING	TA2110	87309	
5	686667-1	CONTAINMENT CLAMP	TA2120	87309	
6	689667-2	CONTAINMENT CLAMP	TA2130	87309	
7	692690	CLUTCH RACE	TA2140	89009	
8	693040B	TURBINE HOUSING ASSY.	TA2150	88340	
9	690738	TUBE CLAMP SET	TA2160	88340	
10	687471	RETAINER	TA2170	87043	
11	693041B	GEAR HOUSING SUBASSEMBLY	TA2180	89040	
12	693817	GOVERNOR HOUSING	TA2190	88319	
13	707795	RING PLENUM AND NOZZLE ASSY	TA2200	89040	
14	692953	BREECH HANDLE ASSEMBLY	TA2230	88326	
15	690915	BREECH CAP	TA2240	89018	
16	687470	ROTATING SEAL	TA2250	89040	
17	717594	SEAL, STATIONARY	TA2260	89040	
18	692220	BREECH CHAMBER	TA2280	88340	
19	690174A	CONNECTOR	TA2290	87043	
20	703985	EXHAUST HOUSING	TA2300	89038	
21	688535	SPACER	TA2310	89059	
22	692217	TURBINE ROTOR	TA2320	89095	
23	716682/687426A	CENTRIFUGAL FAN	TA2360	88354	
24	692218-1	GEARSHAFT, SPUR	TA2370	88266	
25	693076	SEAL, RETAINER	TA2390	88271	
26	690901	BREECH HANDLE	TA2470	88340	
27	688538	STATIONARY SEAL	TA2490	88354	
28	690469	LEVER	TA2500	98225	
29	701175C	ROTATING SEAL	TA2510	88354	
30	693798	SUPPORT BEARING	TA2630	88222	
31	693036	SHAFT, CLUTCH NO. 8	TA2700	88225	
32	693887	SHAFT, CLUTCH	TA2710	98225	
33	692909	SPRING, HELICAL	TA2720	88225	
34	24561	SPRAG CLUTCH	TA2730	87070	

SA-ALC -- INSPECTION

PCN NO. 10598A END ITEM: ATSC 100-87 STARTER

WCD: TA043A DATED: 89026 NOUN: CHAMBER ASSY. PART NO. 361000 & 3502143-3
WCD: TA044A DATED: 88263 NOUN: CHAMBER ASSY. PART NO. 364021-1
WCD: TA057A DATED: 89058 NOUN: PLENUM ASSY. PART NO. 364020-1/ -4
WCD: TA063A DATED: 88081 NOUN: HOUSING ASSY. PART NO. 360244
WCD: G5I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	361000	CHAMBER ASSY (EXCHG. ITEM)	TA043A	89026	
2	3502143-3	CHAMBER ASSY (EXCHG. ITEM)	TA043A	89026	
3	364021-1	CHAMBER ASSY	TA044A	88263	
4	360259	LINER	TA045A	88081	
5	351589-10	GEAR	TA046A	88081	
6	360262	GEAR	TA047A	85115	
7	360323	HUB, INTERNAL GEAR	TA048A	85115	
8	360273	SUPPORT BEARING	TA049A	88264	
9	360269	GEAR SPUR	TA051A	88335	
10	3500162-1	SHAFT ASSY O/P	TA054A	88081	
11	360268	GEARSHAFT, SPUR	TA055A	88264	
12	360293	PAWLS (3 EA)	TA056A	89026	
13	364020-1	PLENUM ASSY	TA057A	87246	
14	3500161-1	SHAFT ASSY	TA058A	88081	
15	360689	GUIDE, BOLT	TA059A	88081	
16	360603	FLANGE ASSY	TA060A	88081	
17	123284-1-1	VALVE CHECK 3 IN. DIAM.	TA061A	88245	
18	360646	RETAINER	TA062A	88081	
19	360244	HOUSING ASSY	TA063A	88081	
20	360604	HOUSING ASSY	TA064A	89048	
21	360283	CARRIER, ASSY	TA066A	89052	
22	361053	NOZZLE PLATE ASSY	TA067A	88081	
23	3502137-1	NOZZLE PLATE ASSY	TA067A	88081	
24	360642	SHIELD	TA068A	88081	
25	364078-1	TURBINE WHEEL ASSY (EX ITEM)	TA075A	88337	
26	3502136-1	TURBINE WHEEL ASSY (EX ITEM)	TA075A	88337	
27	360495	GRIP, HANDLE	TA182A	88081	
28	360656	SPRING	TA187A	88081	

SA-ALC -- INSPECTION

PCN NO. 10718A END ITEM: ATSC 100-97 & 100-97A STARTER

WCD: TA015T DATED: 88132 NOUN: HOUSING ASSY PART NO. 3500464-1
WCD: TA034T DATED: 88272 NOUN: T WHEEL PART NO. 364078-4
WCD: TA035T DATED: 88209 NOUN: CHAMBER ASSY (DOME) PART NO. 3500756-1
WCD: TA037T DATED: 88155 NOUN: CHAMBER ASSY (BREECH CAP) PART NO. 3500572-2
WCD: G6I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	3500538-1	SHIELD	TA001T	88132	
2	3500915-11	ROD, BALL END	TA003T	88132	
3	3500913-1	CLEVIS	TA004T	88132	
4	364052-2	SUPPORT	TA005T	88132	
5	3500906-1	ARM, ACTUATING	TA006T	88132	
6	3500944-11	ARM, ASSEMBLY	TA007T	88132	
7	351355-4	CONNECTOR	TA009T	88132	
8	3500815-1	SPRING	TA010T	88132	
9	3500919-1	SPRING	TA011T	88132	
10	3500908-1	ARM	TA012T	88132	
11	3500464-1	HOUSING ASSY	TA015T	88132	
12	3500502-1	PLENUM ASSY	TA016T	88131	
13	3500782-1	MANIFOLD NOZZLE	TA017T	88132	
14	123284-1-1	CHECK VALVE	TA018T	88131	
15	3500701-1	PLATE	TA019T	88133	
16	350375-27	SHAFT ASSY	TA020T	89080	
17	350375-27	SHAFT-ASSY	TA020T	86201	
18	3500467-1	GEAR	TA021T	88232	
19	3500602-1	SPRING	TA022T	88232	
20	3500603-1	CARRIER	TA023T	88089	
21	357079	HUB	TA024T	87090	
22	3500354-1	GEARSHAFT (3 EA)	TA025T	88232	
23	3500409-1	GEARS (3 EA)	TA026T	88232	
24	351589	GEAR, INTERNAL SPUR	TA027T	88232	
25	356850	CARRIER ASSY, SEAL	TA028T	88040	
26	3500462-1	HOUSING	TA029T	88232	
27	351392	PAWLS (3 EA)	TA031T	88075	
28	364078-4	T WHEEL (EXCHG ITEM)	TA034T	88272	
29	3500756-1	CHAMBER ASSY (EXCHG. ITEM)	TA035T	88209	
30	3500501-1	CHAMBER ASSY (EXHAUST)	TA036T	87284	
31	3500572-2	CHAMBER ASSY (EXCHG. ITEM)	TA037T	88155	
32	356346-10	CARRIER ASSY	TA038T	88188	

SA-ALC -- INSPECTION

PCN NO. 13081A END ITEM: GAS TURBINE ENGINE 85-70A

WCD: TG813A DATED: 88244 NOUN: DIFFUSER ASSY, 2ND STAGE PART NO. 373823
WCD: TG816F DATED: 89097 NOUN: HOUSING ASSY, 1ST STAGE (INLET) PART NO. 378383-3
WCD: TG859A DATED: 87270 NOUN: HOUSING ASSY, ACCESSORY DRIVE PART NO. 373623-3
WCD: TG890A DATED: 87240 NOUN: SHAFT ASSY, FAN IDLER GEAR PART NO. 693522
WCD: G9I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	373613-3	SHAFT ASSY, FAN DRIVE	T6084F	87243	
2	*370479-1-XX	TUBE ASSEMBLY (RIGID)	T6101F	87270	
		*(16 PARTS-SEE WCD T6101F)			
3	370116	PLATE, RETAINER	T6809A	87270	13094A & 13095A
4	373822/76443	DESWIRL ASSY, 2ND STAGE DIFF.	T6812F	87270	13094A
5	373823	DIFFUSER,2ND STAGE DIFFUSER ASSY	T6813A	87270	
6	378383-3	HOUSING ASSY, 1ST STAGE (INLET)	T6816F	89097	
7	693368	SEAL, BEARING HOUSING	T6823F	88217	13094A
8	74623-1	FITTING, OIL DRAIN	T6826F	88217	13094A
9	376794	SHAFT, TORSION	T6831A	89002	13094A
10	371144	SHAFT, TORSION	T6831A	89002	13094A
11	371143	SHAFT, TORSION	T6832F	87270	13094A
12	379483	MOUNT ASSY., BEARING	T6833A	87270	
13	74517	RETAINER, COMPRESSOR BEARING	T6834A	87270	13094A
14	379219	RETAINER (2 EA.)	T6835A	87270	13094A
15	70876	NUT, COMPRESSOR SHAFT	T6837A	87270	13094A
16	696327-2	TURBINE WHEEL ASSY. (NEW)	T6844A	87270	13094A
17	693155-100	NOZZLE ASSY, BRANCHED, OIL JET	T6848A	87270	13094A
18	70966	SPACER, BEARING	T6849A	87270	13094A
19	693327	SPACER, TURB. BRG.	T6850A	87270	13094A
20	693263	RETAINER, BEARING	T6851A	87270	13094A
21	75475	HOUSING, FAN OUTLET	T6855F	88245	
22	75470	FAN ASSY., OIL COOLER	T6856A	87270	
23	370118	HOUSING, FAN INLET	T6857F	87270	
24	373623-3	HOUSING ASSY., ACCESSORY DRIVE	T6859A	87270	
25	370654	SCREEN, FAN HOUSING INLET	T6861A	87270	
26	7346991-10	SCREEN, FAN HOUSING INLET	T6861A	87270	
27	373474	SPACER ASSY., STARTER MOTOR	T6862F	88308	
28	373475	GUARD, BARRIER STARTER	T6864A	87270	
29	74696-2	SLEEVE, FAN DRIVE BEARING	T6865A	87270	
30	72021	SPACER, FAN DRIVE BEARING	T6866A	87270	
31	693123	GEAR, FAN IDLER	T6869A	87270	
32	370079	BUSHING, IDLER GEAR	T6870A	87270	
33	370339	BUSHING, INTERMEDIATE SHAFT	T6871A	87270	
34	73268-1	SHAFT, OVERSPEED SWITCH	T6872A	87270	
35	693126	GEAR, PUMP	T6873A	87270	
36	693125	GEAR, SPUR	T6874A	87270	
37	693211	GEAR ASSY, MAIN DRIVE	T6875A	89009	

38	73653	SHAFT, OVERSPEED SWITCH	TG876A	87270		
39	75677	ADAPTER, CENTRIFUGAL SWITCH	TG877A	87270		
40	378104-1	RETAINER, BEARING	TG878A	87270		
41	378102-10	SPACER SET, BEARING MATCHED	TG879A	87270		
42	378103-10	CARRIER, ACCESS. DRIVE BEARING	TG880A	87270		
43	693120	GEAR, BEVEL	TG881A	87270		
44	370549	RETAINER,SCREEN,OIL COOLER FAN	TG882A	87270		
45	72022	SPRING, FAN SHAFT	TG884A	87270		
46	75675	SPRING	TG885A	87270		
47	74661	INSULATOR	TG887A	87270		
48	693522	SHAFT ASSY, FAN IDLER GEAR	TG890A	87240		
49	371319	ORIFICE ASSY.	TG901A	87270		13094A
50	**MS28741-4-XXXX	HOSE ASSY., (FLEXIBLE)	TG931F	89013		
	**MS28741-8-XXXX	**(13 PARTS-SEE WCD TG931F)				
	**MS28741-6-XXXX					
	**AN6270-4-52					
	**601000-12-0120					

SA-ALC -- INSPECTION

PCN NO. 13094A   END ITEM: GAS TURBINE ENGINE 85-397

WCD: TG813A   DATED: 88244   NOUN: DIFFUSER ASSY. 2ND STAGE   PART NO. 373823
WCD: TG840A   DATED: 89025   NOUN: TORUS, TURBINE   PART NO. 379185-52
WCD: TG841F   DATED: 89090   NOUN: NOZZLE, TURBINE   PART NO. 378513-4
WCD: T504KG   DATED: 9270   NOUN: PLENUM, TURBINE   PART NO. 371083-2
WCD: 6101   DATED: 89152   NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	73268	SHAFT, OVERSPEED SWITCH	TA514F	87300	
2	*694681	TUBE ASSEMBLY (RIGID)	TG401F	87270	
		*(13 PARTS-SEE WCD TG401F)			
3	378916-11	CARRIER ASSY, GEAR, PLANET	TG436F	87077	13095A
4	75532-3	HOUSING, PLANETARY CARRIER	TG450F	87002	
5	75283	GEAR, PLANETARY (E EA.)	TG451F	87002	
6	74339	SHAFT, PLANET GEAR	TG452F	87002	
7	371551	GEAR ASSEMBLY, SPUR	TG454F	87002	
8	74340	BUSHING, PLANET GEAR	TG458F	87102	
9	3604090-1	CASE ASSEMBLY, ACCESSORY	TG490F	88338	13095A
10	372896-16	CASE ASSEMBLY, ACCESSORY	TG490F	88338	13095A
11	75970	HOUSING ASSY, VANE, PRESWIRL	TG492F	89086	13095A
12	692070	FLANGE, MOUNT PLATE	TG493F	87215	
13	75973	FAN ASSY, OIL COOLER	TG494F	88344	13095A
14	75978	COVER ASSY., DRIVE PAD	TG495F	88344	
15	372822	SHAFT ASSY., FAN DRIVE	TG501F	88232	
16	75331-4	GEAR ASSY. GENERATOR DRIVE	TG502F	87300	
17	75331-2	GEAR ASSY. GENERATOR DRIVE	TG502F	87300	
18	371356-1	SHAFT ASSY., FAN IDLER GEAR	TG503F	87300	
19	372080	SPRING, FAN SHAFT	TG505F	87300	
20	73939	RETAINER, BEARING	TG506F	87300	
21	371723	HOUSING, BEARING, GENERATOR DR.	TG507F	87300	
22	75858	RETAINER, BEARING GASKET SEAL	TG508F	87300	13095A
23	75333	RETAINER, SEAL, MAIN SHAFT	TG509F	89017	
24	692531	GEAR, SPUR PUMP	TG510F	87300	
25	72004	GEAR, OVER SPEED SWITCH DRIVE	TG511F	87300	
26	75969	RETAINER, FAN BEARING	TG512F	87300	
27	76389-1	GEAR RING	TG513F	87300	
28	73267	BUSHING, OVERSPEED SW. CUTBD	TG515F	87300	
29	73067-2	SPACER, BEARING	TG516F	87300	
30	375652-2	GUARD, STARTER BARRIER	TG518F	88288	
31	372763	SPACER, STARTER MOTOR	TG519F	87300	
32	73349	GEAR, FAN IDLER	TG520F	87300	
33	74347	RING, RETAINING	TG521F	87300	
34	370343	SPACER, NUT	TG523F	87300	
35	**399-594-XXXX	HOSE, FLEXIBLE (BRAIDED) #6,#9,#15	TG570F	87270	
		**(3 PARTS-SEE WCD TG570F)			
36	370213	CAP ASSY, TURBINE COMBUSTOR	TG807A	89025	13081A

37	370116	PLATE, RETAINER	T6809A	87270	13081A
38	3738221/76443	DESWIRL ASSY,2ND STAGE DIFF.	T6812F	87270	13081A
39	373823	DIFFUSER ASSY, 2ND STAGE	T6813A	88244	
40	372933-2	DIFFUSER ASSY, 1ST STAGE COMPR	T6817F	89095	13081A
41	378101/371690	COMPRESSOR ROTATING ASSEMBLY	T6820A	88150	13081A
42	372556	IMPELLER, 2ND STAGE	T6821A	89025	13081A
43	378101 /0/ -1	IMPELLER 1ST STG	T6822A	89069	13081A
44	693368	SEAL, BEARING HOUSING	T6823F	88217	13081A
45	372696	DUCT, AIR, INTERSTAGE 7 EA.	T6824F	88216	13081A
46	376803	FITTING, OIL DRAIN	T6826F	88217	13081A
47	75678-1	FITTING, OIL AND BREATHER	T6827F	88217	13081A
48	376939	TUBE, OIL BREATHER	T6828F	88217	13081A
49	693157	TUBE, OIL JET	T6830F	88217	13081A
50	376794	SHAFT, TORSION	T6831A	89092	13081A
51	373019-1	SHAFT, TORSION	T6832F	87270	13081A
52	74517	RETAINER, COMPRESSOR BEARING	T6834A	87270	13081A
53	379219	RETAINER (2 EA.)	T6835A	87270	13081A
54	70876	NUT, COMPRESSOR SHAFT	T6837A	87270	13081A
55	358066-1	BUSHING, SLEEVE	T6838A	87237	13081A
56	379185-52	TORUS, TURBINE	T6840A	89025	
57	378513-4	NOZZLE, TURBINE	T6841F	89090	
58	696327-1	WHEEL, TURBINE (WASPASLOY)	T6842F	88216	13081A
59	696327-1	TURBINE WHEEL ASSY. (NEW)	T6844A	87270	13081A
60	75157	SHIELD, TURBINE WHEEL	T6845F	87270	13081A
61	69155-100	NOZZLE ASSY, BRANCHED, OIL JET	T6948A	87270	13081A
62	70866	SPACER, BEARING	T6849A	87270	13081A
63	693327	SPACER, TURB. BRG.	T6850A	87270	13081A
64	693263	RETAINER, BEARING	T6851A	87270	13081A
65	371319	ORIFICE ASSY.	T6921A	87270	13081A
66	372519	DUCT COOLER	T6930A	87270	13081A
67	371083-2	PLENUM, TURBINE	T6[illegible]	9270	

SA-ALC -- INSPECTION

PCN NO. 13095A END ITEM: GAS TURBINE ENGINE 85-180

WCD: TG490F DATED: 88338 NOUN: ACCESSORY CASE PART NO. 372896-20
WCD: TG611D DATED: 88288 NOUN: LINER, COMBUSTION CHAMBER PART NO. 899244-3
WCD: TG615D. DATED: 88224 NOUN: TORUS, TURBINE PART NO. 968959-2
WCD: TG645D DATED: 87287 NOUN: WHEEL & SHAFT ASSY. PART NO. 3606982-1
968095-3/-5

WCD: G11I DATED: 89152 NOUN: GENERIC

ITEM NO.	PART NUMBER	NOUN	WCD NUMBER	WCD DATE	ALTERNATE/ADDITIONAL PCN NUMBER
1	378916-11	CARRIER ASSY, GEAR, PLANET	TG438F	87077	
2	372896-20	CASE ASSEMBLY, ACCESSORY	TG490F	88338	
3	75973	FAN ASSY., OIL COOLER	TG494F	88344	
4	75858	RETAINER, BEARING GASKET SEAL	TG508F	87300	
5	977106-1	PLENUM TURBINE	TG610D	87235	
6	899244-3/ -5	LINER, COMBUSTION CHAMBER	TG611D	88288	
7	695709-4/ -2	CAP, COMBUSTION	TG612D	87273	
8	379692-20	FLANGE	TG613D	87242	
9	372844	VENT TUBE	TG614D	87272	
10	968959-2	TORUS, TURBINE	TG615D	88224	
11	968958-2	RING, CONTAINMENT	TG616D	88056	
12	899607-1	PIPE, EXHAUST	TG617D	88200	
13	968886-1/-2/-4	NOZZLE, TURBINE	TG618D	87253	
14	968233-1	SHROUD, TURBINE WHEEL	TG619D	87302	
15	968972-1	BOLTS, NOZZLE	TG620D	88060	
16	373685	SPACER, NOZZLE	TG621D	88060	
17	698198-1	HOUSING, 2ND STAGE COMPRESSOR	TG622D	89040	
18	698197-1	INLET ASSEMBLY, FIRST STAGE	TG623D	89040	
19	698194-1	DIFFUSER, 1ST STAGE COMPRESSOR	TG624D	89044	
20	372696	DUCT, AIR	TG625D	88060	
21	378854-30	SEAL, AIR	TG626D	88060	
22	379541	BOLT	TG627D	88060	
23	698195-1/-2/-6	HOUSING, 2ND STAGE DIFFUSER	TG628D	89040	
24	892290-1	DIFFUSER, 2ND STAGE COMPRESSOR	TG629D	89058	
25	241102	FITTING, OIL & BREATHER	TG630D	88057	
26	696659-160	HOUSING, BEARING	TG631D	88148	
27	968984-1	SUPPORT, SHROUD	TG632D	87255	
28	969008-1	FLANGES, BEARING HOUSING	TG633D	88056	
29	694040	OIL TUBE	TG634D	88023	
30	899431-1	TUBE, OIL BREATHER	TG635D	88237	
31	379663	SPRING, SHAFT	TG636D	88070	
32	74994	TUBE, SPRING	TG637D	88070	
33	695753-1	BEARING CARRIER	TG638D	88070	
34	692755-10	TEE	TG639D	88070	
35	692755-40	TEE ASSY, ORIFICED	TG640D	88070	
36	968095-35	WHEEL & SHAFT ASSEMBLY	TG645D	87287	
37	3606982-1	WHEEL & SHAFT ASSEMBLY	TG645D	87287	
38	379523	NUT, IMPELLER RETAINING	TG646D	88070	
39	379721	NUT, ROUND PLAIN	TG647D	88075	

40	698192-4	IMPELLER, 1ST STAGE COMPRESSOR	T6648D	87247	
41	693588	SPACER, TURBINE BEARING	T6649D	88228	
42	698193-4	IMPELLER, 2ND STAGE	T6650D	88076	
43	379658/ -1	HOUSING, PLANETARY	T6659D	87287	
44	378916	CARRIER ASSEMBLY, PLANETARY	T6661D	87238	
45	977078-1	COVER, ACCESSORY CASE	T6663D	88096	
46	692070	FLANGE, MOUNT PLATE	T6664D	88096	
47	72906	BAFFLE, OIL PUMP	T6669D	88097	
48	372822-2	SHAFT ASSY, FAN DRIVE	T6674D	87291	
49	73276	WASHER, ROTATING ASSY.	T6676D	88060	
50	73097	NUT, FAN SHAFT	T6677D	88060	
51	379657	SHAFT, TORSION	T6678D	88060	
52	75285-4	SHAFT ASSY., ACCESSORY DRIVE	T6680D	87259	
53	73742	GEAR, MAIN DRIVE BEVEL	T6681D	88060	
54	74347	RING, GEAR RETAINING	T6684D	88060	
55	75331-4	GEAR ASSY, GENERATOR DRIVE	T6686D	87237	
56	73849	GEAR, FAN IDLER	T6688D	88060	
57	72004	GEAR, OVERSPEED DRIVE	T6690D	88060	
58	692531	GEAR, SPUR	T6692D	88060	
59	75334/ 370579	NUT	T6694D	88060	
60	75969	RETAINER, BEARING	T6696D	88060	
61	371728	BEARING HOUSING, GENERATOR	T6699D	88060	
62	73268	SHAFT, SWITCH	T6700D	88060	
63	372080	SPRING, FAN SHAFT	T6702D	88060	
64	75282	GEAR SET, PLANETARY	T6703D	88060	
65	74339	SHAFT, PLANETARY GEAR	T6704D	88060	
66	371551	SPUR GEAR ASSY.	T6707D	88061	
67	379465	RETAINER, COMPRESSOR BEARING	T6708D	88060	
68	73067-1/-2/-3	BEARING SPACER	T6709D	88060	
69	370344	SPACER	T6710D	88060	
70	371856	SHAFT ASSY., FAN IDLER GEAR	T6711D	88060	
71	75333	RETAINER, MAIN SHAFT SEAL	T6713D	88105	
72	3603685-3	SHAFT, FUEL PUMP DRIVE	T6714D	88056	
73	976345-1	TUBE, PNEU.	T6733D	89055	
74	976344-1	TUBE, PNEU.	T6734D	89055	
75	973646-1	TUBE, PNEU.	T6735D	89055	
76	976347-1	TUBE, PNEU.	T6736D	89055	
77	976340-1	TUBE, FUEL	T6737D	89055	
78	976341-1	TUBE, FUEL	T6738D	89055	
79	976343-1	TUBE, FUEL	T6739D	89055	
80	976355-1	TUBE, FUEL	T6740D	89055	
81	976349-1	TUBE, OIL	T6741D	89055	
82	976350-1	TUBE, OIL	T6742D	89055	
83	976351-1	TUBE, OIL	T6743D	89055	
84	976353-1	TUBE, OIL	T6744D	89055	
85	976354-1	TUBE, OIL	T6745D	89055	
86	379747	TUBE, OIL	T6746D	89055	13094A
87	976342-1	TUBE, PNEU.	T6747D	89055	13094A
88	372519	DUCT, AIR	T6748D	89055	13094A
89	969153-1	HOSE, FUEL	T6749D	89055	13094A
90	370116	PLATE RETAINER	T6809A	87270	13094A
91	75970	BUSHING, SLEEVE	T6838A	87337	13081A

2.6 MATERIAL HANDLING

THE INSPECTION FUNCTION HAS TWO METHODS FOR MATERIAL HANDLING. FIRST, A DOUBLE DECKED ROLLER CONVEYOR SYSTEM INTERS THE INSPECTION AREA FROM THE CLEANING AND FLORESCENT PENETRANT WORK AREAS. THE SECOND METHOD OF MATERIAL HANDELING IS BY FOUR WHEEL CARTS MANUALLY PUSHED INTO THE AREA FOR THOSE PARTS ASSIGNED A CRITICAL PRIORITY. AFTER INSPECTION, PARTS LEAVE THE AREA VIA THE UPPER ROLLER CONVEYOR ... THE FOUR WHEEL CARTS.

THE CLEANING FUNCTION USES FOUR WHEEL CARTS TO MOVE PARTS THROUGHOUT THE AREA. PLASIC BASKETS AND HOISTS USED TO DIP PARTS IN THE LARGE DEGREASING TANKS. THE SMALL TANKS ARE MANUALLY OPERATED USING SMALL BASKETS AND HOCKS TO DIP PARTS.

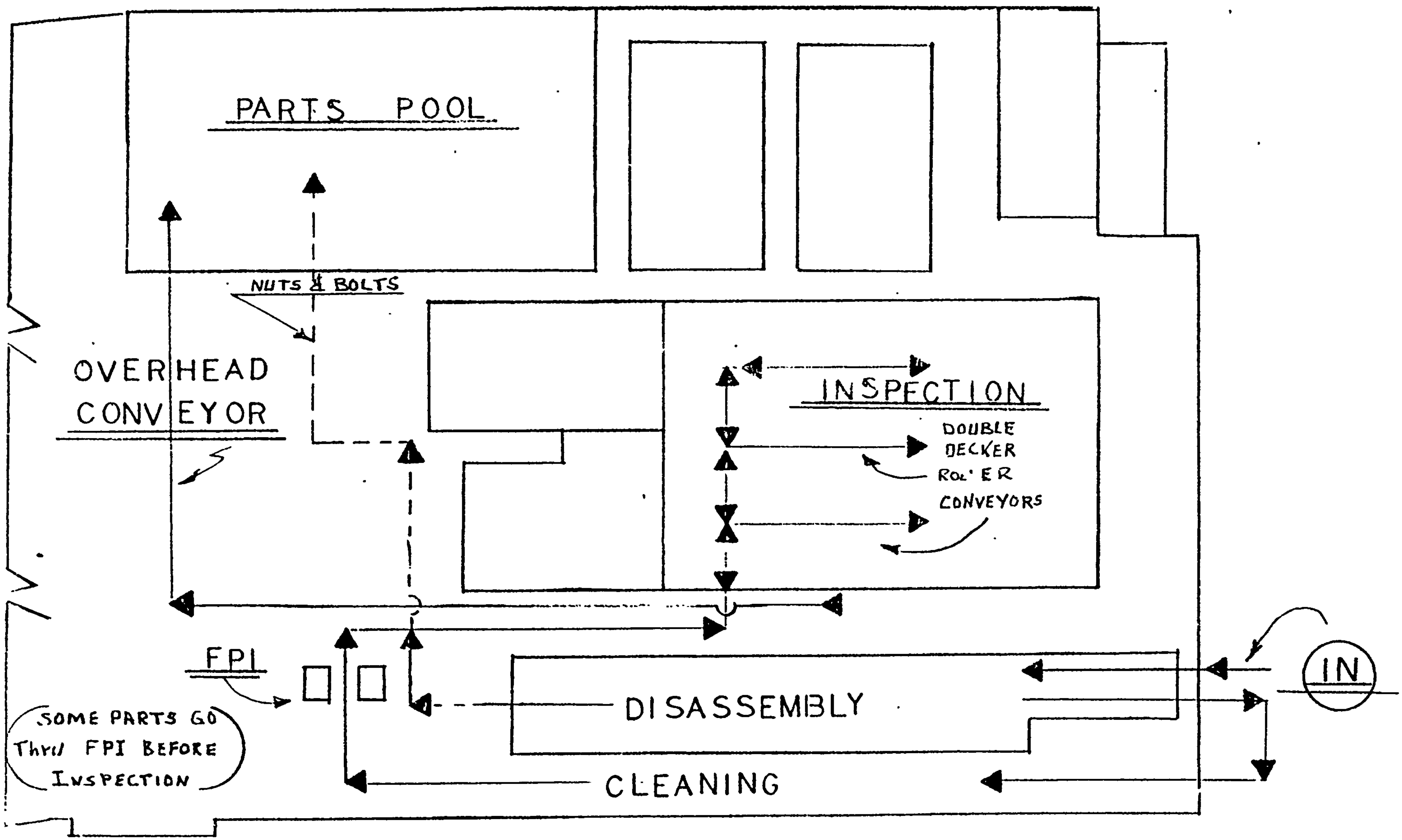
THE DISASSEMBLY FUNCTION CURRENTLY USES PLASTIC BASKETS AND FOUR WHEEL CARTS TO

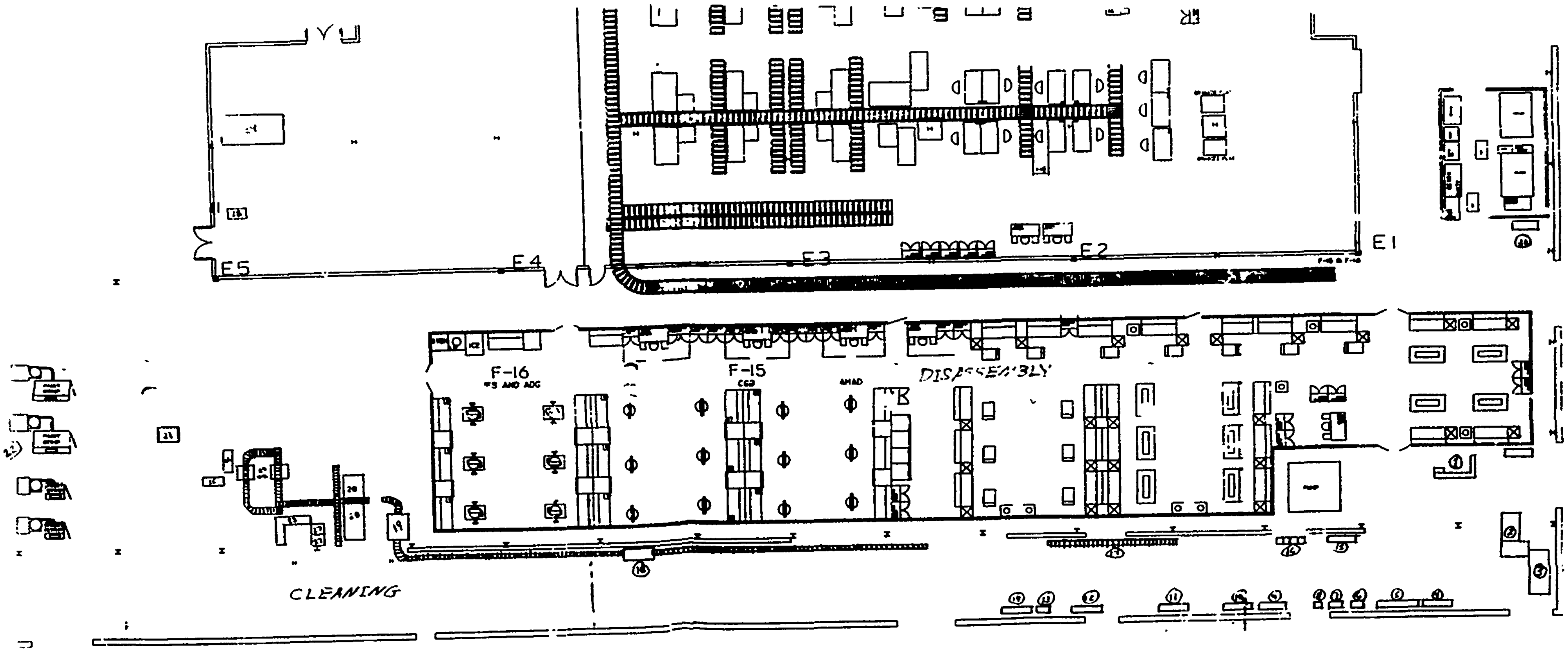
MOVE PARTS IN AND OUT THE AREA. THE DISASSEMBLY AREA IS NOW BEING REMODELED SO A BASKET CONVEYOR SYSTEM CAN BE INSTALLED TO MOVE DISASSEMBLED PARTS FROM INDIVIDUAL WORK STATIONS TO THE CLEANING AREA WICH IS LOCATED OUTSIDE THE MODULE.

2.7 STORAGE

MATPSI HAS NO STORAGE AREA, EXCEPT FOR TOOL CABINETS AND PARTS IN QUEQE ON SHELVES, CONVEYOR, AND CARTS WAITING TO BE INSPECTED.

SA-ALC NORTH END BUILDING 329





E1
E2
E3
E4
E5
F-16
F-15
DISASSEMBLY
CLEANING

5/12/89

SA/ALC MATPSI CLEANING AREA

Jim Eaton (AS IS)

1. Supervisor's Desk
2. Processing Desk
3. Carbon Strip Tank
4. Corrosion Strip Tank
5. Hot Water Rinse
6. Degreaser Tank
7. Emergency Shower
8. Degreaser Tank
9. Hot Water Rinse
10. Grit Blasters
11. Grit Blasters
12. Grit Blasters
13. Grit Blasters
14. Unused Degreaser
15. Sonic Degreaser
16. 4 Degreaser Tanks
17. Unused Conveyer
18. Flourescent Penetrant Line
19. Flourescent Penetrant Oven
20. 2 Degreasers
21. Unused Grit Blaster
22. 4 Grit Blasters
23. Desk & Table
24. 2 - Flourescent Penetrant Inspection Booths
25. Desk
26. MagnaKleen Sonic Degreaser
27. 2 - Shop bilt Hydrostatic Testers
28. Desk
29. Magnetic Particle Inspection
30. MagnaKleen Sonic Degreaser

MATPSI

3.0 80/20 ANALYSIS OF MATPSI

THE PRODUCTS HANDLED IN MATPSI ARE PROVIDED TO RCC's MATPGB AND MATPSS VIA VARIOUS OTHER "BACKSHOP" RCC's FOR ASSEMBLY INTO THE ITEMS PRODUCED BY THEM. THE LIST FOR MATPSI PCN's THEREFORE CONSISTS OF THREE FROM MATPGB AND NINE FROM MATPSS AS SHOWN ON THE FOLLOWING PAGES.

3.1 VALIDATION OF 80/20 ANALYSIS

THE LIST OF ITEMS FOR MATPGB AND MATPSS ACCOUNT FOR MORE THAN 80 PERCENT OF THE WORKLOAD IN EACH RCC AND THEREFORE ARE VALID FOR MATPSI WHICH IS IN SUPPORT OF BOTH OF THESE RCC's.

I" '50ED.ALCSA.G019C.T058435 7:27 WEDNESDAY,

MANAGEMENT OF ITEMS SUBJECT TO REPAIR

LISTING OF MSTR FILE

PS=MTPG

OBS	PCN	ANSN		NOUN	WSA	UC	ODPSH	Per Month	FYIR		YTDTIM	PI
1635	13095 (5)	2835012410074	D.H	GT85-180	A-M32A-60A	7600000	654.0	19	210.0	50	137340.0	4
1636	13094	2835012422189	B.C.	GT85-397	A-M32A-60	7312300	540.0	12	133.0	50	71820.0	2
1637	13081	2835007990148	B.C.	GT85-70A	MA1A GEN	6802100	648.0	10	110.0	50	71280.0	2
1638	12494	2835011814262	M.A.	GEARBOX	G00036050	1040300	150.0		57.0		8550.0	2.
1639	00760 (2)	2835004945720	D.H.	ACCESSAR	9720-4T/S	199971	112.0		26.0		2912.0	0.
1640	01510 (4)	2835007592303	M.A.	ACCESASS	C+141	915700	43.0		36.0		1548.0	0.
1641	13255	2835009490524	B.C.	ACCESRY	VB52	644031	24.0		48.0		1152.0	0.
1642	11489 (3)	2835010163048	D.H.	ACCESSOR	GTCP85180LC	725120	73.0		14.0		1022.0	0.
1643	13247 (1)	2835006825360	B.C.	ACC ASSY	F+4	418600	68.0		4.0		272.0	0.
1644	40855	30100028324 10Y	M.A	CLUTCHAS	C+5A	125100	8.0		23.0		184.0	0.
PS											296080.0	

$$\frac{280440}{296080} = 94.72\%$$

SI

I` `150ED.ALCSA.G019C.T058435 — 7:27 WEDNESDAY.

MANAGE JT OF ITEMS SUBJECT TO REPAIR

LISTING OF MSTR FILE

PS=MTPS

OBS	PCN	ANSN	PCNRS	NOUN	ENGR	WSA	UC	ODPSH	FYIR		YTDTIM
2124	08007	2835010346948	DK	CTRLGB	RK	F+15A-TF15A	5109998	833.0	419.0	81	349027.0
2125	08006	2835010912433	AD	JFSTARTR	RK	F+15A-TF15A	11845000	932.0	345.0	69	321540.0
2126	12712	2835012355249	LQ	A.D.G.	ML	F-16 A/B	6489000	1739.0	183.0	50	318237.0
2127	13096	2835011543533	PC	JFS.	ML	F-16	2802280	916.0	221.0	50	202436.0
2128	08004	2835010207249	YR	LHGB	RK	F+15A-TF15A	3746625	595.0	219.0	50	130305.0
2129	10718	2995010389092	EG	STARTER	KS	B52	1218000	355.0	340.0	68	120700.0
2130	04542	2995001727659	EGILL	STARTER	KS	B52G	3335275	256.0	428.0	86	109568.0
2131	10593	2995010776708	ME	STARTER	KS	F004C	1789500	270.0	282.0	56	76140.0
2132	08005	2835010881009	YR	RHGB	RK	F-5A-TF15A	1558000	573.0	124.0	61	71052.0
2133	40721	2995001134562		STARTER		EC135	929658	272.0	233.0		63376.0
2134	10148	2995010363713		STARTER		F4C	2536200	248.0	227.0		56296.0
2135	11064	1650010053500FS		HEATEXCH		F15A B C D	365375	80.0	468.0		37440.0
2136	12199	2995010489580		STARTER		A10	1046480	196.0	153.0		29988.0
2137	10149	2995004921489		STARTER		C141	1258969	170.0	176.0		29920.0
2138	10172	2995003829870		STARTER		F111	4305400	255.0	111.0		28305.0
2139	12351	2995011396642		STARTER		C/KC-135E	3172194	328.0	73.0		23944.0
2140	43134	2995009985303		STARTER		C005A	1405950	232.0	61.0		14152.0
2141	10150	2995003375116		STARTER		C130	630000	173.0	63.0		10899.0
2142	10015	2995008513212		STARTER		F111A	685485	179.0	54.0		9666.0
2143	10147	2995009513466		STARTER		C135	2515908	304.0	18.0		5472.0
2144	10150	2995003375145		STARTER		C130	630000	173.0	30.0		5190.0
2145	10167	2995000512983		STARTER		C135	802558	160.0	28.0		4480.0
2146	10155	2995008569466		STARTER		C135	1103734	162.0	24.0		3888.0
2147	10144	2995009201719		STARTER		C135	1363300	261.0	6.0		1566.0
2148	12235	2835011072202		FAN & AD		F15ACFT	88600.00	22.0	66.0		1452.0
2149	09264	2835010289688		GEN,GAS		F-15	1958367	627.0	2.0		1254.0
2150	10170	2995000199649		CAP3REEC		F4C	70850.00	42.0	21.0		882.0
2151	11652	2995003935338		CHAMBERA		B52H	134171	17.0	42.0		714.0
2152	47573	2995009959481		BREECHCP		F4C	70850.00	23.0	16.0		368.0
2153	11577	2835010387155		LAYSHAFT		F15	133256	68.0	4.0		272.0
2154	11063	1650010732180FS		HEATEXCH		F15A B C D	279100	79.0	3.0		237.0
2155	47580	2995009246480		CAP		F+111	133400	27.0	6.0		162.0
PS											2028928.0

$$\frac{1699005}{2028928} = 83.74\%$$

WORKLOAD DEFINITION MATRIX

5 855'

PAGE 1 OF

DATE 11/2[illegible]8

PDB

ALC LOCATION SAN ANTONIO

GOOAL [illegible]

5AF71

RCC	WORKLOAD PERCENTAGE % MISTR	PDM	T	M	WORKLOAD DEFINED BY MAC SYS	ALC SYS	BOTH	OTHER	GFI TAPES/S USED CMP.	GMSC	BOTH	OTHER	TIME REQUIRED TO DEFINE W/L	REMARKS
MABPSC		80%	20%			✓	✓					✓	6 DAYS	WAS MABPME & MABPMF
MABPSA	75 60	5	20 35%		✓					✓			2.0 HRS	
MABPSB	85	2	14%		✓					✓			2.0 HRS	
MABPSP	60	10	30%		✓					✓			2.0 HRS	
MATPGB	* 100				✓					✓			2.0 HRS	
MATPGG	NOT USED													GBASSY INCLUDED IN MATPGB
MATPSI	* 100				✓					✓			2.0 HRS	
MATPSS	* 100				✓					✓			2.0 HRS	

* W/L IS A COMBINATION OF MISTR & PROJECT DIRECTIVE (PD) WORK. PD WORK IS TREATED SAME AS MISTR WORK EXCEPT IT IS FUNDED SEPARATELY. FOR OUR PURPOSE IT IS CONSIDERED AS MISTR

MATPGB	MISTR	54%	PD	46%
SI	"	83%	"	17%
SS	"	98%	"	2%

5 ESS1

(5AAF71)

G004L Derivative

PAGE 1
DATE 11/22/88

WORKLOAD DEFINITION MATRIX

ALC LOCATION SAN ANTONIO

RCC	WORKLOAD PERCENTAGE %				WORKLOAD DEFINED BY				GFI TAPES/S USED				TIME REQUIRED TO DEFINE W/L	REMARKS
	MSTR	PDM	T	M	WRAC STS	ALC STS	BOTH	OTHER	G004L	GMSC	BOTH	OTHER		
MABPSC		80%	20%			✓	~~✓~~					✓	6 DAYS	WAS MABPME & MABPMF
MABPSA	60	5	35%		✓					✓			2.0 HRS	
MABPSB	85	2	13%		✓					✓			2.0 HRS	
MABPSP	60	10	30%		✓					✓			2.0 HRS	
MATPGB	* 100				✓					✓			2.0 HRS	
MATPGG	NOT USED													GEARASSY INCLUDED IN MATPGB
MATPSI	* 100				✓					✓			2.0 HRS	
MATPSS	* 100				✓					✓			2.0 HRS	

* W/L IS A COMBINATION OF MSTR & PROJECT DIRECTIVE (PD) WORK. PD WORK IS TREATED SAME AS MSTR WORK EXCEPT IT IS FUNDED SEPARATELY. FOR OUR PURPOSES IT IS CONSIDERED AS MSTR.

MATPGB	MSTR	54%	PD	46%
SE	"	83%	"	17%
SS	"	98%	"	2%

5461-7A

PROFILE SHEET DATA COMPLETION MATRIX

PAGE ______
DATE ______

ALC LOCATION SAN ANTONIO

RCC	WORK CONTROL DOCUMENTS: AVAIL. YES	AVAIL. NO	STORED WHERE: E	P	S	PC	PR	O	HOW LONG (MO): <6	6-12	>12	PROFILE SHEET INTERVIEWS: DATE	NAME	JOB FUNCTION	TIME TO INTERVIEW	MAC TIME TO COMPLETE FORM
MAB PSC					✓				✓							
MAB PSA	✓				✓				✓			11/16/88	MECHANIC / SUPERVISOR	SAME	17	26
MABPSB	✓				✓				✓			11/14/88	" "	"	22	26
MABPSP	✓				✓				✓			11/17/88	" "	"	4	7
MATPGB	✓				✓				✓			10/26/88	" "	"	80	72
MATPGG	–				–				–			NOT USED.				
MATPSI	✓				✓				✓			10/26/88	" "	"	16	16
MATPSS	✓				✓				✓			10/25/88	" "	"	70	124

WORKLOAD DEFINITION MATRIX

PAGE 1
DATE 11/22/98

ALC LOCATION SAN ANTONIO

RCC	WORKLOAD PERCENTAGE %				WORKLOAD DEFINED BY				GFI TAPES/S USED				TIME REQUIRED TO DEFINE WL	REMARKS
	MISTR	PDM	T	M	HMAC STS	ALC STS	BOTH	OTHER	G004L	G402C	BOTH	OTHER		
MABPSC							✓					✓		
MABPSA					✓					✓				
MABPSB					✓					✓				
MABPSP					✓					✓				
MATPGB	100				✓					✓				
MATPGG	NOT USED													GTE ASSY INCLUDED IN MATPGB
MATPSI	100				✓					✓				
MATPSS	100				✓					✓				

PROFILE SHEET DATA COMPLETION MATRIX

PAGE ________ ________
DATE ________________

ALC LOCATION SAN ANTONIO

RCC	WORK CONTROL DOCUMENTS											PROFILE SHEET INTERVIEWS				
	AVAIL.		STORED													
			WHERE						HOW LONG (MO)							
	YES	NO	E	P	S	PC	PR	O	<6	6-12	>12	DATE	NAME	JOB FUNCTION	TIME TO INTERVIEW	[illegible] TIME TO COMPLETE FORM
MAB PSC																
MAB PSA	✓															
MAB PSB	✓															
MAB PSP	✓															
MAT PGB	✓															
MAT PGG	✓															
MAT PSI	✓															
MAT PSS	✓															

PROFILE SHEET DATA
COMPLETION MATRIX

PAGE ______
DATE ______

ALC LOCATION SAN ANTONIO

RCC	WORK CONTROL DOCUMENTS											PROFILE SHEET INTERVIEWS				
	AVAIL		STORED													
			WHERE						HOW LONG (MO)							
	YES	NO	E	P	S	PC	PR	O	<6	6 - 12	>12	DATE	NAME	JOB FUNCTION	TIME TO INTERVIEW	MMAC TIME TO COMPLETE FOR
MAB PSC																
MAB PSA	✓															
MAB PSB	✓															
MAB PSP	✓															
MAT PGB	✓															
MAT PGG	✓															
MAT PSI	✓															
MAT PSS	✓															

PROFILE SHEET DATA
COMPLETION MATRIX

PAGE ____
DATE ____

ALC LOCATION SAN ANTONIO

RCC	WORK CONTROL DOCUMENTS AVAIL.		STORED WHERE						STORED HOW LONG (MO)			PROFILE SHEET INTERVIEWS					
	YES	NO	E	P	S	PC	PR	O	<6	6-12	>12	DATE	NAME		JOB FUNCTION	TIME TO INTERVIEW	MMC TIME TO COMPLETE FORM
MAB PSC																	
MAB PSA	✓																
MAB PSB	✓																
MAB PSP	✓																
MAT PGB	✓																
MAT PGG	✓																
MAT PSI	✓																
MAT PSS	✓																

PROFILE SHEET DATA
COMPLETION MATRIX

PAGE ______ of ______
DATE ______________

LC LOCATION SAN ANTONIO

RCC	WORK CONTROL DOCUMENTS: AVAIL.		STORED: WHERE						STORED: HOW LONG (MO)			PROFILE SHEET INTERVIEWS				
	YES	NO	E	P	S	PC	PR	O	<6	6-12	>12	DATE	NAME	JOB FUNCTION	TIME TO INTERVIEW	MDAC TIME TO COMPLETE FORM
MAB PSC																
MAB PSA	✓															
MAB PSB	✓															
MAB PSP	✓															
MAT PGB	✓															
MAT PGG	✓															
MAT PSI	✓															
MAT PSS	✓															

WORKLOAD DEFINITION MATRI[illegible]

PAGE 1 O[illegible]
DATE 11/22/88

ALC LOCATION SAN ANTONIO

RCC	WORKLOAD PERCENTAGE %				WORKLOAD DEFINED BY				GFI TAPES/S USED				TIME REQUIRED TO DEFINE WL	REMARKS
	MISTR	PDM	T	M	MDAC SYS	ALC SYS	BOTH	OTHER	G004L	G019C	BOTH	OTHER		
MABPSC							✓					✓		
MABPSA					✓					✓				
MABPSB					✓					✓				
MABPSP					✓					✓				
MATPGB	100				✓					✓				
MATPG4	NOT	USED												GIE ASSY INCLUDED IN MATPGB
MATPS1	100				✓					✓				
MATPSS	100				✓					✓				

INSTRUCTIONS

1. WORKLOAD DEFINITION MATRIX

   A. WORKLOAD PERCENTAGE TO BE NUMERICAL UP TO 3 DIGITS
   B. ALL OTHER ENTRIES ARE CHECK MARKS
   C. TIME REQUIRED IN HOURS
   D. ENTER ANY REMARKS YOU FEEL WILL CLARIFY DATA

2. PROFILE SHEET DATA COMPLETION MATRIX

   A. WORK CONTROL DOCUMENT-HEADER
   USE CHECK MARKS IN APPLICABLE COLUMNS

   LEGEND
   E = ENGINEERING
   P = PLANNING
   S = SCHEDULING
   PC = PRODUCTION CONTROL
   PR = PRODUCTION
   O = OTHER (DEFINE IN REMARKS)

   B. PROFILE SHEET INTERVIEW-HEADER

   - JOB FUNCTION - USE CODES SHOWN ABOVE
   - TIME TO INTERVIEW IS 1 ON 1 TIME IN HOURS
   - MDAC TIME TO COMPLETE IS HOURS OVER THE 1 ON 1 INTERVIEW TIME

   C. ADD ANY REMARKS FOR THIS SHEET ON A SEPARATE SHEET.

ALL SITE LEADERS

PLEASE COMPLETE BY WED 11/23
AND FAX TO ME.

THANKS

[illegible signature]
11-18-88.

~NO
ormal

18 November 1988

To: All Site Leaders T.O. #1

Attached: Data Collection History Matrix Sheets With Instructions

1. Please complete the attached Matrix Sheets for your ALC per the instructions. Should there be any questions, please call.

These completed Data Sheets will be used to respond to an action item arising from the HQ Program Review on Tuesday, 11-15-88. This action related to our discussion of data consistency, degree of availability, ease of attainment, etc. Our response is due on 12/1/88; therefore, I need these returned by Wednesday, 11/23/88.

Do not attempt to be 100% accurate in your man hour estimates and workload %. Do the best you can from memory, notes and your team members' inputs.

Our goal with the Matrix is to respond to HQ in a consistent format.

PLEASE DO NOT REVIEW THE DATA WITH ALC PERSONNEL.

Additional information that would be helpful.

> Are you aware of any ALC functional area that is maintaining their own data bases manually or on PC's outside the recognized system? If so, where?

2. Be sure to record in your notebook those areas where you perceive "Quick Fixes" and "Future Focus Study Recommendations" so that our reports can be quickly assembled upon return to St. Louis.

Thanks! Keep up the good work. Our progress looks good. A Happy Thanksgiving to both You and Your Families!

Jerry
Jerry

TO: E. R. Mory	FROM: Jerry Nuell
COMPANY: c/o La Quinta	LOCATION: MDAC Bldg 92-2E Ext: 314-925-
LOCATION: Lockland, TX	FAX NO.: 314-925-3691
PHONE NO:	CONFIRMATION NO. CALL ADDRESSEE
FAX NO.: 512-673-5918	NUMBER OF PAGES: LEAD + 4
CONFIRMATION:	DATE: 11/18/88 TIME OUT:

MCDONNELL DOUGLAS
CORPORATION

SA	11/16	MECH J. SANCHEZ / FOREMAN J. ESQUIVEL	3 ~~2.5~~ HR	4 HRS
	11/16	LD MAN	6	6
	11/16	MECHANIC	3	6
	11/16	"	2	2
	11/18	"	3	8
			17	26
SB	11/14	CHRIS DOUALINA / A. VERDUZCO	8 HRS	12 HRS
	11/16	GREGG BARRIOS / E. CORTEZ	2	4
	11/15	MECHANIC	3	5
	11/15	"	4	6
	11/17	"	1	3
	11/17	"	4	8
			22	26
SP	11/17	MECHANIC	1	1
	11/7	"	1	2
	11/17	SUPERVISOR	2	4
	10/28	MECHANIC	4	8
	11/2	SUPERVISOR	2	4
SS	10/26	DAVID HIGHSMITH / Y. RIOS	12	20
	11/7	PETE CANTU / MARGARET JAMES	2	4
	10/27	RUDY GUEVARA / JOE VILLARREAL	16	8
	10/25	HARPO	8	20
	11/2	PLANNER	4	8
	11/8	PLANNER	4	8
	11/9	PLANNER	6	12
	10/29	PLANNER	12	32
			70	124
SI	10/26	JULIO AYALA / DAN HAYWARD EMILIO CERVANTES / HENRY HALL MARGARET LITTLE	16	18

GB	11/1	BRENT CASTLE / ELCIO AYALA HENRY HALL MARGARET LITTLE	24	16
	11/1	"	24	16
	10/26	PLANNER / MECHANICS	16	24
	10/26	MECHANICS	16	16
			80	72

4.0 DATA COLLECTION

SEVERAL DIFFERENT PROFILE DATA SHEETS WERE MADE AVAILABLE TO THE WORKING GROUP AT THE SITE FOR COLLECTION OF DATA.

THE DATA COLLECTED FROM MATPSS WAS FROM SHOP INTERVIEWS WITH THE SHOP FOREMEN PLANNERS, WORKLEADERS, MECHANICS, TESTERS AND FROM APPROPRIATE ALC PERSONNEL.

DATA HAS BEEN REGISTERED IN RESPECTIVE PROFILE SHEETS FOR THE MATPSS RCC PCN'S.

EXAMPLES OF THESE PROFILE SHEETS AND THEIR RESPECTIVE INSTRUCTIONS ON HOW TO PROPERLY FILL OUT THESE PROFILE SHEETS ARE ATTACHED.

AFLC TECHNOLOGY INSERTION PROGRAM

PROFILE AND INSTRUCTION MASTERS

APRIL 1, 1989

PLEASE FORWARD ANY QUESTIONS, COMMENTS OR REVISION REQUESTS TO C. GONZALES AT (314) 925-5395.

AFLC TECHNOLOGY INSERTION PROGRAM
"IN" AND "OUT" DATES INSTRUCTIONS

IN ORDER TO CAPTURE THE FLOW TIME ENCOUNTERED AT THE BEGINNING OF A PROCESS, (THE TME BETWEEN WHEN AN RCC TAKES POSSESSION OF AN ITEM AND THE END OF THE FIRST OPERATION), AN OPERATION MUST BE ADDED TO THE OPERATION PROFILE. THIS WILL BE THE FIRST OPERATION, DESIGNATED AS OPERATION NUMBER "IN".

IN ORDER TO CAPTURE THE FLOW TIME ENCOUNTERED AT THE END OF A PROCESS, (THE TIME BETWEEN THE END OF THE LAST OPERATION AND THE TIME THE POSSESSION OF THE ITEM IS TRANSFERRED FROM THE RCC), AND OPERATION MUST BE ADDED TO THE OPERATION PROFILE. THIS WILL BE THE LAST OPERATION, DESIGNATED AS OPERATION "9999".

THIS DATA WILL BE ADDED (OPERATIONS "IN" AND "9999") TO EACH OPERATION PROFILE FOR EACH ITEM NUMBER. THE MANDATORY OCCURRENCE FACTOR FOR THESE OPERATIONS WILL ALWAYS BE 1.00. THE MANDATORY FLOW TIME WILL BE DETERMINED BY INTERVIEW. IF THE ALC ENGINEER ASSIGNED TO THE TI TEAM DETERMINES THAT MORE ACCURATE DATA IS AVAILABLE, THIS DATA CAN BE SUBSTITUTED.

THESE OPERATIONS WILL BE TRANSFERRED FROM THE OPERATION PROFILES TO THE LOTUS INPUT USING THE "IN" AND "9999" OPERATION NUMBERS.

THE OPERATION PROFILES PREVIOUSLY GATHERED MUST BE MODIFIED TO INCLUDE OPERATION NUMBERS "IN" AND "9999" AND THE DATA GATHERED. THIS WILL BE ACCOMPLISHED BY WRITING IN THE DATA WHILE GATHERING OTHER SUPPLIMENTARY DATA.

THIS INFORMATION MUST ALSO BE INCLUDED IN THE WCD HISTORY COLLECTION SYSTEM. WHEN BUILDING A MASTER FILE, ADD "IN" AS THE FIRST OPERATION AND "9999" AS THE LAST OPERATION FOR EACH MASTER. THE DATES TO BE ENTERED ON THE WCD DETAIL FILES CAN BE FOUND ON THE STAMPED WCD OR ON ACCOMPANYING DOCUMENTATION.

FOR WCD HISTORY ALREADY COLLECTED, THE "IN" AND "9999" DATA CAN BE COLLECTED ON "IN" DATE PROFILE AND THE "OUT" DATE PROFILE. THIS WILL BE ACCOMPLISHED BY SAMPLING ARCHIVED WCDS FOR ITEMS WHICH ALREADY HAVE HISTORY RESIDENT ON THE WCD HISTORY COLLECTION SYSTEM.

AFLC TECHNOLOGY INSERTION PROGRAM
"IN" AND "OUT" DATES INSTRUCTIONS (CONTINUED)

SITE LEADERS, PLEASE ATTACH A COPY OF THESE INSTRUCTIONS TO THE DOCUMENTATION FOR THE WCD HISTORY DATA SYSTEM, THE MASTER PROFILE PROGRAM GUIDE, AND THE OPERATION PROFILE INSTRUCTIONS.

ANY QUESTIONS ON THESE PROCEDURE WILL BE ANSWERED BY C. GONZALES. CONTACT THROUGH ST. LOUIS OFFICE (314) 925-5395.

"IN" DATE PROFILE

NAME ________ ALC ________ DATE ________ RCC ________ SHEET ____ OF ____

PCN
NSN
P/N ________
PARENT WCD ________
PARENT WCD DATE ________

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD OR DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

LSC-20107A

"OUT" DATE PROFILE

NAME ______ ALC ______ DATE ______ RCC ______ SHEET ___ OF ___

PCN
NSN
P/N ______ PARENT WCD ______ PARENT WCD DATE ______

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

LSC-20108A

AFLC TECHNOLOGY INSERTION PROGRAM
OPERATION PROFILE INSTRUCTIONS

DATA ITEM	DESCRIPTION	SOURCE
NAME	NAME OF PERSON COLLECTING DATA	—
ALC	NAME OF ALC WHERE THIS DATA IS COLLECTED	SM = McCLELLAN AIR BASE OC = TINKER AIR BASE SA = KELLY AIR BASE WR = WARNER ROBINS AIR BASE OO = HILL AIR BASE
DATE	START DATE OF DATA COLLECTION	—
RCC	NAME OF RCC WHERE THIS DATA IS COLLECTED (6 CHARACTERS)	—
ITEM CODE	LIST ONLY ONE ITEM CODE FROM THE FOLLOWING: PCN = PRODUCTION CONTROL NO. NSN = NATIONAL STOCK NO. P/N = PART NO. SHOULD BE SAME ITEM CODE AS ON 80/20 LISTING (18 CHARACTERS) CIRCLE ITEM CODE USED.	• 80/20 LISTING • ITEM 14, 15 OR 18 OF WCD • G037E (PDM) • FORM 206 (T&M)
WCD	NAME/NUMBER OF WORK CONTROL DOCUMENT (THE PRESENT WCD IN USE BY PRODUCTION) (8 CHARACTERS)	• TOP LEFT CORNER OF THE 1ST PAGE OF THE WCD. • G037E WCD (PDM) • FORM 206 (T&M)
WCD DATE	WORK CONTROL DOCUMENT REVISION DATE (6 CHARACTERS)	• ITEM NO. 1 OF WCD. • G037E • FORM 206 PLAN DATE
OPERATION NO.	A THREE DIGIT NUMBER THAT SEQUENCE THE STEPS OF WORK BEING PERFORMED AS LISTED IN WCD (4 CHARACTERS). FROM 1 TO 4 NUMERIC DIGITS OR 1 TO 3 NUMERIC DIGITS WITH ONE ALPHA CHARACTER, RIGHT JUSTIFIED. DO NOT ENTER LEADING ZEROS. (ex. ENTER 10, NOT 010).	LISTED IN COLUMNS UNDER ITEM 19 OF WCD.

AFLC TECHNOLOGY INSERTION PROGRAM
OPERATION PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
RCC	ENTER RCC NAME FOR THAT OPERATION. IF THIS RCC NAME IS NOT THE PRIMARY RCC, THE OPERATION WILL BE A BACK SHOP OPERATION. IF BACK SHOP, ENTER ONLY MANDATORY OCCURRENCE FACTOR AND MANDATORY FLOW HOURS. (6 CHARACTERS)	RCC WILL BE LISTED UNDER THE OPERATION NO. IN COLUMN 19 OF WCD.
OPERATION DESCRIPTION	ENTER AN ABBREVIATED DESCRIPTION OF WORK BEING PERFORMED. LIMIT FOUR CHARACTERS. USE THE FOLLOWING ABBREVIATIONS AND CREATE ADDITIONAL ABBREVIATIONS AS REQUIRED.	ITEM 20 OF WCD

ABBREVIATION	DESCRIPTION
ASSY	ASSEMBLY
DIS	DISASSEMBLY
NDI	NON-DESTRUCTIVE INSPECTION
MOVE	TRAVEL BETWEEN OPERATIONS
PROC	PROCESS OPERATION
REP	REPAIR
REPL	REPLACE
MFG	MANUFACTURE
LOAD	LOAD
UNLD	UNLOAD
TEST	TEST
INSP	INSPECTION
REC	RECEIVE OF ITEM
SHIP	SHIPMENT OF ITEM
INFO	INFORMATION
MACH	MACHINING
CLN	CLEAN
IND	INDUCTION
SELL	SELL DATE

AFLC TECHNOLOGY INSERTION PROGRAM
OPERATION PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
MANDATORY OCCURRENCE FACTOR	ENTER MANDATORY OCCURANCE FACTOR FOR ALL THE OPERATIONS. (4 CHARACTERS, UP TO 3 DECIMAL PLACES)	INTERVIEWEE
OPERATION TYPE TRANSIT (T) SETUP (S) PROCESS (P)	TRANSIT - THE MOVEMENT BETWEEN OPERATIONS. SETUP - MAKING READY OR PREPARING FOR THE PERFORMANCE OF A JOB OR OPERATION. MACHINE SETUP INVOLVES EQUIPING A MACHINE WITH APPROPRIATE ACCESSORIES, TOOLS AND FIXTURES, SETING THE PROPER FEED, SPEED AND DEPTH OF CUT AND SO FORTH. IN MANUAL WORK, SETUP IS THE ARRANGEMENT PRIOR TO COMMENCING THE WORK, OF THE TOOLS, ACCESSORIES, COMPONENT PARTS AND DETAILS INVOLVED. IT ALSO INCLUDES THE TEARDOWN TO RETURN THE MACHINE OR WORK AREA TO ITS ORIGINAL OR NORMAL CONDITION. PROCESS - ACTUAL WORK PERFORMED ON THE ITEM. A PLANNED SERIES OF ACTIONS WHICH ADVANCES A MATERIAL OR PROCEDURE FROM ONE STAGE OF COMPLETION TO ANOTHER.	INTERVIEWEE
MANDATORY FLOW HOURS	MANDATORY FLOW HOURS REQUIRED TO COMPLETE AN OPERATION (INCLUDE TRANSIT TIME) (i.e., WAITING 24 HOURS MINIMUM FOR SEALANT TO CURE. (5 CHARACTERS WITH ONE DECIMAL PLACE) ALL BACK SHOP OPERATIONS MUST HAVE FLOW HOURS. IF THE TIMES ARE CONSTANT, ENTER WITHOUT A PERCENT. IF THE TIMES ARE VARIABLE DUE TO A CHANGING LEVEL OF EFFORT, ENTER VARIABLE TIMES WITH A PERCENT. SEE EXAMPLE FOR TIME REQUIRED.	INTERVIEWEE
SKILL CODE/LEVEL	INDICATE THE SKILL CODE/LEVEL REQUIRED TO PERFORM THE OPERATION (8 CHARACTERS) (i.e., SHEET METAL MECHANIC - SA WG 10 ENTER SA10)	INTERVIEWEE/ SUPERVISOR

AFLC TECHNOLOGY INSERTION PROGRAM
OPERATION PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
QTY	QUANTITY OF MANPOWER AT THE SKILL CODE/LEVEL REQUIRED TO PERFORM THE OPERATION (3 CHARACTERS)	INTERVIEWEE
TIME REQUIRED	THE TIME MANPOWER IS REQUIRED TO PERFORM THE OPERATION. IF THE TIMES ARE CONSTANT, ENTER TIME WITHOUT A PERCENT. IF THE TIMES ARE VARIABLE DUE TO A CHANGING LEVEL OF EFFORT, ENTER VARIABLE TIMES WITH A PERCENT. IF AN OPERATION IS PERFORMED : 20% OF THE TIME IN 1 HOUR 80% OF THE TIME IN 2 HOURS ENTER: TIME % / REQUIRED HRS 20 / 1.0 80 / 2.3 (5 CHARACTERS MAX. WITH ONE DECIMAL PLACE). TRIANGULAR DISTRIBUTIONS MAY ALSO BE USED, SUCH AS: MIN. 4.0 MAX. 10.0 MEAN 6.0	INTERVIEWEE
EQUIPMENT CODE	ENTER ALPHANUMERIC CODE OF EQUIPMENT NEEDED TO PERFORM THE OPERATION. USE ALC CODES AND SHORTEN TO 8 CHARACTERS. THIS CODE WILL ALSO BE USED ON THE EQUIPMENT PROFILE SHEET. (8 CHARACTERS)	INTERVIEWEE LOCATION OF EQUIP. EQUIPMENT LIST
QTY	INDICATE THE QUANTITY OF EQUIPMENT NEEDED TO PERFORM OPERATION (3 CHARACTERS)	INTERVIEWEE
TIME REQUIRED	SEE TIME REQUIRED FOR MANPOWER	INTERVIEWEE
DATA SOURCE	PLEASE INDICATE THE SOURCE OF INFORMATION (i.e., PERSONNEL DATABASE, PAPER REPORT) ALSO LIST ANY PECULIARITIES ASSOCIATED WITH AN OPERATION NUMBER.	INTERVIEWEE

OPERATIC.. ?ROFILE

NAME ______ ALC ______ DATE ______ RCC ______ SHEET ____ OF ____

PCN
NSN
P/N ______

WCD ______ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
							SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

AFLC TECHNOLOGY INSERTION PROGRAM
PARALLEL PROCESS PROFILE INSTRUCTIONS

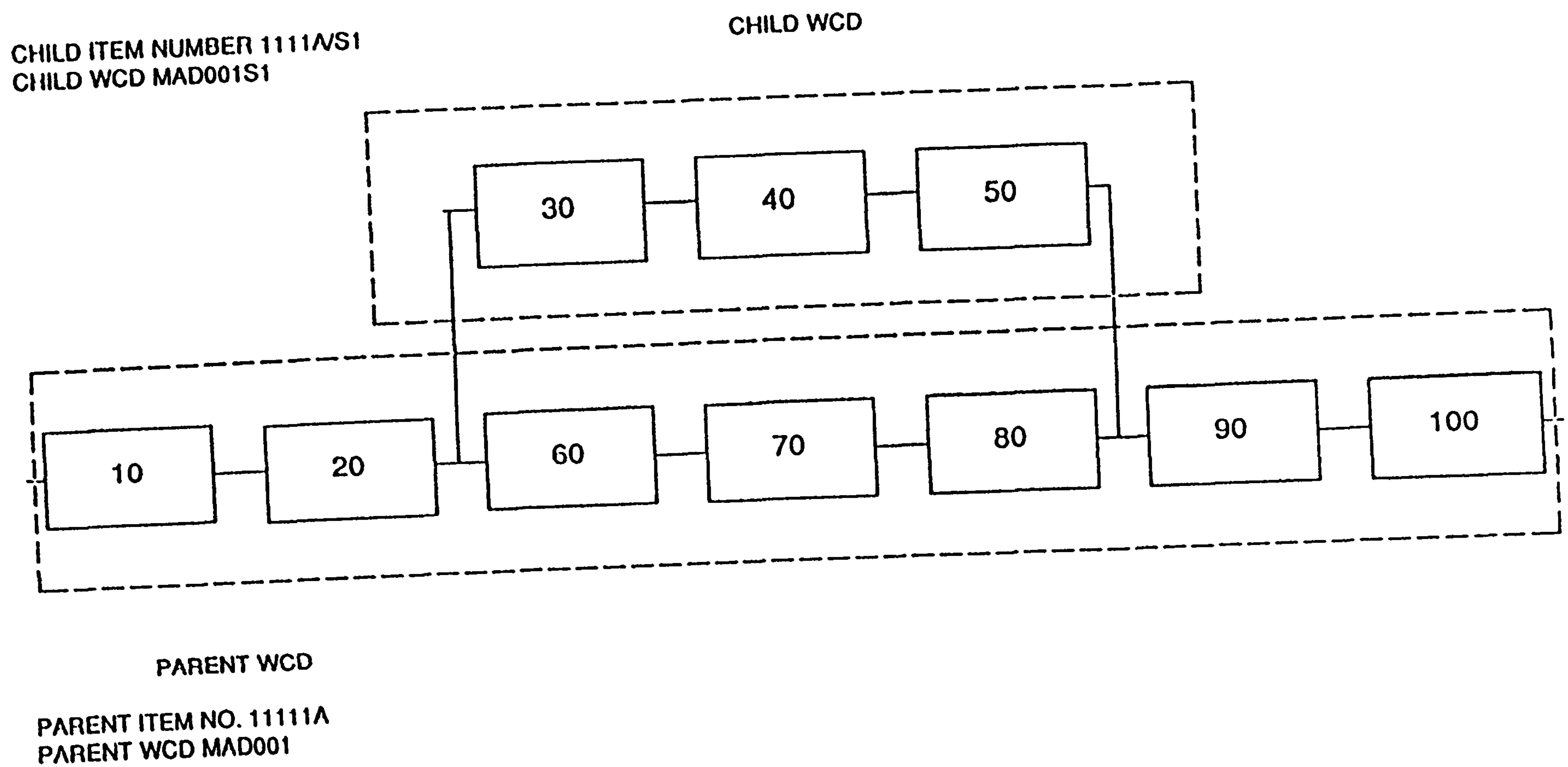
DATA ITEM	DESCRIPTION	SOURCE
NAME	NAME OF PERSON COLLECTING DATA	—
ALC	NAME OF ALC WHERE THIS DATA IS COLLECTED	SM = McCLELLAN AIR BASE OC = TINKER AIR BASE SA = KELLY AIR BASE WR = WARNER ROBINS AIR BASE OO = HILL AIR BASE
DATE	START DATE OF DATA COLLECTION	—
RCC	NAME OF RCC WHERE THIS DATA IS COLLECTED (6 CHARACTERS)	—
ITEM CODE	LIST ONLY ONE ITEM CODE FROM THE FOLLOWING: PCN = PRODUCTION CONTROL NO. NSN = NATIONAL STOCK NO. P/N = PART NO. SHOULD BE SAME ITEM CODE AS ON 80/20 LISTING (18 CHARACTERS) CIRCLE ITEM CODE USED.	• 80/20 LISTING • ITEM 14, 15 OR 16 OF WCD • G037E (PDM) • FORM 206 (T&M)
PARENT WCD	NAME/NUMBER OF WORK CONTROL DOCUMENT (THE PRESENT WCD IN USE BY PRODUCTION) (8 CHARACTERS)	• TOP LEFT CORNER OF THE 1ST PAGE OF THE WCD. • G037E WCD (PDM) • FORM 206 (T&M)
PARENT WCD DATE	WORK CONTROL DOCUMENT REVISION DATE (6 CHARACTERS)	• ITEM NO. 1 OF WCD. • G037E • FORM 206 PLAN DATE
BEGINNING OPERATION NO.	A THREE DIGIT OPERATION NUMBER IN THE PARENT WCD, WHICH REPRESENTS THE START OF A PARALLEL PROCESS. THE PARALLEL PROCESS WILL BEGIN AT THE END TIME OF THE "BEGINNING OPERATION".	LISTED IN COLUMNS UNDER ITEM 19 OF WCD.

AFLC TECHNOLOGY INSERTION PROGRAM
PARALLEL PROCESS PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
ENDING OPERATION NO.	THE THREE DIGIT OPERATION NUMBER IN THE PARENT WCD, WHICH REPRESENTS THE END OF THE PARALLEL PROCESSING.	LISTED IN COLUMNS UNDER ITEM 19 OF WCD.
CHILD PROCESS INFORMATION		
• ITEM NUMBER	SAME AS ITEM CODE DESCRIPTION WHEN CHILD HARDWARE HAS A SEPARATE WCD. THIS ITEM NUMBER AND WCD MUST BE ENTERED ON THE WORKLOAD PROFILE.	---
	WHEN NO SEPARATE WCD IS PROVIDED - DEVELOP AN ITEM NO. BY USING THE PARENT'S ITEM CODE NO. FOLLOWED BY A SLASH AND S1 (FIRST SUB-COMPONENT) i.e., 1111A/S1	---
• CHILD WCD	USE THE GIVEN WCD NAME/NUMBER WHEN A WCD IS PROVIDED FOR A GIVEN CHILD.	---
	WHEN NO SEPARATE WCD IS PROVIDED - DEVELOP A WCD NAME/NUMBER BY USING A RE-ABBREVIATED SUFFIX OF THE ITEM NUMBER. i.e., ITEM NO. = 1111A/S1 (CHILD WCD = SUB 1) (8 CHARACTER)	---
• CHILD WCD DATE	USE THE GIVEN WCD DATE WHEN A WORK CONTROL DOCUMENT IS PROVIDED.	---
	WHEN NO SEPARATE WCD IS PROVIDED - USE WCD DATE OF PARENT.	---

AFLC TECHNOLOGY INSERTION PROGRAM
PARALLEL PROCESS PROFILE INSTRUCTIONS (CONTINUED)

IN THIS EXAMPLE, OPERATIONS 30, 40 AND 50 ARE BEING PROCESSED IN PARALLEL WITH OPERATIONS 60, 70 AND 80.
THE BEGINNING OPERATION NUMBER IS 20.
THE ENDING OPERATION NUMBER IS 90.



PARALLEL PRC_ _SS PROFILE

NAME__________ ALC__________ DATE__________ RCC__________ SHEET____ OF____

ITEM NUMBER	PARENT WCD	PARENT WCD DATE	BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
					ITEM NUMBER	CHILD WCD	CHILD WCD DATE
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		

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AFLC TECHNOLOGY INSERTION PROGRAM
DISASSEMBLY/ASSEMBLY PROFILE INSTRUCTIONS

DATA ITEM	DESCRIPTION	SOURCE
NAME	NAME OF PERSON COLLECTING DATA	—
ALC	NAME OF ALC WHERE THIS DATA IS COLLECTED	SM = McCLELLAN AIR BASE OC = TINKER AIR BASE SA = KELLY AIR BASE WR = WARNER ROBINS AIR BASE OO = HILL AIR BASE
DATE	START DATE OF DATA COLLECTION	—
RCC	NAME OF RCC WHERE THIS DATA IS COLLECTED (6 CHARACTERS)	—
ITEM CODE	LIST ONLY ONE ITEM CODE FROM THE FOLLOWING: PCN = PRODUCTION CONTROL NO. NSN = NATIONAL STOCK NO. P/N = PART NO. SAME AS ON OPERATION PROFILE SHEET AND 80/20 LISTING.	
WCD	NAME/NUMBER OF WCD (SAME AS ON OPERATION PROFILE SHEET)	
WCD DATE	REVISION DATA OF WCD (SAME AS ON OPERATION PROFILE SHEET).	
REMOVAL OPERATION NUMBER	THE OPERATION NUMBER OF THE WCD IN WHICH A PART IS DISASSEMBLED OR REMOVED. REMOVAL OCCURS AT THE END OF AN OPERATION.	WCD - INTERVIEW
INSTALLATION OPERATION NUMBER	THE OPERATION NUMBER OF THE WCD IN WHICH A PART IS ASSEMBLED OR INSTALLED. INSTALLATION OCCURS AT THE BEGINNING OF AN OPERATION. NOTE: IF INSTALLATION OPERATION IS NOT IN THE SAME WCD AS THE REMOVAL OPERATION, THE REMOVAL OPERATION WOULD BE LISTED ON ONE LINE WITH ITS WCD, AND THE INSTALLATION OPERATION WOULD BE LISTED ON A SEPARATE LINE WITH ITS WCD.	WCD - INTERVIEW

AFLC TECHNOLOGY INSERTION PROGRAM
DISASSEMBLY/ASSEMBLY PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
REMOVED/ DISASSEMBLED PART	PART THAT WAS REMOVED/DISASSEMBLED IN THE REMOVAL OPERATION NUMBER.	WCD
ITEM NUMBER	LIST ONLY ONE ITEM CODE FROM THE FOLLOWING: PCN = PRODUCTION CONTROL NUMBER NSN = NATIONAL STOCK NUMBER P/N = PART NUMBER CIRCLE ITEM CODE USED.	---
WCD	NAME/NUMBER OF WCD THAT IS USED TO PROCESS THE REMOVED ITEM NUMBER.	WCD
WCD DATE	REVISION DATE OF WCD.	WCD
SAME REMOVED ITEM INSTALLED INTO ASSY	IF THE REMOVAL ITEM MUST BE REPAIRED AND REINSTALLED INTO THE SAME END ITEM, ENTER YES. WHEN A SPARE PART CAN BE USED TO REPAIR THE END ITEM, ENTER NO.	INTERVIEWEE

NOTE: ALL ITEM NUMBERS AND THEIR WCD MUST BE LISTED ON THE WORKLOAD PROFILE.

DISASSEMBLY/ASSEMBLY ...OFILE

NAME________ ALC ________ DATE________ RCC ________ SHEET____ OF____

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-2005A

AFLC TECHN LOGY INSERTION PROGRAM
MANPOWER PROFILE INSTRUCTIONS

DATA ITEM	DESCRIPTION	SOURCE
NAME	NAME OF PERSON COLLECTING DATA	—
ALC	NAME OF ALC WHERE THIS DATA IS COLLECTED	—
DATE	START DATE OF DATA COLLECTION	—
RCC	NAME OF RCC WHERE THIS DATA IS COLLECTED (6 CHARACTERS)	—
SKILL CODE/ LEVEL	IDENTIFY SKILL CODES AND THE LEVELS WITHIN RCC. ALL SKILL CODES AND LEVELS LISTED ON OPERATION PROFILE SHEETS MUST BE ENTERED. (EIGHT CHARACTERS) (e.g., SA – SKILL CODE, 08 – LEVEL - ENTER SA08)	SUPERVISOR
JOB DESCRIPTION	BRIEF DESCRIPTION OF JOB TO BE PERFORMED. e.g., AIRCRAFT SHEET METAL MECHANIC (9 CHARACTERS)	
QUARTER	FY88 - AFLC's CALENDER WHICH STARTS OCTOBER (FOUR QUARTERS)	—
QUANTITY AVAILABLE	THE MANPOWER QUANTITY FOR EACH SKILL CODE AND LEVEL. ENTER THE QUANTITY AVAILABLE FOR WORK WEEK, WEEKENDS, AND HOLIDAYS PER SHIFT. (3 CHARACTERS)	RCC SECTION CHIEF
MANPOWER AVAILABLE (HOURS)	THE WORK STANDARD/MANPOWER FACTOR (WHICH ALCs USE FOR WORKLOAD NEGOTIATION) FOR EACH SKILL CODE AND LEVEL PER SHIFT. NUMBER OF HOURS AVAILABLE PER PERSON PER DAY, EXCLUDING TRAINING, TDY, ETC. (4 CHARACTERS WITH ONE DECIMAL PLACE)	RCC SECTION CHIEF

AFLC TECHNOLOGY INSERTION PROGRAM
MANPOWER PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
ALTERNATE SKILL CODE/LEVEL	MANPOWER SKILL CODE/LEVEL THAT CAN BE USED IN PLACE OF THE SPECIFIED MANPOWER SKILL CODE/LEVEL. USE THE SAME CODE AS IN OPERATION PROFILE. IN A SITUATION WHERE A SKILL/LEVEL CAN SUBSTITUTE FOR ANOTHER SKILL/ LEVEL FOR SAME OPERATIONS BUT NOT FOR OTHERS, THE TECHNIQUE AS SHOWN IN THE FOLLOWING EXAMPLE CAN BE USED.	RCC SECTION CHIEF

EXAMPLE: SA08 IS USED IN 4 OPERATIONS (10, 20, 30, 40) AND CAN BE SUBTITUTED BY SA10 IN OPERATIONS (10, 20 AND 40). THIS CAN BE CODED BY USING SA08 AS THE SKILL CODE FOR OPERATIONS 10, 20 AND 40 AND USING A PSENDO NAME SA08A FOR OPERATION 30. THEN IN YOUR MANPOWER TABLE, THE FOLLOWING WOULD BE ENTERED.

SKILL CODE/LEVEL	ALTERNATE SKILL CODE/LEVEL
SA08	SA10
SA08A (LEAVE QTY BLANK OR 0)	SA08

SINCE SA08A IS ENTERED WITH A QTY OF O, IT WILL IMMEDIATELY USE THE ALTERNATE WHICH IS SA08.

MANPOWER PROFILE

NAME __________ ALC __________ DATE __________ RCC __________ SHEET ____ OF ____

SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE									MANPOWER AVAILABLE (HOURS)									ALTERNATE SKILL CODE/LEVEL
			WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK			WEEKEND			HOLIDAYS			
			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	
		1																			
		2																			
		3																			
		4																			
		1																			
		2																			
		3																			
		4																			
		1																			
		2																			
		3																			
		4																			
		1																			
		2																			
		3																			
		4																			
		1																			
		2																			
		3																			
		4																			

AFLC TECHNOLOGY INSERTION PROGRAM
EQUIPMENT PROFILE INSTRUCTIONS

DATA ITEM	DESCRIPTION	SOURCE
NAME	NAME OF PERSON COLLECTING DATA	—
ALC	NAME OF ALC WHERE THIS DATA IS COLLECTED	SM = McCLELLAN AIR BASE OC = TINKER AIR BASE SA = KELLY AIR BASE WR = WARNER ROBINS AIR BASE OO = HILL AIR BASE
DATE	START DATE OF DATA COLLECTION	—
RCC	NAME OF RCC WHERE THIS DATA IS COLLECTED (6 CHARACTERS)	—
EQUIPMENT CODE	ENTER ALPHANUMERIC CODE OF EQUIPMENT. USE ALC CODES AND SHORTEN TO 8 CHARACTERS. KEEP SAME CODE AS USED ON OPERATION PROFILE SHEET.	INTERVIEWEE LOCATION OF EQUIP. EQUIPMENT LIST LAYOUT DRAWINGS
EQUIPMENT TYPE/ DESCRIPTION	ENTER A NOUN TO DESCRIBE EQUIPMENT (9 CHARACTERS)	—
QTY PER SHIFT	ENTER QUANTITY OF EQUIPMENT AVAILABLE PER SHIFT (3 CHARACTERS)	—
PREVENTIVE MAINTENANCE	DOWNTIME THAT IS SCHEDULED FOR PREVENTIVE MAINTENANCE ON THE EQUIPMENT LIST	G017C INTERVIEWS EQUIPMENT SPECS. G004i - INSPECTION AND CALIBRATION REPORT

AFLC TECHNOLOGY INSERTION PROGRAM
EQUIPMENT PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
FREQ	INDICATE THE FREQUENCY THAT PREVENTIVE MAINTENANCE IS PERFORMED IN DAYS. (3 CHARACTERS)	—
SHIFT	INDICATE ON WHICH SHIFT PREVENTIVE MAINTENANCE IS PERFORMED. (1, 2, 3)	—
DOWNTIME	THE TIME REQUIRED TO PERFORM PREVENTIVE MAINTENANCE (i.e., ALIGNMENT, TESTING, CALIBRATION, MINOR REPAIR, ETC. - IN HOURS) (5 CHARACTERS WITH 1 DECIMAL PLACE)	G017C INTERVIEWS EQUIPMENT SPECS. G004i - INSPECTION AND CALIBRATION REPORT
UNSCHEDULED BREAKDOWN REPAIR TIME	EQUIPMENT DOWNTIME THAT IS NOT SCHEDULED. BREAKDOWN/ EQUIPMENT FAILURES	G017C TROUBLE CALL REPORTS, EQUIPMENT OPERATORS, EQUIPMENT SPECS.
MTBF	MEAN TIME BETWEEN FAILURES. AVERAGE TIME INTERVAL BETWEEN FAILURES IN DAYS (3 CHARACTERS)	G017C TROUBLE CALL REPORTS, EQUIPMENT OPERATORS, EQUIPMENT SPECS.
MTTR	MEAN TIME TO REPAIR AVERAGE TIME TO REPAIR FAILED EQUIPMENT - HOURS WITH ONE DECIMAL PLACE (5 CHARACTERS)	G017C TROUBLE CALL REPORTS, EQUIPMENT OPERATORS, EQUIPMENT SPECS.
PERCENT USED FOR OTHER RCC	INDICATE THE PERCENT THAT THE EQUIPMENT IS BEING USED BY OTHER RCCs.	INTERVIEWEE
ENVELOP UNITS MIN/MAX	MINIMUM QUANTITY OF ENVELOP UNITS EQUIPMENT CAN PROCESS. MAXIMUM QUANTITY OF ENVELOP UNITS EQUIPMENT CAN PROCESS. (4 CHARACTERS)	—

AFLC TECHNOLOGY INSERTION PROGRAM
EQUIPMENT PROFILE INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION	SOURCE
ALTERNATE EQUIPMENT	EQUIPMENT THAT CAN BE USED IN PLACE OF THE EQUIPMENT LISTED IN THE EQUIPMENT CODE COLUMN. ENTER ALPHANUMERIC CODE OF EQUIPMENT. USE ALC CODES AND SHORTEN TO 8 CHARACTERS. KEEP SAME CODE AS USED ON OPERATION PROFILE SHEET.	INTERVIEWEE
DATA SOURCE	PLEASE INDICATE THE SOURCE OF THE INFORMATION (i.e., PERSONNEL, DATABASE, PAPER REPORT). ALSO LIST ANY OTHER PECULIARITIES THAT MAY BE HELPFUL.	

EQUIPME.. .ROFILE

NAME________ ALC________ DATE________ RCC________ SHEET____ OF____

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3d	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		

LSC-2009-4B

AFLC TECHNOLOGY INSERTION PROGRAM
WORKLOAD PROFILE INSTRUCTIONS

DATA ITEM	DESCRIPTION	SOURCE
NAME	NAME OF PERSON COLLECTING DATA	—
ALC	NAME OF ALC WHERE THIS DATA IS COLLECTED	—
DATE	START DATE OF DATA COLLECTION	—
RCC	NAME OF RCC WHERE THIS DATA IS COLLECTED (6 CHARACTERS)	—
ITEM CODE	USE SAME ITEM CODE AS IN OPERATION PROFILE P/N, PCN OR NSN.	OPERATION PROFILE
AIRCRAFT MODEL	LIST THE AIRCRAFT MODEL ON WHICH THIS ITEM IS USED.	
WCD	LIST WCD NAME/NUMBER. IF WCD HAS DIS/ASS OR PARALLEL OP. WCD ASSOCIATED WITH IT, LIST THEM BELOW THE PARENT WCD IN THE ORDER WHICH THEY ARE PROCESSED.	OPERATION PROFILE
WORKLOAD TYPE	ENTER ONE OF THE FOLLOWING WORKLOAD NUMBERS: MISTR = 4, PDM = 0, T = 8, M = 7, MICAP = 2	SUPERVISOR
FLOATING STOCK	NUMBER OF ITEMS THAT ARE AVAILABLE FOR USE.	SUPERVISOR
ACTUAL PRODUCTION PER QUARTER	ACTUAL OUTPUTS OF END ITEMS FOR RCC PER QUARTER OF FY88. (4 CHARACTERS)	G019C, G004L G037E
NUMBER OF ENVELOP UNITS	ENTER ENVELOP UNIT SIZE (2 CHARACTERS)	
MAXIMUM W.I.P.	MAXIMUM QUANTITY OF END ITEMS PER ITEM CODE THAT CAN BE IN PROCESS FOR REPAIR AT ANY ONE TIME, GIVEN THE "AS-IS" WORKLOAD MIX.	SUPERVISOR
STANDARD HOURS	THE HOURS ALLOCATED BY RCC TO PERFORM THE OPERATIONS IN THE REPAIR CYCLE.	E046B, G037E, G004L

WORKLOA... ROFILE

NAME ______ ALC ______ DATE ______ RCC ______ SHEET ___ OF ___

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
					1	2	3	4			
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											

LSC-20096B

AFLC TECHNOLOGY INSERTION PROGRAM
ENVELOP INSTRUCTIONS

ENVELOP UNITS ARE CONSIDERED AS THE EVALUATION OF BATCH PROCESS EQUIPMENT TO DETERMINE THE MIN/MAX NUMBER OF PARTS THAT CAN BE PROCESSED AT ONE TIME.

DATA ITEM	DESCRIPTION
ALC	NAME OF ALC
RCC	NAME OF RCC (6 CHARACTERS)
WCD	NAME/NUMBER OF WORK CONTROL DOCUMENT (SAME AS ON OPERATION PROFILE) (8 CHARACTERS)
WCD DATE	WORK CONTROL DOCUMENT REVISION DATE. (6 CHARACTERS) SAME AS ON OPERATION PROFILE
EQUIPMENT CODE	ENTER ALPHANUMERIC CODE OF PROCESS EQUIPMENT. USE ALC CODES AND SHORTEN TO 8 CHARACTERS
TOTAL VOLUME OF EQUIPMENT IN CU. FT.	TOTAL USABLE VOLUME OF PROCESS EQUIPMENT IN CU. FT. ROUND TO NEAREST TENTH.
LIST OF PARTS BY ITEM CODE	LIST THE ITEM CODE OF EACH TYPE OF PART THAT IS PROCESSED BY THE LISTED EQUIPMENT.
VOLUME IN CU. FT.	DETERMINE THE VOLUME OF THE PART IN CU. FT. INCLUDING FIXTURES. ROUND UP TO NEXT TENTH OF CU. FT.
UNIT VALUE	ASSIGN A UNIT VALUE OF ONE (1) TO THE SMALLEST PART DETERMINE THE UNIT VALUE OF THE OTHER PARTS LISTED IN DIRECT RELATION TO THE SMALLEST PART. ROUND EACH NUMBER UP TO THE NEAREST WHOLE NUMBER.

AFLC TECHNOLOGY INSERTION PROGRAM
ENVELOP INSTRUCTIONS (CONTINUED)

DATA ITEM	DESCRIPTION
MINIMUM	MINIMUM NUMBER OF PARTS THAT CAN BE PLACED IN THE EQUIPMENT FOR PROCESSING ON A PRACTICAL BASIS (USE IE JUDGEMENT)
MAXIMUM	MAXIMUM NUMBER OF PARTS THAT CAN BE PLACED IN THE EQUIPMENT FOR PROCESSING.

ENVL..JP
(For Internal Use, Not a Model Input)

ALC ______________ RCC ______________ EQUIPMENT CODE ______________

TOTAL VOLUME OF EQUIPMENT IN CU. FT. ______________

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

RCC CH .IST
(For Internal Use, Not a Model Input)

NAME ______ ALC ______ DATE ______ SHEET ___ OF ___

	DATABASE DOCUMENTATION								PROCESS CHARACTERIZATION			
RCC	FACILITY LAYOUT	EQUIPMENT	WORK FORCE	REPAIR WORK TECHNOLOGY	WORKLOAD MIX & VOLUME	MATERIAL HANDLING	STORAGE	FLOW CHARTS	EQUIPMENT PROFILE	MANPOWER PROFILE	WORKLOAD PROFILE	80/20 ANALYSIS

LSC-2009A

ITEM CHECKLIST
(For Internal Use, Not a Model Input)

NAME ____________ ALC ____________ DATE ____________ RCC ____________ SHEET ____ OF ____

ITEM NUMBER	SPECIFY IF PCN NSN P/N	WCD NO.	WCD DATE	OPERATION PROFILE	DS/AS PROFILE	PARALLEL OPS PROFILE	HISTORICAL DATA	INDUCTION SELL DATE	BLANK WCD	STAMPED OFF WCD REVISIONS	STANDARD HOURS	STANDARD FLOW TIMES	PROCESS FLOW CHARTS

LSC 20098A

ITEM S MARY
(For Internal Use, Not a Model Input)

NAME__________ ALC__________ DATE__________ RCC __________ SHEET____ OF____

ITEM NUMBER	WCD	WORKLOAD TYPE	HISTORICAL FLOW TIME	STANDARD HOURS	EXPECTED HOURS
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

NOTE: HISTORICAL FLOW TIME WILL BE GENERATED BY DATA PROCESSING. IF NO HISTORY IS COLLECTED ON WCD DATA COLLECTION SYSTEM, THIS INFORMATION MUST BE OBTAINED ON-SITE. EXPECTED HOURS WILL BE GENERATED FROM OPS. PROFILES BY DATA PROCESSING.

LSC-2009?B

CPS-0 MOD

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OPERATION PROFILE

8:51 TUESDAY, MARCH 28, 1989 1

NAME K. Attavia ALC SA DATE 5- -89 RCC MATPSI SHEET 1 OF ___

ITEM CD PCN 04542A WCD TA2020 WCDDATE 88188

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~10~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~			.	.	.		.	.	.	EVELYN HALL 925-5330 FORMAN ALTERNATE
~~10~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
10	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2 ~~0.5~~		1	.		
~~20~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
20	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.5	AB-1	1	.	0.1	✓
~~30~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	MATPSI				P						AB-1	1		0.5	
30	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.5	AB-2	1	.	0.5 ~~0.0~~	
~~40~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~40~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
40	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.4 ~~0.3~~	AB-3	1 1	.	0.4 ~~0.0~~	
~~50~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSI SHEET 2 OF ___

ITEM CD PCN 04542A WCD TA2020 WCDDATE 88188

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~50~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
50	MATPSI	DIS	.	1.0	P	.	~~WG-3~~ 8602BA08	1	.	~~0.5~~ 0.7	AB-4	1	.	~~0.0~~ 0.1	EVELYN HALL 925-5330
50	MATPSI	DIS			P						AB-1	1		0.7	FORMAN ALTRNATE
50	MATPSI	DIS	.	.	P	.		.	.	.	AB-5	1	.	0.1	
50	MATPSI	DIS	.	.	P	.		.	.	.	AB-6	1	.	~~0.0~~ 0.1	
50	MATPSI	DIS	.	.	P	.		.	.	.	AB-7	1	.	0.1	
~~60~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~60~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
60	MATPSI	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.5		1	.	.	
70	MATPSI	DIS	1.00	.	T	.		.	.	.		.	.	.	
70	MATPSI	DIS	.	.	S	.		.	.	.		.	.	.	
70	MATPSI	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3		1	.	.	
80	MATPSI	DIS	1.00	1.0	T	.	8602BA05	1	.	0.5		1	.	.	Route

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OPERATION PROFILE

NAME ______________ ALC SA DATE ________ RCC MATPSI SHEET 3 OF __

ITEM CD PCN 04542A WCD TA2020 WCDDATE 88188

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~80~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
~~8~~	~~MATPSI~~	~~DIS~~	.	.	~~P~~	.	~~WG-8~~	~~1~~	.	~~0.5~~		.	.	.	
~~90~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~90~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
90	MATPSI	DIS	.	1.0	P	.	8602BA05 ~~WG-8~~	1	.	0.2		.	.	.	
100	MATPSI	DIS	1.00	1.0	T	.	8602BA05	1	.	0.5		.	.	.	sort & Route part to cleaning
~~100~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
~~100~~	~~MATPSI~~	~~DIS~~	.	.	~~P~~	.	~~WG-8~~	~~1~~	.	~~0.5~~		.	.	.	

FLOW PROCESS CHART

SUBJECT CPS-02 MOD START DISASSEMBLY DATE 5/24/89

ITEM CODE
PCN ☒ 04542A
NSN ☐
P/N ☐

WCD TA2020 WCD DATE 88188

CHART BEGINS OPERATION 10

CHART ENDS OPERATION 100 PREPARED BY K. ATTARIA

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	● ▷ D □ ▽	DISASSEMBLY			○ ▷ D □ ▽	
20	20	● ▷ D □ ▽	″			○ ▷ D □ ▽	
30	30	● ▷ D □ ▽	″			○ ▷ D □ ▽	
40	40	● ▷ D □ ▽	″			○ ▷ D □ ▽	
50	50	● ▷ D □ ▽	″			○ ▷ D □ ▽	
60	60	● ▷ D □ ▽	″			○ ▷ D □ ▽	
70	70	● ▷ D □ ▽	″			○ ▷ D □ ▽	
80	80	● ▷ D □ ▽	″			○ ▷ D □ ▽	
90	90	● ▷ D □ ▽	″			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	″			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

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						OPERATION PROFILE			SAS					8:18 TUESDAY, MARCH 28, 1989	8
NAME	APH				ALC SA			DATE	4-10-89		RCC MATPS~~S~~ I			SHEET 1 OF 21	
ITEM CD PCN 08004A					WCD TA007K		WCDDATE 88141								
OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F.HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
10	~~MATPSS~~ I	~~DIS~~				.		.	.	.		.	.	.	
10	~~MATPSS~~	~~DIS~~		.	~~S~~	.		.	.	.		.	.	.	
10	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2 ~~0.1~~	A-14 ~~A2-4/3~~	1	.	.2 ~~0.1~~	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	.2 ~~0.1~~	
20	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
20	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
20	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-4/3~~	1	.	0.1	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	
~~30~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	A-14 ~~A2-4/3~~	1	.	0.2	
30	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
~~40~~ 05	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~I SHEET 2 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~40~~	~~MATPSS~~	~~DIS~~			~~S~~										OP40 becomes OP5 - Done first
5 ~~40~~	MATPS~~S~~I	NDI ~~DIS~~		1.0	P		8602BA08 ~~WG-8~~	1		.2 ~~0.1~~	~~A2-4/3~~	~~1~~		~~0.1~~	
~~40~~	~~MATPSS~~	~~DIS~~			~~T~~						~~A2-4/4~~	~~1~~		~~0.1~~	
~~50~~	~~MATPSS~~	~~DIS~~			~~T~~										
~~50~~	~~MATPSS~~	~~DIS~~			~~S~~										
50	MATPS~~S~~I	DIS		1.0	P		8602BA08 ~~WG-8~~	1		0.3	A-14 ~~A2-4/3~~	1		0.3	
50	MATPSI	DIS			P						A-15	1		.3	
~~60~~	~~MATPSS~~	~~DIS~~			~~T~~										
~~60~~	~~MATPSS~~	~~DIS~~			~~S~~										
60	MATPSS	DIS		1.0	P		8602BA08 ~~WG-8~~	1		0.1	A-14 ~~A2-4/5~~	1		.1 ~~0.0~~	
60	MATPSS	DIS			P						A-15	1		.1	
60	MATPSS	DIS			P						A-38	1		.1	
~~70~~	~~MATPSS~~	~~DIS~~			~~T~~										
~~70~~	~~MATPSS~~	~~DIS~~			~~S~~ P										
70	MATPS~~S~~I	DIS		1.0	P		8602BA08 ~~WG-8~~	1		0.2	A-14 ~~A2-4/3~~	1		.2 ~~0.1~~	
70	MATPSI	DIS			P						A-15	1		.2	
70	MATPSI	DIS			P						A-34	1		.2	

OPERATION PROFILE

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NAME ______________ ALC SA DATE ________ RCC MATPS~~$~~I SHEET 3 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
80	MATPS~~$~~I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	
80	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
80	MATPSI	DIS			P						A-28	1		.2	
~~90~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~90~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
90	MATPS~~$~~I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	~~0.0~~ .2	
90	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	~~0.0~~ .2	
90	MATPSI	DIS			P						A-28	1		.2	
~~100~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~100~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
100	MATPS~~$~~I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	
100	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
~~110~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~$~~ I SHEET 4 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~110~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
110	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	~~A2-4/3~~ A-14	1	.	0.1	
110	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	A2-4/4 A-15	1	.	0.1	
110	MATPSI	DIS			P						A-38	1		.1	
~~130~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~130~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
130	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-2~~ 8602BA08	1	.	0.1	~~A2-11/2~~ A-14	1	.	0.1	
130	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~A2-4/3~~ A-15	1	.	0.1	
130	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-35	1	.	0.1	
~~140~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~140~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
140	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-2~~ 8602BA08	1	.	0.1	~~A2-4/3~~ A-14	1	.	0.1	
140	MATPSI	DIS			P						A-15	1		.1	
~~150~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

SAS

NAME ____________ ALC SA DATE ________ RCC MATPS~~S~~I SHEET 5 OF __

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~150~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
150	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-7/3~~	1	.	0.1	
150	MATPSI	DIS			P						A-15	1		.1	
150	MATPSI	DIS			P						A-39	1		.1	39
~~160~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~160~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
160	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-32/1~~	1	.	.1 ~~0.0~~	
160	MATPSI	DIS			P						A-15	1		.1	
160	MATPSI	DIS			P						A-39	1		.1	
~~170~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~170~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
170	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	A-14	1	.	.3	
170	MATPSI	DIS			P						A-15	1		.3	
~~180~~	~~MATPSS~~	~~DIS~~		.	~~T~~	.						.	.	.	
~~180~~	~~MATPSS~~	~~DIS~~		.	~~S~~	.		.	.	.		.	.	.	
180	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14	1	.	.1	
180	MATPSI	DIS			P						A-15	1		.1	
~~190~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	
~~190~~	~~MATPSS~~	DIS		.	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 6 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
190	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	A-14	1	.	.1	
190	MATPSI	DIS			P						A-15	1		.1	
~~200~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
~~200~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
200	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	A-14	1	.	.1	
200	MATPSI	DIS			P						A-15	1		.1	
~~210~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
~~210~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
210	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	A-14	1	.	.1	
210	MATPSI	DIS			P						A-15	1		.1	
~~220~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
~~220~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
220	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.2	A-14	1	.	.2	
220	MATPSI	DIS			P						A-15	1		.2	
~~230~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
230	MATPS~~S~~ I	DIS	.	1.0	P	.	8662BA08	1	.	.2	A-14	1	.	.2	
230	MATPSI	DIS			P						A-15	1		.2	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS$ I SHEET 2 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
230	MATPS$ I	DIS	.	.	P	.	~~[illegible]~~	~~[illegible]~~	.	~~0.2~~	A-1 ~~[illegible]~~	1	.	0.2	
~~240~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~240~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
240	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-3~~	1	.	0.2	A-14	1	.	.2	
240	MATPSI	DIS			P						A-15	1		.2	
~~250~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~250~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
250	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-3~~	1	.	0.2	A-14 ~~A2-4/3~~	1	.	0.2	
[illegible]	MATPSI	DIS			P						A-31	1		.2	
[illegible]0	MATPS$ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
~~260~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~260~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
260	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-3~~	1	.	0.2	A-6 ~~A2-4/3~~	1	.	0.2	
260	MATPSI	DIS			P						A-14	1		.2	
260	MATPS$ I	DIS	.	.	P	.		.	.	.	A-15 A2-4/4	1	.	0.2	
~~270~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	

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OPERATION PROFILE

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NAME ____________ ALC SA DATE ________ RCC MATPS~~S~~I SHEET 8 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~270~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.	~~—~~	.	.	.	
270	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG-6~~ 8602BA08	1	.	0.1	~~A2-4/3~~ A-14	1	.	0.1	
270	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.1	
270	MATPSI	DIS									A-29	1		.1	
~~280~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~280~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
280	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	
280	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
~~290~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~290~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
290	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	
290	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
290	MATPSI	DIS			P						A-4	1		.1	
~~300~~ 290	MATPS~~S~~I	DIS	.	.	~~S~~P	.		.	.	.	A-10	1		.1	
290	MATPSI	DIS			P						A-12	1		.1	
290	MATPSI	DIS			P						A-30	1		.1	
290	MATPSI	DIS			P						A-46	1		.1	
290	MATPSI	DIS			P										

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~I SHEET 9 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~300~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
300	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2	A-14 ~~A2-1/8~~	1	.	0.2	
300	MATPSI	DIS			P						A-12	1		.2	
300	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-[illegible]~~	1	.	0.2	
300	MATPSI	DIS			P						A-37	1		.2	
~~310~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	
~~310~~	~~MATPSS~~	~~DIS~~		~~.~~	~~S~~	.		.	.	.		.	.	.	
310	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.1	A-14	1	.	.1	
310	MATPSI	DIS			P						A-15	1		.1	
~~320~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~320~~	~~MATPSS~~	~~DIS~~		~~.~~	~~S~~	.		.	.	.		.	.	.	
320	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.1	A-14 ~~A2-[illegible]~~	1	.	0.1	
320	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-1/4~~	1	.	0.1	
~~330~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~330~~	~~MATPSS~~	~~DIS~~		~~.~~	~~S~~	.		.	.	.		.	.	.	
330	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.1	A-14 ~~A2-[illegible]~~	1	.	0.1	

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NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 10 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
330	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.1	
~~340~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~340~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
340	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-1/3~~ A-14	1	.	0.2	
340	MATPSI	DIS			P						A-15	1		.2	
340	MATPSI	DIS			P						A-38	1		.2	
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
350	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	~~A2-1/3~~ A-14	1	.	0.1	
350	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.1	
~~360~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~360~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	38
360	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-1/3~~ A-14	1	.	0.2	
360	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.2	
360	MATPSI	DIS			P						A-38	1		.2	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 11 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~370~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~370~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
370	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	
370	MATPSI	DIS			P						A-38	1		.1	
370	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
~~380~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~380~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
380	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	~~A2-4/3~~ A-14	1	.	0.1	
380	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.1	
~~390~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~390~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
390	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-8/1~~ A-7	1	.	0.1	
390	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/3~~ A-14	1	.	0.2	
390	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	

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8:18 TUESDAY, MARCH 28, 1989 19

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 12 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~400~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.		.		.	.	.	
~~400~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
400	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-5~~	1	.	0.3	A-14 ~~A2-4/6~~	1	.	0.3	
400	MATPSI	DIS			P						A-29	1		.3	
400	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.3	
~~410~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~410~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
410	MATPS~~Y~~ I	DIS	.	1.0	P	.	8600BA08 ~~WG-5~~	1	.	0.3	A-40 ~~A2-10/1~~	1	.	0.1	
410	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-4/3~~	1	.	0.3	
410	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.3	
~~420~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~420~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
420	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-5~~	1	.	0.2	A-14 ~~A2-4/3~~	1	.	0.2	
420	MATPSI	DIS			P						A-38	1		.2	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 13 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
0	MATPS~~S~~ I	DIS	.	.	P	:		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
~~430~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.	.	.	.	.	
~~430~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
430	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-4/2~~	1	.	0.1	
430	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	
~~0~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~440~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
440	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	A-14 ~~A2-4/2~~	1	.	0.2	
440	MATPSI	DIS			P						A-42	1		.2	
440	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
~~450~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~450~~	~~MATPSS~~	~~DIS~~		~~.~~	~~S~~	.		.	.	.		.	.	.	
450	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	A-14 ~~A2-4/2~~	1	.	0.2	
450	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	

OPERATION PROFILE SAS

NAME ________ ALC SA . DATE ________ RCC MATPS~~S~~ I SHEET 14 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~460~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~460~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
460	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	A-24 ~~A2-072~~	1	.	0.1	
460	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-478~~	1	.	0.2	
460	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.2	
~~470~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~470~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
470	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.1	A-24 ~~A2-372~~	1	.	.1 ~~0.0~~	
470	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-473~~	1	.	0.1	
470	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.1	
~~480~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~480~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPSI SHEET 15 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
480	MATPSI	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	~~A2-471~~ A-10	1	.	0.3	
480	MATPSI	DIS	.	.	P	.		.	.	.	~~A2-473~~ A-14	1	.	0.3	
480	MATPSI	DIS			P						A-12	1		.3	
480	MATPSI	DIS	.	.	P	.		.	.	.	~~A2-474~~ A-15	1	.	0.3	
~~490~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~490~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
490	MATPSI	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	~~A2-10/1~~ A-40	1	.	0.1	
490	MATPSI	DIS	.	.	P	.		.	.	.	~~A2-473~~ A-14	1	.	0.1	
490	MATPSI	DIS	.	.	P	.		.	.	.	~~A2-474~~ A-15	1	.	0.1	
~~500~~	~~MATPMM~~		~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~500~~	~~MATPMM~~		~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
500	MATPSI		.	1.0	P	.	8602BA08	1.	.	.1	A-14	1	.	.1	
500	MATPSI		.	.	P	.		.	.	.	A-15	1	.	.1	
~~510~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS 8:18 TUESDAY, MARCH 28, 1989 23

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 16 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~510~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
510	MATPS~~S~~ I	DIS	.	1,0	P	.	~~WG-5~~ 8602BA08	1	.	0.2	~~A2-1/2~~ A-2	1	.	0.2	
510	MATPSI	DIS			P						A-37	1		.2	
510	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/8~~ A-14	1	.	0.2	
510	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.2	
~~520~~	~~MATPSS~~	~~DIS~~		~~.~~	~~T~~	.		.	.	.		.	.	.	
~~520~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
520	MATPS~~S~~ I	DIS	.	1,0	P	.	~~WG-5~~ 8602BA08	1	.	0.2	~~A2-14/5~~ A-37	1	.	0.2	
520	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-2/3~~ A-14	1	.	0.2	
520	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
~~530~~	~~MATPSS~~	~~DIS~~		~~.~~	~~I~~	.		.	.	.		.	.	.	
~~530~~	~~MATPSS~~	~~DIS~~		~~.~~	~~S~~	.		.	.	.		.	.	.	
530	MATPS~~S~~ I	DIS	.	1,0	P	.	~~WG-5~~ 8602BA08	1	.	0.1	~~A2-4/3~~ A-14	1	.	0.1	
530	MATPSI	DIS			P						A-22	1		.1	

OPERATION PROFILE

NAME ______________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 17 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
530	MATPSS	DIS	.	.	P	.	.	.	.	.	~~A2-1/4~~ A-15	1	.	0.1	
~~540~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	
~~540~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
540	MATPS~~S~~ I	DIS	.	1,0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-1/0~~ A-14	1	.	0.2	
540	MATPSI	DIS			P						A-10	1		.2	
540	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.2	
540	MATPSI	DIS			P						A-11	1		.2	
~~540~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~550~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
550	MATPS~~S~~ I	DIS	.	1,0	P	.	~~WG-3~~ 8602BA08	1	.	0.1	~~A2-1/5~~ A-14	1	.	0.1	
550	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.1	
~~560~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~560~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
560	MATPS~~S~~ I	DIS	.	1,0	P	.	~~WG-5~~ 8602BA08	1	.	0.2	~~A2-1/2~~ A-37	1	.	0.1	
560	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/0~~ A-2	1	.	0.2	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 18 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
560	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-4/4~~	1	.	0.2	
560	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-10/4~~	1	.	0.2	
~~570~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~570~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
70	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2	A-14 ~~A2-4/3~~	1	.	0.2	
70	MATPSI	DIS			P						A-37	1		.2	
570	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
~~580~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~580~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
580	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2	A-10 ~~A2-4/1~~	1 ~~1~~	.	.1 ~~0.0~~	
580	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-4/3~~	1	.	0.2	
580	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
580	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-11 ~~[illegible]~~	1 ~~1~~	.	.1 ~~0.0~~	
580	MATPSI	DIS			P						A-16	1		.1	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 19 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~580~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~590~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
590	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG30~~	1	.	0.2	A-14 ~~A2-4/3~~	1	.	0.2	
590	MATPSI	DIS			P						A-11	1		.2	
590	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	
590	MATPSI	DIS			P						A-45	1		.2	
~~600~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~?~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
600	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-5~~	1	.	0.5	A-3 ~~A3-1/3~~	1	.	0.1	
.0	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-4/3~~	1	.	0.5	
600	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.5	
~~610~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~610~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
610	MATPSS	DIS	.	1.0	P	.	8602BA08 ~~WG-I~~	1	.	0.1	A-10 ~~A8-1/1~~	1	.	.1 ~~0.0~~	
											A-11	1		.1	
610	MATPSS	DIS	.	.	P	.		.	.	.	A-14 ~~A2-4/3~~	1	.	0.1	

SAS

OPERATION PROFILE

8:18 TUESDAY, MARCH 28, 1989 27

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 20 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
:0	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	
~~620~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
~~620~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
620	MATPS~~S~~ I	DIS	.	1,0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-4/3~~	1	.	0.1	
-0	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	
5	MATPSI	DIS			P						A-44	1		.1	
~~.30~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
~~630~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
.30	MATPS~~S~~ I	DIS	.	1,0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-43 ~~A2-2/8~~	1	.	0.1	
630	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-4/3~~	1	.	0.1	
630	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	
~~640~~	~~MATPSS~~	~~DIS~~	.	.	~~I~~	.		.	.	.		.	.	.	
~~640~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	

SAS

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPSI SHEET 21 OF ___

ITEM CD PCN 08004A WCD TA007K WCDDATE 88141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
640	MATPSI	DIS	.	1.0	P	.	~~[illegible]~~ 8602BA08	1	.	0.3	~~[illegible]~~ A-14	1	.	0.3	
640	MATPSI	DIS	.	.	P	.		.	.	.	~~[illegible]~~ A-15	1	.	0.3	
640	MATPSI	DIS	.	.	P	.		.	.	.	~~[illegible]~~ A-25	1	.	0.3	
690	MATPSI	DIS			P						A-41	1		.3	

FLOW PROCESS CHART

SUBJECT: F15 AMAD-LH DISASSEMBLE DATE: 5-25-89

ITEM CODE: PCN ■ NSN □ P/N □ 08004A

WCD: TA007K WCD DATE: 88141

CHART BEGINS:

CHART ENDS: PREPARED BY: A.P.Holm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
5	40	○▷D■▽	INSP	340	340	●▷D□▽	DIS
10	10	●▷D□▽	DIS	350	350	●▷D□▽	DIS
20	20	●▷D□▽	DIS	360	360	●▷D□▽	DIS
30	30	●▷D□▽	DIS	370	370	●▷D□▽	DIS
50	50	●▷D□▽	DIS	380	380	●▷D□▽	DIS
60	60	●▷D□▽	DIS	390	390	●▷D□▽	DIS
70	70	●▷D□▽	DIS	400	460	●▷D□▽	DIS
80	80	●▷D□▽	DIS	410	410	●▷D□▽	DIS
90	90	●▷D□▽	DIS	420	420	●▷D□▽	DIS
100	100	●▷D□▽	DIS	430	430	●▷D□▽	DIS
110	110	●▷D□▽	DIS	440	440	●▷D□▽	DIS
130	130	●▷D□▽	DIS	450	450	●▷D□▽	DIS
140	140	●▷D□▽	DIS	460	460	●▷D□▽	DIS
150	150	●▷D□▽	DIS	470	470	●▷D□▽	DIS
160	160	●▷D□▽	DIS	480	480	●▷D□▽	DIS
170	170	●▷D□▽	DIS	490	490	●▷D□▽	DIS
180	180	●▷D□▽	DIS	500	500	●▷D□▽	DIS
190	190	●▷D□▽	DIS	510	510	●▷D□▽	DIS
200	200	●▷D□▽	DIS	520	520	●▷D□▽	DIS
210	210	●▷D□▽	DIS	530	530	●▷D□▽	DIS
220	220	●▷D□▽	DIS	540	540	●▷D□▽	DIS
230	230	●▷D□▽	DIS	550	550	●▷D□▽	DIS
240	240	●▷D□▽	DIS	560	560	●▷D□▽	DIS
250	250	●▷D□▽	DIS	570	570	●▷D□▽	DIS
260	260	●▷D□▽	DIS	580	580	●▷D□▽	DIS
270	270	●▷D□▽	DIS	590	590	●▷D□▽	DIS
280	280	●▷D□▽	DIS	600	600	●▷D□▽	DIS
290	290	●▷D□▽	DIS	610	610	●▷D□▽	DIS
300	360	●▷D□▽	DIS	620	620	●▷D□▽	DIS
310	310	●▷D□▽	DIS	630	630	●▷D□▽	DIS
320	320	●▷D□▽	DIS	640	640	●▷D□▽	DIS
330	330	●▷D□▽	DIS			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Act Hand Anod Dis Assy

cF

SAS

OPERATION PROFILE

NAME D P Holm ALC SA DATE 4-10-89 RCC MATPSI SHEET 1 OF 19

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~10~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~10~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~ P	.		.	.	.		.	.	.	
10	MATPSS /MATPSI	DIS	.	1,0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2~~	1	.	0.1	A-14
10	MATPSS	DIS	.	.	P	.		.	.	.	A-15 ~~A2~~	1	.	0.1	
~~20~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
20	MATPSI	DIS	.	1,0	P	.	8602BA08 ~~WG~~	1	.	0.1	A-14 ~~A2~~	1	.	0.1	
20	MATPSI	DIS	.	.	P	.		.	.	.	A-15 ~~A2~~	1	.	0.1	
~~30~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	MATPSI	DIS	.	1,0	P	.	8606BA08 ~~WG-9~~	1	.	0.2	A-14 ~~A2~~	1	.	0.2	
30	MATPSI	DIS	.	.	P	.		.	.	.	A-15 ~~A2~~	1	.	0.2	
~~40~~	~~MATPSS~~	~~NDI~~	.			.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 2 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~30~~	~~MATPSS~~	~~NDI~~	~~.~~	~~.~~	~~S~~	.		.	.	.	.	.	.	.	OP40 Done 1st.
~~40~~	MATPS~~S~~ I	NDI	.	1,0	P	.	8602BA08 ~~WG 8~~	1	.	0.1	~~[illegible]~~	~~[illegible]~~	.	~~[illegible]~~	
~~40~~	~~MATPSS~~	~~NDI~~	~~.~~	~~.~~	~~P~~	.		.	.	.	~~[illegible]~~	~~1~~	.	~~0.1~~	
~~50~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~50~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
50	MATPS~~S~~ I	DIS	.	1,0	P	.	8602BA08 ~~WG 9~~	1	.	0.1	A-14 ~~A2 4/3~~	1	.	0.1	~~A-14~~
50	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2 4/1~~	1	.	0.1	~~A-15~~
~~60~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~60~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
60	MATPS~~S~~ I	DIS	.	1,0	P	.	8602BA08 ~~WG 9~~	1	.	0.2	A-14 ~~A2 4/6~~	1	.	0.2	~~A-14~~
60	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2 4/4~~	1	.	0.2	~~A-15~~
~~70~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

SAS

8:18 TUESDAY, MARCH 28, 1989 64

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 3 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
[illegible]	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
70	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-4/3~~	1	.	0.1	~~A-14~~
70	MATPSI	DIS			P						A-15 A-28	1		.1	~~A-28~~
70	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~	1	.	0.1	~~A-15~~
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
80	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	A-14 ~~A2-4/3~~	1	.	0.1	A-14
	MATPSI	DIS			P						A-15 A-28	1		.1	A-28
80	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~	1	.	0.1	A-15
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~90~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
90	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	A-14 ~~A2-4/3~~	1	.	0.2	A-14
90	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.2	~~A-15~~
~~100~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~100~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC ~~MATPS$~~ MATPSI SHEET 4 OF __

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
100	~~MATPS$~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	~~A-14~~
100	MATPSI	DIS			P						A-15	1		.2	~~A-38~~
100	~~MATPS$~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-38	1	.	0.2	
~~110~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~110~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
:0	~~MATPS$~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	~~A2-4/3~~ A-14	1	.	0.2	~~A-14~~
110	~~MATPS$~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	~~A-15~~
~~120~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~120~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~			.	.	.		.	.	.	
120	~~MATPS$~~ MATPSI	DIS	.	1.0	P		~~WG-9~~ 8602BA08	1	.	0.2	~~A2-1/1~~ A-1	1	.	0.0	~~A-14~~
120	~~MATPS$~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/3~~ A-14	1	.	0.2	~~A-1~~ ~~A-15~~
120	~~MATPS$~~ MATPSI	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	0.2	
~~130~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~$~~I SHEET 5 OF __

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~130~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
130	MATPS~~$~~I	DIS	.	1.0	P		8602BA08 ~~[illegible]~~	1	.	0.1	A-14 A2-4/3	1	.	0.1	~~A-14~~
130	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	A-15 A2-4/4	1	.	0.1	~~A-15~~
~~140~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.			.	.	.	
~~140~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
140	MATPS~~$~~I	DIS	.	1.0	P		8602BA08 ~~[illegible]~~	1	.	0.1	A-14 ~~A2-4/3~~	1	.	0.1	~~A-14~~
140	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	~~A-15~~
~~150~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~150~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
150	MATPS~~$~~I	DIS	.	1.0	P		8602BA08 ~~[illegible]~~	1	.	0.1	A-14 ~~A2-15/2~~	1	.	0.1	~~A-14~~ ~~A-6~~ ~~A-15~~
150	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/3~~	1	.	0.1	
150	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	A-6 ~~A2-4/4~~	1	.	0.1	
~~160~~	~~MATPSS~~	~~DIS~~	~~.~~		~~T~~	.		.	.			.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 6 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~160~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
160	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.1	A-14 ~~A2-12/1~~	1	.	.1 ~~0.0~~	~~A-14~~
160	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-15/14~~	1	.	.1 ~~0.0~~	~~A-15~~
160	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-31 ~~A2-1/8~~	1	.	0.1	~~A-31~~
160	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-32 ~~A2-[illegible]~~	1	.	0.1	~~A-32~~
~~170~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.			.	.	.	
~~170~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
170	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	.1 ~~0.0~~	A-14 ~~A2-4/1~~	1	.	.1 ~~0.0~~	~~A-14~~
170	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-1/2~~	1	.	.1 ~~0.0~~	~~A-15~~
170	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-12 ~~A2-1/4~~	1	.	.1 ~~0.0~~	~~A-12~~
170	MATPSI	DIS			P						A-1D			.1	~~A-1D~~
~~180~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~180~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 7 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
180	MATPS~~S~~I	DIS	.	.	P		8602BA08	1	.	0.1	A-14	1	.	0.1	A-14
180	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	A-15	1	.	0.1	A-15
~~180~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~190~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
190	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08	1	.	0.1	A-14	1	.	0.1	A-14
190	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	A-15	1	.	0.1	A-15
~~200~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~200~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
200	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08	1	.	0.1	A-14	1	.	0.1	A-14
200	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	A-15	1	.	0.1	A-15
~~210~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~210~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
210	MATPS~~S~~I	DIS	.	1.0	P	.	8602BA08	2	.	0.3	A-14	1	.	~~0.0~~ .3	A-14

OPERATION PROFILE SAS 8:18 TUESDAY, MARCH 28, 1989 69

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 8 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
210	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-473~~	1	.	0.3	~~A-14~~
210	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-38 ~~A2-474~~	1	.	0.3	~~A-38~~
~~220~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~220~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
220	MATPS~~S~~ I	DIS	.	.	P	.	8602 BA08 ~~[illegible]~~	1	.	0.1	A-14 ~~A2-473~~	1	.	0.1	~~A-14~~
220	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.1	~~A-15~~
~~230~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~230~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
230	MATPS~~S~~ I	DIS	.	.	P	.	8602 BA08 ~~[illegible]~~	1	.	0.2	A-14 ~~A2-473~~	1	.	0.2	~~A-14~~ A-38 ~~A-15~~
230	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.2	
230	MATPSI	DIS			P					.	A-38	1		.2	
~~240~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~240~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 9 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
240	MATPS~~S~~ I	DIS		1.0	P		~~W3-0~~ 8662BA08	1		0.2	~~A2-413~~ A-14	1		0.2	
240	MATPSI	DIS			P						A-15	1		.2	
240	MATPS~~S~~ I	DIS			P						~~A2-4/6~~ A-38	1		0.2	A-15
240	MATPSI	DIS			P						A-40	1		.2	A ~~-8~~
~~250~~	~~MATPSS~~	~~DIS~~			~~T~~										
~~250~~	~~MATPSS~~	~~DIS~~			~~S~~										
250	MATPS~~S~~ I	DIS		1.0	P	1.	~~W3-0~~ 8662BA08	1		0.1	~~A2-413~~ A-14	1		0.1	
250	MATPS~~S~~ I	DIS			P						~~A2-4/4~~ A-15	1		0.1	~~A-15~~
~~260~~	~~MATPSS~~	~~DIS~~			~~T~~										
~~260~~	~~MATPSS~~	~~DIS~~			~~S~~										
260	MATPS~~S~~ I	DIS		1.0	P		~~W3-0~~ 8662BA08	1		0.2	~~A2-3/4~~ A-8	1		0.1	A-14
260	MATPS~~S~~ I	DIS			P						~~A2-4/3~~ A-14	1		0.2	A-15
260	MATPS~~S~~ I	DIS			P						~~A2-4/4~~ A-15	1		0.2	~~-8~~
~~270~~	~~MATPSS~~	~~DIS~~			~~T~~										
~~270~~	~~MATPSS~~	~~DIS~~			~~S~~										

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 10 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
270	MATPS~~S~~ I	DIS	.	1.0	P		~~WG-9~~ 8602BA08	1	.	0.3	A-14 ~~A2-473~~	1	.	0.3	~~A-14~~ ~~A-15~~ ~~A-11.5~~
270	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.3	
276	MATPSI	DIS			P						A-29	1		.1	
~~280~~	~~MATPSS~~	~~EID~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~280~~	~~MATPSS~~	~~EID~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
280	MATPS~~S~~ I	EID	.	1.0	P		~~WG-9~~ 8602BA08	1	.	0.3	A-40 ~~A2-1011~~	1	.	0.1	~~A-14~~ ~~A-15~~ ~~A-40~~
280	MATPS~~S~~ I	EID	.	.	P	.		.	.	.	A-14 ~~A2-473~~	1	.	0.3	
280	MATPS~~S~~ I	EID	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.3	
~~290~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.			.	.	.	
~~290~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
290	MATPS~~S~~ I	DIS	.	1.0	P		~~WG-8~~ 8602BA08	1	.	0.1	A-14 ~~A2-473~~	1	.	0.1	~~A-14~~ ~~A-15~~ ~~A-38~~
290	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.1	
290	MATPSI	DIS			P						A-38	1		.1	
~~300~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.			.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 11 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~800~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
300	MATPS~~S~~ I	DIS	.	.	P		~~WG-9~~ 8602BA08	1	.	0.1	~~A2-4/3~~ A-14	1	.	~~0.1~~	~~A-14~~
300	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A2-~~4~~/4 A-15	1	.	0.1	~~A-15~~
~~310~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~310~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
310	MATPS~~S~~ I	DIS	.	1.0	P		~~WG-9~~ 8602BA08	1	.	0.1	A2~~-4/3~~ A-14	1	.	0.1	~~A-14~~
310	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A2-4/4 A-15	1	.	0.1	~~A-42~~
310	MATPSI	DIS			P						"A-42	1		.1	~~A-15~~
~~320~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~320~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
320	MATPS~~S~~ I	DIS	.	1.0	P		~~WG-9~~ 8600BA08	1	.	~~0.0~~ .1	~~A2-4/3~~ A-14	1	.	~~0.0~~ .1	~~A-14~~
320	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2-4/4~~ A-15	1	.	~~0.0~~ .1	~~A-15~~
~~330~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~330~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 12 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
330	MATPS~~S~~ I	DIS	.	1.0	P		~~W0-0~~ 8602 BA08	1	.	0.2	A-24 ~~A2-072~~	1	.	0.1	~~A-24~~
330	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-078~~	1	.	0.2	~~A-14~~
330	MATPS~~S~~	DIS	.	.	P	.		.	.	.	A-15 ~~A2-174~~	1	.	0.2	~~A-15~~
330	MATPSI	DIS			P						A-37	1		.1	~~A-37~~
~~340~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.			.	.	.	
~~340~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
340	MATPS~~S~~ I	DIS	.	1.0	P		~~WG-01~~ 8602 BA08	1	.	0.1	A-37 ~~A2-072~~	1	.	.1 ~~0.0~~	~~A-37~~
340	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-172~~	1	.	0.1	~~A-14~~
340	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-174~~	1	.	0.1	~~A-15~~
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.			.	.	.	
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.			.	.	.	
350	MATPSS	DIS	.	1.0	P		~~WG-0~~ 8602 BA08	1	.	0.3	A-14 ~~A2-171~~	1	.	.3 ~~0.0~~	~~A-14~~
350	MATPSS	DIS	.	.	P	.		.	.	.	A-15 ~~A2-1/2~~	1	.	0.3	~~A-15~~
350	MATPSS	DIS			P						A-12	1		.1	~~A-12~~
350	MATPSS	DIS			P						A-1D	1		.1	~~A-1D~~
350	MATPSS	DIS			P						A-4D	1		.1	~~A-4D~~

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OPERATION PROFILE

8:18 TUESDAY, MARCH 28, 1989 74

NAME ________ ALC SA DATE ________ RCC MATPSS SHEET 13 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~P~~	~~.~~		.	.	.	~~A2-4/4~~	~~1~~	~~.~~	~~0.3~~	
~~360~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~360~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
360	MATPSS	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	A-40 ~~A2-[illegible]~~	1	.	0.1	
360	MATPSS I I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-[illegible]~~	1	—	0.1	~~A-Di~~ ~~A-40~~ ~~A-15~~
360	MATPSS I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-4/4~~	1	.	0.1	
~~370~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~370~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
370	MATPSS	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	A-14 ~~A2-[illegible]~~	1	.	0.3	~~A-14~~
370	MATPSS	DIS	.	.	P	.		.	.	.	A-15 ~~A2-[illegible]~~	1	.	0.3	~~A-15~~
~~375~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~375~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
375	MATPSS	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	A-2 ~~A2-[illegible]~~	1	.	.1 ~~0.0~~	~~A-2~~
											A-37	1		.1	~~A-37~~

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 14 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
375	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2 4/6~~ A-14	1	.	0.1	~~A-14~~ ~~A-15~~
375	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2 4/6~~ A-15	1	.	0.1	
~~380~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~380~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
380	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	~~A2 14/5~~ A-37	1	.	0.1	~~A-37~~ ~~A-14~~ ~~A-15~~
[illegible]0	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2 4/5~~ A-14	1	.	0.1	
[illegible]0	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2 4/4~~ A-15	1	.	0.1	
~~390~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~390~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
390	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	~~A2 4/5~~ A-14	1	.	0.1	~~A-23~~ ~~A-14~~ ~~A-15~~
390	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	~~A2 4/4~~ A-15	1	.	0.1	
390	MATPSI	DIS			P						A-23	1		.1	
~~400~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~0~~ I SHEET 15 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~400~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	~~A-13~~ ~~A-10~~ ~~A-14~~ ~~A-12~~
400	MATPS~~0~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8662BA08	1	.	0.2	~~A2-1/2~~ A-14	1	.	0.2	
400	MATPSI	DIS			P						A-10	1		.1	
400	MATPS~~0~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.2	
400	MATPSI	DIS			P						A-12	1		.1	
~~410~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~410~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
410	MATPS~~0~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	~~A2-1/8~~ A-14	1	.	0.1	~~A-14~~
410	MATPS~~0~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.1	~~A-15~~
~~420~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~420~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
420	MATPS~~0~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	~~A2-1/2~~ A-2	1	.	~~0.2~~ .1	~~A-2~~ ~~A-4~~
420	MATPS~~0~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/8~~ A-14	1	.	0.1	~~A-14~~
420	MATPSI	DIS			P						A-4	1		.1	
420	MATPS~~0~~ I	DIS	.	.	P	.		.	.	.	~~A2-1/4~~ A-15	1	.	0.1	~~A-15~~
~~420~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 16 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~440~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
440	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08	1	.	0.2	A-37	1	.	0.1	
440	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14	1	.	0.2	
440	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15	1	.	0.2	
~~450~~	~~MATPSS~~	~~DIS~~		~~.~~	~~T~~	.		.	.	.		.	.	.	
~~450~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
450	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08	1	.	0.1	A-10	1	.	.1	
450	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-11	1	.	0.1	~~A-11~~
450	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14	1	.	0.1	~~A-14~~ ~~A-15~~
450	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15	1	.	.1	~~A-10~~
~~460~~	~~MATPSS~~	~~DIS~~	~~.~~		~~T~~	.		.	.	.		.	.	.	
~~460~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
460	MATPSI	DIS		1.0	P		8602BA08	1		.1	A-14	1		.1	
					P						A-15	1		.1	
					P						A-11	1		.1	

		SAS	
	OPERATION PROFILE		8:18 TUESDAY, MARCH 28, 1989 78
NAME ________	ALC SA	DATE ________ RCC MATPS~~S~~ I	SHEET 17 OF ___
ITEM CD PCN 08005A	WCD TA278K WCDDATE 87141		

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
460	MATPS~~S~~ I	DIS	.	.	P	.	[illegible]	[illegible]	.	[illegible]	~~A2-473~~ A-45	1 /	.	0.1	[illegible]
~~460~~	~~MATPSS~~	~~DIS~~	.	.	[illegible]	.		.	.	.	~~A2-474~~	~~1~~	.	~~0.1~~	
~~470~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.	..	.	.	.	
~~470~~	~~MATPSS~~	~~DIS~~		.	~~S~~	.		.	.	.	...	.	.	.	
470	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WD9~~ 8602BA08	1	.	0.2	A-3 ~~A2-173~~	1	.	0.1	[illegible]
470	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-478~~	1	.	0.2	[illegible]
470	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.2	[illegible]
~~480~~	~~MATPSS~~	~~DIS~~		.	~~T~~	.		.	.	.		.	.	.	
~~480~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
480	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WD9~~ 8602BA08	1	.	0.1	A-10 ~~A2-471~~	1	.	.1 ~~0.8~~	A-10
480	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-14 ~~A2-478~~	1	.	0.1	
480	MATPSI	DIS			P						A 11	/		.1	A-15
480	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	A-15 ~~A2-474~~	1	.	0.1 .1	A-11
~~480~~	~~MATPSS~~	~~DIS~~		.	~~T~~	.		.	.	.		.	.	.	

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OPERATION PROFILE

8:18 TUESDAY, MARCH 28, 1989 79

NAME ________ ALC SA DATE ________ RCC MATPSI SHEET 18 OF ___

ITEM CD PCN 08005A WCD TA278K WCDDATE 87141

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~490~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
490	MATPSI	DIS	.	1.0	P	.	~~WG 5~~ 8602BA08	1	.	0.2	A-14 ~~A2 4/3~~	1	.	0.2	~~A-14~~ ~~A-15~~
490	MATPSI	DIS	.	.	P	.		.	.	.	A-15 ~~A2 4/4~~	1	.	0.2	
~~500~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~500~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
500	MATPSI	DIS	.	1.0	P	.	~~WG 5~~ 8602BA08	1	.	0.1	A-14 ~~A2 8/8~~	1	.	0.1	~~A-43~~ ~~A-14~~ ~~A-45~~
500	MATPSI	DIS	.	.	P	.		.	.	.	A-15 ~~A2 4/3~~	1	.	0.1	
500	MATPSI	DIS	.	.	P	.		.	.	.	A-43 ~~A2 4/4~~	1	.	0.1	
~~510~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~510~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
510	MATPSI	DIS	.	1.0	P	.	~~WG 5A~~	1	.	0.3	A-25 ~~A2 0/4~~	1	.	0.3	~~A-41~~ ~~A-25~~
510	MATPSI	DIS	.	.	P	.		.	.	.	A-41 ~~A2 4/3~~	1	.	0.3	

ITEM CD PCN 08005A ALC SA ...ROFILE

WCD TA278K WCDDATE 8714[illegible] D[illegible] RCC MATPS$ I

8:18 TUESDAY, MAR[illegible]8, 1989 80

SHEET 19 OF

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~510~~	~~MATPSS~~	~~DIS~~			~~P~~						~~A2 4/4~~	~~1~~		~~0.3~~	

[redacted]

FLOW PROCESS CHART

SUBJECT F15 AMAD - RH DISASSEMBLE DATE 5-24-89

ITEM CODE
PCN ■
NSN □ 08005A
P/N □

WCD TA278K WCD DATE 87141

CHART BEGINS 5

CHART ENDS 510 PREPARED BY A P Holm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
5	40	○▷D■▽	INSP	330	330	●▷D□▽	DIS
10	10	●▷D□▽	DIS	340	340	●▷D□▽	DIS
20	20	●▷D□▽	DIS	350	350	●▷D□▽	DIS
30	30	●▷D□▽	DIS	360	360	●▷D□▽	DIS
50	50	●▷D□▽	DIS	370	370	●▷D□▽	DIS
60	60	●▷D□▽	DIS	375	375	●▷D□▽	DIS
70	70	●▷D□▽	DIS	380	380	●▷D□▽	DIS
80	80	●▷D□▽	DIS	390	390	●▷D□▽	DIS
90	90	●▷D□▽	DIS	400	400	●▷D□▽	DIS
100	100	●▷D□▽	DIS	410	410	●▷D□▽	DIS
110	110	●▷D□▽	DIS	420	420	●▷D□▽	DIS
120	120	●▷D□▽	DIS	440	440	●▷D□▽	DIS
130	130	●▷D□▽	DIS	450	450	●▷D□▽	DIS
140	140	●▷D□▽	DIS	460	460	●▷D□▽	DIS
150	150	●▷D□▽	DIS	470	470	●▷D□▽	DIS
160	160	●▷D□▽	DIS	480	480	●▷D□▽	DIS
170	170	●▷D□▽	DIS	490	490	●▷D□▽	DIS
180	180	●▷D□▽	DIS	500	500	●▷D□▽	DIS
190	190	●▷D□▽	DIS	510	510	●▷D□▽	DIS
200	200	●▷D□▽	DIS			○▷D□▽	
200	210	●▷D□▽	DIS			○▷D□▽	
220	220	●▷D□▽	DIS			○▷D□▽	
230	230	●▷D□▽	DIS			○▷D□▽	
240	240	●▷D□▽	DIS			○▷D□▽	
250	250	●▷D□▽	DIS			○▷D□▽	
260	260	●▷D□▽	DIS			○▷D□▽	
270	270	●▷D□▽	DIS			○▷D□▽	
280	280	●▷D□▽	DIS			○▷D□▽	
290	290	●▷D□▽	DIS			○▷D□▽	
300	300	●▷D□▽	DIS			○▷D□▽	
310	310	●▷D□▽	DIS			○▷D□▽	
320	320	●▷D□▽	DIS			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 -T + Fuel Starter Disassembly   3A ✓/F

OPERATION PROFILE

SAS

NAME A. Holm   ALC SA   DATE 4-13-89   RCC MATPS~~$~~ I   SHEET 1 OF ___

ITEM CD PCN 08006A   WCD TA113H   WCDDATE 88065 ✓

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~2~~	~~MATPSS~~	~~PREP~~	~~0.97~~	~~.~~	~~T~~	.		.	.	.		.	.	.	Juan Martinez
~~2~~	~~MATPSS~~	~~PREP~~			~~S~~	.		.	.	.		.	.	.	8602BC09 Joe Villarreal Supervisor
1 ~~0~~	MATPS~~$~~ I	PREP	.	1.0	P	.	8602EA08 ~~WG-8~~	1	.	0.3		.	.	.	
~~3~~	~~MATPSS~~	~~PREP~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~3~~	~~MATPSS~~	~~PREP~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
2 ~~3~~	MATPS~~$~~ I	PREP	.	1.0	P	.	8602EA08 ~~WG-8~~	1	.	~~0.0~~ 1		.	.	.	
~~4~~	~~MATPSS~~	~~PREP~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~4~~	~~MATPSS~~	~~PREP~~	~~.~~		~~S~~	.		.	.	.		.	.	.	
4	MATPS~~$~~ I	PREP	.	1.0	P	.	8602BA08 ~~WG-8~~	2	.	0.5	G-32	1	.	0.5	
4	MATPS~~$~~ I	PREP	.	.	P	.		.	.	.	G-33	1	.	0.5	
~~5~~	~~MATPSS~~	~~INSP~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~5~~	~~MATPSS~~	~~INSP~~			~~S~~	.		.	.	.		.	.	.	
5	MATPS~~$~~ I	INSP	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	G-32	1	.	0.3	

(3)

OPERATION PROFILE SAS

NAME ____________ ALC SA DATE ________ RCC MATPS~~$~~ I SHEET 2 OF __

ITEM CD PCN 08006A WCD TA113H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
5	MATPS~~$~~ I	INSP	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~8~~	~~MATPSS~~	~~INSP~~	~~0.87~~	.	~~T~~	.		.	.	.		.	.	.	
~~8~~	~~MATPSS~~	~~INSP~~	.	.	~~S~~	.		.	.	.		.	.	.	
6	MATPS~~$~~ I	INSP	.	0.4	P	.	8602BA08 ~~WG 8~~	1	.	0.5	G-98 ~~G-32~~	1	.	0.5	
6	MATPSI	INSP			P						G-32	1		0.5	
6	MATPS~~$~~ I	INSP	.	.	P	.		.	.	.	G-33	1	.	0.5	
~~8~~	~~MATPSS~~	~~PREP~~	~~1.00~~	.	~~T~~	.		.	.	.		.	.	.	
~~8~~	~~MATPSS~~	~~PREP~~			~~S~~	.		.	.	.		.	.	.	
3 ~~8~~	MATPS~~$~~ I	PREP	.	1.0	P	.	8602BA08 ~~WG 9~~	1	.	0.1	G-32	1	.	0.1	Revise sequence OP 8 becomes OP3
3 ~~8~~	MATPS~~S~~ I	PREP	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~10~~	~~MATPSS~~	~~DIS~~	~~1.00~~	.	~~T~~	.		.	.	.		.	.	.	
~~10~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
10	MATPS~~$~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG 9~~	1	.	0.8	G-32	1	.	0.8	

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OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~I SHEET 3 OF ___

ITEM CD PCN 08006A WCD TA113H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.8	
~~12~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~12~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.		.	
12	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	G-32	1	.	0.3	
12	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~14~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~14~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
14	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	G-32	1	.	0.3	
14	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~16~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~16~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
16	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	G-32	1	.	0.3	
16	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	

OPERATION PROFILE SAS

8:18 TUESDAY, MARCH 28, 1989 170

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 4 OF ___

ITEM CD PCN 08006A WCD TA113H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~18~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~18~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
18	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-0~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
18	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
~~20~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
20	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-0~~ 8602BA08	1	.	0.3	G-32	1	.	0.3	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~22~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~22~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
22	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-0~~ 8602BA08	1	.	0.3	G-32	1	.	0.3	
22	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 5 OF ___

ITEM CD PCN 08006A WCD TA113H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~23~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~23~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
23	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG 8~~	1	.	0.1	G-32	1	.	0.1	
23	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~24~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~24~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
24	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG 3~~	1	.	0.3	G-32	1	.	0.3	
24	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~26~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
26	MATPS~~S~~ I	DIS	.	1.0	~~S~~ P	.	8602BA08	1	.	.4	G32	1	.	.4	
26	MATPS~~S~~ I	DIS	.	.	P	.	~~WG 8~~	~~1~~	.	~~0.4~~	G-33	1	.	.4	
28	MATPS~~S~~ I	PROC	~~1.00~~	1.0	~~S~~ P	.	8602BA08	1	.	.1	G32	1	.	.1	
28	MATPS~~S~~ I	PROC	.	.	~~S~~ P	.		.	.	.	G33	1	.	.1	

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OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 6 OF ___

ITEM CD PCN 08006A WCD TA113H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~28~~	~~MATPSS~~	~~PROC~~	~~.~~	~~.~~	~~P~~	~~.~~	~~WG-8~~	~~1~~	~~.~~	~~[illegible]~~		.	.	.	
~~30~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
30	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.3		.	.	.	
~~35~~	~~MATPSS~~	~~MOVE~~	~~0.23~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~35~~	~~MATPSS~~	~~MOVE~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
35	MATPS~~S~~ I	MOVE	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.4		.	.	.	
~~40~~	~~MATPSS~~	~~PREP~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~40~~	~~MATPSS~~	~~PREP~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
40	MATPS~~S~~ I	PREP	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.8		.	.	.	

FLOW PROCESS CHART

SUBJECT F15 - JFS Disassembly DATE 5-22-89

ITEM CODE WCD TA 113 H WCD DATE 88065

PCN ■
NSN □
P/N □ 08006A

CHART BEGINS ____________________

CHART ENDS ____________________ PREPARED BY AP Holm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
1	2	●▷D□▽	Receive			○▷D□▽	
2	3	●▷D□▽	Prep			○▷D□▽	
3	8	●▷D□▽	Prep			○▷D□▽	
4	4	●▷D□▽	Prep			○▷D□▽	
5	5	○▷D■▽	INsp			○▷D□▽	
6	6	○▷D■▽	INsp			○▷D□▽	
10	10	●▷D□▽	Dis			○▷D□▽	
12	12	●▷D□▽	Dis			○▷D□▽	
14	14	●▷D□▽	Dis			○▷D□▽	
16	16	●▷D□▽	Dis			○▷D□▽	
18	18	●▷D□▽	Dis			○▷D□▽	
20	20	●▷D□▽	Dis			○▷D□▽	
22	22	●▷D□▽	Dis			○▷D□▽	
23	23	●▷D□▽	Dis			○▷D□▽	
24	24	●▷D□▽	Dis			○▷D□▽	
26	26	●▷D□▽	Dis			○▷D□▽	
28	28	○▶D□▽	Route			○▷D□▽	
30	30	●▷D□▽	Dis			○▷D□▽	
35	35	○▶D□▽	ROUTE			○▷D□▽	
40	40	○▶D□▽	ROUTE			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 J. S DISASSEMBLY
Gas Generator Module & Housing

BA ✓ F

8:18 TUESDAY, MARCH 28, 1989 193

OPERATION PROFILE

SAS

NAME Al Holm ALC SA ✓ DATE 4-14-89 RCC ~~MATPSS~~ MATPSI SHEET 1 OF ___

ITEM CD PCN 08006A~~SUB1~~ WCD TA108H WCDDATE 88065 ✓

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS
~~10~~	~~MATPSS~~	~~DIS~~	~~0.98~~	~~.~~	~~T~~	.		.	.	.		.	.	.
~~10~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.
10	~~MATPS$~~ MATPSI	DIS	.	1.5	P	.	8602BA08 ~~WG-9~~	1	.	0.2	G-12 ~~G-32~~	1	.	0.2
~~10~~	~~MATPSS~~	~~DIS~~			~~P~~	.		.	.	.	~~G-33~~	~~1~~	.	~~0.2~~
~~10~~	~~MATPSS~~	~~DIS~~			~~P~~						~~G-12~~	~~1~~		~~0.1~~
~~15~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.
15	MATPSS	DIS	.	.	S	.		.	.	.		.	.	.
15	~~MATPS$~~ MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	G-44 ~~G-32~~	1	.	0.1
~~15~~	~~MATPS$~~	~~DIS~~			~~P~~	.		.	.	.	~~G-33~~	~~1~~	.	~~0.1~~
15	MATPSS	DIS	.	.	P	.		.	.	.	G-44	1	.	0.0
~~20~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.
~~20~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.
20	~~MATPS$~~ MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.1	G-32	1	.	0.1

NOTES Juan Martinez 8602BC09
Joe Villarrell Supervisor

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSS SHEET 2 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
20	MATPSS	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~25~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
25	MATPSS	DIS	.	.	S	.		.	.	.		.	.	.	
25	MATPSS I	DIS	.	1.0	P	.	~~WG-0~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
25	MATPSS I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
25	MATPSS I	DIS	.	.	P	.		.	.	.	G-14	1	.	0.1	
30	MATPSS	DIS	1.00	.	T	.		.	.	.		.	.	.	
30	MATPSS	DIS	.	.	S	.		.	.	.		.	.	.	
30	MATPSS I	DIS	.	1.0	P	.	~~WG-0~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
30	MATPSS I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
30	MATPSS I	DIS	.	.	P	.		.	.	.	G-60	1	.	0.1	
~~35~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS$ I SHEET 3 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~35~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
35	MATPS$ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
35	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
35	MATPS$ I	DIS	.	.	P	.		.	.	.	G-30	1	.	0.2	
~~40~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~40~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
40	MATPS$ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
40	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
40	MATPS$ I	DIS	.	.	P	.		.	.	.	G-60	1	.	0.2	
~~45~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~45~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
45	MATPS$ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
45	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS$ I SHEET 4 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
45	MATPS$ I	DIS	.	.	P	.		.	.	.	G-40	1	.	0.1	
~~50~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~50~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
50	MATPS$ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
50	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
~~55~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~55~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
55	MATPS$ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
55	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~60~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~60~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
60	MATPS$ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS$ I SHEET 5 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
60	MATPS$ I	DIS	.	.	P	. .		.	.	.	G-33	1	.	0.1	
60	MATPS$ I	DIS	.	.	P	.		.	.	.	G-35	1	.	~~0.0~~ .1	
60	MATPS$ I	DIS	.	.	P	.		.	.	.	G-38	1	.	~~0.0~~ .1	
~~65~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~65~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
65	MATPS$ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
65	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
65	MATPSI	DIS			P					.	G23	1		.1	
65	MATPSI	DIS			P					.	G38	1		.1	
~~70~~	MATPSS	~~ASSY~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~70~~	~~MATPSS~~	~~ASSY~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
70	MATPS$ I	ASSY	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
70	MATPS$ I	ASSY	.	.	P	.		.	.	.	G-33	1	.	0.1	
70	MATPS$ I	ASSY	.	.	P	.		.	.	.	G-21	1	.	~~0.0~~ .1	
~~75~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

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OPERATION PROFILE

NAME ____________ ALC SA DATE ________ RCC MATPS~~$~~ I SHEET 6 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~75~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
75	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
75	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
75	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	G-24	1	.	~~0.0~~ .1	
80	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
80	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
80	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~85~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~85~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
85	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
85	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~G-02~~ G-33	1	.	~~0.0~~ .1	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS$ I SHEET 7 OF __

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
85	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33 G-25	1	.	0.1	
~~90~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~90~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
90	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.3	G-32	1	.	0.3	
90	MATPS$ I	DIS	.	.	P	.		.	.	.	G-22	1	.	0.2	
90	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~95~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~95~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
95	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	G-32	1	.	0.2	
95	MATPS$ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
~~100~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~100~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
100	MATPS$ I	DIS	.	.	P	.	8602BA08 ~~WG-9~~	1	.	0.1	G-32	1	.	0.1	

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8:18 TUESDAY, MARCH 28, 1989 200

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~$~~I SHEET 8 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
100	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	G-25	1	.	~~0.0~~ .1	
100	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~120~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~120~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
120	MATPS~~$~~I	DIS	.	.	P	.	~~WG-9~~ 8602BA08	1	.	0.1	G-32	1	.	0.1	
120	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.1	
~~125~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~125~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
125	MATPS~~$~~I	DIS	.	1,0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
125	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
125	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	G-27	1	.	~~0.0~~ .1	
125	MATPS~~$~~I	DIS	.	.	P	.		.	.	.	G-28	1	.	~~0.0~~ .1	
12[illegible]	MATPSI	DIS			P						G-54	1		0,1	Holder Diffuser [illegible] Fig 2-13 F per T WCD needs Rev

OPERATION PROFILE

SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 9 OF ___

ITEM CD PCN 08006ASUB1 WCD TA108H WCDDATE 88065

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
130	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~130~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
130	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8607BA38	1	.	0.2	G-34	1	.	~~0.0~~ .1	
140	~~MATPSI~~	~~MOVE~~	~~1.00~~		~~T~~	.		.	.	.		.	.	.	
140	~~MATPSI~~	~~MOVE~~			~~S~~	.		.	.	.		.	.	.	
140	MATPSI	MOVE	.	1.0	P	.	8607BA08	1	.	0.1		.	.	.	
145	~~MATPSS~~	~~PREP~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
145	~~MATPSS~~	~~PREP~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
145	MATPS~~S~~ I	PREP	.	1.0	P	.	~~WG-9~~ 8607BA08	1	.	0.3		.	.	.	

FLOW PROCESS CHART

SUBJECT F15-JFS DISCV Gas Generator Module DATE 5-22-89

ITEM CODE
PCN ■
NSN □
P/N □

03006A

WCD TA108H WCD DATE 88065

CHART BEGINS

CHART ENDS: PREPARED BY APHolm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●▷D□▽	D/S			○▷D□▽	
15	15	●▷D□▽	D/S			○▷D□▽	
20	20	●▷D□▽	D/S			○▷D□▽	
25	25	●▷D□▽	D/S			○▷D□▽	
30	30	●▷D□▽	D/S			○▷D□▽	
35	35	●▷D□▽	D/S			○▷D□▽	
40	40	●▷D□▽	D/S			○▷D□▽	
45	45	●▷D□▽	D/S			○▷D□▽	
50	50	●▷D□▽	D/S			○▷D□▽	
55	55	●▷D□▽	D/S			○▷D□▽	
60	60	●▷D□▽	D/S			○▷D□▽	
65	65	●▷D□▽	D/S			○▷D□▽	
70	70	●▷D□▽	ASSY			○▷D□▽	
75	75	●▷D□▽	D/S			○▷D□▽	
80	80	●▷D□▽	D/S			○▷D□▽	
85	85	●▷D□▽	D/S			○▷D□▽	
90	90	●▷D□▽	D/S			○▷D□▽	
95	95	●▷D□▽	D/S			○▷D□▽	
100	100	●▷D□▽	D/S			○▷D□▽	
120	120	●▷D□▽	D/S			○▷D□▽	
125	125	●▷D□▽	D/S			○▷D□▽	
130	130	●▷D□▽	D/S			○▷D□▽	
140	140	○▶D□▽	Route			○▷D□▽	
145	145	○▶D□▽	Route			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 JFS DISASSEMBLY
Power Turbine Module

BA.

OPERATION PROFILE SAS

NAME APHolm ALC SA DATE 4-14-89 RCC MATPS~~S~~ I SHEET 1 OF 4

ITEM CD PCN 08006A~~SUB8~~ WCD TA106H ✓ WCDDATE 88070 ✓

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~5~~	~~MATPSS~~	~~PREP~~	~~0.16~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~5~~	~~MATPSS~~	~~PREP~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
5	MATPS~~S~~ I	PREP	.	1.0	P	.	8602 BA08 ~~WG-9~~	1	.	~~0.0~~ .1	G-32	1	.	~~0.0~~ .1	
5	MATPS~~S~~ I	PREP	.	.	P	.		.	.	.	G-33	1	.	~~0.0~~ .1	
~~10~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~10~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
10	MATPS~~S~~ I	DIS	.	1.0	P	.	8602 BA08 ~~WG-9~~	1	.	~~0.0~~ .1	G-32	1	.	~~0.0~~ .1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	~~0.0~~ .1	
~~20~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
20	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	G-32	1	.	0.2	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
~~30~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

Juan Martinez
Mechanic
8602BC09
Joe Villarreal
Supervisor

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 2 OF ___

ITEM CD PCN 08006ASUB2 WCD TA106H WCDDATE 88070

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
30	MATPSI	DIS	.	1.0	P	.	8602BA08	1.	.	.3	G-18	1	.	.3	
30	MATPSI	DIS	.	.	P	.	~~WG-8~~	~~1~~	.	~~0.3~~	G-32	1	.	0.3	
30	MATPSI	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~40~~	~~MATPSS~~	~~DIS~~	~~1.00~~	.	~~T~~	.		.	.	.		.	.	.	
~~40~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
40	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	G-32	1	.	0.2	
40	MATPSI	DIS	.	.	P	.		.	.	.	G-19	1	.	0.1	
40	MATPSI	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
~~50~~	~~MATPSS~~	~~DIS~~	~~1.00~~	.	~~T~~	.		.	.	.		.	.	.	
~~50~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
50	MATPSS	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	G-32	1	.	0.3	
50	MATPSS	DIS	.	.	P	.		.	.	.	G-64	1	.	0.2	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 3 OF ___

ITEM CD PCN 08006ASUB2 WCD TA106H WCDDATE 88070 ✓

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
50	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~60~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~60~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
60	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.2	G-32	1	.	0.2	
60	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-15	1	.	0.1	
60	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-20	1	.	0.0	
60	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.2	
~~70~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~70~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
70	MATPS~~S~~ I	DIS	.	.	P	.	~~WG-8~~ 8602BA08	1	.	0.3	G-32	1	.	0.3	
70	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-16	1	.	0.1	
70	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.3	
~~80~~	~~MATPSS~~	~~DIS~~	~~1.00~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~I SHEET 4 OF ___

ITEM CD PCN 08006ASUB2 WCD TA106H WCDDATE 88070

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~80~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~G~~	.		.	.	.		.	.	.	
80	MATPS~~S~~I	DIS	.	1.6	P	.	~~WG-9~~ 8602BA08	1	.	0.4	G-32	1	.	0.4	
80	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	G-33	1	.	0.4	
~~85~~	~~MATPSS~~	~~PREP~~	~~0.32~~		~~P~~	.		.	.	.		.	.	.	
~~85~~	~~MATPSS~~	~~PREP~~	~~.~~	~~.~~	~~G~~	.		.	.	.			.	.	
85	MATPS~~S~~I	PREP	.	1.0	P	.	~~WG-9~~ 8662BA08	1	.	0.1	G-32	1	.	0.1	
85	MATPS~~S~~I	PREP	.	.	P	.		.	.	.	G-33	1	.	0.1	

FLOW PROCESS CHART

SUBJECT F15 JFS DISSY Power Turbine Module DATE 5-22-88

ITEM CODE
PCN ■
NSN ☐
P/N ☐

WCD TA106H WCD DATE 88070

08006A

CHART BEGINS

CHART ENDS

PREPARED BY APHolm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
5	5	●▷D□▽	Prep			○▷D□▽	
10	10	●▷D□▽	DIS			○▷D□▽	
20	20	●▷D□▽	DIS			○▷D□▽	
30	30	●▷D□▽	DIS			○▷D□▽	
40	40	●▷D□▽	DIS			○▷D□▽	
50	50	●▷D□▽	DIS			○▷D□▽	
60	60	●▷D□▽	DIS			○▷D□▽	
70	70	●▷D□▽	DIS			○▷D□▽	
80	80	●▷D□▽	DIS			○▷D□▽	
85	85	○▶D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

C 2 appy.

OPERATION PROFILE

NAME K. ATTARIA   ALC SA   DATE 5-10-89   RCC MATP~~S5~~ SI   SHEET 1 OF 10

ITEM CD PCN 08007A   WCD TA145R   WCDDATE 88244

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~5~~	~~MATPS9~~ I	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~5~~	~~MATPS9~~ I	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
5	MATPS~~9~~ I	INSP	.	1.0	P	.	~~WG-9~~ 8602BC05	1	.	~~0.1~~ 1.0	L-1	1	.	~~0.1~~ 1.0	
5	MATPSI	INSP			P						L-95	1		1.0	
5	MATPS~~8~~ I	INSP	.	.	P	.		.	.	.	L-2	1	.	~~0.1~~ 1.0	
~~10~~	~~MATPS9~~ I	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~10~~	~~MATPS9~~ I	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
10	MATPS~~9~~ I	DIS	.	1.0	P	2.0	~~WG-9~~ 8602BC5	1	.	~~4.0~~ 2.0	L-1	1	.	~~4.0~~ 2.0	
10	MATPSI	DIS			P						L-96	1		2.0	
10	MATPS~~8~~ I	DIS	.	.	P	.		.	.	.	L-2	1	.	~~4.0~~ 2.0	
10	MATPS~~9~~ I	DIS	.	.	P	.		.	.	.	L-3	1	.	0.1	
10	MATPS~~9~~ I	DIS	.	.	P	.		.	.	.	L-4	1	.	0.1	
10	MATPS~~9~~ I	DIS	.	.	P	.		.	.	.	L-5	1	.	0.1	
10	MATPS~~9~~ I	DIS	.	.	P	.		.	.	.	L-6	1	.	0.1	
10	MATPS~~9~~ I	DIS	.	.	P	.		.	.	.	L-7	1	.	0.1	

OPERATION PROFILE

NAME ____________ ALC SA DATE ________ RCC MATPSS SHEET 2 OF ___

ITEM CD PCN 08007A WCD TA145R WCDDATE 88244

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-8	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-9	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-10	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-11	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-12	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-13	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-14	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-15	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-16	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-17	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-18	1	.	0.1	
10	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	L-19	1	.	0.1	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSS SHEET 3 OF ___

ITEM CD PCN 08007A WCD TA145R WCDDATE 88244

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
10	MATPS~~S~~ I	DIS	.	.	P	.	~~WG 9~~	1	.	~~4.0~~	L-20	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-21	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-22	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-23	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-24	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-25	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-26	1	.	0.1	
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-27	1	.	0.1	
~~20~~	~~MATPSS~~ I	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSS~~ I	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
20	MATPS~~S~~ I	DIS	.	1.0	P	.	B602 BC05 ~~WG 9~~	1	.	1.0	L-1	1	.	1.0	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-2	1	.	1.0	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-28	1	.	0.2	

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPSS SHEET 4 OF ___

ITEM CD PCN 08007A WCD TA145R WCDDATE 88244

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-29	1	.	0.2	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-30	1	.	0.2	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-31	1	.	0.2	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-32	1	.	0.2	
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-33	1	.	0.2	
~~30~~	~~MATPSS~~ I	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSS~~ I	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG 9~~ 8602BC05	1	.	1.0	L-1	1	.	1.0	
30	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-2	1	.	1.0	
30	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-28	1	.	0.2	
30	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-29	1	.	0.2	
30	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-30	1	.	0.2	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSS SHEET 5 OF ___

ITEM CD PCN 08007A WCD TA145R WCDDATE 88244

7:?? 5'

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
30	MATPS$ I	DIS	.	.	P	.		.	.	.	L-31	1	.	0.2	
30	MATPS9 I	DIS	.	.	P	.	~~WG 9~~	~~1~~	.	~~1.0~~	L-32	1	.	0.2	
30	MATPS$ I	DIS	.	.	P	.		.	.	.	L-33	1	.	0.2	
~~40~~	~~MATPS$~~ I	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~40~~	~~MATPS9~~ I	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
40	MATPS$ I	DIS	.	1.0	P	.	8602BC05 ~~WG 9~~	1	.	1.0	L-1	1	.	1.0	
40	MATPS9 I	DIS	.	.	P	.		.	.	.	L-2	1	.	1.0	
40	MATPS$ I	DIS	.	.	P	.		.	.	.	L-34	1	.	0.2	
40	MATPS$ I	DIS	.	.	P	.		.	.	.	L-35	1	.	0.2	
40	MATPS$ I	DIS	.	.	P	.		.	.	.	L-36	1	.	0.2	
40	MATPS9 I	DIS	.	.	P	.		.	.	.	L-37	1	.	0.2	
40	MATPS9 I	DIS	.	.	P	.		.	.	.	L-38	1	.	0.2	
40	MATPS$ I	DIS	.	.	P	.		.	.	.	L-39	1	.	0.2	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSS SHEET 6 OF ___

ITEM CD PCN 08007A WCD TA145R WCDDATE 88244

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~45~~	~~MATPSS~~ I	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~45~~	~~MATPSS~~ I	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
45	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BC05	1	.	1.0	L-1	1	.	1.0	
45	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-2	1	.	1.0	
45	MATPS~~S~~ I	DIS	.	.	P	.	~~WG-9~~	1	.	~~1.0~~	L-10	1	.	0.3	
45	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	L-40	1	.	0.3	
45	MATPS~~S~~ I	DIS	.	.	P	.	~~WG-9~~	1	.	~~1.0~~	L-41	1	.	0.3	
50	MATPS~~S~~ I	~~DIS~~ MOVE	.	1.0	T	.	8602BC05	1	.	1.0		.	.	.	
~~50~~	~~MATPSS~~ I	DIS	.	.	~~S~~	.		.	.	.		.	.	.	
~~50~~	~~MATPSS~~ I	~~DIS~~	.	.	~~P~~	.	~~WG-9~~	~~1~~	.	~~1.0~~		.	.	.	

FLOW PROCESS CHART

SUBJECT CENTRAL GEAR BOX DISASSEMBLY DATE 5/22/89

ITEM CODE
PCN ☒ 08007A
NSN ☐
P/N ☐

WCD TA145R WCD DATE 88244

CHART BEGINS OPERATION 005 CENTRAL GEAR BOX INSPECTION

CHART ENDS OPERATION 050 ROUTE PARTS PREPARED BY KA

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
5	005	○ ▷ D □ ▽	VISUAL: INSP.			○ ▷ D □ ▽	
10	010	○ ▷ D □ ▽	DISASEMBLE			○ ▷ D □ ▽	
20	020	○ ▷ D □ ▽	〃			○ ▷ D □ ▽	
30	030	○ ▷ D □ ▽	〃			○ ▷ D □ ▽	
40	040	○ ▷ D □ ▽	〃			○ ▷ D □ ▽	
45	045	○ ▷ D □ ▽	〃			○ ▷ D □ ▽	
50	050	○ ▷ D □ ▽	ROUTE PARTS			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

ATS 100-87

9.20149
[illegible]

OPERATION PROFILE SAS

NAME K. Attavia ALC SA DATE 5-15-89 RCC MATPSI SHEET 1 OF 3

ITEM CD PCN 10598A WCD TA079A WCDDATE 88245

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	Q.Y	%	HRS	NOTES
~~5~~	~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	EVELYN HALL
5	MATPSI	DIS	.	1.0	S	.	8602BA08	1	.	0.2		.	.	.	925-5330
~~5~~	~~MATPSI~~	~~DIS~~	.	.	~~P~~	.	~~WG-9~~	~~1~~	.	~~0.3~~		.	.	.	FORMAN ALTERNATE
~~10~~	~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~10~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
10	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.6 ~~0.5~~		.	.	.	
~~20~~	~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
20	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	1.0	AB-8	1	.	0.1	
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-9	1	.	0.1	
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-10	1	.	0.1	
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-11	1	.	0.1	
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-12	1	.	0.1	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPSI SHEET 2 OF ___

ITEM CD PCN 10598A WCD TA079A WCDDATE 88245

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-13	1	.	0.1	
~~30~~	~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG 9~~	1	.	0.5		.	.	.	
~~35~~	~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~35~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
35	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG 9~~	1	.	0.5		.	.	.	
38	MATSS ~~MATPSI~~	MOVE ~~DIS~~	.	.	T	.	8602BA05	1	.	0.2		.	.	.	Route
~~38~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
~~38~~	~~MATPSI~~	~~DIS~~	.	.	~~P~~	.	~~WG 9~~	~~1~~	.	~~0.4~~		.	.	.	
40	MATSS ~~MATPSI~~	DIS	.	.	T	.	8602BA05	1	.	1.0		.	.	.	sort and Route parts to cleaning
~~40~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSI SHEET 3 OF ___

ITEM CD PCN 10598A WCD TA079A WCDDATE 88245

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~40~~	~~MATPSI~~	~~DIS~~	.	.	~~P~~	.	~~WG-8~~	~~1~~	.	~~1.0~~		.	.	.	

FLOW PROCESS CHART

SUBJECT ATSC 100-87 STARTER DISASSEMBLY DATE 5/24/89

ITEM CODE
PCN ☒ 10598A
NSN ☐
P/N ☐

WCD TA079A WCD DATE 88245

CHART BEGINS OPERATION 5

CHART ENDS OPERATION 40 PREPARED BY K Attari

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
5	5	●▷D□▽	SET UP			○▷D□▽	
10	10	●▷D□▽	DISASSEMBLY			○▷D□▽	
20	20	●▷D□▽	"			○▷D□▽	
30	30	●▷D□▽	"			○▷D□▽	
35	35	●▷D□▽	"			○▷D□▽	
38	38	○▶D□▽	MOVE B/S			○▷D□▽	
40	40	○▶D□▽	MOVE B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

ATS('00-97-97A

disassy

OPERATION PROFILE

NAME KAttaria ALC SA DATE 5-15-89 RCC MATPSI SHEET 1 OF 3

ITEM CD PCN 10718A WCD TA042T WCDDATE 88232

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~5~~	~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	EVELYN HALL
5	MATPSI	DIS	.	1.0	S	.	8602BA08	1	.	.02		.	.	.	925-5330
~~5~~	~~MATPSI~~	~~DIS~~	.	.	~~P~~	.	~~WG-8~~	~~1~~	.	~~0.1~~		.	.	.	FORMAN ALTERNATE
~~10~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~10~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
10	MATPSI	DIS	.	.	P	.	8602BA08 ~~WG-8~~	1	.	0.3	AB-9	1	.	0.3	
10	MATPSI	DIS	.	.	P	.		.	.	.	AB-17	1	.	0.3	
10	MATPSI	DIS	.	.	P	.		.	.	.	AB-18	1	.	0.3	
~~20~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
20	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.8	AB-14	1	.	0.8	
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-8	1	.	0.4	
20	MATPSI	DIS	.	.	P	.		.	.	.	AB-15	1	.	0.4	

SAS

OPERATION PROFILE

8:51 TUESDAY, MARCH 28, 1989 8

NAME ______ ALC SA DATE ______ RCC MATPSI SHEET 2 OF ___

ITEM CD PCN 10718A WCD TA042T WCDCATE 88232

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~30~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.3	AB-14	1	.	0.3	
30	MATPSI	DIS	.	.	P	.		.	.	.	AB-15	1	.	0.3	
30	MATPSI	DIS	.	.	P	.		.	.	.	~~AB-10~~	~~1~~	.	~~0.3~~	
~~40~~	~~MATPSI~~	~~DIS~~	0.98	.	~~T~~	.		.	.	.		.	.	.	
~~40~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
40	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.9 ~~0.7~~	.	.	.	.	
~~50~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~50~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
50	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.8	.	.	.	.	
~~55~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPSI SHEET 3 OF __

ITEM CD PCN 10718A WCD TA042T WCDDATE 88232

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~55~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
55	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2		.	.	.	
~~60~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~60~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
60	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.4 ~~0.3~~		.	.	.	
~~70~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~70~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
70	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2		.	.	.	
~~80~~	~~MATPSI~~	~~DIS~~	1.00	.	~~T~~	.		.	.	.		.	.	.	
~~80~~	~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
80	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.9 ~~0.2~~		.	.	.	
90	MATPSI	DIS		1.0	T		8602BA08	1		0.5		.		.	sort & Route parts to cleaning.

FLOW PROCESS CHART

SUBJECT ATSC 100-97-97A STARTER DISASSEMBLY DATE 5/24/89

ITEM CODE
PCN ☒ 10718A
NSN ☐
P/N ☐

WCD TA042T WCD DATE 88232

CHART BEGINS OPERATION 005

CHART ENDS OPERATION 090 PREPARED BY K. ATTARIA

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
5	5	●▷D□▽	SET UP			○▷D□▽	
10	10	●▷D□▽	DISASSEMBLY			○▷D□▽	
20	20	●▷D□▽	//			○▷D□▽	
30	30	●▷D□▽	//			○▷D□▽	
40	40	●▷D□▽	//			○▷D□▽	
50	50	●▷D□▽	//			○▷D□▽	
60	60	●▷D□▽	//			○▷D□▽	
70	70	●▷D□▽	//			○▷D□▽	
80	80	●▷D□▽	TAG PARTS			○▷D□▽	
90	—	○▶D□▽	SORT / ROUTE			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

ADG DIS ASSY (ACCESSORY DRIVE GEARBOX)

OPERATION PROFILE SAS

NAME BILL MORGAN ALC SA DATE 4-17-89 RCC ~~MATPSS~~ MATPSI SHEET 1 OF 30

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
10	~~MATPSS~~ MATPSI	DIS	.	1.0	T	.	8602BA08	1	.	.1		.	.	.	
10	~~MATPSS~~ MATPSI	DIS	.	1.0	S	.	8602BA08	1	.	.2		.	.	.	
10	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	~~2.8~~ 2.5	J-39	1	.	~~2.8~~ 2.5	
10	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	2.3	
~~20~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~20~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
20	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.3	J-23	1	.	0.3	
20	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	
~~30~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
30	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.2	J-23	1	.	0.2	
30	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
~~40~~	~~MATPSS~~ MATPSI	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

SAS

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 2 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~40~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
40	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-23	1	.	0.3	
40	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	
~~50~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~50~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
50	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	J-23	1	.	0.1	
50	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.1	
~~60~~	~~MATPSS~~ ~~MATPSI~~	DIS	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~60~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
60	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-23	1	.	0.2	
60	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
~~70~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ____________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 3 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~70~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
70	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-23	1	.	0.3	
70	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	
70	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-1	1	.	0.3	
~~80~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~80~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
80	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.1	J-39	1	.	0.1	
80	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.1	
~~90~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~90~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
90	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.8	J-39	1	.	0.8	
90	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.8	
90	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-43	1	.	0.8	

OPERATION PROFILE SAS

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 4 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~100~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~100~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
100	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.5	J-23	1	.	0.5	
100	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.5	
100	MATPSS MATPSI	DIS	.	.	P	.		.	.	.	J-42	1	.	0.5	
~~110~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	T	.		.	.	.		.	.	.	
~~110~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
110	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-44	1	.	0.2	
110	MATPSS MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
110	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
110	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-45	1	.	0.2	
~~120~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

8:18 TUESDAY, MARCH 28, 1989 348

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 6 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~120~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	. .		.	.	.		.	.	.	
120	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BAC8	1	.	0.2	J-39	1	.	0.2	
120	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~125~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~125~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
125	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BAO8	1	.	0.2	J-39	1	.	0.2	
125	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~130~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
130	~~MATPSS~~ ~~MATPSI~~	DIS	~~.~~	~~.~~	S	.		.	.	.		.	.	.	
130	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BAO8	1	.	0.3	J-39	1	.	0.3	
130	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
130	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-46	1	.	0.3	
~~135~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 6 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~135~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
135	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
135	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~140~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~140~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
140	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
140	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~150~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	.	~~T~~	.		.	.	.		.	.	.	
~~150~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
150	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
150	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
150	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-46	1	.	0.3	

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 7 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~155~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~155~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
155	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
155	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~160~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~160~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
160	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.5	J-39	1	.	0.5	
160	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.		J-23	1	.	0.5	
~~165~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~165~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
165	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
165	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.		J-23	1	.	0.2	
~~170~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 4 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~170~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
170	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-5~~ 8602BA08	1	.	0.1	J-39	1	.	0.1	
170	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.1	
~~180~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~180~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
180	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-5~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
180	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~190~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~190~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
190	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-5~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
190	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~195~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

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OPERATION PROFILE

NAME ______________ ALC SA DATE ________ RCC MATPS~~V~~ I SHEET 9 OF __

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~195~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
195	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
195	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~200~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~200~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
200	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
200	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
200	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	~~J-23~~ J-34	1	.	0.3	
~~205~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~205~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
205	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
205	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~210~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~		~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPSI SHEET 10 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~210~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
210	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	J-39	1	.	0.3	
210	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
210	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-33	1	.	0.3	
~~215~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~215~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
215	~~MATPSS~~ MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	J-39	1	.	0.2	
215	~~MATPSS~~ MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~220~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~220~~	~~MATPSS~~ ~~MATPSI~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
220	MATPSS MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	J-23	1	.	0.3	
220	MATPSS MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	

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OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC ~~MATPSS~~ MATPS I SHEET 11 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~225~~	~~MATPSS~~ ~~MATPS I~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~225~~	~~MATPSS~~ ~~MATPS I~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
225	~~MATPSS~~ MATPS I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	J-23	1	.	0.2	
225	MATPSS MATPS I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
~~230~~	~~MATPSS~~ ~~MATPS I~~	~~DIS~~	.	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~230~~	~~MATPSS~~ MATPS I	~~DIS~~	.	~~.~~	~~S~~	.		.	.	.		.	.	.	
230	MATPS I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	J-23	1	.	0.3	
230	MATPS I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	
~~235~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~235~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
235	MATPS I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	J-23	1	.	0.2	
235	MATPS I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
~~240~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~I SHEET 12 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~240~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
240	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.1	J-23	1	.	0.1	
240	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.1	
~~250~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~250~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
250	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.3	J-2	1	.	0.3	
250	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	
250	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	J-18	1	.	0.3	
250	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~270~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~270~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
270	MATPS~~S~~I	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	

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OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPSI SHEET 13 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
270	MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~280~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~280~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
280	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2	J-39	1	.	0.2	
280	MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~290~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~290~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
290	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2	J-39	1	.	0.2	
290	MATPSI	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~295~~	~~MATPSS~~	~~DIS~~	.	.	T	.		.	.	.		.	.	.	
~~295~~	~~MATPSS~~	~~DIS~~	.	.	S	.		.	.	.		.	.	.	
295	MATPSI	DIS	.	1.0	P	.	8602BA08 ~~WG-8~~	1	.	0.2	J-23	1	.	0.2	
295	MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	

SAS

OPERATION PROFILE

8:18 TUESDAY, MARCH 28, 1989 357

NAME ____________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 14 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~300~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~300~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
300	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
300	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~305~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~305~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
305	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
305	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~310~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~310~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
310	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-0~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
310	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	

OPERATION PROFILE SAS

NAME ____________ ALC SA DATE ________ RCC MATPSS I SHEET 15 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~320~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~320~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
320	MATPSS I	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
320	MATPSS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~330~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~330~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
330	MATPSS I	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
330	MATPSS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~335~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	
~~335~~	~~MATPSS~~	~~DIS~~	.	.	~~S~~	.		.	.	.		.	.	.	
335	MATPSS I	DIS	.	1.0	P	.	~~WG 9~~ 8602BA08	1	.	0.5	J-39	1	.	0.5	
335	MATPSS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	
~~340~~	~~MATPSS~~	~~DIS~~	.	.	~~T~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 16 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~340~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
340	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-S~~ 8602BA08	1	.	0.2	J-23	1	.	0.2	
340	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~350~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
350	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-S~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
350	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-27	1	.	0.2	
350	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~370~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~370~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
370	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG-S~~ 8602BA08	1	.	0.2	J-39	1	.	0.2	
370	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	

OPERATION PROFILE SAS

8:18 TUESDAY, MARCH 28, 1989 360

NAME ______ ALC SA DATE ______ RCC MATPS$ I SHEET 17 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~380~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~380~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
380	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	J-39	1	.	0.2	
380	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~390~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~390~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
390	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	J-39	1	.	0.3	
390	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~400~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~400~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
400	MATPS$ I	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	J-23	1	.	0.2	
400	MATPS$ I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.2	
~~410~~	~~MATPS$~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~$~~I SHEET 18 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~410~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
410	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
410	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-31	1	.	0.3	
410	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~420~~	~~MATPSS~~ *	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~420~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
420	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
420	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~J-1~~ J-31	1	.	0.3	
420	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~430~~	~~MATPSS~~ *	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~430~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
430	MATPS~~$~~ I	DIS	.	1.0	P	.	~~WG-9~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 19 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
430	MATPSS	DIS	.	.	P	.		.	.	.	J-47	1	.	0.3	
430	MATPSS	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~440~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~440~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
440	MATPSS	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.2	J-39	1	.	0.2	
440	MATPSS	DIS	.	.	P	.		.	.	.	J-23	1	.	0.2	
~~450~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~450~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
450	MATPSS	DIS	.	1.0	P	.	8602BA08 ~~WG-9~~	1	.	0.3	J-39	1	.	0.3	
450	MATPSS	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
450	MATPSS	DIS	.	.	P	.		.	.	.	J-48 ~~J-23~~	1	.	0.3	
~~460~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~460~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS$ I SHEET 20 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAN OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
460	MATPS$ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	J-~~28~~ 39	1	.	0.3	
460	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~470~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~470~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
470	MATPS$ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
470	MATPS$ I	DIS	.	.	P	.		.	.	.	J-27	1	.	0.3	
470	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~480~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~480~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
480	MATPS$ I	DIS	.	1.0	P	.	~~WG-8~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
480	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~490~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 21 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~490~~	~~MATPSS~~	~~DIS~~			~~S~~	..		.	.	.		.	.	.	
490	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG 5~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
490	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-28	1	.	0.3	
490	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~500~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~500~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
500	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG 0~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
500	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-30	1	.	0.3	
500	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~510~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~510~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
510	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG 0~~ 8602BA08	1	.	0.3	J-39	1	.	0.3	
510	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-26	1	.	0.3	

OPERATION PROFILE SAS

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NAME ______ ALC SA DATE ______ RCC MATPS$ I SHEET 22 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
510	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~520~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~520~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
520	MATPS$ I	DIS	.	1.0	P	.	8602BA08	1	.	0.8	J-39	1	.	0.8	
520	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.8	
~~530~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~530~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
530	MATPS$ I	DIS	.	1.0	P	.	8602BA08	1	.	3.5	J-39	1	.	3.5	
530	MATPS$ I	DIS	.	.	P	.		.	.	.	J-23	1	.	3.5	
530	MATPS$ I	DIS	.	.	P	.		.	.	.	J-32	1	.	0.5	
530	MATPS$ I	DIS	.	.	P	.		.	.	.	J-35	1	.	0.5	
530	MATPS$ I	DIS	.	.	P	.		.	.	.	J-36	1	.	0.5	

SAS

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~$~~ I SHEET 23 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-38	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-1	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-16	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-25	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-10	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-21	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-24	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-29	1	.	0.5	
530	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-49	1	.	0.5	
~~535~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~535~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
535	MATPS~~$~~ I	DIS	.	1.0	P	.	8602BA08	1	.	0.3		.	.	.	
~~540~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	

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OPERATION PROFILE

NAME ____________ ALC SA DATE ________ RCC MATPSI SHEET 29 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~540~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
540	MATPSI	DIS	.	1.0	P	.	8602BA08	1	.	3.5	J-23	1	.	3.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-39	1	.	3.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-56	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-7	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-8	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-17	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-9	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-22	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-25	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-40	1	.	0.5	
540	MATPSI	DIS	.	.	P	.		.	.	.	J-41	1	.	0.5	

SAS

OPERATION PROFILE

8:18 TUESDAY, MARCH 28, 1989 368

NAME ________ ALC SA DATE ________ RCC MATPS~~S~~ I SHEET 25 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
~~550~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~550~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
550	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG 3~~ 8602BA09	1	.	0.3	J-39	1	.	0.3	
550	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-4	1	.	0.3	
											J-40	1		0.3	
550	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
~~560~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~560~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
560	MATPS~~S~~ I	DIS	.	1.0	P	.	~~WG 3~~ 8602BA09	1	.	~~0.3~~ 0.8	J-37	1	.	0.3	
560	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-39	1	.	0.3	
560	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-15	1	.	0.3	
560	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.3	
560	MATPSI	DIS		.	P						X-2	1	.	0.5	
~~570~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~570~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	

OPERATION PROFILE SAS

NAME ________ ALC SA DATE ________ RCC MATPS I SHEET 26 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
570	MATPS I	DIS	.	1.0	P	.	8602BA08	1	.	1.0 ~~0.5~~	J-39	1	.	0.5	
570	MATPS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	
570	MATPS I	DIS	.	.	P	.		.	.	.	J-13	1	.	0.5	
570	MATPS I	DIS	.	.	P	.		.	.	.	J-19	1	.	0.5	
570	MATPS I	DIS	.	.	P	.		.	.	.	J-37	1	.	0.5	
570	MATPS I	DIS	.	.	P	.		.	.	.	J-40	1	.	0.5	
570	MATPS I	DIS	.	.	P	.		.	.	.	J-50	1	.	0.5	
570	MATPSI	DIS			P						X-2	1	.	0.5	
~~580~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~580~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
580	MATPS I	DIS	.	1.0	P	.	8602BA08	1	.	0.5	J-39	1	.	0.5	
580	MATPS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	
580	MATPS I	DIS	.	.	P	.		.	.	.	J-4	1	.	0.5	

SAS

OPERATION PROFILE

NAME ______ ALC SA DATE ______ RCC MATPSS SHEET 27 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
580	MATPSS I	DIS	.	.	P	.		.	.	.	J-40	1	.	0.5	
580	MATPSS I	DIS	.	.	P	.		.	.	.	J-51	1	.	0.5	
~~590~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~590~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
590	MATPSS I	DIS	.	1.0	P	.	8662BA08	1	.	0.5	J-39	1	.	0.5	
590	MATPSS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	
590	MATPSS I	DIS	.	.	P	.		.	.	.	J-3	1	.	0.5	
590	MATPSS I	DIS	.	.	P	.		.	.	.	J-40	1	.	0.5	
590	MATPSS I	DIS	.	.	P	.		.	.	.	J-54	1	.	0.5	
~~600~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~I~~	.		.	.	.		.	.	.	
~~600~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
600	MATPSS I	DIS	.	1.0	P	.	8602BA08	1	.	0.5	J-39	1	.	0.5	
600	MATPSS I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS~~$~~ I SHEET 28 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
600	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~J-1~~ J-53	1	.	0.5	
600	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~J-2~~ J-40	1	.	0.5	
600	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-12	1	.	0.5	
600	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-14	1	.	0.5	
610	~~MATPSS~~	DIS	.	.	T	.		.	.	.		.	.	.	
610	MATPSS	DIS	.	.	S	.		.	.	.		.	.	.	
610	MATPS~~$~~ I	DIS	.	1.0	P	.	~~W0~~ 8602BA08	1	.	0.8	J-39	1	.	0.8	
610	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.8	
610	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	~~J-2~~ J-40	1	.	0.8	
610	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-5	1	.	0.8	
610	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-22	1	.	0.8	
610	MATPS~~$~~ I	DIS	.	.	P	.		.	.	.	J-37	1	.	0.8	

OPERATION PROFIL.. SAS 8:18 TUESDAY, MARCH 28, 1989 372

NAME ________ ALC SA DATE ______ RCC MATPS~~S~~ I SHEET 29 OF __

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
610	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-52	1	.	0.8	
610	MATPSI	DIS			P						X-2	1		0.5	
~~620~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	
~~620~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
620	MATPSS	DIS	.	1.0	P	.	8602BA08 ~~W0-05~~	1	.	1.0 ~~0.5~~	J-39	1	.	0.5	
620	MATPSS	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	
?0	MATPSS	DIS	.	.	P	.		.	.	.	J-55	1	.	0.5	
0	MATPSS	DIS			P						X-2	1		0.5	
~~630~~	~~MATPSS~~	~~DIS~~			~~T~~	.		.	.	.		.	.	.	
~~630~~	~~MATPSS~~	~~DIS~~			~~S~~	.		.	.	.		.	.	.	
630	MATPS~~S~~ I	DIS	.	1.0	P	.	8602BA08 ~~W0-0~~	1	.	2.0	J-39	1	.	0.5	
630	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-23	1	.	0.5	
630	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-6	1	.	0.5	
630	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-20	1	.	0.5	
630	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	J-40	1	.	0.5	

OPERATION PROFILE

NAME ________ ALC SA DATE ________ RCC MATPS$ I SHEET 30 OF ___

ITEM CD PCN 12712A WCD TA998L WCDDATE 88124

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
630	MATPS$ I	DIS	.	.	P	.		.	.	.	J-21	1	.	0.5	
630	MATPS$ I	DIS	.	.	P	.		.	.	.	J-11	1	.	0.5	

FLOW PROCESS CHART

SUBJECT F16 ADG DISASSEMBLY DATE 5-23-89

ITEM CODE
PCN ■
NSN □
P/N □

127/2A

WCD TA998L WCD DATE 88124

CHART BEGINS 10

CHART ENDS 1030

PREPARED BY A P Holm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◁D□▽	DIS	240	240	●◁D□▽	DIS
20	20	●◁D□▽	DIS	250	250	●◁D□▽	DIS
30	30	●◁D□▽	DIS	270	270	●◁D□▽	DIS
40	40	●◁D□▽	DIS	280	280	●◁D□▽	DIS
50	50	●◁D□▽	DIS	290	290	●◁D□▽	DIS
60	60	●◁D□▽	DIS	300	300	●◁D□▽	DIS
70	70	●◁D□▽	DIS	305	305	●◁D□▽	DIS
80	80	●◁D□▽	DIS	310	310	●◁D□▽	DIS
90	90	●◁D□▽	DIS	320	320	●◁D□▽	DIS
100	100	●◁D□▽	DIS	330	330	●◁D□▽	DIS
110	110	●◁D□▽	DIS	335	335	●◁D□▽	DIS
120	120	●◁D□▽	DIS	340	340	●◁D□▽	DIS
125	125	●◁D□▽	DIS	350	350	●◁D□▽	DIS
130	130	●◁D□▽	DIS	370	370	●◁D□▽	DIS
135	135	●◁D□▽	DIS	380	380	●◁D□▽	DIS
140	140	●◁D□▽	DIS	390	390	●◁D□▽	DIS
150	150	●◁D□▽	DIS	400	400	●◁D□▽	DIS
155	155	●◁D□▽	DIS	410	410	●◁D□▽	DIS
160	160	●◁D□▽	DIS	420	420	●◁D□▽	DIS
165	165	●◁D□▽	DIS	430	430	●◁D□▽	DIS
170	170	●◁D□▽	DIS	440	440	●◁D□▽	DIS
180	180	●◁D□▽	DIS	450	450	●◁D□▽	DIS
190	190	●◁D□▽	DIS	460	460	●◁D□▽	DIS
195	195	●◁D□▽	DIS	470	470	●◁D□▽	DIS
200	200	●◁D□▽	DIS	480	480	●◁D□▽	DIS
205	205	●◁D□▽	DIS	490	490	●◁D□▽	DIS
210	210	●◁D□▽	DIS	500	500	●◁D□▽	DIS
215	215	●◁D□▽	DIS	510	510	●◁D□▽	DIS
220	220	●◁D□▽	DIS	520	520	●◁D□▽	DIS
225	225	●◁D□▽	DIS	530	530	●◁D□▽	DIS
230	230	●◁D□▽	DIS	540	540	●◁D□▽	DIS
235	235	●◁D□▽	DIS	550	550	●◁D□▽	DIS

○ OPERATION ▽ STORAGE □ INSPECTION

◁ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT F16 ADG DISASSEMBLY DATE 5-23-89

ITEM CODE
PCN ■
NSN □
P/N □
12712A

WCD TA998L WCD DATE 88124

CHART BEGINS 10

CHART ENDS 630 PREPARED BY AP Holm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
560	560	●▷D□▽	DIS			○▷D□▽	
570	570	●▷D□▽	DIS			○▷D□▽	
580	580	●▷D□▽	DIS			○▷D□▽	
590	590	●▷D□▽	DIS			○▷D□▽	
600	600	●▷D□▽	DIS			○▷D□▽	
610	610	●▷D□▽	DIS			○▷D□▽	
620	620	●▷D□▽	DIS			○▷D□▽	
623	630	●▷D□▽	DIS			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FIG-: =S -DISASSEMBLY

OPERATION PROFILE SAS

NAME AP Holm ALC SA DATE 4-18-89 RCC ~~MATPSS~~ MATPSI SHEET 1 OF 2

ITEM CD PCN 13096A WCD TA030Q ✓ WCDDATE 86343 ✓

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS
10	MATPS~~S~~ I	DIS	.	1	T	. .	8602BC09	1	.	.1		.	.	.
~~10~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.
10	MATPS~~S~~ I	DIS	.	1	P	.	~~WG-S~~ 8602BC09	1	.	2.0	M-12	1	.	0.3
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-1	1	.	0.3
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-2	1	.	0.3
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-3	1	.	2.0
10	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-11	1	.	2.0
~~20~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.
~~20~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.
20	MATPS~~S~~ I	DIS	.	1	P	.	~~WG-S~~ 8602BC09	1	.	1.0	M-4	1	.	0.1
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-5	1	.	0.1
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-6	1	.	0.1
20	MATPS~~S~~ I	DIS	.	.	P	.		.	.	.	M-3	1	.	1.0

NOTES

T.O. 2JA3-57-
"Marty" Mech
Juan Martinez

Replaced
By WCD
TA129U
Date 89

OPERATION PROFILE

SAS

NAME APH

ALC SA

DATE 4-18-89

RCC ~~MATPSS~~ MATRSI

ITEM CD PCN 13096A

WCD TA030Q ✓ WCDDATE 86343 ✓

OPER NUMB	RCC	OPER DESC	HIST OCCR	MAND OCCR	OPER TYPE	MAND F HRS	SKILL CD/LVL	QTY	%	HRS	EQUIP CODE	QTY	%	HRS	NOTES
20	MATPSI	DIS			P						X-8	1		1.0	
20	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	M-11	1	.	1.0	
~~30~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~T~~	.		.	.	.		.	.	.	
~~30~~	~~MATPSS~~ I	~~DIS~~	~~.~~	~~.~~	~~S~~	.		.	.	.		.	.	.	
30	MATPS~~S~~I	DIS	.	1	P	.	~~WG-9~~ 8602B609	1	.	2.0	M-7	1	.	0.1	
30	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	M-8	1	.	1.0	
30	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	M-9	1	.	0.5	
30	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	M-10	1	.	0.2	
~~30~~	~~MATPSS~~	~~DIS~~	~~.~~	~~.~~	~~P~~	.		.	.	.	~~M-11~~	~~1~~	.	~~2.0~~	
30	MATPS~~S~~I	DIS	.	.	P	.		.	.	.	M-3	1	.	2.0	
30	MATPSI	DIS			P						X-2	1		2.0	
30	MATPSI	DIS			P						X-8	1		2.0	

FLOW PROCESS CHART

SUBJECT F16 - JFS DISASSEMBLY DATE 5-23-89

ITEM CODE
PCN ●
NSN ☐
P/N ☐

WCD TA030Q WCD DATE 86343

13096A

CHART BEGINS 10

CHART ENDS 30 PREPARED BY DP Holm

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●▷D☐▽	DIS			○▷D☐▽	
20	20	●▷D☐▽	DIS			○▷D☐▽	
30	30	●▷D☐▽	DIS			○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
		○▷D☐▽				○▷D☐▽	

○ OPERATION ▽ STORAGE ☐ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Starter C4542A

FLOW PROCESS CHART

SUBJECT Turbine Housing Assy DATE 6/1/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
4542A

WCD CTA 2150 WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

Startpt 04542A

FLOW PROCESS CHART

SUBJECT Turbine Housing Assy DATE 6/3/99

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

04542A

WCD TA3150 WCD DATE 88340

CHART BEGINS 001

CHART ENDS 195 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
001	001	●▷D□▽	Info			○▷D□▽	
005	005	○▷D■▽	Insp FPI			○▷D□▽	
007	007	●▷D□▽	Tag Part			○▷D□▽	
010	010	○▷D■▽	Insp V/S			○▷D□▽	
015	015	○▷D■▽	Insp DIM			○▷D□▽	
020	020	●▷D□▽	Deburr			○▷D□▽	
030	030	○▶D□▽	Route - B/S			○▷D□▽	
	031	○▶D□▽	B/S			○▷D□▽	
	032	○▶D□▽				○▷D□▽	
	033	●▷D□▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	065	○▷D■▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	071	●▷D□▽				○▷D□▽	
	073	●▷D□▽				○▷D□▽	
	075	○▷D■▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	095	●▷D□▽				○▷D□▽	
	096	●▷D□▽				○▷D□▽	
	140	●▷D□▽				○▷D□▽	
	150	●▷D□▽				○▷D□▽	
	170	○▷D■▽				○▷D□▽	
	180	●▷D□▽				○▷D□▽	
	185	○▶D□▽				○▷D□▽	
	186	○▶D□▽				○▷D□▽	
	190	●▷D□▽				○▷D□▽	
	192	●▷D□▽				○▷D□▽	
030	195	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

STerTyy 04542A

FLOW PROCESS CHART CLEANING

SUBJECT Gear MOUNTING SUB ASSY DATE 6/1/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐ 4542A

WCD CTH2180 WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷D□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Stator 04542A

FLOW PROCESS CHART Inspection

SUBJECT Gear Housing Subassembly DATE 6/3/59

ITEM CODE ✓ WCD TA 2180 WCD DATE 89040

- PCN ☑
- NSN ☐ 04542A
- P/N ☐

CHART BEGINS 005

CHART ENDS 998 PREPARED BY J Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	.005	●▷D□▽				○▷D□▽	
010	010	○▷D■▽	Insp VIS			○▷D□▽	
020	020	○▷D■▽	Insp DIM			○▷D□▽	
025	025	●▷D□▽	Deburr			○▷D□▽	
030	030	○▶D□▽	Route - B/S			○▷D□▽	
	031	○▶D□▽				○▷D□▽	
	032	●▷D□▽				○▷D□▽	
	033	○▶D□▽				○▷D□▽	
	040	○▶D□▽				○▷D□▽	
	041	○▶D□▽				○▷D□▽	
	045	○▷D■▽				○▷D□▽	
	046	○▷D■▽				○▷D□▽	
	050	●▷D□▽				○▷D□▽	
	051	●▷D□▽				○▷D□▽	
	052	●▷D□▽				○▷D□▽	
	053	●▷D□▽				○▷D□▽	
	055	○▷D■▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	061	●▷D□▽				○▷D□▽	
	062	●▷D□▽				○▷D□▽	
	065	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	075	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	081	○▷D■▽				○▷D□▽	
	082	●▷D□▽				○▷D□▽	
	090	○▶D□▽				○▷D□▽	
	091	○▶D□▽				○▷D□▽	
	100	●▷D□▽				○▷D□▽	
	105	●▷D□▽				○▷D□▽	
	110	●▷D□▽				○▷D□▽	
030	998	○▶D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Starter 4542 A

FLOW PROCESS CHART Cleaning

SUBJECT Exhaust Hsg DATE 6/1/89

WCD CTH2300 WCD DATE 89152

ITEM CODE
PCN ☑ 4542A
NSN ☐
P/N ☐

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Wash			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

Starter 04542A

FLOW PROCESS CHART Inspection

SUBJECT Exhaust Housing DATE 6/3/59

ITEM CODE
PCN ☑ 04542A
NSN ☐
P/N ☐

WCD TH 2300 WCD DATE 89038

CHART BEGINS 008

CHART ENDS 190 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
008	008	○ ▷ D ■ ▽	Insp VIS		195	○ ▶ D □ ▽	B/S
010	010	○ ▷ D ■ ▽	Insp VIS		200	○ ▶ D □ ▽	
020	020	○ ▶ D □ ▽	B/S	020	998	○ ▶ D □ ▽	
	025	○ ▶ D □ ▽				○ ▷ D □ ▽	
	030	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	031	○ ▶ D □ ▽				○ ▷ D □ ▽	
	033	○ ▶ D □ ▽				○ ▷ D □ ▽	
	034	● ▷ D □ ▽				○ ▷ D □ ▽	
	035	○ ▶ D □ ▽				○ ▷ D □ ▽	
	036	○ ▶ D □ ▽				○ ▷ D □ ▽	
	038	● ▷ D □ ▽				○ ▷ D □ ▽	
	046	○ ▶ D □ ▽				○ ▷ D □ ▽	
	047	○ ▶ D □ ▽				○ ▷ D □ ▽	
	050	● ▷ D □ ▽				○ ▷ D □ ▽	
	051	○ ▶ D □ ▽				○ ▷ D □ ▽	
	052	○ ▶ D □ ▽				○ ▷ D □ ▽	
	060	● ▷ D □ ▽				○ ▷ D □ ▽	
	065	○ ▶ D □ ▽				○ ▷ D □ ▽	
	070	● ▷ D □ ▽				○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
	090	● ▷ D □ ▽				○ ▷ D □ ▽	
	100	● ▷ D □ ▽				○ ▷ D □ ▽	
	110	● ▷ D □ ▽				○ ▷ D □ ▽	
	120	● ▷ D □ ▽				○ ▷ D □ ▽	
	130	● ▷ D □ ▽				○ ▷ D □ ▽	
	140	● ▷ D □ ▽				○ ▷ D □ ▽	
	150	● ▷ D □ ▽				○ ▷ D □ ▽	
	160	● ▷ D □ ▽				○ ▷ D □ ▽	
	165	○ ▶ D □ ▽				○ ▷ D □ ▽	
	170	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	185	● ▷ D □ ▽				○ ▷ D □ ▽	
020	190	○ ▷ D ■ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Turbine Rotor DATE 6/1/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

21-42A

WCD CTA2320 WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Starter 045429

FLOW PROCESS CHART Inspection

SUBJECT Turbine Rotor DATE 6/3/09

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

WCD TA2320 WCD DATE 89095

CHART BEGINS Op 010

CHART ENDS Op 108 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp FPI	108	210	●▷D□▽	
015	015	○▷D■▽	Insp VIS		215	●▷D□▽	
020	020	○▷D■▽	Insp VIS		220	○▷D■▽	
025	025	○▷D■▽	Insp VIS		232	○▶D□▽	
030	030	○▷D■▽	Insp DIM		234	○▶D□▽	
040	040	○▷D■▽	Insp DIM		236	○▶D□▽	
050	050	○▷D■▽	Insp DIM		240	●▷D□▽	
060	060	○▷D■▽	Insp DIM		250	●▷D□▽	
065	065	○▷D■▽	Insp DIM		252	●▷D□▽	
070	070	○▷D■▽	Insp DIM		254	●▷D□▽	
080	080	○▷D■▽	Insp DIM		256	●▷D□▽	
090	090	○▷D■▽	Insp DIM		258	●▷D□▽	
095	095	○▷D■▽	Insp DIM		260	●▷D□▽	
100	100	○▷D■▽	Insp DIM		265	●▷D□▽	
103	103	○▷D■▽	Insp DIM		270	●▷D□▽	
105	105	○▷D■▽	Insp DIM		275	●▷D□▽	
106	035	○▷D■▽	Insp DIM		280	●▷D□▽	
107	106	○▶D□▽	Route - Parts		300	●▷D□▽	
108	107	○▶D□▽	Route - B/S	108	310	○▶D□▽	
	108	●▷D□▽	B/S			○▷D□▽	
	120	●▷D□▽				○▷D□▽	
	130	●▷D□▽				○▷D□▽	
	140	●▷D□▽				○▷D□▽	
	150	●▷D□▽				○▷D□▽	
	160	○▷D■▽				○▷D□▽	
	162	○▶D□▽				○▷D□▽	
	164	○▶D□▽				○▷D□▽	
	165	●▷D□▽				○▷D□▽	
	170	○▶D□▽				○▷D□▽	
	180	●▷D□▽				○▷D□▽	
	190	○▶D□▽				○▷D□▽	
108	200	○▶D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

Starter 04542A

FLOW PROCESS CHART

SUBJECT Gear Housing Subassembly DATE 6/9/89

ITEM CODE
PCN ☑ 04542A
NSN ☐
P/N ☐

WCD TH2740 WCD DATE 87300

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp FPI			○▷D□▽	
020	020	○▷D■▽	Insp MAG			○▷D□▽	
030	030	○▶D□▽	Conte - Dim			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Generic

FLOW PROCESS CHART Clean

SUBJECT Starter 04542 A DATE 6/1/89

ITEM CODE
PCN ☑
NSN ☐ 45424
P/N ☐

WCD G40 WCD DATE 59152

CHART BEGINS 010

CHART ENDS 040 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◁D☐▽	Degrease			○◁D☐▽	
020	020	●◁D☐▽	Hot Water Wash			○◁D☐▽	
030	030	●◁D☐▽	Grit Blast			○◁D☐▽	
040	040	○◁D☐▽ (D filled)	24 Hr Cool			○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	
		○◁D☐▽				○◁D☐▽	

○ OPERATION ▽ STORAGE ☐ INSPECTION

◁ TRANSPORTATION D DELAY

LSC-20147

Starter 04542A Generic

FLOW PROCESS CHART Inspection

SUBJECT Exhaust Hsg. DATE 6/3/89

ITEM CODE
PCN ☑ 04542A
NSN ☐
P/N ☐

WCD G4I WCD DATE 89152

CHART BEGINS 010

CHART ENDS 090 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Info			○▷D□▽	
020	020	○▷D■▽	Insp VIS			○▷D□▽	
030	030	●▷D□▽	Deburr			○▷D□▽	
040	040	○▷D■▽	Insp FPI			○▷D□▽	
050	050	○▷D■▽	Insp DIM			○▷D□▽	
060	060	○▶D□▽	Route - B/S			○▷D□▽	
070	070	○▶D□▽	Route - Parts			○▷D□▽	
080	080	○▷D■▽	Insp HYD			○▷D□▽	
090	090	○▶D□▽	Route - B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Cleaning

SUBJECT F15 LH AMAD DATE 6/7/89

ITEM CODE
PCN ☑ 08002H
NSN ☐
P/N ☐

WCD CTA071K WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● (Operation)	Sonic Clean				
020	020	D (Delay)	24 Hr Cool				

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 2AGB

FLOW PROCESS CHART Inspection

SUBJECT Flange General Mounting DATE 6/7/89

ITEM CODE
PCN ☑
NSN ☐ 08004A
P/N ☐

WCD TA071K WCD DATE 89107

CHART BEGINS OP 005

CHART ENDS ~~140~~ 120 PREPARED BY Tim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	○▷D■▽	Insp VIS			○▷D□▽	
010	010	○▷D■▽	Insp VIS			○▷D□▽	
020	020	○▷D■▽	Insp DIM			○▷D□▽	
030	030	○▷D■▽	Insp VIS			○▷D□▽	
040	040	●▷D□▽	Strip Paint			○▷D□▽	
050	050	○▷D■▽	Insp FPI			○▷D□▽	
060	060	○▶D□▽	Route - B/S			○▷D□▽	
	070	○▶D□▽				○▷D□▽	
	072	●▷D□▽				○▷D□▽	
	074	●▷D□▽				○▷D□▽	
	075	●▷D□▽				○▷D□▽	
	076	●▷D□▽				○▷D□▽	
	077	●▷D□▽				○▷D□▽	
	078	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	090	○▶D□▽				○▷D□▽	
060	100	○▶D□▽	B/S			○▷D□▽	
110	110	●▷D□▽	Touchup			○▷D□▽	
120	120	○▶D□▽	Route - B/S			○▷D□▽	
120	130	●▷D□▽	B/S			○▷D□▽	
120	140	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F152:GB

FLOW PROCESS CHART Cleaning

SUBJECT Gearshift Idg Spur **DATE** 6/7/89

ITEM CODE **WCD** CTA072K **WCD DATE** 89152

- **PCN** ☑ 08004A
- **NSN** ☐
- **P/N** ☐

CHART BEGINS 010

CHART ENDS 020 **PREPARED BY** Jim Feton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 2M6B

FLOW PROCESS CHART

SUBJECT Gearshaft IDG Spur DATE 6/7/89

ITEM CODE
PCN ☒ WCD TAD72K WCD DATE 89086
NSN ☐ 08004A
P/N ☐

CHART BEGINS 010

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
015	015	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
035	035	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
040	040	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
	050	○ ▶ D □ ▽				○ ▷ D □ ▽	
	060	● ▷ D □ ▽				○ ▷ D □ ▽	
	070	● ▷ D □ ▽				○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
	082	● ▷ D □ ▽				○ ▷ D □ ▽	
	085	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	090	○ ▶ D □ ▽				○ ▷ D □ ▽	
	100	● ▷ D □ ▽				○ ▷ D □ ▽	
	105	● ▷ D □ ▽				○ ▷ D □ ▽	
	110	○ ▶ D □ ▽				○ ▷ D □ ▽	
	120	○ ▶ D □ ▽				○ ▷ D □ ▽	
	130	● ▷ D □ ▽				○ ▷ D □ ▽	
	135	● ▷ D □ ▽				○ ▷ D □ ▽	
	140	● ▷ D □ ▽				○ ▷ D □ ▽	
	150	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	160	○ ▶ D □ ▽				○ ▷ D □ ▽	
040	170	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
180	180	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
190	190	● ▷ D □ ▽	Clean			○ ▷ D □ ▽	
200	200	○ ▶ D □ ▽	Route - PSI			○ ▷ D □ ▽	
210	210	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
998	998	○ ▶ D □ ▽	Route Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F15L4GE

FLOW PROCESS CHART CLEANING

SUBJECT Gear, 2nd Idl Spur Assy DATE 6/7/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 08004A

WCD CTH074K WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● (Operation)	Sonic Clean				
020	020	● (Delay)	24 Hr Cool				

○ OPERATION ▽ STORAGE ☐ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 LHGB

FLOW PROCESS CHART Inspection

SUBJECT Oper 2nd Idl Spar Assy DATE 6/7/89

ITEM CODE
PCN ☑
NSN ☐ 08004A
P/N ☐

WCD TA074L WCD DATE 89086

CHART BEGINS 010

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
025	025	○ ▶ D □ ▽	Ronfo. B/S			○ ▷ D □ ▽	
	030	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	040	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	050	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	060	● ▷ D □ ▽				○ ▷ D □ ▽	
	070	● ▷ D □ ▽				○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
	085	○ ▶ D □ ▽				○ ▷ D □ ▽	
	090	● ▷ D □ ▽				○ ▷ D □ ▽	
	100	○ ▶ D □ ▽				○ ▷ D □ ▽	
025	110	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
120	120	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
125	125	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
130	130	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	140	○ ▶ D □ ▽				○ ▷ D □ ▽	
	150	● ▷ D □ ▽				○ ▷ D □ ▽	
	160	○ ▶ D □ ▽				○ ▷ D □ ▽	
130	165	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
170	170	● ▷ D □ ▽	Demagnetize			○ ▷ D □ ▽	
998	998	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 LHGE

FLOW PROCESS CHART

SUBJECT LH AMAD Gearbox DATE 3/7/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 08004A

WCD CT7092A WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◁D□▽	Degrease			○◁D□▽	
020	020	○◁D□▽	24 Hr Cool			○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◁ TRANSPORTATION D DELAY

LSC-20147

F15 LHGB

FLOW PROCESS CHART Inspection

SUBJECT LH AMAD Gearbox DATE 6/7/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
080046

WCD TA092K WCD DATE 89039

CHART BEGINS 010

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp VIS	050	340	●▷D□▽	B/S
030	030	○▷D■▽	Insp DIM		350	●▷D□▽	
040	040	○▷D■▽	Insp DIM		360	●▷D□▽	
050	050	○▶D□▽	Route - B/S		370	○▷D■▽	
	060	○▶D□▽			380	●▷D□▽	
	070	●▷D□▽			400	●▷D□▽	
	080	●▷D□▽			410	●▷D□▽	
	090	●▷D□▽			420	●▷D□▽	
	100	●▷D□▽			430	●▷D□▽	
	110	●▷D□▽			440	●▷D□▽	
	120	●▷D□▽			450	○▶D□▽	
	130	●▷D□▽		050	460	○▶D□▽	B/S
	140	●▷D□▽		470	470	●▷D□▽	Flush Clean
	150	●▷D□▽		480	480	○▶D□▽	B/S
	160	○▷D■▽		490	490	○▷D■▽	Insp VIS
	170	●▷D□▽		500	500	○▶D□▽	Route - B/S
	180	●▷D□▽		500	510	●▷D□▽	
	190	●▷D□▽		500	998	○▶D□▽	
	200	●▷D□▽				○▷D□▽	
	210	●▷D□▽				○▷D□▽	
	220	●▷D□▽				○▷D□▽	
	230	●▷D□▽				○▷D□▽	
	240	●▷D□▽				○▷D□▽	
	260	●▷D□▽				○▷D□▽	
	270	●▷D□▽				○▷D□▽	
	280	●▷D□▽				○▷D□▽	
	290	●▷D□▽				○▷D□▽	
	300	●▷D□▽				○▷D□▽	
	310	●▷D□▽				○▷D□▽	
	315	●▷D□▽				○▷D□▽	
	320	●▷D□▽				○▷D□▽	
050	330	●▷D□▽	B/S			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

Generic

FLOW PROCESS CHART Cleaning

SUBJECT F15 L+ AMAD DATE 6/7/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

080049

WCD G12C WCD DATE 89152

CHART BEGINS 010

CHART ENDS 040 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Sonic Clean			○▷D□▽	
030	030	●▷D□▽	Flush-Rinse			○▷D□▽	
040	040	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F15 L-GE GENERIC

FLOW PROCESS CHART Inspection

SUBJECT F15 LH AMAD DATE 6/7/89

ITEM CODE ✓ PCN ☐ NSN ☐ P/N ☐ 08004A

WCD G12I WCD DATE 89152

CHART BEGINS 010

CHART ENDS 160

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp VIS			○▷D□▽	
020	020	○▷D■▽	Insp DIM			○▷D□▽	
030	030	○▷D■▽	Insp DIM			○▷D□▽	
040	040	○▷D■▽	Insp FPI			○▷D□▽	
050	050	○▷D■▽	Insp MAG			○▷D□▽	
060	060	●▷D□▽	Repair			○▷D□▽	
070	070	○▶D□▽	Route - Parts			○▷D□▽	
080	080	○▶D□▽	Route - B/S			○▷D□▽	
090	090	●▷D□▽	Corrosion			○▷D□▽	
100	100	●▷D□▽	Degrease			○▷D□▽	
110	110	●▷D□▽	Grit Blast			○▷D□▽	
120	120	●▷D□▽	Wash			○▷D□▽	
130	130	○▷D■▽	Insp DIM			○▷D□▽	
140	140	○▷D■▽	Insp DIM			○▷D□▽	
150	150	●▷D□▽	Deburr			○▷D□▽	
160	160	○▶D□▽	Route - Parts			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE ☐ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 RTG?

FLOW PROCESS CHART C2541

SUBJECT Flange General Mounting DATE 1/-/84

ITEM CODE PCN ☒ NSN ☐ P/N ☐ 08005H

WCD CTA071K WCD DATE 84152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Sonic Clean			○▷D□▽	
020	020	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 [illegible]

FLOW PROCESS CHART Inspection

SUBJECT: Flange General Mounting DATE: [illegible]

ITEM CODE: PCN ☑ NSN ☐ P/N ☐ 06005A

WCD: TA071K WCD DATE: 89107

CHART BEGINS: OP 005

CHART ENDS: ~~140~~ 120 PREPARED BY: Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
040	040	● ▷ D □ ▽	Strip Paint			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
060	060	○ ▶ D □ ▽	Route B/S			○ ▷ D □ ▽	
	070	○ ▶ D □ ▽				○ ▷ D □ ▽	
	072	● ▷ D □ ▽				○ ▷ D □ ▽	
	074	● ▷ D □ ▽				○ ▷ D □ ▽	
	075	● ▷ D □ ▽				○ ▷ D □ ▽	
	076	● ▷ D □ ▽				○ ▷ D □ ▽	
	077	● ▷ D □ ▽				○ ▷ D □ ▽	
	078	● ▷ D □ ▽				○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
	090	○ ▶ D □ ▽				○ ▷ D □ ▽	
060	100	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
110	110	● ▷ D □ ▽	Touchup			○ ▷ D □ ▽	
120	120	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
120	130	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
120	140	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▷ TRANSPORTATION ▽ STORAGE D DELAY □ INSPECTION

LSC-20147

F15 RMG3

FLOW PROCESS CHART CLEANING

SUBJECT Gearshift, Idg Spur DATE 6/6/89

ITEM CODE WCD 6TA072K WCD DATE 89152

PCN ☑ 08005H

NSN ☐

P/N ☐

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F/F [illegible]

FLOW PROCESS CHART Inspection

SUBJECT [illegible] DATE 6/6/[illegible]

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
[illegible]

WCD T[illegible]072[illegible] WCD DATE [illegible]

CHART BEGINS 010

CHART ENDS 998 PREPARED BY Jim [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
015	015	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
035	035	○ ▷ D ■ ▽	Insp [illegible]			○ ▷ D □ ▽	
040	040	○ ▶ D □ ▽	Route [illegible]			○ ▷ D □ ▽	
|	050	○ ▶ D □ ▽	|			○ ▷ D □ ▽	
|	060	● ▷ D □ ▽	|			○ ▷ D □ ▽	
|	070	● ▷ D □ ▽	|			○ ▷ D □ ▽	
|	080	● ▷ D □ ▽	|			○ ▷ D □ ▽	
|	082	● ▷ D □ ▽	|			○ ▷ D □ ▽	
|	085	○ ▷ D ■ ▽	|			○ ▷ D □ ▽	
|	090	○ ▶ D □ ▽	|			○ ▷ D □ ▽	
|	100	● ▷ D □ ▽	|			○ ▷ D □ ▽	
	[illegible]	● ▷ D □ ▽	|			○ ▷ D □ ▽	
	110	○ ▶ D □ ▽	|			○ ▷ D □ ▽	
	120	○ ▶ D □ ▽	|			○ ▷ D □ ▽	
	130	● ▷ D □ ▽				○ ▷ D □ ▽	
	135	● ▷ D □ ▽				○ ▷ D □ ▽	
	140	● ▷ D □ ▽				○ ▷ D □ ▽	
|	150	○ ▷ D ■ ▽				○ ▷ D □ ▽	
|	160	○ ▶ D □ ▽	|			○ ▷ D □ ▽	
040	170	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
180	180	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
190	190	● ▷ D □ ▽	Clean			○ ▷ D □ ▽	
200	200	○ ▶ D □ ▽	Route [illegible]			○ ▷ D □ ▽	
210	210	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
998	998	○ ▶ D □ ▽	Route [illegible]			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▷ TRANSPORTATION ▽ STORAGE D DELAY □ INSPECTION

LSC-20147

FIS [illegible]

FLOW PROCESS CHART

SUBJECT [illegible] DATE [illegible]

ITEM CODE
PCN ☑ C60C[illegible]
NSN ☐
P/N ☐

WCD CTR074 [illegible] WCD DATE [illegible]

CHART BEGINS [illegible]

CHART ENDS 020

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◇D□▽	Sonic Clean			○◇D□▽	
020	020	○◇◗□▽	24 hr Cool			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

F/E [illegible]

FLOW PROCESS CHART Inspection

SUBJECT Gea, 2d [illegible] Assy DATE [illegible]

ITEM CODE
PCN ☑ O[illegible]
NSN ☐
P/N ☐

WCD T-074[illegible] WCD DATE [illegible]

CHART BEGINS 010

CHART ENDS 998 PREPARED BY Jim E[illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp Vis			○▷D□▽	
025	025	○▶D□▽	Route - PIS			○▷D□▽	
	030	●▷D□▽	B/S			○▷D□▽	
	040	○▷D■▽				○▷D□▽	
	050	○▷D■▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	085	○▶D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	100	○▶D□▽				○▷D□▽	
025	110	○▶D□▽	B/S			○▷D□▽	
120	120	●▷D□▽	Degrease			○▷D□▽	
125	125	○▷D■▽	Insp Dim			○▷D□▽	
130	130	●▷D□▽	B/S			○▷D□▽	
	140	○▶D□▽				○▷D□▽	
	150	●▷D□▽				○▷D□▽	
	160	○▶D□▽				○▷D□▽	
130	165	○▶D□▽	B/S			○▷D□▽	
170	170	●▷D□▽	Demagnetize			○▷D□▽	
998	998	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

[illegible]

FLOW PROCESS CHART [illegible]

SUBJECT [illegible] DATE [illegible]

ITEM CODE
- PCH ☑
- NSN ☐
- P/N ☐

[illegible]

WCD [illegible] WCD DATE [illegible]

CHART BEGINS 010

CHART ENDS 020

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	[illegible]			○▷D□▽	
020	020	○▷D□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

[illegible]

FLOW PROCESS CHART Inspection

SUBJECT [illegible] DATE [illegible]

ITEM CODE
PCN ☑ 09005H
NSN ☐
P/N ☐

WCD TA092KC WCD DATE 39059

CHART BEGINS 010

CHART ENDS 998 PREPARED BY Jim Feton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp Vis
030	030	○▷D■▽	Insp Dim
040	040	○▷D■▽	Insp Dim
050	050	○▶D□▽	Route - P/S
|	060	○▶D□▽	|
|	070	●▷D□▽	|
|	080	●▷D□▽	|
|	090	●▷D□▽	|
|	100	●▷D□▽	|
|	110	●▷D□▽	|
|	120	●▷D□▽	|
|	130	●▷D□▽	|
|	140	●▷D□▽	|
|	150	●▷D□▽	|
|	160	○▷D■▽	|
|	170	●▷D□▽	|
|	180	●▷D□▽	|
|	190	●▷D□▽	|
|	200	●▷D□▽	|
	210	●▷D□▽	|
	220	●▷D□▽	|
	230	●▷D□▽	|
	240	●▷D□▽	
	260	●▷D□▽	|
	270	●▷D□▽	|
	280	●▷D□▽	|
	290	●▷D□▽	
	300	●▷D□▽	
|	310	●▷D□▽	
|	315	●▷D□▽	
▼	320	●▷D□▽	▼
050	330	●▷D□▽	B/S

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
050	340	●▷D□▽	B/S
|	350	●▷D□▽	
|	360	●▷D□▽	|
|	370	○▷D■▽	|
|	380	●▷D□▽	|
|	400	●▷D□▽	|
|	410	●▷D□▽	|
|	420	●▷D□▽	|
|	430	●▷D□▽	|
|	440	●▷D□▽	|
▼	450	○▶D□▽	▼
050	460	○▶D□▽	B/S
470	470	●▷D□▽	Flush Clean
480	480	○▶D□▽	B/S
490	490	○▷D■▽	Insp Vis
500	500	○▶D□▽	Route - P/S
500	510	●▷D□▽	
500	998	○▶D□▽	
		○▷D□▽	
		○▷D□▽	
		○▷D□▽	
		○▷D□▽	
		○▷D□▽	
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		○▷D□▽	
		○▷D□▽	
		○▷D□▽	
		○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

GENERAL

SUBJECT Fl... [illegible] FLOW PROCESS CHART [illegible] DATE [illegible]

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

06005 [illegible]

WCD 510 WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 040 PREPARED BY Jim Ekton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	[illegible] Clean			○ ▷ D □ ▽	
030	030	● ▷ D □ ▽	Flush - Rinse			○ ▷ D □ ▽	
040	040	○ ▷ ◗ □ ▽	24 hr cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

[illegible]

FLOW PROCESS CHART [illegible]

SUBJECT F15 [illegible] DATE [illegible]

ITEM CODE
PCN ☑ 08005[illegible]
NSN ☐
P/N ☐

WCD G/I WCD DATE [illegible]9/52

CHART BEGINS 010

CHART ENDS 160

PREPARED BY [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp /15			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
030	0.30	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
[illegible]	040	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp [illegible]			○ ▷ D □ ▽	
060	060	● ▷ D □ ▽	Repair			○ ▷ D □ ▽	
070	070	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
080	080	○ ▶ D □ ▽	Route - E/S			○ ▷ D □ ▽	
090	090	● ▷ D □ ▽	Corrossior			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	Decrease			○ ▷ D □ ▽	
110	110	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
120	120	● ▷ D □ ▽	Water Rinse			○ ▷ D □ ▽	
130	130	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
140	140	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
150	150	● ▷ D □ ▽	Deburr			○ ▷ D □ ▽	
160	160	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▷ TRANSPORTATION ▽ STORAGE D DELAY □ INSPECTION

LSC-20147

FLOW PROCESS CHART

SUBJECT — Compt Cleaning (handwritten, partly illegible) DATE [illegible]

ITEM CODE
PCN ✓ 080061
NSN ☐
P/N ☐

WCD CT40327 WCD DATE [illegible]

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Hot Water Rinse			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr. Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Th Combust Chamber DATE [illegible]

ITEM CODE PCN NSN PN 0ECC6H

WCD 7A0334 WCD DATE 89075

CHART BEGINS 015

CHART ENDS 120 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
015	015	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
040	040	● ▷ D □ ▽	Log Repairs			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
055	055	● ▷ D □ ▽	Post Status			○ ▷ D □ ▽	
060	060	○ ▶ D □ ▽	Route - P/S			○ ▷ D □ ▽	
	062	○ ▶ D □ ▽				○ ▷ D □ ▽	
	065	○ ▷ D □ ▽				○ ▷ D □ ▽	
	070	○ ▷ D □ ▽				○ ▷ D □ ▽	
	075	○ ▷ D □ ▽				○ ▷ D □ ▽	
	081	○ ▷ D □ ▽				○ ▷ D □ ▽	
	082	○ ▷ D □ ▽				○ ▷ D □ ▽	
	083	○ ▷ D □ ▽				○ ▷ D □ ▽	
	084	○ ▷ D □ ▽				○ ▷ D □ ▽	
	085	○ ▷ D □ ▽				○ ▷ D □ ▽	
	086	○ ▷ D □ ▽				○ ▷ D □ ▽	
060	088	○ ▷ D □ ▽	P/S			○ ▷ D □ ▽	
090	090	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
091	091	○ ▷ D □ ▽	P/S			○ ▷ D □ ▽	
092	092	○ ▷ D □ ▽	P/S			○ ▷ D □ ▽	
093	093	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
095	095	○ ▶ D □ ▽	Route - P/S			○ ▷ D □ ▽	
	100	○ ▷ D □ ▽				○ ▷ D □ ▽	
	110	○ ▷ D □ ▽				○ ▷ D □ ▽	
095	120	○ ▷ D □ ▽	P/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART [illegible]

SUBJECT [illegible] DATE [illegible]

WCD CTH356[illegible] WCD DATE [illegible]

ITEM CODE
PCN ☑
NSN ☐
PN ☐

0EC064

CHART BEGINS 010

CHART ENDS C40 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Wash			○▷D□▽	
C20	020	●▷D□▽	Bait			○▷D□▽	
[illegible]	030	●▷D□▽	Grit Blast			○▷D□▽	
040	C40	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Inlet Gr Box Insp, Hsg, Ind DATE 5/3/99

ITEM CODE
PCN ☑
NSN ☐ 08006A
P/N ☐

WCD TH056H WCD DATE 59095

CHART BEGINS 020

CHART ENDS 090 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○ ▷ D □ ▽	—			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
025	025	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
026	026	● ▷ D □ ▽	Repair			○ ▷ D □ ▽	
028	028	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
035	035	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
041	041	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
045	045	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
046	046	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
047	047	● ▷ D □ ▽	Strip Paint			○ ▷ D □ ▽	
048	048	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
065	065	○ ▷ D □ ▽				○ ▷ D □ ▽	
	067	○ ▷ D □ ▽				○ ▷ D □ ▽	
	068	○ ▷ D □ ▽				○ ▷ D □ ▽	
	070	○ ▷ D □ ▽				○ ▷ D □ ▽	
	071	○ ▷ D □ ▽				○ ▷ D □ ▽	
	075	○ ▷ D □ ▽				○ ▷ D □ ▽	
	077	○ ▷ D □ ▽				○ ▷ D □ ▽	
	080	○ ▷ D □ ▽				○ ▷ D □ ▽	
	085	○ ▷ D □ ▽				○ ▷ D □ ▽	
065	090	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART [illegible]

SUBJECT: Power Turbine [illegible] DATE: [illegible]

ITEM CODE
PCN ✓
NSN
P/N

WCD: [illegible]-077- WCD DATE: [illegible]

[illegible]

CHART BEGINS: 010

CHART ENDS: 030

PREPARED BY: Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Wash			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Buff			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr. Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT [illegible] DATE [illegible]

ITEM CODE
PCN ☑ [illegible]
NSN ☐
P/N ☐

WCD [illegible] WCD DATE [illegible]

CHART BEGINS 001

CHART ENDS 200 PREPARED BY Jim E[illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
001	001	● ▷ D □ ▽	Record	075	110	○ ▷ D □ ▽	B/S
002	002	○ ▷ D ■ ▽	Insp. Vis	075	117	○ ▷ D □ ▽	B/S
003	003	○ ▶ D □ ▽	Route - B/S	130	130	● ▷ D □ ▽	Press Flush
	004	○ ▷ D □ ▽		160	160	○ ▷ D ■ ▽	Insp. FPI
	005	○ ▷ D □ ▽		170	170	○ ▶ D □ ▽	Route - B/S
	006	○ ▷ D □ ▽			180	○ ▷ D □ ▽	B/S
	007	○ ▷ D □ ▽		[illegible]	200	○ ▶ D □ ▽	Route - Parts
	008	○ ▷ D □ ▽				○ ▷ D □ ▽	
	009	○ ▷ D □ ▽				○ ▷ D □ ▽	
	014	○ ▷ D □ ▽				○ ▷ D □ ▽	
	016	○ ▷ D □ ▽				○ ▷ D □ ▽	
	018	○ ▷ D □ ▽				○ ▷ D □ ▽	
003	019	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	
[illegible]	020	○ ▷ D ■ ▽	Insp. Vis			○ ▷ D □ ▽	
022	[illegible]	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
024	[illegible]	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
[illegible]	026	○ ▷ D ■ ▽	Insp. FPI			○ ▷ D □ ▽	
045	045	○ ▷ D ■ ▽	Insp. Vis			○ ▷ D □ ▽	
050	050	● ▷ D □ ▽	Record			○ ▷ D □ ▽	
055	[illegible]	○ ▷ D ■ ▽	Insp. Dim			○ ▷ D □ ▽	
070	[illegible]	○ ▶ D □ ▽	Route			○ ▷ D □ ▽	
075	075	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	076	○ ▷ D □ ▽				○ ▷ D □ ▽	
	078	○ ▷ D □ ▽				○ ▷ D □ ▽	
	080	○ ▷ D □ ▽				○ ▷ D □ ▽	
	085	○ ▷ D □ ▽				○ ▷ D □ ▽	
	090	○ ▷ D □ ▽				○ ▷ D □ ▽	
	095	○ ▷ D □ ▽				○ ▷ D □ ▽	
	100	○ ▷ D □ ▽				○ ▷ D □ ▽	
	102	○ ▷ D □ ▽				○ ▷ D □ ▽	
	105	○ ▷ D □ ▽				○ ▷ D □ ▽	
	109	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

[illegible]

FLOW PROCESS CHART

SUBJECT [illegible] DATE [illegible]

ITEM CODE
PCN ✓ 080067
NSN ☐
PN ☐

WCD [illegible] WCD DATE [illegible]

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Wash			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Buff			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT: Power Turbine Brg Hsg Assy   DATE: May 31, 1985

WCD: TA088H   WCD DATE: 88350

ITEM CODE
- PCN ☑ 08006A
- NSN ☐
- P/N ☐

CHART BEGINS: 010

CHART ENDS: 640   PREPARED BY: Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Info	155	231	○▶D□▽	B/S
015	015	●▷D□▽	Degrease	235	235	●▷D□▽	Vapor Degrease
017	017	○▷D■▽	Insp Vis	240	240	●▷D□▽	Grit Blast
018	018	●▷D□▽	Grit Blast	245	245	○▶D□▽	Route - B/S
020	020	○▶D□▽	Route - B/S		250	●▷D□▽	
	040	●▷D□▽			251	○▶D□▽	
	050	○▶D□▽			260	○▷D■▽	
020	055	○▶D□▽	B/S		261	○▶D□▽	
060	060	○▷D■▽	Insp Vis		270	●▷D□▽	
062	062	○▷D■▽	Insp Vis		280	●▷D□▽	
070	070	○▷D■▽	Insp FPI		290	○▷D■▽	
080	080	○▷D■▽	Insp Dim		295	●▷D□▽	
090	090	○▶D□▽	Route - B/S		300	○▷D■▽	
	100	○▶D□▽	Route - B/S		310	●▷D□▽	
	110	○▷D■▽			320	●▷D□▽	
	120	○▶D□▽			450	●▷D□▽	
090	130	○▶D□▽	B/S		451	○▶D□▽	
140	140	○▶D□▽	Route		452	●▷D□▽	
150	150	○▷D■▽	Insp Vis		453	●▷D□▽	
155	155	○▶D□▽	Route - B/S		454	○▷D■▽	
	156	○▶D□▽	Route - B/S		455	○▶D□▽	
	157	●▷D□▽		245	456	○▶D□▽	
	158	○▷D■▽		457	457	●▷D□▽	Press Flush
	159	○▶D□▽		458	458	○▶D□▽	Route B/S
	160	●▷D□▽			459	●▷D□▽	
	163	●▷D□▽			460	●▷D□▽	
	165	●▷D□▽			490	●▷D□▽	
	167	○▷D■▽			500	●▷D□▽	
	170	●▷D□▽			580	●▷D□▽	
	180	●▷D□▽			590	○▷D■▽	
	190	●▷D□▽			592	○▶D□▽	
155	230	○▶D□▽	B/S		597	●▷D□▽	B/S

○ OPERATION   ▽ STORAGE   □ INSPECTION

▷ TRANSPORTATION   D DELAY

FLOW PROCESS CHART

SUBJECT Power Turbine Bearing Housing Assy DATE 5-31-89

ITEM CODE PCN ☒ NSN ☐ P/N ☐ 08006 WCD TA088H WCD DATE 88350

CHART BEGINS 010

CHART ENDS 640 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
458	598	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	599	○ ▶ D □ ▽				○ ▷ D □ ▽	
	600	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	610	○ ▶ D □ ▽				○ ▷ D □ ▽	
458	620	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
625	625	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
630	630	● ▷ D □ ▽	Press Flush			○ ▷ D □ ▽	
635	635	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
640	640	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Generic F15 JFS Cleaning DATE 5/31/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
08006A

WCD 62C WCD DATE 89152

CHART BEGINS 010

CHART ENDS 060 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Rinse-Dry			○▷D□▽	
020	020	●▷D□▽	Paint Strip			○▷D□▽	
030	030	●▷D□▽	Degrease			○▷D□▽	
040	040	●▷D□▽	Buff			○▷D□▽	
050	050	●▷D□▽	Grit Blast			○▷D□▽	
060	060	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

GENERIC

FLOW PROCESS CHART Inspection

SUBJECT F15 JFS DATE 5/31/89

ITEM CODE
PCN ☑ 08006A
NSN ☐
P/N ☐

WCD G2I WCD DATE 89152

CHART BEGINS 010

CHART ENDS 120 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
060	060	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
070	070	○ ▷ D ■ ▽	Insp - VIS			○ ▷ D □ ▽	
080	080	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
090	090	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
100	100	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
110	110	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
120	120	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 CGB

FLOW PROCESS CHART

SUBJECT Fan Oil Cooler Inlet Housing DATE 6/5/89

ITEM CODE ✓ WCD CTA004R WCD DATE 89152
PCN ☑
NSN ☐ D8007A
P/N ☐

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Scrape & Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 C&B

FLOW PROCESS CHART Inspection

SUBJECT Fan Oil Cooler Inlet Housing DATE 2/5/39

ITEM CODE ✓
PCN ☑
NSN ☐ 08007A
P/N ☐

WCD TA004R WCD DATE 38181

CHART BEGINS 010

CHART ENDS 050 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp VIS			○▷D□▽	
015	—	○▶D□▽	Route - Parts			○▷D□▽	
016	—	○▶D□▽	Route - B/S			○▷D□▽	
	020	●▷D□▽				○▷D□▽	
	025	●▷D□▽				○▷D□▽	
	030	○▷D■▽				○▷D□▽	
	035	●▷D□▽				○▷D□▽	
	040	○▶D□▽				○▷D□▽	
	045	●▷D□▽				○▷D□▽	
016	050	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 CGIS

FLOW PROCESS CHART CLEANING

SUBJECT Gear Box Matching Set Housing DATE 3/5/89

ITEM CODE
PCN ☑ 08C07A
NSN ☐
P/N ☐

WCD CTA046R WCD DATE J89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Flush & Dry			○▷D□▽	
020	020	○▷D□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F15 CGB

FLOW PROCESS CHART Inspection

SUBJECT Gear Box Matched Set Housing DATE 6/5/89

ITEM CODE ✓
PCN ☑
NSN ☐ 08007A
P/N ☐

WCD TAD46R WCD DATE 89082

CHART BEGINS 010

CHART ENDS 070 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
015	015	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
017	017	○ ▶ D □ ▽	Route B/S			○ ▷ D □ ▽	
↓	018	● ▷ D □ ▽	↓			○ ▷ D □ ▽	
↓	020	○ ▶ D □ ▽	↓			○ ▷ D □ ▽	
↓	035	● ▷ D □ ▽	↓			○ ▷ D □ ▽	
↓	040	● ▷ D □ ▽	↓			○ ▷ D □ ▽	
↓	041	● ▷ D □ ▽	↓			○ ▷ D □ ▽	
017	050	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
051	051	● ▷ D □ ▽	Flush Clean			○ ▷ D □ ▽	
052	052	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
053	053	● ▷ D □ ▽	Route to Parts			○ ▷ D □ ▽	
053	055	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
053	070	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F15 CGE

FLOW PROCESS CHART CLEANING

SUBJECT Driven Bevel Gear DATE 6/5/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 08007A

WCD CTA092B WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Sonic Clean			○▷D□▽	
020	020	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 CGB

FLOW PROCESS CHART Inspection

SUBJECT Driven Bevel Gear DATE 6/5/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
08007H

WCD TA092R WCD DATE 89005

CHART BEGINS 005

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	● ▷ D □ ▽	Info			○ ▷ D □ ▽	
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
025	025	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
026	—	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
030	030	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
	040	● ▷ D □ ▽				○ ▷ D □ ▽	
	042	○ ▶ D □ ▽				○ ▷ D □ ▽	
	044	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	046	○ ▶ D □ ▽				○ ▷ D □ ▽	
	048	● ▷ D □ ▽				○ ▷ D □ ▽	
	050	○ ▶ D □ ▽				○ ▷ D □ ▽	
	060	● ▷ D □ ▽				○ ▷ D □ ▽	
	070	○ ▶ D □ ▽				○ ▷ D □ ▽	
	075	○ ▶ D □ ▽				○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
	085	○ ▶ D □ ▽				○ ▷ D □ ▽	
	090	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	095	○ ▶ D □ ▽				○ ▷ D □ ▽	
030	998	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F15 CGB

FLOW PROCESS CHART Cleaning

SUBJECT Decoupler Assy Piston DATE 6/?/89

ITEM CODE ✓ WCD CTA093R WCD DATE 89152

PCN ☒ 08007A
NSN ☐
P/N ☐

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FI5 CGB

FLOW PROCESS CHART

SUBJECT Decoupler Assy Piston DATE 6/6/89

ITEM CODE WCD TA0098R WCD DATE 89082

PCN ☑ 08007H
NSN ☐
P/N ☐

CHART BEGINS 005

CHART ENDS PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
	005	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
	010	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
	011	● ▷ D □ ▽	Repair			○ ▷ D □ ▽	
	012	● ▷ D □ ▽	Package			○ ▷ D □ ▽	
	015	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
	018	● ▷ D □ ▽	Package			○ ▷ D □ ▽	
	020	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
	040	● ▷ D □ ▽				○ ▷ D □ ▽	
	045	● ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT F15 CGB Generic DATE 6/5/89

ITEM CODE ✓ WCD G3C WCD DATE 89152

PCN ☒
NSN ☐
P/N ☐ 08007A

CHART BEGINS 010

CHART ENDS 040 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Sonic Clean			○▷D□▽	
030	030	●▷D□▽	Scrape & Spray			○▷D□▽	
040	040	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT F15 CGB Generic DATE 6/5/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
08007A

WCD G3I WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 090 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp VIS			○▷D□▽	
020	020	○▷D■▽	Insp FPI			○▷D□▽	
030	030	○▷D■▽	Insp DIM			○▷D□▽	
040	040	○▷D■▽	Insp DIM			○▷D□▽	
050	050	○▷D■▽	Insp MAG			○▷D□▽	
060	060	○▶D□▽	Route - Parts			○▷D□▽	
070	070	○▶D□▽	Route - B/S			○▷D□▽	
080	080	○▷D■▽	Insp - VIS			○▷D□▽	
090	090	○▶D□▽	Route - Parts			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Cleaning

SUBJECT Chamber, Assy DATE 5/30/89

ITEM CODE ✓
PCN ☑ 10598A
NSN ☐
P/N ☐

WCD CTA043A WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT Chamber Assy DATE 5/30/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

10598A

WCD TA043A WCD DATE 89026

CHART BEGINS 010

CHART ENDS 040 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○▷D□▽	—	40	380	●▷D□▽	B/S
010	010	○▷D■▽	Insp FPI		400	●▷D□▽	
020	020	○▷D■▽	Insp Vis		410	●▷D□▽	
030	030	○▷D■▽	Insp Dim		440	●▷D□▽	
040	040	○▷D■▽	Insp Vis		450	○▷D■▽	
	060	●▷D□▽	B/S		460	●▷D□▽	
	070	○▷D■▽		40	510	○▶D□▽	B/S
	080	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	100	●▷D□▽				○▷D□▽	
	110	●▷D□▽				○▷D□▽	
	120	●▷D□▽				○▷D□▽	
	130	●▷D□▽				○▷D□▽	
	140	●▷D□▽				○▷D□▽	
	150	●▷D□▽				○▷D□▽	
	160	●▷D□▽				○▷D□▽	
	170	●▷D□▽				○▷D□▽	
	175	○▷D■▽				○▷D□▽	
	180	●▷D□▽				○▷D□▽	
	190	●▷D□▽				○▷D□▽	
	200	●▷D□▽				○▷D□▽	
	210	●▷D□▽				○▷D□▽	
	212	○▷D■▽				○▷D□▽	
	213	●▷D□▽				○▷D□▽	
	214	●▷D□▽				○▷D□▽	
	215	●▷D□▽				○▷D□▽	
	220	●▷D□▽				○▷D□▽	
	225	●▷D□▽				○▷D□▽	
	260	●▷D□▽				○▷D□▽	
	345	●▷D□▽				○▷D□▽	
	347	○▷D■▽				○▷D□▽	
	350	○▷D■▽	B/S			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Cleaning

SUBJECT Chamber Assy DATE 7/30/94

ITEM CODE WCD CTA044A WCD DATE 09152

- PCN ☑ 10598A
- NSN ☐
- P/N ☐

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

FLOW PROCESS CHART Inspection

SUBJECT Chamber Assy DATE 8 May 89

ITEM CODE WCD TA044A WCD DATE 38263

PCN ☑ 10598A
NSN ☐
P/N ☐

CHART BEGINS 001

CHART ENDS 060 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
001	001	● ▷ D □ ▽	Info			○ ▷ D □ ▽	
003	003	○ ▷ D ■ ▽	Insp HYD			○ ▷ D □ ▽	
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
040	040	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
↓	050	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	
↓	060	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

FLOW PROCESS CHART CLEANING

SUBJECT Plenum Assy DATE 5/30/98

ITEM CODE
PCN ☑ 10548H
NSN ☐
P/N ☐

WCD CTA 057A WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr. Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

FLOW PROCESS CHART Inspection

SUBJECT Plenum Assy DATE 8 May 89

ITEM CODE
PCN ☑
NSN ☐ 10598A
P/N ☐

WCD TA057A WCD DATE 89058

CHART BEGINS 010

CHART ENDS 230 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp FPI			○▷D□▽	
020	020	○▷D■▽	Insp VIS			○▷D□▽	
030	030	○▷D■▽	Insp DIM			○▷D□▽	
050	050	○▶D□▽	Route R/S			○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	091	●▷D□▽				○▷D□▽	
	093	●▷D□▽				○▷D□▽	
	096	●▷D□▽				○▷D□▽	
	099	●▷D□▽				○▷D□▽	
	101	●▷D□▽				○▷D□▽	
	102	●▷D□▽				○▷D□▽	
	103	●▷D□▽				○▷D□▽	
	105	○▷D■▽				○▷D□▽	
	110	●▷D□▽				○▷D□▽	
	118	●▷D□▽				○▷D□▽	
	120	●▷D□▽				○▷D□▽	
	122	●▷D□▽				○▷D□▽	
	124	●▷D□▽				○▷D□▽	
	126	●▷D□▽				○▷D□▽	
	130	○▷D■▽				○▷D□▽	
	135	●▷D□▽				○▷D□▽	
	140	●▷D□▽				○▷D□▽	
	200	●▷D□▽				○▷D□▽	
	220	●▷D□▽				○▷D□▽	
	230	○▶D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Cleaning

SUBJECT Housing Assy DATE 5/30/89

ITEM CODE ✓ WCD CTA063A WCD DATE 89152

PCN ☑ 10598A
NSN ☐
P/N ☐

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Paint Strip			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART INSPECTION

SUBJECT Housing Assy DATE 5/30/[illegible]

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

10598A

WCD TA063A WCD DATE 88081

CHART BEGINS 010

CHART ENDS 090

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp			○ ▷ D □ ▽	
025	025	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
030	030	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
	039	● ▷ D □ ▽				○ ▷ D □ ▽	
	040	● ▷ D □ ▽				○ ▷ D □ ▽	
	044	● ▷ D □ ▽				○ ▷ D □ ▽	
	045	● ▷ D □ ▽				○ ▷ D □ ▽	
	046	● ▷ D □ ▽				○ ▷ D □ ▽	
	050	○ ▶ D □ ▽				○ ▷ D □ ▽	
	080	○ ▶ D □ ▽				○ ▷ D □ ▽	
	090	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

105A8H GENERIC CLEANING F4L STARTER

FLOW PROCESS CHART CLEANING

SUBJECT F4L STARTER DATE 5/30/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 105A8H

WCD G5C WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●	Degrease				
020	020	●	Grit Blast				
030	030	D (filled)	24Hr Cool				

○ OPERATION ▽ STORAGE ☐ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

Generic FLOW PROCESS CHART Inspection

SUBJECT Inspection Overall 10598A Starter DATE 5/31/89

ITEM CODE
PCN ☑ 10598H
NSN ☐
P/N ☐

WCD G5I WCD DATE 89152

CHART BEGINS 010

CHART ENDS 120 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
060	060	○ ▷ D ■ ▽	Insp HYD			○ ▷ D □ ▽	
070	070	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
080	080	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
090	090	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
100	100	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
110	110	○ ▷ D ■ ▽	Insp HYD			○ ▷ D □ ▽	
120	120	○ ▶ D □ ▽	Route B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

Starter 10718

FLOW PROCESS CHART

SUBJECT Housing Assy DATE 6/1/89

WCD CTA015T WCD DATE 89152

ITEM CODE
PCN ☒ 10718A
NSN ☐
P/N ☐

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Paint Strip			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT Housing Assy DATE 6/1/89

ITEM CODE
PCN ☑ 10718A
NSN ☐
P/N ☐

WCD TA 015 T WCD DATE E8132

CHART BEGINS 010

CHART ENDS 031 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
012	012	○ ▶ D □ ▽	Route - R/S			○ ▷ D □ ▽	
	015	○ ▶ D □ ▽	Route - R/S			○ ▷ D □ ▽	
	020	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
	025	○ ▶ D □ ▽	Route - R/S			○ ▷ D □ ▽	
	026	○ ▶ D □ ▽	Route - R/S			○ ▷ D □ ▽	
	030	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
	031	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

SUBJECT T Wheel

FLOW PROCESS CHART CLEANING

DATE 9/1/89

ITEM CODE
PCN ☒
NSN ☐ 10718A 1
P/N ☐

WCD CTA034T WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Wash			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

SUBJECT T Wheel FLOW PROCESS CHART Inspection DATE 6/1/89

ITEM CODE
PCN ☑ 10718A
NSN ☐
P/N ☐

WCD TA034T WCD DATE 88272

CHART BEGINS 010

CHART ENDS ~~255~~ OP 035 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
035	035	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	040	○ ▶ D □ ▽	Route			○ ▷ D □ ▽	
	050	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	051	● ▷ D □ ▽				○ ▷ D □ ▽	
	052	● ▷ D □ ▽				○ ▷ D □ ▽	
	053	● ▷ D □ ▽				○ ▷ D □ ▽	
	054	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	055	● ▷ D □ ▽				○ ▷ D □ ▽	
	056	● ▷ D □ ▽				○ ▷ D □ ▽	
	057	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	060	● ▷ D □ ▽				○ ▷ D □ ▽	
	070	● ▷ D □ ▽				○ ▷ D □ ▽	
	240	● ▷ D □ ▽				○ ▷ D □ ▽	
	255	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Chamber Assy (Dome) DATE 6/1/89

ITEM CODE
PCN ☑
NSN ☐ 10718
P/N ☐

WCD CTA035T WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Elton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D☐▽	Grit Blast			○▷D☐▽	
020	020	○▷◗☐▽	24 Hr Cool			○▷D☐▽	
		○▷D☐▽				○▷D☐▽	
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○ OPERATION ▽ STORAGE ☐ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART INSPECTION

SUBJECT Chamber Assy (Dome) DATE 6/1/89

ITEM CODE
PCN ☑ 10718
NSN ☐
P/N ☐

WCD TA035T WCD DATE 88209

CHART BEGINS OP 005

CHART ENDS OP 140 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	○▷D■▽	Insp HYD	140	140	●▷D□▽	B/S
010	010	○▷D■▽	Insp FPI		150	●▷D□▽	
020	020	○▷D■▽	Insp Vis		160	●▷D□▽	
030	030	○▷D■▽	Insp DIM		180	○▶D□▽	Route - Parts
032	032	●▷D□▽	B/S			○▷D□▽	
	033	●▷D□▽				○▷D□▽	
	040	●▷D□▽				○▷D□▽	
	045	●▷D□▽				○▷D□▽	
	050	●▷D□▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	095	●▷D□▽				○▷D□▽	
	096	●▷D□▽				○▷D□▽	
	101	●▷D□▽				○▷D□▽	
	102	●▷D□▽				○▷D□▽	
	103	●▷D□▽				○▷D□▽	
	104	●▷D□▽				○▷D□▽	
	105	●▷D□▽				○▷D□▽	
	107	●▷D□▽				○▷D□▽	
	108	●▷D□▽				○▷D□▽	
	110	●▷D□▽				○▷D□▽	
	112	●▷D□▽				○▷D□▽	
	120	●▷D□▽				○▷D□▽	
	121	●▷D□▽				○▷D□▽	
	122	●▷D□▽				○▷D□▽	
	123	●▷D□▽				○▷D□▽	
	124	●▷D□▽				○▷D□▽	
	127	○▶D□▽	Route			○▷D□▽	
130	130	○▷D□▽	Insp HYD			○▷D□▽	
140	140	●▷D□▽	B/S			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Chamber Assy (Breech Cap) DATE 6/1/89

ITEM CODE
PCN ☒ 10718H
NSN ☐
P/N ☐

WCD CTA037T WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	mark			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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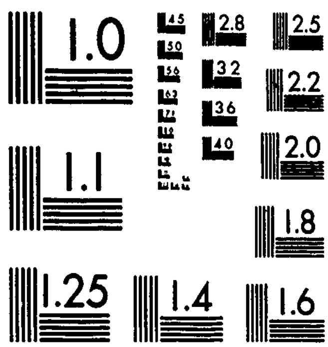
○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY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FLOW PROCESS CHART Inspection

SUBJECT Chamber Assy (Breech Cap) DATE 6/1/89

ITEM CODE
PCN ☑
NSN ☐ 10718A
P/N ☐

WCD TA037T WCD DATE 88155

CHART BEGINS 020

CHART ENDS 091 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
020	020	●▷D□▽	Disassemble			○▷D□▽	
025	025	○▷D■▽	Insp HYD			○▷D□▽	
030	030	○▷D■▽	Insp MAG			○▷D□▽	
035	035	○▷D■▽	Insp VIS			○▷D□▽	
040	040	○▷D■▽	Insp DIM			○▷D□▽	
050	050	○▶D□▽	Route - B/S			○▷D□▽	
	060	○▶D□▽	Route - B/S			○▷D□▽	
	070	●▷D□▽	B/S			○▷D□▽	
	085	○▶D□▽	Route - B/S			○▷D□▽	
	086	○▶D□▽	Route - B/S			○▷D□▽	
	087	●▷D□▽	B/S			○▷D□▽	
	088	●▷D□▽				○▷D□▽	
	089	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	091	○▶D□▽	Route - Parts			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

"OVERALL GENERIC"

SUBJECT B-52 Starter FLOW PROCESS CHART CLEANING DATE 6/1/89

ITEM CODE
PCN ☑ NSN ☐ P/N ☐ 10718A

WCD G6C WCD DATE 89152

CHART BEGINS 010

CHART ENDS 050 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◊D☐▽	Masking			○◊D☐▽	
020	020	●◊D☐▽	Degrease			○◊D☐▽	
030	030	●◊D☐▽	Paint Strip			○◊D☐▽	
040	040	●◊D☐▽	Grit Blast			○◊D☐▽	
050	050	○◊D☐▽ (D filled)	24 Hr Cool			○◊D☐▽	
		○◊D☐▽				○◊D☐▽	
		○◊D☐▽				○◊D☐▽	
		○◊D☐▽				○◊D☐▽	
		○◊D☐▽				○◊D☐▽	
		○◊D☐▽				○◊D☐▽	
		○◊D☐▽				○◊D☐▽	
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○ OPERATION ◊ TRANSPORTATION ▽ STORAGE D DELAY ☐ INSPECTION

LSC-20147

Generic for 10718A

FLOW PROCESS CHART Inspection

SUBJECT R-52 Starter DATE 6/1/89

ITEM CODE WCD G6I WCD DATE 89152

PCN ☑ 10718A

NSN ☐

P/N ☐

CHART BEGINS 010

CHART ENDS 090 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010		Insp HYD				
020	020		Insp FPI				
030	030		Insp MAG				
040	040		Insp VIS				
050	050		Insp DIM				
060	060		Route - B/S				
070	070		Route - Parts				
080	080		Insp HYD				
090	090		Route - B/S				

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F16 ADG

FLOW PROCESS CHART CLEANING

SUBJECT Carb Face Seal DATE 6/5/89

ITEM CODE ✓
PCN ☑
NSN ☐
P/N ☐ 12712A

WCD CTA0142 WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Tim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F16 HDG

FLOW PROCESS CHART Inspection

SUBJECT Carbon Face Seal DATE 6/5/89

ITEM CODE ✓ WCD TA014L WCD DATE 89081

- PCN ☒
- NSN ☐
- P/N ☐

12712A

CHART BEGINS 010

CHART ENDS ~~080~~ ~~0~~ 060 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
030	030	○ ▶ D □ ▽	Route - R/S			○ ▷ D □ ▽	
060	060	● ▷ D □ ▽	↓			○ ▷ D □ ▽	
060	070	○ ▶ D □ ▽	↓			○ ▷ D □ ▽	
060	080	○ ▶ D □ ▽	R/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FIG AD6

FLOW PROCESS CHART Cleaning

SUBJECT Impeller Assy DATE 6/5/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

WCD CTA076L WCD DATE 89152

12712#

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F16 ADG

FLOW PROCESS CHART Inspection

SUBJECT Impeller Assy DATE 6/5/89

ITEM CODE ✓ WCD TA076L WCD DATE 89075

PCN ☐
NSN ☐ 12712A
P/N ☐

CHART BEGINS 001

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
001	001	●▷D□▽	Info			○▷D□▽	
010	010	○▷D■▽	Insp VIS			○▷D□▽	
020	020	○▷D■▽	Insp VIS			○▷D□▽	
030	030	○▷D■▽	Insp DIM			○▷D□▽	
040	040	○▷D■▽	Insp MAG			○▷D□▽	
050	050	○▶D□▽	Rte to Parts			○▷D□▽	
051	—	○▶D□▽	Rte to B/S			○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	095	○▶D□▽				○▷D□▽	
	100	●▷D□▽				○▷D□▽	
	110	○▷D■▽				○▷D□▽	
	120	●▷D□▽				○▷D□▽	
	130	○▷D■▽				○▷D□▽	
	140	○▶D□▽				○▷D□▽	
	150	○▶D□▽				○▷D□▽	
	160	●▷D□▽				○▷D□▽	
	170	●▷D□▽				○▷D□▽	
	180	○▶D□▽				○▷D□▽	
051	998	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F16 ADG

FLOW PROCESS CHART Cleaning

SUBJECT Turbine Housing DATE 3/5/89

ITEM CODE
PCN ☑
NSN ☐ 12712
P/N ☐

WCD CTA077L WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F16 ADG

FLOW PROCESS CHART Inspection

SUBJECT Turbine Hsg DATE 6/5/89

ITEM CODE ✓ WCD TA077L WCD DATE 89075

PCN ☑
NSN ☐ 12712A
P/N ☐

CHART BEGINS 001

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
001	001	●▷D□▽	Info			○▷D□▽	
010	010	○▷D■▽	Insp VIS			○▷D□▽	
020	020	○▷D■▽	Insp DIM			○▷D□▽	
030	030	○▷D■▽	Insp MAG			○▷D□▽	
039	—	○▶D□▽	Route · Parts			○▷D□▽	
040	040	○▶D□▽	Route - B/S			○▷D□▽	
	050	●▷D□▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	085	○▶D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	100	○▷D■▽				○▷D□▽	
	110	●▷D□▽				○▷D□▽	
	120	○▶D□▽				○▷D□▽	
	130	○▶D□▽				○▷D□▽	
	140	●▷D□▽				○▷D□▽	
	150	●▷D□▽				○▷D□▽	
	160	○▶D□▽				○▷D□▽	
40	998	○▶D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FIGADG

SUBJECT Turbine FLOW PROCESS CHART CLEANING DATE 6/5/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 12712A

WCD CTH080L WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Clean			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F16 ADG

FLOW PROCESS CHART Inspection

SUBJECT Turbine DATE 6/5/89

ITEM CODE PCK ☑ NSN ☐ P/N ☐ 12712A

WCD TAD8OL WCD DATE 89060

CHART BEGINS 001

CHART ENDS 230 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
001	001	○ ▷ D □ ▽	Info			○ ▷ D □ ▽	
010	010	○ ▷ D □ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	Insp			○ ▷ D □ ▽	
030	030	○ ▷ D □ ▽	Insp DIM			○ ▷ D □ ▽	
040	040	○ ▷ D □ ▽	Insp FPI			○ ▷ D □ ▽	
041	—	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
045	045	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
	047	● ▷ D □ ▽				○ ▷ D □ ▽	
	050	● ▷ D □ ▽				○ ▷ D □ ▽	
	110	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	120	● ▷ D □ ▽				○ ▷ D □ ▽	
	130	● ▷ D □ ▽				○ ▷ D □ ▽	
	140	○ ▶ D □ ▽				○ ▷ D □ ▽	
	150	● ▷ D □ ▽				○ ▷ D □ ▽	
	160	○ ▶ D □ ▽				○ ▷ D □ ▽	
	170	● ▷ D □ ▽				○ ▷ D □ ▽	
	180	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	190	○ ▶ D □ ▽				○ ▷ D □ ▽	
	200	● ▷ D □ ▽				○ ▷ D □ ▽	
	210	○ ▶ D □ ▽				○ ▷ D □ ▽	
	220	● ▷ D □ ▽				○ ▷ D □ ▽	
045	230	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F16 ADG Generic

FLOW PROCESS CHART Cleaning

SUBJECT F16 ADG DATE 6/5/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
12712A

WCD G7C WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Sonic Clean			○▷D□▽	
020	020	●▷D□▽	Degrease			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

F16 [illegible] Generic

FLOW PROCESS CHART Inspection

SUBJECT F16 ADG Generic DATE 6/5/89

ITEM CODE ✓ WCD G7I WCD DATE 89152

PCN ☑ 12712 A
NSN ☐
P/N ☐

CHART BEGINS 010

CHART ENDS 060 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
060	060	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Diffuser Assy 2nd Stage DATE 5/30/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13081A

WCD CT6813A WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT DIFFUSER ASSY, 2ND STAGE DATE 5-24-89

ITEM CODE
PCN ☑
NSN ☐ 13081A
P/N ☐

WCD TG 813 A WCD DATE 88244

CHART BEGINS 010

CHART ENDS 520 PREPARED BY R. G. ROBISON

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○▷D□▽	—	170	220	●▷D□▽	B/S
010	010	●▷D□▽	F.V.I		221	●▷D□▽	
020	020	●▷D□▽	INSP. VIS.		222	●▷D□▽	
030	030	○▷D■▽	INSP. DIM.		223	●▷D□▽	
—	—	○▷D□▽	—		224	●▷D□▽	
040	040	●▷D□▽	RECORD DATA		225	●▷D□▽	
050	050	○▶D□▽	B/S		226	●▷D□▽	
060	060	●▷D□▽			227	●▷D□▽	
	070	●▷D□▽			228	●▷D□▽	
	100	●▷D□▽			229	●▷D□▽	
	110	○▷D□▽			230	●▷D□▽	
	111	○▷D□▽			232	●▷D□▽	
	112	○▷D□▽			235	●▷D□▽	
	113	○▷D□▽			240	●▷D□▽	
	114	○▷D□▽			300	●▷D□▽	
	115	○▷D□▽			305	○▷D■▽	
	116	○▷D□▽			310	○▶D□▽	
	117	○▷D□▽			320	○▶D□▽	
	118	○▷D□▽			330	●▷D□▽	
	119	○▷D□▽			340	○▶D□▽	
	120	○▷D□▽			350	●▷D□▽	
	130	○▷D□▽			355	●▷D□▽	
	131	○▷D□▽			360	●▷D□▽	
	132	○▷D□▽			370	●▷D□▽	
	133	○▷D□▽			380	●▷D□▽	
60	150	○▶D□▽	B/S		390	●▷D□▽	
160	160	●▷D□▽	Glass Blast		410	●▷D□▽	
165	165	○▶D□▽	B/S		420	●▷D□▽	
170	170	○▷D■▽			430	●▷D□▽	
	200	●▷D□▽			440	●▷D□▽	
	210	●▷D□▽			450	●▷D□▽	
170	215	●▷D□▽	B/S	170	460	●▷D□▽	B/S

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

SHEET 2 OF 2

FLOW PROCESS CHART

SUBJECT DIFFUSER ASSY, 2ND STAGE DATE 5-24-89

ITEM CODE
PCN ☑
NSN ☐ 13081A
P/N ☐

WCD TG 813 A WCD DATE 88244

CHART BEGINS 005

CHART ENDS ~~520~~ 170 PREPARED BY R. G. Robison

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
170	470	○▷D■▽	B/S			○▷D□▽	
170	490	●▷D□▽	B/S			○▷D□▽	
170	520	●▷D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Housing Assy, 1st Stage Inlet DATE 5/31/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

13081A

WCD CTG816F WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Housing Assy 1st Stage (Inlet) DATE 5/25/89

ITEM CODE ✓ PCN ☐ NSN ☐ P/N ☐ 13081A WCD TS 816 F WCD DATE 89097

CHART BEGINS ~~020~~ 005

CHART ENDS 990 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	● ▷ D □ ▽	Check P/N	30	610	● ▷ D □ ▽	Clean
010	010	● ▷ D □ ▽	Check FPI		615	○ ▶ D □ ▽	Route
020	020	○ ▷ D ■ ▽	Insp Vis		620	○ ▷ D ■ ▽	Inspect
030	030	○ ▷ D ■ ▽	Insp Dim	30	640	● ▷ D □ ▽	Corrosion Treat
	060	○ ▶ D □ ▽	Route	980	980	○ ▶ D □ ▽	Route
	070	○ ▶ D □ ▽	Route	990	990	○ ▷ D □ ▼	Parts Pool
	080	● ▷ D □ ▽	Clean			○ ▷ D □ ▽	
	100	● ▷ D □ ▽	Remove Studs			○ ▷ D □ ▽	
	180	● ▷ D □ ▽	Repair Cracks			○ ▷ D □ ▽	
	200	● ▷ D □ ▽	Prepare Welding			○ ▷ D □ ▽	
	220	● ▷ D □ ▽	Prepare Welding			○ ▷ D □ ▽	
	240	● ▷ D □ ▽	Prepare Welding			○ ▷ D □ ▽	
	250	○ ▶ D □ ▽	Route			○ ▷ D □ ▽	
	260	● ▷ D □ ▽	Preheat			○ ▷ D □ ▽	
	280	● ▷ D □ ▽	Weld			○ ▷ D □ ▽	
	300	● ▷ D □ ▽	Weld			○ ▷ D □ ▽	
	320	● ▷ D □ ▽	Weld			○ ▷ D □ ▽	
	340	● ▷ D □ ▽	Weld			○ ▷ D □ ▽	
	360	● ▷ D □ ▽	Stress Relieve			○ ▷ D □ ▽	
	380	○ ▷ D ■ ▽	Check Welds			○ ▷ D □ ▽	
	390	○ ▶ D □ ▽	Route			○ ▷ D □ ▽	
	400	● ▷ D □ ▽	Grind			○ ▷ D □ ▽	
	420	● ▷ D □ ▽	Repair Holes			○ ▷ D □ ▽	
	440	● ▷ D □ ▽	Repair Surface			○ ▷ D □ ▽	
	460	○ ▶ D □ ▽	Route			○ ▷ D □ ▽	
	480	● ▷ D □ ▽	Mask			○ ▷ D □ ▽	
	500	● ▷ D □ ▽	Anodize			○ ▷ D □ ▽	
	520	○ ▶ D □ ▽	Route			○ ▷ D □ ▽	
	540	● ▷ D □ ▽	Replace Studs			○ ▷ D □ ▽	
	560	● ▷ D □ ▽	Premachine			○ ▷ D □ ▽	
	580	● ▷ D □ ▽	Install Sleeve			○ ▷ D □ ▽	
030	600	● ▷ D □ ▽	Nicks & Burrs			○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

FLOW PROCESS CHART Cleaning

SUBJECT Housing Assy [illegible] DATE 5/30/89

ITEM CODE
PCN ☑ 130814
NSN ☐
P/N ☐

WCD CTG859A WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 030.

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT Housing Assy, Accessory Drive DATE 5-24-89

ITEM CODE WCD TG 859A WCD DATE 87270

PCN ☑
NSN ☐ 130814
P/N ☐

CHART BEGINS ~~[illegible]~~ 005

CHART ENDS ~~170~~ 035 PREPARED BY R. G. Robison

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○▷D□▽	—			○▷D□▽	
—	—	○▷D□▽	—			○▷D□▽	
005	005	●▷D□▽	"I.D." PN/NSN/CN			○▷D□▽	
010	010	○▷D■▽	INSP. VIS.			○▷D□▽	
020	020	○▷D■▽	INSP. Dim			○▷D□▽	
—	—	○▷D□▽	—			○▷D□▽	
030	030	○▶D□▽	B/S			○▷D□▽	
035	035	○▶D□▽				○▷D□▽	
*	038	○▶D□▽				○▷D□▽	
	040	●▷D□▽				○▷D□▽	
	045	●▷D□▽				○▷D□▽	
	050	○▷D■▽				○▷D□▽	
	055	○▶D□▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	080	●▷D□▽				○▷D□▽	
	090	●▷D□▽				○▷D□▽	
	100	●▷D□▽				○▷D□▽	
	110	●▷D□▽				○▷D□▽	
	115	●▷D□▽				○▷D□▽	
	120	●▷D□▽				○▷D□▽	
	125	○▶D□▽				○▷D□▽	
	130	○▷D■▽				○▷D□▽	
	135	○▶D□▽				○▷D□▽	
	140	●▷D□▽				○▷D□▽	
	150	●▷D□▽				○▷D□▽	
035	170	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Shaft Assy, Fan Idler Gear DATE [illegible]

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13081A

WCD CTG890A WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○▷D□▽	—			○▷D□▽	
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr. Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT SHAFT ASSY, FAN IDLER GEAR DATE 5-24-89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

13081A

WCD TG890A WCD DATE 87240

CHART BEGINS 010

CHART ENDS ~~080~~ 060 PREPARED BY R. G. ROBISON

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○ ▷ D □ ▽	—			○ ▷ D □ ▽	
—	—	○ ▷ D □ ▽	—			○ ▷ D □ ▽	
010	010	● ▷ D □ ▽	I.D." PN/NSN/CN			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	INSP VIS			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	INSP DIM			○ ▷ D □ ▽	
—	—	○ ▷ D □ ▽	—			○ ▷ D □ ▽	
040	040.	● ▷ D □ ▽	COR. TREAT			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
060	060	○ ▷ D □ ▽				○ ▷ D □ ▽	
060	070	○ ▷ D □ ▽				○ ▷ D □ ▽	
060	080	○ ▷ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

SUBJECT Liner Combustion Chamber **FLOW PROCESS CHART** Cleaning DATE 5/30/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

13081-A

WCD G9C WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
		○▷D□▽				○▷D□▽	
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr. Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT L30R1A GTE Generic DATE [illegible] 85

ITEM CODE
PSN ☑
NSN ☐ 13081A
P/N ☐

WCD G9I WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 130 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
060	060	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
↑	070	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
↓	090	● ▷ D □ ▽	↓			○ ▷ D □ ▽	
60	100	○ ▶ D □ ▽	Route Insp			○ ▷ D □ ▽	
110	110	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
120	120	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
130	130	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Diffuser Assembly, 2nd Stage DATE [illegible]

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13094 A

WCD CTG813A WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Elton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Diffuser Assy, 2nd Stage DATE 5/25/89

ITEM CODE ✓
PCN ☑
NSN ☐
P/N ☐

WCD TG813H WCD DATE 88214

13094A

CHART BEGINS Op 010

CHART ENDS Op 170 (pg 2) PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D■▽	Insp FPI	170:	222	●▷D□▽	B/S
020	020	○▷D□▽	Insp Vis		223	●▷D□▽	
030	030	○▷D□▽	Insp Dim		224	●▷D□▽	
040	040	○▷D□▽	List Defects		225	●▷D□▽	
050	050	○▶D□▽	B/S		226	●▷D□▽	
060	060	●▷D□▽			227	●▷D□▽	
	070	●▷D□▽			228	●▷D□▽	
	100	●▷D□▽			229	●▷D□▽	
	110	●▷D□▽			230	●▷D□▽	
	111	●▷D□▽			232	●▷D□▽	
	112	●▷D□▽			235	●▷D□▽	
	113	●▷D□▽			240	●▷D□▽	
	114	●▷D□▽			300	●▷D□▽	
	115	●▷D□▽			305	○▷D■▽	
	116	●▷D□▽			310	○▶D□▽	
	117	●▷D□▽			320	○▶D□▽	
	118	●▷D□▽			330	●▷D□▽	
	119	●▷D□▽			340	○▶D□▽	
	120	●▷D□▽			345	●▷D□▽	
	130	●▷D□▽			350	●▷D□▽	
	131	●▷D□▽			355	●▷D□▽	
	132	●▷D□▽			360	●▷D□▽	
	133	●▷D□▽			370	●▷D□▽	
60	150	○▶D□▽	B/S		380	●▷D□▽	
160	160	●▷D□▽	Glass Blast		390	●▷D□▽	
165	165	○▶D□▽	B/S		400	●▷D□▽	
170	170	○▷D■▽			410	●▷D□▽	
	200	●▷D□▽			420	●▷D□▽	
	210	●▷D□▽			430	●▷D□▽	
	215	●▷D□▽			440	●▷D□▽	
	220	●▷D□▽			450	●▷D□▽	
	221	●▷D□▽	B/S	170	460	●▷D□▽	B/S

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT ______ DATE 5/25/89

ITEM CODE
PCN ☑
NSN ☐ 13094H
P/N ☐

WCD TG813H WCD DATE 88244

CHART BEGINS 010

CHART ENDS 520 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
470	470	○ ▷ D ■ ▽	R/S			○ ▷ D □ ▽	
170	490	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
170	520	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

13094 SE

FLOW PROCESS CHART CLEANING

SUBJECT [illegible] Turbine DATE 5/30/[illegible]

ITEM CODE
PCN ☑
NSN ☐
P/N ☐ 13094H

WCD CTG840A WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Elton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr. Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

GTE 13094A

FLOW PROCESS CHART Inspection

SUBJECT Torus Turbine DATE 5/25/99

ITEM CODE
PCN ☑ 13094A
NSN ☐
P/N ☐

WCD TG840H WCD DATE 89025

CHART BEGINS 010

CHART ENDS

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Atch Doc.			○▷D□▽	
020	020	○▷D■▽	Insp Vis			○▷D□▽	
030	030	○▷D■▽	Insp Dim			○▷D□▽	
998	998	●▷D□▽	Route			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Nozzle Turbine DATE 5/30/89

ITEM CODE
PCN ☑
NSN ☐ 13094A
P/N ☐

WCD CTG 841F WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

FLOW PROCESS CHART

Insp.

SUBJECT Nozzle, Turbine DATE 5/25/[illegible]

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

130A4A

WCD TG 841 F WCD DATE 99090

CHART BEGINS 005

CHART ENDS 998 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	● ▷ D □ ▽	Circle P/N			○ ▷ D □ ▽	
010	010	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	Trans • Parts			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	120	○ ▶ D □ ▽				○ ▷ D □ ▽	
	140	● ▷ D □ ▽				○ ▷ D □ ▽	
	150	● ▷ D □ ▽				○ ▷ D □ ▽	
	160	● ▷ D □ ▽				○ ▷ D □ ▽	
	170	● ▷ D □ ▽				○ ▷ D □ ▽	
	175	● ▷ D □ ▽				○ ▷ D □ ▽	
	180	● ▷ D □ ▽				○ ▷ D □ ▽	
	200	○ ▶ D □ ▽				○ ▷ D □ ▽	
	220	● ▷ D □ ▽				○ ▷ D □ ▽	
	230	○ ▶ D □ ▽				○ ▷ D □ ▽	
	240	● ▷ D □ ▽				○ ▷ D □ ▽	
	250	○ ▶ D □ ▽				○ ▷ D □ ▽	
	260	● ▷ D □ ▽				○ ▷ D □ ▽	
	270	● ▷ D □ ▽				○ ▷ D □ ▽	
	280	● ▷ D □ ▽				○ ▷ D □ ▽	
	290	● ▷ D □ ▽				○ ▷ D □ ▽	
	350	○ ▶ D □ ▽				○ ▷ D □ ▽	
	400	● ▷ D □ ▽				○ ▷ D □ ▽	
	440	● ▷ D □ ▽				○ ▷ D □ ▽	
	500	○ ▶ D □ ▽				○ ▷ D □ ▽	
100	998	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Plenum Tunairo DATE 5/30/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
130997A

WCD CTS04KG WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT Plenum Turbine DATE 7/25/87

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13094A

WCD TS04K3 WCD DATE 9270

CHART BEGINS 002

CHART ENDS 022 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
002	002	○▷D■▽	Insp FPI			○▷D□▽	
004	004	○▷D■▽	Insp Vis			○▷D□▽	
005	005	●▷D□▽	B/S			○▷D□▽	
	006	●▷D□▽				○▷D□▽	
	008	●▷D□▽				○▷D□▽	
	010	●▷D□▽				○▷D□▽	
	012	●▷D□▽				○▷D□▽	
	014	●▷D□▽				○▷D□▽	
	016	○▷D■▽				○▷D□▽	
	018	●▷D□▽				○▷D□▽	
	020	○▷D■▽				○▷D□▽	
	022	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Generic - GTE 35-397 DATE 5/30/89

ITEM CODE
PCN ☑ 13094
NSN ☐
P/N ☐

WCD G10C WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030.

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷D□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

GENERAL

SUBJECT GTE 85-397 FLOW PROCESS CHART Inspection DATE 5/30/87

ITEM CODE WCD G 10 I WCD DATE 89152

PCN ☑ 13094 A
NSN ☐
P/N ☐

CHART BEGINS 010

CHART ENDS 110 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
060	060	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
070	070	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
080	080	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
090	090	○ ▶ D □ ▽	Route - B/S			○ ▷ D □ ▽	
100	100	○ ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
110	110	○ ▷ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Accessory Case DATE 5/30/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13095A

WCD CTG490F WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr. Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

GTE

FLOW PROCESS CHART Inspection

SUBJECT Accessory Case DATE 5/25/89

ITEM CODE
PCN ☑
NSN ☐ 13095A
P/N ☐

WCD TG 490 F WCD DATE 88338

CHART BEGINS 003

CHART ENDS 200 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○⇨D□▽	—	45	156	●⇨D□▽	B/S
—	—	○⇨D□▽	—		160	●⇨D□▽	
—	—	○⇨D□▽	—		161	●⇨D□▽	
003	003	●⇨D□▽	Circle P/N		162	●➧D□▽	
005	005	○⇨D■▽	Insp FPI		163	○⇨D■▽	
010	010	○⇨D■▽	Insp Vis		165	○➧D□▽	
—	~	○⇨D□▽		45	167	○➧D□▽	
040	040	○⇨D■▽	Insp Dim	170	170	●⇨D□▽	Clean Shavings
041	041	●⇨D□▽	List Defects	180	180	●⇨D□▽	Oil Flush
045	045	○➧D□▽	B/S	190	190	●⇨D□▽	B/S
	050	●⇨D□▽		200	200	○➧D□▽	B/S
	055	○➧D□▽				○⇨D□▽	
	060	●⇨D□▽				○⇨D□▽	
	065	○⇨D■▽				○⇨D□▽	
	067	●⇨D□▽				○⇨D□▽	
	068	○➧D□▽				○⇨D□▽	
	070	●⇨D□▽				○⇨D□▽	
	075	●⇨D□▽				○⇨D□▽	
	078	○➧D□▽				○⇨D□▽	
	080	○⇨D■▽				○⇨D□▽	
	083	○➧D□▽				○⇨D□▽	
	085	●⇨D□▽				○⇨D□▽	
	090	●⇨D□▽				○⇨D□▽	
	095	●⇨D□▽				○⇨D□▽	
	100	●⇨D□▽				○⇨D□▽	
	105	●⇨D□▽				○⇨D□▽	
	110	●⇨D□▽				○⇨D□▽	
	120	●⇨D□▽				○⇨D□▽	
	130	●⇨D□▽				○⇨D□▽	
	140	●⇨D□▽				○⇨D□▽	
	150	●⇨D□▽				○⇨D□▽	
45	155	●⇨D□▽	B/S			○⇨D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
⇨ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Torus, Turbine DATE 5/30/89

ITEM CODE ✓ WCD CTG6110 WCD DATE 89/152
PCN ☑
NSN ☐ 13095H
P/N ☐

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART INSP

SUBJECT Liner, Combustion Chamber DATE 5/25/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐ 13095A

WCD TG 611D WCD DATE 88258

CHART BEGINS 005

CHART ENDS 090

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○▷D□▽	—			○▷D□▽	
—	—	○▷D□▽	—			○▷D□▽	
—	—	○▷D□▽	—			○▷D□▽	
005	005	○▷D■▽	Insp Vis			○▷D□▽	
010	010	○▷D■▽	Insp Vis			○▷D□▽	
020	020	●▷D□▽	Mach Setup			○▷D□▽	
—	—	○▷D□▽	—			○▷D□▽	
025	B/S	○▶D□▽	B/S			○▷D□▽	
032	032	●▷D□▽				○▷D□▽	
	034	●▷D□▽				○▷D□▽	
	036	●▷D□▽				○▷D□▽	
	038	●▷D□▽				○▷D□▽	
	039	○▷D■▽				○▷D□▽	
	040	●▷D□▽				○▷D□▽	
	045	●▷D□▽				○▷D□▽	
	050	●▷D□▽				○▷D□▽	
	052	●▷D□▽				○▷D□▽	
	055	●▷D□▽				○▷D□▽	
	057	●▷D□▽				○▷D□▽	
	060	●▷D□▽				○▷D□▽	
	065	●▷D□▽				○▷D□▽	
	070	●▷D□▽				○▷D□▽	
	075	●▷D□▽				○▷D□▽	
	080	○▷D■▽				○▷D□▽	
	082	●▷D□▽				○▷D□▽	
	085	○▶D□▽				○▷D□▽	
032	090	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Torus, Turbine DATE 5/30/89

ITEM CODE
PCN ☑ 13095A
NSN ☐
P/N ☐

WCD CTG615D WCD DATE 89/152

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr. Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Torus, Turbine DATE 5/25/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐ 13095A

WCD TG615D WCD DATE 88224

CHART BEGINS 010

CHART ENDS 310 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○ ▷ D □ ▽	—	55	250	● ▷ D □ ▽	B/S
—	—	○ ▷ D □ ▽	—		260	● ▷ D □ ▽	
—	—	○ ▷ D □ ▽	—		270	○ ▷ D ■ ▽	
010	010	○ ▷ D ■ ▽	Insp FPI		280	● ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp Vis		290	○ ▶ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp Vis		300	○ ▶ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp Vis	55	310	○ ▷ D □ ▼	B/S
045	045	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
—	—	○ ▷ D □ ▽	—			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	B/S			○ ▷ D □ ▽	
055	055	○ ▶ D □ ▽				○ ▷ D □ ▽	
	060	● ▷ D □ ▽				○ ▷ D □ ▽	
	070	● ▷ D □ ▽				○ ▷ D □ ▽	
	080	● ▷ D □ ▽				○ ▷ D □ ▽	
	090	● ▷ D □ ▽				○ ▷ D □ ▽	
	100	● ▷ D □ ▽				○ ▷ D □ ▽	
	110	● ▷ D □ ▽				○ ▷ D □ ▽	
	120	● ▷ D □ ▽				○ ▷ D □ ▽	
	130	● ▷ D ■ ▽				○ ▷ D □ ▽	
	140	● ▷ D □ ▽				○ ▷ D □ ▽	
	150	● ▷ D □ ▽				○ ▷ D □ ▽	
	155	● ▷ D □ ▽				○ ▷ D □ ▽	
	160	● ▷ D □ ▽				○ ▷ D □ ▽	
	165	● ▷ D □ ▽				○ ▷ D □ ▽	
	170	● ▷ D □ ▽				○ ▷ D □ ▽	
	180	● ▷ D □ ▽				○ ▷ D □ ▽	
	190	● ▷ D □ ▽				○ ▷ D □ ▽	
	200	● ▷ D □ ▽				○ ▷ D □ ▽	
	205	● ▷ D □ ▽				○ ▷ D □ ▽	
	210	○ ▷ D ■ ▽				○ ▷ D □ ▽	
	220	● ▷ D □ ▽				○ ▷ D □ ▽	
55	230	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Wheel & Shaft Assembly DATE 5/30/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

13095A

WCD CTG645D WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 030

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Degrease			○▷D□▽	
020	020	●▷D□▽	Grit Blast			○▷D□▽	
030	030	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT Wheel & Shaft Assembly　　DATE 5/25/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
13095A

WCD TG645D　　WCD DATE 87287

CHART BEGINS 010

CHART ENDS ~~100~~ 120　　PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○ ▷ D □ ▽	—	120	270	● ▷ D □ ▽	B/S
—	—	○ ▷ D □ ▽	—		275	● ▷ D □ ▽	
—	—	○ ▷ D □ ▽	—		280	● ▷ D □ ▽	
010	010	○ ▷ D ■ ▽	Insp FPI		290	● ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp Vis	120	300	● ▷ D □ ▽	B/S
030	030	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
055	055	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
060	060	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
070	070	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
080	080	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
085	085	○ ▷ D ■ ▽	Insp Vis			○ ▷ D □ ▽	
090	090	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
100	100	○ ▷ D ■ ▽	Insp Dim			○ ▷ D □ ▽	
110	110	○ ▶ D □ ▽	Route-Parts			○ ▷ D □ ▽	
120	120	○ ▶ D □ ▽	Route-B/S			○ ▷ D □ ▽	
	130	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	140	● ▷ D □ ▽				○ ▷ D □ ▽	
	150	● ▷ D □ ▽				○ ▷ D □ ▽	
	160	● ▷ D □ ▽				○ ▷ D □ ▽	
	170	● ▷ D □ ▽				○ ▷ D □ ▽	
	180	● ▷ D □ ▽				○ ▷ D □ ▽	
	190	● ▷ D □ ▽				○ ▷ D □ ▽	
	200	● ▷ D □ ▽				○ ▷ D □ ▽	
	210	● ▷ D □ ▽				○ ▷ D □ ▽	
	220	● ▷ D □ ▽				○ ▷ D □ ▽	
	230	● ▷ D □ ▽				○ ▷ D □ ▽	
	240	● ▷ D □ ▽				○ ▷ D □ ▽	
	250	● ▷ D □ ▽				○ ▷ D □ ▽	
120	260	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	

○ OPERATION　▽ STORAGE　□ INSPECTION
▷ TRANSPORTATION　D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Generic DATE 5/30/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐ 13095A

WCD G11C WCD DATE 89/52

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
—	—	○ ▷ D □ ▽	—			○ ▷ D □ ▽	
010	010	● ▷ D □ ▽	Degrease			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
030	030	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

GENERIC "

SUBJECT GTE 85-180 FLOW PROCESS CHART Inspection DATE 6/2/89

ITEM CODE ✓ PCN ☑ NSN ☐ P/N ☐ 13095 A

WCD G11I WCD DATE 89152

CHART BEGINS 010

CHART ENDS 110 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
060	060	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
070	070	○ ▷ D ■ ▽	Insp MAG			○ ▷ D □ ▽	
080	080	○ ▶ D □ ▽	Route-Parts			○ ▷ D □ ▽	
090	090	○ ▶ D □ ▽	Route-R/S			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	Grit Blast			○ ▷ D □ ▽	
110	110	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Combustor Housing Assy DATE 6/5/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

130964

WCD CTA109U WCD DATE 89152

CHART BEGINS 010

CHART ENDS 040 PREPARED BY Jim Exton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Clean Carbon			○▷D□▽	
020	020	●▷D□▽	Rinse - Dry			○▷D□▽	
030	030	●▷D□▽	Clean Solvent			○▷D□▽	
040	040	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F14 TFS 13096A

FLOW PROCESS CHART Inspection

SUBJECT Combustor Hsg Assy DATE ?/5/89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐
13098A

WCD TA109U WCD DATE 89089

CHART BEGINS CCC

CHART ENDS 090 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	005	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
010	010	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
031	031	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
	033	● ▷ D □ ▽				○ ▷ D □ ▽	
	035	● ▷ D □ ▽				○ ▷ D □ ▽	
	036	● ▷ D □ ▽				○ ▷ D □ ▽	
	040	● ▷ D □ ▽				○ ▷ D □ ▽	
	041	● ▷ D □ ▽				○ ▷ D □ ▽	
	042	● ▷ D □ ▽				○ ▷ D □ ▽	
	050	● ▷ D □ ▽				○ ▷ D □ ▽	
031	055	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
060	060	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
065	065	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
080	080	○ ▶ D □ ▽	ROUTE			○ ▷ D □ ▽	
090	090	○ ▶ D □ ▽	ROUTE			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F16 JTS 13096A

FLOW PROCESS CHART Cleaning & Inspection

SUBJECT Fuel Manifold DATE 6/5/99

ITEM CODE
PCN ☑
NSN ☐
P/N ☐ 13096A

WCD TA 1131 WCD DATE 89089

CHART BEGINS 010

CHART ENDS 080 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	B/S			○▷D□▽	
020	C20	●▷D□▽	Sonic Cleaner			○▷D□▽	
025	—	○▷◗□▽	24 Hr Cool			○▷D□▽	
030	030	○▷D□▽	Insp VIS			○▷D□▽	
040	040	○▶D□▽	Route B/S			○▷D□▽	
	050	○▶D□▽				○▷D□▽	
	060	○▷D■▽				○▷D□▽	
	065	●▷D□▽				○▷D□▽	
	070	○▶D□▽				○▷D□▽	
040	080	○▶D□▽	B/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART CLEANING

SUBJECT Start Fuel Nozzel DATE 5/5/89

ITEM CODE
PCN ☑ 13046A
NSN ☐
P/N ☐

WCD CTA 1154 WCD DATE 89152

CHART BEGINS 010

CHART ENDS 020 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	Sonic Cleaner			○ ▷ D □ ▽	
020	020	○ ▷ ◗ □ ▽	24 Hr Cool			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT Start Fuel Nozzel DATE 4/5/39

ITEM CODE ✓
PCN ☑
NSN ☐
P/N ☐ 130964

WCD TA115U WCD DATE 39089

CHART BEGINS 010

CHART ENDS 040 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	R/S			○▷D□▽	
020	020	○▷D■▽	Insp VIS			○▷D□▽	
030	030	●▷D□▽	R/S			○▷D□▽	
030	040	○▷D■▽	R/S			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

F16 JFS [illegible]

FLOW PROCESS CHART

SUBJECT Comp Rotor Shaft DATE 1/5/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13096A WCD CTA1304 WCD DATE 89152

CHART BEGINS 010

CHART ENDS 030 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◇D□▽	Sonic Clean			○◇D□▽	
020	020	●◇D□▽	Grit Blast			○◇D□▽	
030	030	○◇◗□▽	24 Hr Cool			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

F16 JFJ

FLOW PROCESS CHART Inspection

SUBJECT Comp Rotor Shaft DATE 6/5/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 13096A

WCD TA130U WCD DATE 89089

CHART BEGINS 010

CHART ENDS 080

PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
010	020	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
010	025	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
028	028	○ ▷ D ■ ▽	Insp OPT			○ ▷ D □ ▽	
030	030	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
030	040	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp OPT			○ ▷ D □ ▽	
070	070	● ▷ D □ ▽	R/S			○ ▷ D □ ▽	
080	080	○ ▷ D ■ ▽	Insp OPT			○ ▷ D □ ▽	
090	090	● ▷ D □ ▽	B/S			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

F16 JFS

FLOW PROCESS CHART CLEANING

SUBJECT Generic F16 JFS 13096A DATE [illegible]

ITEM CODE
PCN ☑
NSN ☐ 13096A
P/N ☐

WCD G8C WCD DATE 89152

CHART BEGINS 010

CHART ENDS 060 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	Remove Carbon			○▷D□▽	
020	020	●▷D□▽	Degrease			○▷D□▽	
030	030	●▷D□▽	Sonic Clean			○▷D□▽	
040	040	●▷D□▽	Water Rinse			○▷D□▽	
050	050	●▷D□▽	Grit Blast			○▷D□▽	
060	060	○▷◗□▽	24 Hr Cool			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART Inspection

SUBJECT Generic F16 JFS 13096A DATE 6/5/89

ITEM CODE ✓
PCN ☐
NSN ☐ 13096A
P/N ☐

WCD G8I WCD DATE 89152

CHART BEGINS 010

CHART ENDS 110 PREPARED BY Jim Eaton

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
020	020	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
030	030	○ ▷ D ■ ▽	Insp VIS			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
050	050	○ ▷ D ■ ▽	Insp OPT			○ ▷ D □ ▽	
060	060	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
070	070	○ ▶ D □ ▽	Route - T/S			○ ▷ D □ ▽	
080	080	○ ▷ D ■ ▽	Insp FPI			○ ▷ D □ ▽	
090	090	○ ▷ D ■ ▽	Insp DIM			○ ▷ D □ ▽	
100	100	○ ▶ D □ ▽	Route - Parts			○ ▷ D □ ▽	
110	110	○ ▶ D □ ▽	Route - Holding			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

5.2 MODEL INPUT FILES

THE MODEL INPUT FILES FOR THIS RCC WHERE SUBMITTED UNDER SEPARATE COVER AS AN ATTACHMENT TO MDMSC LETTER NKE-E016-7622 DATED 19 JULY 1989.

MCDONNELL DOUGLAS

McDonnell Douglas
Missile Systems Company

19 July 1989
NKE-E016-7622

Subject: Contract F33600-88-D-0567, Technology Insertion Engineering Services, Submittal of Validation Minutes

To: Department of the Air Force
Attention: Ms. J. Hoyt (PMRP)
Contracting Officer
Building 1, Area C
Wright Patterson Air Force Base, Ohio 45433-5320

Enclosure: (1) Task Order 1, Process Characterization, Validation of RCCs MATPGB, MATPSI, and MATPSS at SA-ALC, 10-14 July 1989

1. For documentation purposes, McDonnell Missile Systems Company (MDMSC) herein submits the Enclosure (1) validation minutes.

2. Please address any questions or requests for additional information to the undersigned at (314) 233-8724.

D.W. Engelbart

D. W. Engelbart
Senior Contracts Administrator
Advanced Programs

EC: Department of the Air Force
SA-ALC/MAWF
Attn: Mr. Pete Garza
Building 171
Kelly AFB, TX 78241

Department of the Air Force
HQ AFLC/MAQF
Attn: Mr. Doxie Cripe
Building 262, Area A
Wright Patterson AFB, OH 45433-5320

KSS/0112-8

SA-ALC/

MDMSC MODEL

VALIDATION MINUTES

10-14 JULY 1989

0051P/22

VALIDATION IN-BRIEFING
MONDAY, 10 JUL 89, 0845

NAME	ORGANIZATION	PHONE NUMBER
Brown, Trixie	HQ-AFLC/MAQF	(513)257-7114
Conway, Bill	SA-ALC/MAWFT	(512)925-7491
Gardner, Greg	MDMSC	(314)925-5396
Garza, Pete	SA-ALC/MAWFT	(512)925-7491
Gill, Edward	SA-ALC/MATEA	(512)925-8885
Gonzales, Dan	SA-ALC/MATEG	(512)925-4667
Holm, Allen	MDMSC	(314)925-5433
McFarland, Sadie	MDMSC	(314)925-5395
Pfeiffer, Lamar	SA-ALC/MAWSD	(512)925-4747
Stirgus, Connie	SA-ALC/MAWSD	(512)925-4747
Totten, Evan	MDMSC	(314)925-5440
Vroman, Scott	MDMSC/Soft Services	(314)925-5842

10 JULY 1989

- The meeting began at 0800. Greg Gardner briefed the UDOS 2.0 simulation process and model goals and objectives.

- Trixie Brown requested the group establish goals for acceptable variances for validation. Bill recommended ± 10% on throughput and ± 15% on flow time. These goals were accepted by the validation group for all RCCs.

PSS

- Historical flow for all PCNs was examined and found to be erroneous. The historical flow times did not include all WCDs that were applicable. This was corrected and all flow-time variances reduced.

- All parts were found to have acceptable throughputs except 13096A at 32% variance.

- Corrected historical flow times were substantially higher than model flow times. SA-ALC engineers and planners examined the historical data and reported that it was too high. The historical data contained considerable delay time where PCNs were held awaiting parts (clutch assemblies and bearings in particular) in 1988.

- Changes were made in the equipment required for two operations on PCN 13096A.

- Paint shop times were adjusted on 08004A and 08005A from 5 to 60 hours. A new run was conducted.

11 JULY 1989

PSS

- The changes made on 10 Jul corrected the throughput for 13096A. All throughputs were accepted. The increased flow caused an increase in flow time/queue time for several parts.

- SA-ALC engineers examined the equipment profile and felt that it was too detailed. The equipment with utilizations below 5% was deleted. A new run was conducted.

PGB

- The historical data for 13081A, 13094A, and 13095A (parent items) were examined and corrected as for PSS. Corrected flow times were substantially higher than model flow times. SA-ALC personnel examined the history and felt that the history contained substantial delay time for parts and should be much longer than model time.

- All throughputs were found to be acceptable except 13095A, which had a substantial queue for equipment. The machine utilization was changed and a new run conducted.

- Backshop flow times were modified to reflect historical flow vs. interview.

PSI

- No historical data was available. Trixie Brown and the SA-ALC engineers decided to validate using estimated flow time vs. model flow time and throughput. Operations were examined for each PCN and estimates provided.

12 JULY 1989

PSS

- The new run was examined. Equipment deletions had no significant effect on flow times. Queues were distributed across the operations, caused primarily by highly utilized manpower and equipment. RCC supervisory personnel were called in to review the outputs vs. real-world RCC conditions. The RCC personnel indicated that the queue distribution was generally representative of that found in the RCC itself. Examination of flow times was continued.

PSI

- PCNs 13081A/13094A/13096A are disassembled by MATPGB, then received by MATPSI for cleaning and inspection. These three parent assemblies were found to be unnecessary in modeling MATPSI as they are not actually present in this RCC. These PCNs seem to represent "as is" conditions to the best of ALC knowledge.

- RCC personnel were asked to compare conditions within the model and in the RCC.

PGB

- The new run was examined. All throughput problems were corrected and throughputs were accepted. Examination of flow times was continued.

13 JULY 1989

- A brainstorming session was conducted with participants from MDMSC and each RCC, facilitated by Greg Gardner. The factors and levels shown on Attachment (1) were selected by the group. These factors will be fit to a Taguchi orthogonal array and the appropriate experiments conducted by MDMSC beginning 17 Jul 89 in St. Louis.

PSS

- After examination of the most current run, SA-ALC personnel and AFLC representative agreed that all variances could be adequately explained. The model for this RCC seems to represent "as is" shop floor to the best of ALC knowledge.

PSI

- Given the minimal impact of equipment deletion in PSS it was decided not to delete low-utilization equipment in PSI. As a result of the brainstorming session, it was determined (by RCC personnel) that the queues indicated in the model were realistic. When parts actually begin to queue on the shop floor, a temporary second shift is added and/or workers are borrowed from another RCC.

- Backshop flow times were adjusted per SA-ALC personnel on several PCNs. A new run was conducted.

14 JULY 1989

PSI

- After examination of the most current run, SA-ALC personnel and AFLC representatives agreed that all variances could be adequately explained. The model for this RCC seems to represent "as is" conditions of the shop floor to the best of ALC knowledge. The problems with temporary additional manpower/2nd shift operations are heavily addressed in the Taguchi experimentation schedule for the week of 17 Jul 89.

ALL

- The SA-ALC, MDMSC, and HQ-AFLC validation team members agreed that the models for MATPSI, MATPSS, and MATPGB seem to represent the shop floor "as is" condition and are accepted for experimentation.

SA BRAINSTORMING
13 JULY 1989

TAGUCHI FACTORS	LEVELS		
PSI	1	2	3
WORKLOAD	AS IS	SURGE	(E)[1]
CHEM CLEAN	AS IS	IN-HOUSE	SPLIT ~25% IN-HOUSE ~75% BACK-SHOP
INSP TNG	AS IS	+20 INSP TRAINED	+20 INSP UNTRAINED NEW @ 50%
INDUCTIONS	RANDOM FULL SHOP	LEVEL	AS IS EMPTY SHOP @ START[2]

NOTES:

1 (E) IS ACCELERATED INDUCTIONS, VALUE CURRENTLY UNSPECIFIED

2 THIS IS THE ACTUAL "AS IS" FOR PSI

MOMSC MODEL VALIDATION MINUTES
ATTACHMENT (1)
PAGE 2 OF 3

SA BRAINSTORMING
13 JULY 1989

TAGUCHI FACTORS	LEVELS		
PSS	1	2	3
WORKLOAD	AS IS	SURGE	E[1]
TEST CAPABILITY	AS IS	3 SHIFT 7 DAY	EXTRA 12712AS 13096A TEST STAND
ASSEMBLER TNG	AS IS	+5 TRAINED	+5 UNTRAINED NEW @ 50%
INDUCTION	RANDOM FULL SHOP	LEVEL	AS IS EMPTY SHOP
TEST REJECTION	AS IS	0[2]	MID POINT

NOTES:

1 E IS ACCELERATED INDUCTIONS, VALUE CURRENTLY UNSPECIFIED

2 NIL

SA BRAINSTORMING
13 JULY 1989

TAGUCHI FACTORS	LEVELS		
PGB	1	2	3
WORKLOAD	AS IS	SURGE	E[1]
TEST CAPACITY (1)	AS IS	3 SHIFT 7 DAY	+1 ADDED 13094 13095 TEST STAND
BALANCER TNG	AS IS	+3 TRAINED	+3 UNTRAINED NEW @ 50%
INDUCTIONS	RANDOM FULL SHOP	LEVEL	AS IS EMPTY SHOP
TEST REJECTION	AS IS	0[2]	MID POINT
TEST CAPACITY (2)	NEW EQUIP 1-SHIFT	X[3]	X[3]

NOTES:

1 E IS ACCELERATED INDUCTIONS, VALUE CURRENTLY UNSPECIFIED

2 NIL

3 X - VALUE NOT KNOWN

7.0 COMPUTER SIMULATION

THE COMPUTER SIMULATION ANALSIS FILES FOR THIS RCC WHERE SUBMITTED UNDER SERARATE COVER AS AN ATTACHMENT TO MDMSC LETTER NKE-E016-7622 DATED 19 JULY 1989.

13 JULY 1989

- A brainstorming session was conducted with participants from MDMSC and each RCC, facilitated by Greg Gardner. The factors and levels shown on Attachment (1) were selected by the group. These factors will be fit to a Taguchi orthogonal array and the appropriate experiments conducted by MDMSC beginning 17 Jul 89 in St. Louis.

SA BRAINSTORMING
13 JULY 1989

TAGUCHI FACTORS	LEVELS		
PSI	1	2	3
WORKLOAD	AS IS	SURGE	E[1]
CHEM CLEAN	AS IS	IN-HOUSE	SPLIT ~25% IN-HOUSE ~75% BACK-SHOP
INSP TNG	AS IS	+20 INSP TRAINED	+20 INSP UNTRAINED NEW @ 50%
INDUCTIONS	RANDOM FULL SHOP	LEVEL	AS IS EMPTY SHOP @ START[2]

NOTES:

1 E IS ACCELERATED INDUCTIONS. VALUE CURRENTLY UNSPECIFIED

2 THIS IS THE ACTUAL "AS IS" FOR PSI

10.0 EXPERIMENTATION OF TAGUCHI FACTORS

THE TAGUCHI EXPERIMENTATION WORK SHEETS AND ANALYSIS DRAFTS FOR THIS RCC ARE ENCLOSED IN THIS SECTION. THE FINISHED DRAFT OF THIS DATA IS PRESENTED IN THE "STATISTICAL SYSTEM PERFORMANCE MEASURES" SECTION FOR THIS RCC IN THE CONTRACT SUMMARY REPORT. THE PRINTOUTS FOR THE INDIVIDUAL EXPERIMENTAL RUNS ARE BEING FURNISHED SEPARATELY TO SA-ALC.

MATPSI

PCN #08004A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	1896	198
EXP# 2	1805	46
EXP# 3	2381	143
EXP# 4	1802	37
EXP# 5	4447	58
EXP# 6	5117	68
EXP# 7	3984	72
EXP# 8	2953	89
EXP# 9	1694	29

AVG FLOWTIME = 2897.667 AVG THROUGHPUT = 43.27486 %

```
EXPERIMENTAL RESULTS:
                    FACTOR A
LEVEL  1  : FLOWTIME EFFECT = -30.03566 %
LEVEL  1  : THROUGHPUT EFFECT =  7.489386  db

LEVEL  2  : FLOWTIME EFFECT =  30.74888 %
LEVEL  2  : THROUGHPUT EFFECT = -9.15063  db

LEVEL  3  : FLOWTIME EFFECT = -.7132204 %
LEVEL  3  : THROUGHPUT EFFECT = -6.931472  db

                    FACTOR B
LEVEL  1  : FLOWTIME EFFECT = -11.63005 %
LEVEL  1  : THROUGHPUT EFFECT =  1.546939  db

LEVEL  2  : FLOWTIME EFFECT =  5.889791 %
LEVEL  2  : THROUGHPUT EFFECT = -6.69555  db

LEVEL  3  : FLOWTIME EFFECT =  5.740248 %
LEVEL  3  : THROUGHPUT EFFECT = -3.184537  db

                    FACTOR C
LEVEL  1  : FLOWTIME EFFECT =  14.64396 %
LEVEL  1  : THROUGHPUT EFFECT =  5.014799  db

LEVEL  2  : FLOWTIME EFFECT = -39.01991 %
LEVEL  2  : THROUGHPUT EFFECT = -14.0837  db

LEVEL  3  : FLOWTIME EFFECT =  24.37593 %
LEVEL  3  : THROUGHPUT EFFECT = -.8426036  db

                    FACTOR D
LEVEL  1  :FLOWTIME EFFECT = -7.546304 %
LEVEL  1  :THROUGHPUT EFFECT =  0  db

LEVEL  2  :FLOWTIME EFFECT =  25.45726 %
LEVEL  2  :THROUGHPUT EFFECT = -7.248959  db

LEVEL  3  :FLOWTIME EFFECT = -17.91096 %
LEVEL  3  :THROUGHPUT EFFECT = -1.12399  db
```

MATPSI

PCN #08005A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	1725	94
EXP# 2	1893	21
EXP# 3	2207	69
EXP# 4	1662	16
EXP# 5	4623	26
EXP# 6	5161	34
EXP# 7	3238	9
EXP# 8	1708	3
EXP# 9	1743	13

AVG FLOWTIME = 2662.222 AVG THROUGHPUT = 29.32099 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -27.06595 %
LEVEL 1 : THROUGHPUT EFFECT = 2.732931 db

LEVEL 2 : FLOWTIME EFFECT = 43.31386 %
LEVEL 2 : THROUGHPUT EFFECT = -11.82695 db

LEVEL 3 : FLOWTIME EFFECT = -16.24791 %
LEVEL 3 : THROUGHPUT EFFECT = -24.81568 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -17.04925 %
LEVEL 1 : THROUGHPUT EFFECT = -5.430864 db

LEVEL 2 : FLOWTIME EFFECT = 2.971619 %
LEVEL 2 : THROUGHPUT EFFECT = -17.01105 db

LEVEL 3 : FLOWTIME EFFECT = 14.07763 %
LEVEL 3 : THROUGHPUT EFFECT = -5.839478 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 7.604346 %
LEVEL 1 : THROUGHPUT EFFECT = -3.874928 db

LEVEL 2 : FLOWTIME EFFECT = -33.66444 %
LEVEL 2 : THROUGHPUT EFFECT = -17.01105 db

LEVEL 3 : FLOWTIME EFFECT = 26.0601 %
LEVEL 3 : THROUGHPUT EFFECT = -7.492364 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = 1.306346 %
LEVEL 1 :THROUGHPUT EFFECT = -3.619243 db

LEVEL 2 :FLOWTIME EFFECT = 28.86478 %
LEVEL 2 :THROUGHPUT EFFECT = -14.01799 db

LEVEL 3 :FLOWTIME EFFECT = -30.17112 %
LEVEL 3 :THROUGHPUT EFFECT = -9.864949 db

MATPSI

PCN #08006A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	3157	248
EXP# 2	2818	72
EXP# 3	4108	127
EXP# 4	2987	39
EXP# 5	4591	45
EXP# 6	6619	39
EXP# 7	4287	18
EXP# 8	4245	10
EXP# 9	3172	34

AVG FLOWTIME = 3998.222 AVG THROUGHPUT = 21.60684 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -15.93764 %
LEVEL 1 : THROUGHPUT EFFECT = -1.665377 db

LEVEL 2 : FLOWTIME EFFECT = 18.36095 %
LEVEL 2 : THROUGHPUT EFFECT = -19.35402 db

LEVEL 3 : FLOWTIME EFFECT = -2.4233 %
LEVEL 3 : THROUGHPUT EFFECT = -26.89602 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -13.03635 %
LEVEL 1 : THROUGHPUT EFFECT = -7.86966 db

LEVEL 2 : FLOWTIME EFFECT = -2.840148 %
LEVEL 2 : THROUGHPUT EFFECT = -18.98694 db

LEVEL 3 : FLOWTIME EFFECT = 15.8765 %
LEVEL 3 : THROUGHPUT EFFECT = -13.54546 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 16.89362 %
LEVEL 1 : THROUGHPUT EFFECT = -8.254151 db

LEVEL 2 : FLOWTIME EFFECT = -25.15841 %
LEVEL 2 : THROUGHPUT EFFECT = -17.44692 db

LEVEL 3 : FLOWTIME EFFECT = 8.264782 %
LEVEL 3 : THROUGHPUT EFFECT = -14.1866 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -8.959536 %
LEVEL 1 :THROUGHPUT EFFECT = -6.839304 db

LEVEL 2 :FLOWTIME EFFECT = 14.41752 %
LEVEL 2 :THROUGHPUT EFFECT = -18.80707 db

LEVEL 3 :FLOWTIME EFFECT = -5.45798 %
LEVEL 3 :THROUGHPUT EFFECT = -15.12877 db

MATPSI

PCN #08007A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	765	371
EXP# 2	1905	76
EXP# 3	1274	294
EXP# 4	1899	62
EXP# 5	2350	211
EXP# 6	2983	277
EXP# 7	2068	194
EXP# 8	1820	207
EXP# 9	1849	49

AVG FLOWTIME = 1879.222 AVG THROUGHPUT = 48.48232 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -30.04198 %
LEVEL 1 : THROUGHPUT EFFECT = 4.85508 db

LEVEL 2 : FLOWTIME EFFECT = 28.28003 %
LEVEL 2 : THROUGHPUT EFFECT = -1.624281 db

LEVEL 3 : FLOWTIME EFFECT = 1.761963 %
LEVEL 3 : THROUGHPUT EFFECT = -5.068176 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -16.06456 %
LEVEL 1 : THROUGHPUT EFFECT = .9531036 db

LEVEL 2 : FLOWTIME EFFECT = 7.75735 %
LEVEL 2 : THROUGHPUT EFFECT = -3.528214 db

LEVEL 3 : FLOWTIME EFFECT = 8.307225 %
LEVEL 3 : THROUGHPUT EFFECT = .7187717 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = -1.235733 %
LEVEL 1 : THROUGHPUT EFFECT = 9.162909 db

LEVEL 2 : FLOWTIME EFFECT = .2719852 %
LEVEL 2 : THROUGHPUT EFFECT = -16.86597 db

LEVEL 3 : FLOWTIME EFFECT = .9637608 %
LEVEL 3 : THROUGHPUT EFFECT = 3.390505 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -11.94939 %
LEVEL 1 :THROUGHPUT EFFECT = 1.087118 db

LEVEL 2 :FLOWTIME EFFECT = 23.38439 %
LEVEL 2 :THROUGHPUT EFFECT = -1.725236 db

LEVEL 3 :FLOWTIME EFFECT = -11.43499 %
LEVEL 3 :THROUGHPUT EFFECT = -1.187692 db

MATPSI

PCN #04542A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	813	370
EXP# 2	571	302
EXP# 3	644	376
EXP# 4	572	235
EXP# 5	1232	296
EXP# 6	2003	311
EXP# 7	1958	451
EXP# 8	1708	540
EXP# 9	596	188

AVG FLOWTIME = 1121.889 AVG THROUGHPUT = 80.23529 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -39.74448 %
LEVEL 1 : THROUGHPUT EFFECT = 15.29689 db

LEVEL 2 : FLOWTIME EFFECT = 13.1128 %
LEVEL 2 : THROUGHPUT EFFECT = 6.65042 db

LEVEL 3 : FLOWTIME EFFECT = 26.63167 %
LEVEL 3 : THROUGHPUT EFFECT = 25.08074 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -.6734661 %
LEVEL 1 : THROUGHPUT EFFECT = 15.73172 db

LEVEL 2 : FLOWTIME EFFECT = 4.318115 %
LEVEL 2 : THROUGHPUT EFFECT = 21.17047 db

LEVEL 3 : FLOWTIME EFFECT = -3.644649 %
LEVEL 3 : THROUGHPUT EFFECT = 7.827592 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 34.41616 %
LEVEL 1 : THROUGHPUT EFFECT = 31.18442 db

LEVEL 2 : FLOWTIME EFFECT = -48.33119 %
LEVEL 2 : THROUGHPUT EFFECT = 2.762536 db

LEVEL 3 : FLOWTIME EFFECT = 13.91502 %
LEVEL 3 : THROUGHPUT EFFECT = 19.99879 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -21.53115 %
LEVEL 1 :THROUGHPUT EFFECT = 7.072984 db

LEVEL 2 :FLOWTIME EFFECT = 34.65385 %
LEVEL 2 :THROUGHPUT EFFECT = 16.17933 db

LEVEL 3 :FLOWTIME EFFECT = -13.12271 %
LEVEL 3 :THROUGHPUT EFFECT = 22.28105 db

PCN #10598A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	671	208
EXP# 2	515	87
EXP# 3	467	221
EXP# 4	545	126
EXP# 5	817	142
EXP# 6	1334	142
EXP# 7	1314	106
EXP# 8	1164	101
EXP# 9	604	89

AVG FLOWTIME = 825.6667 AVG THROUGHPUT = 57.77778 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -33.26605 %
LEVEL 1 : THROUGHPUT EFFECT = 10.0436 db

LEVEL 2 : FLOWTIME EFFECT = 8.84134 %
LEVEL 2 : THROUGHPUT EFFECT = 3.29182 db

LEVEL 3 : FLOWTIME EFFECT = 24.42471 %
LEVEL 3 : THROUGHPUT EFFECT = -3.233557 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = 2.13968 %
LEVEL 1 : THROUGHPUT EFFECT = 5.070451 db

LEVEL 2 : FLOWTIME EFFECT = .7670545 %
LEVEL 2 : THROUGHPUT EFFECT = -1.278332 db

LEVEL 3 : FLOWTIME EFFECT = -2.906742 %
LEVEL 3 : THROUGHPUT EFFECT = 5.802927 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 27.93702 %
LEVEL 1 : THROUGHPUT EFFECT = 5.74133 db

LEVEL 2 : FLOWTIME EFFECT = -32.82196 %
LEVEL 2 : THROUGHPUT EFFECT = -2.885096 db

LEVEL 3 : FLOWTIME EFFECT = 4.884939 %
LEVEL 3 : THROUGHPUT EFFECT = 6.867712 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -15.543 %
LEVEL 1 :THROUGHPUT EFFECT = 5.010031 db

LEVEL 2 :FLOWTIME EFFECT = 27.69479 %
LEVEL 2 :THROUGHPUT EFFECT = -.9937248 db

LEVEL 3 :FLOWTIME EFFECT = -12.1518 %
LEVEL 3 :THROUGHPUT EFFECT = 5.557172 db

MATPSI

PCN #10718A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	902	235
EXP# 2	685	142
EXP# 3	886	227
EXP# 4	760	98
EXP# 5	970	204
EXP# 6	1551	202
EXP# 7	2327	144
EXP# 8	1546	155
EXP# 9	811	68

AVG FLOWTIME = 1159.778 AVG THROUGHPUT = 63.52282 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -28.92317 %
LEVEL 1 : THROUGHPUT EFFECT = 12.67776 db

LEVEL 2 : FLOWTIME EFFECT = -5.700334 %
LEVEL 2 : THROUGHPUT EFFECT = 6.241544 db

LEVEL 3 : FLOWTIME EFFECT = 34.62349 %
LEVEL 3 : THROUGHPUT EFFECT = -1.034512 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = 14.64839 %
LEVEL 1 : THROUGHPUT EFFECT = 4.737844 db

LEVEL 2 : FLOWTIME EFFECT = -7.999622 %
LEVEL 2 : THROUGHPUT EFFECT = 6.071344 db

LEVEL 3 : FLOWTIME EFFECT = -6.648791 %
LEVEL 3 : THROUGHPUT EFFECT = 5.845726 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 14.93581 %
LEVEL 1 : THROUGHPUT EFFECT = 11.795 db

LEVEL 2 : FLOWTIME EFFECT = -35.16 %
LEVEL 2 : THROUGHPUT EFFECT = -4.140859 db

LEVEL 3 : FLOWTIME EFFECT = 20.22418 %
LEVEL 3 : THROUGHPUT EFFECT = 10.61065 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -22.88753 %
LEVEL 1 :THROUGHPUT EFFECT = 6.412625 db

LEVEL 2 :FLOWTIME EFFECT = 31.14581 %
LEVEL 2 :THROUGHPUT EFFECT = 5.343237 db

LEVEL 3 :FLOWTIME EFFECT = -8.258291 %
LEVEL 3 :THROUGHPUT EFFECT = 4.902065 db

MATPSI

PCN #12712A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	1230	123
EXP# 2	606	138
EXP# 3	2198	91
EXP# 4	633	95
EXP# 5	2965	12
EXP# 6	4360	8
EXP# 7	2294	32
EXP# 8	2121	41
EXP# 9	638	88

AVG FLOWTIME = 1893.889   AVG THROUGHPUT = 48.45679 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -28.99971 %
LEVEL 1 : THROUGHPUT EFFECT = 14.81605 db

LEVEL 2 : FLOWTIME EFFECT = 40.06454 %
LEVEL 2 : THROUGHPUT EFFECT = -10.1397 db

LEVEL 3 : FLOWTIME EFFECT = -11.06483 %
LEVEL 3 : THROUGHPUT EFFECT = -5.207144 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -26.83485 %
LEVEL 1 : THROUGHPUT EFFECT = 3.174542 db

LEVEL 2 : FLOWTIME EFFECT = .1818722 %
LEVEL 2 : THROUGHPUT EFFECT = -2.325234 db

LEVEL 3 : FLOWTIME EFFECT = 26.65298 %
LEVEL 3 : THROUGHPUT EFFECT = -2.701495 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 35.71721 %
LEVEL 1 : THROUGHPUT EFFECT = -4.131871 db

LEVEL 2 : FLOWTIME EFFECT = -66.96391 %
LEVEL 2 : THROUGHPUT EFFECT = 10.61911 db

LEVEL 3 : FLOWTIME EFFECT = 31.2467 %
LEVEL 3 : THROUGHPUT EFFECT = -7.884573 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -14.93693 %
LEVEL 1 :THROUGHPUT EFFECT = .6483751 db

LEVEL 2 :FLOWTIME EFFECT = 27.77941 %
LEVEL 2 :THROUGHPUT EFFECT = -3.555508 db

LEVEL 3 :FLOWTIME EFFECT = -12.84248 %
LEVEL 3 :THROUGHPUT EFFECT = 1.019399 db

MATPSI

.N #13081A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	429	77
EXP# 2	912	38
EXP# 3	570	66
EXP# 4	810	41
EXP# 5	785	88
EXP# 6	1116	104
EXP# 7	2078	64
EXP# 8	1361	59
EXP# 9	719	28

AVG FLOWTIME = 975.5556 AVG THROUGHPUT = 58.67082 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -34.70387 %
LEVEL 1 : THROUGHPUT EFFECT = 2.568546 db

LEVEL 2 : FLOWTIME EFFECT = -7.369017 %
LEVEL 2 : THROUGHPUT EFFECT = 9.737016 db

LEVEL 3 : FLOWTIME EFFECT = 42.0729 %
LEVEL 3 : THROUGHPUT EFFECT = -1.185185 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = 13.33713 %
LEVEL 1 : THROUGHPUT EFFECT = 2.695328 db

LEVEL 2 : FLOWTIME EFFECT = 4.487471 %
LEVEL 2 : THROUGHPUT EFFECT = 3.077011 db

LEVEL 3 : FLOWTIME EFFECT = -17.8246 %
LEVEL 3 : THROUGHPUT EFFECT = 4.760828 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = -.7061469 %
LEVEL 1 : THROUGHPUT EFFECT = 10.8619 db

LEVEL 2 : FLOWTIME EFFECT = -16.59453 %
LEVEL 2 : THROUGHPUT EFFECT = -6.931471 db

LEVEL 3 : FLOWTIME EFFECT = 17.30069 %
LEVEL 3 : THROUGHPUT EFFECT = 7.497661 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -33.95216 %
LEVEL 1 :THROUGHPUT EFFECT = 4.1066 db

LEVEL 2 :FLOWTIME EFFECT = 40.29613 %
LEVEL 2 :THROUGHPUT EFFECT = 5.829439 db

LEVEL 3 :FLOWTIME EFFECT = -6.34396 %
LEVEL 3 :THROUGHPUT EFFECT = .6856277 db

MATPSI

PCN 413094A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	791	188
EXP# 2	1108	62
EXP# 3	761	161
EXP# 4	1099	54
EXP# 5	1718	135
EXP# 6	1960	158
EXP# 7	2142	120
EXP# 8	1850	117
EXP# 9	1139	33

AVG FLOWTIME = 1396.445 AVG THROUGHPUT = 61.74174 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -36.50541 %
LEVEL 1 : THROUGHPUT EFFECT = 10.4878 db

LEVEL 2 : FLOWTIME EFFECT = 14.02769 %
LEVEL 2 : THROUGHPUT EFFECT = 5.117865 db

LEVEL 3 : FLOWTIME EFFECT = 22.47772 %
LEVEL 3 : THROUGHPUT EFFECT = -.5406718 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -3.755571 %
LEVEL 1 : THROUGHPUT EFFECT = 6.289542 db

LEVEL 2 : FLOWTIME EFFECT = 11.6168 %
LEVEL 2 : THROUGHPUT EFFECT = 2.64596 db

LEVEL 3 : FLOWTIME EFFECT = -7.861239 %
LEVEL 3 : THROUGHPUT EFFECT = 5.504253 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 9.826539 %
LEVEL 1 : THROUGHPUT EFFECT = 16.15938 db

LEVEL 2 : FLOWTIME EFFECT = -20.13049 %
LEVEL 2 : THROUGHPUT EFFECT = -10.02407 db

LEVEL 3 : FLOWTIME EFFECT = 10.30395 %
LEVEL 3 : THROUGHPUT EFFECT = 10.96211 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -12.92171 %
LEVEL 1 :THROUGHPUT EFFECT = 5.81626 db

LEVEL 2 :FLOWTIME EFFECT = 24.36346 %
LEVEL 2 :THROUGHPUT EFFECT = 4.583077 db

LEVEL 3 :FLOWTIME EFFECT = -11.44176 %
LEVEL 3 :THROUGHPUT EFFECT = 3.979632 db

MATPSI

PCN #13095A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	626	210
EXP# 2	966	98
EXP# 3	608	195
EXP# 4	933	88
EXP# 5	1718	148
EXP# 6	2083	168
EXP# 7	2184	125
EXP# 8	1507	114
EXP# 9	895	68

AVG FLOWTIME = 1280 AVG THROUGHPUT = 63.62683 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -42.70834 %
LEVEL 1 : THROUGHPUT EFFECT = 13.30241 db

LEVEL 2 : FLOWTIME EFFECT = 23.28125 %
LEVEL 2 : THROUGHPUT EFFECT = 5.546777 db

LEVEL 3 : FLOWTIME EFFECT = 19.42708 %
LEVEL 3 : THROUGHPUT EFFECT = -.6920992 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -2.526045 %
LEVEL 1 : THROUGHPUT EFFECT = 6.860801 db

LEVEL 2 : FLOWTIME EFFECT = 9.140625 %
LEVEL 2 : THROUGHPUT EFFECT = 2.657031 db

LEVEL 3 : FLOWTIME EFFECT = -6.61458 %
LEVEL 3 : THROUGHPUT EFFECT = 7.430982 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 9.79167 %
LEVEL 1 : THROUGHPUT EFFECT = 12.28666 db

LEVEL 2 : FLOWTIME EFFECT = -27.23959 %
LEVEL 2 : THROUGHPUT EFFECT = -4.080863 db

LEVEL 3 : FLOWTIME EFFECT = 17.44792 %
LEVEL 3 : THROUGHPUT EFFECT = 10.24504 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -15.65104 %
LEVEL 1 :THROUGHPUT EFFECT = 7.073317 db

LEVEL 2 :FLOWTIME EFFECT = 36.27605 %
LEVEL 2 :THROUGHPUT EFFECT = 4.674492 db

LEVEL 3 :FLOWTIME EFFECT = -20.625 %
LEVEL 3 :THROUGHPUT EFFECT = 5.074727 db

MATPSI

PCN #13096A

TAGUCHI L9 ORTHOGONAL ARRAY CALCULATIONS

	FLOWTIME	THROUGHPUT
EXP# 1	1142	151
EXP# 2	1091	76
EXP# 3	1203	126
EXP# 4	1018	33
EXP# 5	2539	74
EXP# 6	2587	88
EXP# 7	2292	65
EXP# 8	1887	100
EXP# 9	1063	45

AVG FLOWTIME = 1646.889   AVG THROUGHPUT = 40.49145 %

EXPERIMENTAL RESULTS:

FACTOR A

LEVEL 1 : FLOWTIME EFFECT = -30.45473 %
LEVEL 1 : THROUGHPUT EFFECT = 2.643492 db

LEVEL 2 : FLOWTIME EFFECT = 24.35569 %
LEVEL 2 : THROUGHPUT EFFECT = -7.884573 db

LEVEL 3 : FLOWTIME EFFECT = 6.099043 %
LEVEL 3 : THROUGHPUT EFFECT = -6.787586 db

FACTOR B

LEVEL 1 : FLOWTIME EFFECT = -9.890704 %
LEVEL 1 : THROUGHPUT EFFECT = -4.094731 db

LEVEL 2 : FLOWTIME EFFECT = 11.66509 %
LEVEL 2 : THROUGHPUT EFFECT = -4.027949 db

LEVEL 3 : FLOWTIME EFFECT = -1.774394 %
LEVEL 3 : THROUGHPUT EFFECT = -3.430693 db

FACTOR C

LEVEL 1 : FLOWTIME EFFECT = 13.66887 %
LEVEL 1 : THROUGHPUT EFFECT = 1.735109 db

LEVEL 2 : FLOWTIME EFFECT = -35.79814 %
LEVEL 2 : THROUGHPUT EFFECT = -11.1578 db

LEVEL 3 : FLOWTIME EFFECT = 22.12927 %
LEVEL 3 : THROUGHPUT EFFECT = -3.035926 db

FACTOR D

LEVEL 1 :FLOWTIME EFFECT = -3.980569 %
LEVEL 1 :THROUGHPUT EFFECT = -2.70875 db

LEVEL 2 :FLOWTIME EFFECT = 20.83389 %
LEVEL 2 :THROUGHPUT EFFECT = -5.451637 db

LEVEL 3 :FLOWTIME EFFECT = -16.85333 %
LEVEL 3 :THROUGHPUT EFFECT = -3.430693 db

MATPSI

TAGUCHI FACTORS		LEVELS		
		1	2	3
A	WORKLOAD	FY88	130% FY88	SURGE
B	INSPECTORS	AS -IS	+20 TRAINED	+20 UNTRAINED
C	INDUCTIONS	RANDOM INDUCTIONS INTO FULL SHOP	INDUCTIONS LEVELED	LEVEL INDUCTIONS: WIP = 25% OF SMALLEST FY88 QTRs INDUCTIONS
D	RANDOMNESS (SEED)	SEED 1	SEED 2	SEED 3

PSI TAGUCHI EXP.

L_9

WORK LOAD = 'AS IS' RES / SURGE

	CHEM CLEAN OPS/RES	INSPECTOR / TNG RES	INDUCTION SCHED. WHERE	RNDM SEED
→ 1	AS IS	AS IS	RANDOM FULL SHOP	~~SEED~~ 1
2	AS IS	+20 TNED	LEVEL	~~SEED~~ 2
→ 3	AS IS	+20 50% T	RANDOM EMPTY SHOP	~~SEED~~ 3
4	IN HOUSE	AS IS	LEVEL	~~SEED~~ 3
5	IN HOUSE	+20 TNED	RNDM EMPTY	~~SEED~~ 1
6	IN HOUSE	+20 50% T	RNDM Full	~~SEED~~ 2
7	SPLIT	AS IS	RNDM EMPTY	~~SEED~~ 2
8	SPLIT	+20 TNED	RNDM FULL	~~SEED~~ 3
9	SPLIT	+20 50% T	LEVEL	~~SEED~~ 1

CHEM CLEAN (2 QTRS) — IN HOUSE = Eliminate CLN BS + Add 5 hrs + CLN
SPLIT = Add 1 hr + CLN / TRIM BS 25%
MAEINC / MAEPNC

INSP TNG (2 QTRS) — +20 TNED = Add 20 Inspectors
+20 50% T = Add 20 ALT Inspect v 50% Avail.

TION — RANDOM FULL SHOP = "AS I
) LEVEL = Set MWIP TO
RANDOM Empty SHOP = SET 1 TO Ø

MATPSI L_9 TAGUCHI ORTHOGONAL ARRAY

TABLE 8.6.2-1

EXP #	A WORKLOAD	B INSPECTORS	C INDUCTIONS	D NOISE
1	FY88 BASELINE	AS IS	RANDOM FULL SHOP	RANDOM SEED 1
2	FY88 BASELINE	+20 TRAINED	LEVEL	RANDOM SEED 2
3	FY88 BASELINE	+20 UNTRAINED	RANDOM EMPTY SHOP	RANDOM SEED 3
4	130% OF BASE	AS IS	LEVEL	RANDOM SEED 3
5	130% OF BASE	+20 TRAINED	RANDOM EMPTY SHOP	RANDOM SEED 1
6	130% OF BASE	+20 UNTRAINED	RANDOM FULL SHOP	RANDOM SEED 2
7	SURGE	AS IS	RANDOM EMPTY SHOP	RANDOM SEED 2
8	SURGE	+20 TRAINED	RANDOM FULL SHOP	RANDOM SEED 3
9	SURGE	+20 UNTRAINED	LEVEL	RANDOM SEED 1

MAT PSI

Run	QTY	Day	133	43	150	193	217	130	122	69	60	68	113	112	4066 4208 3807 4590
		WU	40/47=190	27/15/30 36=108	82/68/85 90=325	120/73/72 134=399	110/107/80 128=425	50/80 43/62=235	4/78/77 59=258	35/34/36 39=144	20/40/58 90=208	34/34/20 19=107	54/59/38 34=185	/63 53/47=212	16671
			08004A	08005A	08006A	08007A	04592A	10598A	10718A	12712A	13096A	13081A	13094A	13095A	RUN Hr.
1	4	91	1895.90	1724.89	3157.29	765.01	812.73	671.31	901.92	1229.72	1141.74	429.47	791.25	626.16	10920
			$\boxed{190}$ 198	$\boxed{108}$ 94	$\boxed{325}$ 248	$\boxed{399}$ 371	$\boxed{425}$ 376	$\boxed{235}$ 208	$\boxed{258}$ 235	$\boxed{144}$ 123	$\boxed{208}$ 151	$\boxed{107}$ 77	$\boxed{185}$ 188	$\boxed{212}$ 210	$\boxed{16671}$
2	2	91	1805.35	1893.12	2817.60	1905.30	571.14	514.96	684.81	605.52	1090.50	912.15	1108.20	966.30	6552
			$\boxed{103}$ 25	$\boxed{42}$ 8	$\boxed{150}$ 33	$\boxed{193}$ 37	$\boxed{217}$ 154	$\boxed{130}$ 80	$\boxed{122}$ 67	$\boxed{69}$ 66	$\boxed{60}$ 22	$\boxed{68}$ 24	$\boxed{113}$ 38	$\boxed{112}$ 52	$\boxed{4429}$
3	4	0	2380.62	2206.47	4108.60	1274.29	643.79	467.21	885.72	2198.26	1202.76	570.00	760.76	607.99	8736
			$\boxed{190}$ 143	$\boxed{108}$ 69	$\boxed{325}$ 127	$\boxed{399}$ 294	$\boxed{425}$ 376	$\boxed{235}$ 221	$\boxed{258}$ 227	$\boxed{144}$ 91	$\boxed{208}$ 126	$\boxed{107}$ 66	$\boxed{185}$ 161	$\boxed{212}$ 195	$\boxed{16516}$
4	4	91	1801.58	1661.84	2986.75	1899.35	572.19	544.82	759.70	633.46	1017.62	810.19	1098.60	932.99	10920
			$\boxed{247}$ 48	$\boxed{143}$ 21	$\boxed{423}$ 51	$\boxed{479}$ 80	$\boxed{552}$ 306	$\boxed{235}$ 164	$\boxed{335}$ 127	$\boxed{178}$ 123	$\boxed{270}$ 43	$\boxed{139}$ 53	$\boxed{290}$ 70	$\boxed{279}$ 114	$\boxed{9525}$
5	4	0	4447.06	4622.73	4591.[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]					

51 54 51

MATPSI L_8 TAGUCHI ORTHOGANAL ARRAY
THROUGHPUT EXPERIMENTATION RESULTS
TABLE 8.6.2-2

SWITCH COLUMNS 1, 2

QTRS	EXP #	A WORKLOAD	B INSPECTORS	C INDUCTIONS	D NOISE	THROUGHPUT AVG	THROUGHPUT BEST	THROUGHPUT WORST
4	1	FY88 BASE LINE	AS IS	RANDOM FULL SAMP	RANDOM SEED 1	88%	08004A 104%	13081A 72%
2	2	FY88 BASE LINE	+20 TRAINED	LEVEL	RANDOM SEED 2	44%	12712A 96%	08007A 19%
4	3	FY88 BASE LINE	+20 UNTRAINED	RANDOM EMPTY SAMP	RANDOM SEED 3	75%	13095A 92%	08006A 39%
4	4	130% OF BASE	AS IS	LEVEL	RANDOM SEED 3	34%	12712A 69%	08005A 15%
4	5	130% OF BASE	+20 TRAINED	RANDOM EMPTY SAMP	RANDOM SEED 1	52%	13081A 83%	12712A 8%
				RANDOM	RANDOM		13081A	12712A

8-26-89

MATPSI

PCN	BEST FACTOR/LEVEL				WORST FACTOR/LEVEL			
	A	B	C	D				
08004A	A1	B1	C1	D1	A2	B2	C2	D2
08005A	A1	B1	C1	D1	A2	B2	C2	D2
08006A	A1	B1	C1	D1	A2	B2	C2	D2
08007A	A1	B1	C1	D1	A3	B2	C2	D2
04542A	A1	B2	C1	D3	A3	B3	C2	D1
10598A	A1	B3	C3	D3	A3	B2	C2	D2
10718A	A1	B3	C1	D1	A3	B1	C3	D2
12712A	A1	B1	C2	D1	A2	B3	C3	D2
13096A	A1	B1	C1	D3	A2	B2	C2	D2
13081A	A2	B3	C1	D1	A3	B1	C2	D2
13094A	A1	B1	C1	D1	A3	B2	C2	D2
13095A	A1	B1	C1	D1	A3	B2	C2	D2

ALC: SA

RCC: MATPSI

PCN

EXP RUN#	QTR #	WARM-UP DAYS #	08004A	08005A	08006A	08007A	04542A	10598A	10718A	12712A	13096A
1	4		1896 190 / 172	1725 108 / 94	3157 325 / 248	765 399 / 371	813 425 / 390	671 235 / 208	962 258 / 235	1230 144 / 123	1142 208 / 151
2	2		1805 103 / 25	1893 42 / 8	2818 150 / 33	1905 193 / 37	571 217 / 154	515 130 / 80	649 122 / 67	606 69 / 66	1091 40 / 22
3	4		2361 190 / 143	2206 108 / 69	4109 325 / 127	1274 399 / 274	644 425 / 376	467 235 / 201	886 258 / 227	2198 144 / 91	1203 208 / 126
4	4		1802 247 / 48	1662 143 / 21	2981 423 / 51	1549 477 / 80	572 552 / 366	545 235 / 164	760 335 / 127	633 178 / 123	1018 270 / 43
5	4		4447 248 / 76	4623 148 / 34	4591 417 / 58	2350 583 / 274	1232 562 / 395	817 243 / 184	770 357 / 265	2965 193 / 15	2539 260 / 96
6	4		5117 248 / 89	5161 148 / 44	6619 417 / 51	2983 503 / 360	2003 568 / 484	1334 243 / 184	1551 357 / 263	4360 193 / 10	2589 260 / 114
7	4		3984 297 / 115	3238 157 / 14	4287 512 / 28	2068 621 / 310	1958 1206 / 722	1314 243 / 169	2327 553 / 231	2294 189 / 51	2292 268 / 104
8	2		2953 152 / 74	1708 74 / 2	4245 255 / 8	1820 322 / 173	1908 610 / 435	1164 140 / 94	1546 281 / 126	2121 81 / 27	1887 79 / 49
9	2		1694 153 / 24	1743 75 / 10	3172 256 / 21	1849 324 / 41	596 607 / 152	604 141 / 82	811 281 / 55	638 178 / 60	1063 82 / 21
			AVG FLOW HRS IND. / OUTPT.								

ALC:

RCC: MAT ØI

EXP RUN#	QTR #	WARM-UP DAYS #	PCN 13091A	13094A	13095A	—	—	—	—	—	—
1	4		429 107 / 77	791 185 / 188	626 212 / 210						
2	2		912 68 / 24	1108 113 / 38	966 112 / 52						
3	4		570 107 / 66	761 185 / 161	608 212 / 195						
4	4		810 139 / 53	1099 240 / 70	933 279 / 114						
5	4		785 137 / 114	1718 248 / 176	1718 272 / 193						
6	4		1116 137 / 135	1760 248 / 205	2083 272 / 218						
7	4		2078 168 / 103	2142 296 / 192	2164 333 / 200						
8	2		1361 101 / 56	1850 186 / 116	1509 180 / 102						
9	2		719 100 / 27	1139 182 / 34	895 181 / 59						
			AVG FLOW HRS IND. / OUTPT.								

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89
ALC : SA RCC : MATPSI PCN: 08004A TAG1

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	1896	1.04	190	198	A 1	2027.3	30.03	0.68	55.61
2	1	2	2	2	1805	0.24	103	25	A 2	3788.5	-30.75	0.29	-34.34
3	1	3	3	3	2381	0.75	190	143	A 3	2876.9	0.71	0.34	-21.26
4	2	1	2	3	1802	0.19	247	48	B 1	2560.4	11.63	0.54	24.00
5	2	2	3	1	4447	0.31	248	76	B 2	3068.5	-5.90	0.35	-20.88
6	2	3	1	2	5117	0.36	248	89	B 3	3063.8	-5.74	0.42	-3.13
7	3	1	3	2	3984	0.39	297	115	C 1	3321.9	-14.65	0.63	44.18
8	3	2	1	3	2953	0.49	152	74	C 2	1766.9	39.02	0.20	-54.64
9	3	3	2	1	1694	0.16	153	24	C 3	3603.8	-24.38	0.48	10.46
									D 1	2678.9	7.55	0.50	14.98
									D 2	3635.4	-25.46	0.33	-24.48
			TOTAL		26078	3.93	1928	792	D 3	2378.4	17.92	0.48	9.51
			AVERAGE		2897.6	0.44	203.1	88.0		2897.6	0.00	0.44	0.00
			MAXIMUM		5116.87	1.04	297	198		3788.5	39.02	0.68	55.61
			MINIMUM		1693.77	0.16	103	24		1766.9	-30.75	0.20	-54.64

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 08005A PSI08005

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	1725	0.87	108	94	A 1	1941.5	27.07	0.57	94.39
2	1	2	2	2	1893	0.19	42	8	A 2	3815.3	-43.32	0.22	-22.93
3	1	3	3	3	2206	0.64	108	69	A 3	2229.4	16.25	0.08	-71.46
4	2	1	2	3	1662	0.15	143	21	B 1	2208.1	17.05	0.37	26.53
5	2	2	3	1	4623	0.23	148	34	B 2	2741.3	-2.78	0.15	-48.85
6	2	3	1	2	5161	0.30	148	44	B 3	3036.8	-14.08	0.36	22.32
7	3	1	3	2	3238	0.09	157	14	C 1	2864.8	-7.61	0.40	36.63
8	3	2	1	3	1708	0.03	74	2	C 2	1765.8	33.67	0.16	-46.17
9	3	3	2	1	1743	0.13	75	10	C 3	3355.6	-26.05	0.32	9.54
									D 1	2696.7	-1.30	0.41	41.06
									D 2	3430.7	-28.87	0.19	-34.02
			TOTAL		23959	2.62	1003	296	D 3	1858.8	30.18	0.27	-7.05
			AVERAGE		2662.1	0.29	111.4	32.9		2662.1	0.00	0.29	0.00
			MAXIMUM		5161.46	0.87	157	94		3815.3	33.67	0.57	94.39
			MINIMUM		1661.84	0.03	42	2		1765.8	-43.32	0.08	-71.46

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 08006A PS108006

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	3157	0.76	325	248	A 1	3361.2	15.93	0.46	111.65
2	1	2	2	2	2818	0.22	150	33	A 2	4732.4	-18.36	0.13	-41.16
3	1	3	3	3	4109	0.39	325	127	A 3	3901.2	2.43	0.06	-70.49
4	2	1	2	3	2987	0.12	423	51	B 1	3477.0	13.04	0.31	44.56
5	2	2	3	1	4591	0.14	417	58	B 2	3884.6	2.84	0.13	-39.85
6	2	3	1	2	6619	0.12	417	51	B 3	4633.3	-15.88	0.21	-4.71
7	3	1	3	2	4287	0.05	512	28	C 1	4673.9	-16.90	0.31	41.23
8	3	2	1	3	4245	0.03	255	8	C 2	2992.0	25.17	0.15	-31.29
9	3	3	2	1	3172	0.11	256	27	C 3	4328.8	-8.27	0.19	-9.95
									D 1	3640.0	8.96	0.34	55.23
									D 2	4574.6	-14.42	0.13	-38.84
TOTAL					35984	1.95	3080	631	D 3	3780.1	5.46	0.18	-16.39
AVERAGE					3998.3	0.22	342.2	70.1		3998.3	0.00	0.22	0.00
MAXIMUM					6619.43	0.76	512	248		4732.4	25.17	0.46	111.65
MINIMUM					2817.6	0.03	150	8		2992.0	-18.36	0.06	-70.49

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 08007A PSI08007

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	765	0.93	399	371	A 1	1314.9	30.04	0.62	25.32
2	1	2	2	2	1905	0.19	193	37	A 2	2410.9	-28.28	0.48	-3.74
3	1	3	3	3	1274	0.74	399	294	A 3	1912.7	-1.77	0.39	-21.57
4	2	1	2	3	1899	0.17	479	80	B 1	1577.6	16.07	0.53	7.63
5	2	2	3	1	2350	0.54	503	274	B 2	2025.4	-7.76	0.42	-14.11
6	2	3	1	2	2983	0.72	593	360	B 3	2035.6	-8.31	0.53	6.48
7	3	1	3	2	2068	0.50	621	310	C 1	1856.2	1.24	0.73	47.19
8	3	2	1	3	1820	0.54	322	173	C 2	1884.7	-0.28	0.16	-67.28
9	3	3	2	1	1849	0.13	324	41	C 3	1897.6	-0.96	0.59	20.08
									D 1	1654.9	11.95	0.53	7.97
									D 2	2318.9	-23.38	0.47	-5.15
			TOTAL		16916	4.45	3743	1940	D 3	1664.7	11.43	0.48	-2.82
			AVERAGE		1879.5	0.49	415.9	215.6		1879.5	0.00	0.49	0.00
			MAXIMUM		2983.14	0.93	621	371		2410.9	30.04	0.73	47.19
			MINIMUM		765.01	0.13	193	37		1314.9	-28.28	0.16	-67.28

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 04542A PS104542

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	813	0.87	425	370	A 1	675.9	39.75	0.82	23.49
2	1	2	2	2	571	0.71	217	154	A 2	1269.1	-13.13	0.65	-1.76
3	1	3	3	3	644	0.88	425	376	A 3	1420.6	-26.63	0.52	-21.74
4	2	1	2	3	572	0.55	552	306	B 1	1114.4	0.66	0.67	1.38
5	2	2	3	1	1232	0.70	568	395	B 2	1170.5	-4.33	0.71	6.12
6	2	3	1	2	2003	0.71	568	404	B 3	1080.7	3.67	0.62	-7.50
7	3	1	3	2	1958	0.60	1206	722	C 1	1507.8	-34.40	0.75	14.97
8	3	2	1	3	1708	0.71	610	435	C 2	579.6	48.33	0.50	-24.13
9	3	3	2	1	596	0.25	607	152	C 3	1278.2	-13.93	0.73	9.15
									D 1	880.2	21.54	0.61	-9.00
									D 2	1510.7	-34.66	0.67	1.18
			TOTAL		10097	5.99	5178	3314	D 3	974.6	13.13	0.72	7.82
			AVERAGE		1121.9	0.67	575.3	368.2		1121.9	0.00	0.67	0.00
			MAXIMUM		2002.76	0.88	1206	722		1510.7	48.33	0.82	23.49
			MINIMUM		571.14	0.25	217	152		579.6	-34.66	0.50	-24.13

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : 5A RCC : MATPSI PCN: 10598A PSI10598

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	671	0.89	235	208	A 1	551.2	33.24	0.81	10.92
2	1	2	2	2	515	0.62	130	80	A 2	898.5	-8.82	0.74	0.53
3	1	3	3	3	467	0.94	235	221	A 3	1027.2	-24.42	0.65	-11.46
4	2	1	2	3	545	0.70	235	164	B 1	843.4	-2.16	0.76	3.54
5	2	2	3	1	817	0.76	243	184	B 2	831.9	-0.75	0.68	-7.11
6	2	3	1	2	1334	0.76	243	184	B 3	801.6	2.91	0.76	3.57
7	3	1	3	2	1314	0.70	243	169	C 1	1056.2	-27.93	0.77	5.14
8	3	2	1	3	1164	0.67	140	94	C 2	554.5	32.83	0.63	-13.89
9	3	3	2	1	604	0.58	141	82	C 3	866.1	-4.90	0.80	8.75
									D 1	697.4	15.54	0.74	1.06
									D 2	1054.3	-27.70	0.69	-6.02
			TOTAL		7431	6.60	1845	1386	D 3	725.2	12.16	0.77	4.96
			AVERAGE		825.6	0.73	205.0	154.0		825.6	0.00	0.73	0.00
			MAXIMUM		1333.68	0.94	243	221		1056.2	33.24	0.81	10.92
			MINIMUM		467.21	0.58	130	80		551.2	-27.93	0.63	-13.89

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 10718A PSI10718

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	902	0.91	258	235	A 1	812.2	29.72	0.78	33.46
2	1	2	2	2	649	0.55	122	67	A 2	1093.3	5.39	0.62	5.98
3	1	3	3	3	886	0.88	258	227	A 3	1561.2	-35.10	0.35	-39.44
4	2	1	2	3	760	0.38	335	127	B 1	1329.4	-15.04	0.57	-2.60
5	2	2	3	1	970	0.74	357	265	B 2	1054.9	8.71	0.58	-0.76
6	2	3	1	2	1551	0.74	357	263	B 3	1082.4	6.33	0.60	3.36
7	3	1	3	2	2327	0.42	553	231	C 1	1332.9	-15.34	0.70	19.54
8	3	2	1	3	1546	0.45	281	126	C 2	739.8	35.98	0.37	-35.39
9	3	3	2	1	811	0.20	281	55	C 3	1394.0	-20.63	0.68	16.35
									D 1	894.2	22.62	0.62	5.45
									D 2	1508.6	-30.55	0.57	-2.83
			TOTAL		10400	5.26	2802	1596	D 3	1063.9	7.93	0.57	-2.62
			AVERAGE		1155.6	0.58	311.3	177.3		1155.6	0.00	0.58	0.00
			MAXIMUM		2326.57	0.91	553	265		1561.2	35.98	0.78	33.46
			MINIMUM		648.81	0.20	122	55		739.8	-35.10	0.35	-39.44

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 12-Sep-89

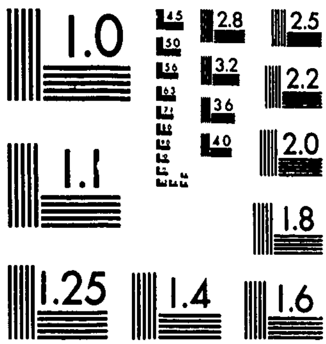
ALC : SA — RCC : MATPSI — PCN: 12712A — PSI12712

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	1230	0.85	144	123	A 1	1344.5	29.00	0.81	58.08
2	1	2	2	2	606	0.96	69	66	A 2	2652.7	-40.08	0.27	-46.90
3	1	3	3	3	2198	0.63	144	91	A 3	1684.1	11.07	0.46	-11.18
4	2	1	2	3	633	0.69	178	123	B 1	1385.6	26.84	0.61	17.46
5	2	2	3	1	2965	0.08	193	15	B 2	1897.1	-0.17	0.46	-11.49
6	2	3	1	2	4360	0.05	193	10	B 3	2398.7	-26.66	0.48	-5.97
7	3	1	3	2	2294	0.27	189	51	C 1	2570.0	-35.71	0.41	-19.80
8	3	2	1	3	2121	0.33	81	27	C 2	625.7	66.96	0.81	56.41
9	3	3	2	1	638	0.77	78	60	C 3	2485.6	-31.25	0.33	-36.51
									D 1	1610.9	14.94	0.57	10.09
									D 2	2419.6	-27.77	0.43	-17.28
			TOTAL		17044	4.64	1269	566	D 3	1650.6	12.83	0.55	7.19
			AVERAGE		1893.8	0.52	141.0	62.9		1893.8	0.00	0.52	0.00
			MAXIMUM		4359.72	0.96	193	123		2652.7	66.96	0.81	58.08
			MINIMUM		605.52	0.05	69	10		625.7	-40.08	0.27	-46.90

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 13081A PSI13081

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	429	0.72	107	77	A 1	637.2	34.69	0.56	-4.84
2	1	2	2	2	912	0.35	68	24	A 2	903.9	7.35	0.73	23.86
3	1	3	3	3	570	0.62	107	66	A 3	1386.0	-42.05	0.48	-19.02
4	2	1	2	3	810	0.38	139	53	B 1	1105.8	-13.33	0.57	-3.45
5	2	2	3	1	785	0.83	137	114	B 2	1019.6	-4.50	0.58	-2.01
6	2	3	1	2	1116	0.99	137	135	B 3	801.8	17.83	0.62	5.46
7	3	1	3	2	2078	0.61	168	103	C 1	969.0	0.69	0.75	27.28
8	3	2	1	3	1361	0.55	101	56	C 2	813.8	16.59	0.33	-43.43
9	3	3	2	1	719	0.27	100	27	C 3	1144.3	-17.29	0.69	16.15
									D 1	644.6	33.93	0.61	2.62
									D 2	1368.7	-40.28	0.65	9.92
			TOTAL		8781	5.33	1064	655	D 3	913.8	6.34	0.52	-12.54
			AVERAGE		975.7	0.59	118.2	72.8		975.7	0.00	0.59	0.00
			MAXIMUM		2077.59	0.99	168	135		1386.0	34.69	0.75	27.28
			MINIMUM		429.47	0.27	68	24		637.2	-42.05	0.33	-43.43



MICROCOPY RESOLUTION TEST CHART
NATIONAL BUREAU OF STANDARDS-1963-A

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89
ALC : SA RCC : MATPSI PCN: 13094A PSI13094

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	791	1.02	185	188	A 1	886.7	36.50	0.74	21.03
2	1	2	2	2	1108	0.34	113	38	A 2	1592.0	-14.01	0.61	-0.47
3	1	3	3	3	761	0.87	185	161	A 3	1710.5	-22.49	0.49	-20.55
4	2	1	2	3	1099	0.29	240	70	B 1	1343.9	3.76	0.65	6.53
5	2	2	3	1	1718	0.71	248	176	B 2	1558.8	-11.63	0.56	-9.09
6	2	3	1	2	1960	0.83	248	205	B 3	1286.5	7.87	0.63	2.56
7	3	1	3	2	2142	0.65	296	192	C 1	1533.8	-9.83	0.82	34.30
8	3	2	1	3	1850	0.62	186	116	C 2	1115.3	20.13	0.27	-55.64
9	3	3	2	1	1139	0.19	182	34	C 3	1540.2	-10.29	0.74	21.34
									D 1	1216.1	12.91	0.64	4.14
									D 2	1736.6	-24.36	0.60	-1.37
			TOTAL		12568	5.51	1883	1180	D 3	1236.6	11.45	0.60	-2.78
			AVERAGE		1396.4	0.61	209.2	131.1		1396.4	0.00	0.61	0.00
			MAXIMUM		2141.95	1.02	296	205		1736.6	36.50	0.82	34.30
			MINIMUM		760.76	0.19	113	34		886.7	-24.36	0.27	-55.64

TAGUCHI EXPERIMENT ANALYSIS　　　　　　　　　　　　　　　　L9 ARRAY　　　　12-Sep-89

ALC : SA　　　　RCC : MATPSI　　　　PCN: 13095A　　　　　　　　　　　　PSI13095

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	626	0.99	212	210	A 1	733.5	42.70	0.79	23.31
2	1	2	2	2	966	0.46	112	52	A 2	1577.8	-23.27	0.64	-0.31
3	1	3	3	3	608	0.92	212	195	A 3	1528.7	-19.43	0.49	-23.00
4	2	1	2	3	933	0.41	279	114	B 1	1247.8	2.52	0.67	3.85
5	2	2	3	1	1718	0.71	272	193	B 2	1396.8	-9.13	0.58	-9.62
6	2	3	1	2	2083	0.80	272	218	B 3	1195.4	6.61	0.68	5.77
7	3	1	3	2	2184	0.60	333	200	C 1	1405.2	-9.78	0.79	22.49
8	3	2	1	3	1507	0.57	180	102	C 2	931.6	27.22	0.40	-38.29
9	3	3	2	1	895	0.32	187	59	C 3	1503.3	-17.44	0.74	15.80
									D 1	1079.7	15.65	0.67	4.67
									D 2	1744.4	-36.28	0.62	-3.08
			TOTAL		11520	5.78	2059	1343	D 3	1015.8	20.64	0.63	-1.59
			AVERAGE		1280.0	0.64	228.8	149.2		1280.0	0.00	0.64	0.00
			MAXIMUM		2184.16	0.99	333	218		1744.4	42.70	0.79	23.31
			MINIMUM		607.99	0.32	112	52		733.5	-36.28	0.40	-38.29

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 12-Sep-89

ALC : SA RCC : MATPSI PCN: 13096A PSI13096

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	TOTAL INDUCTED FOR RUN	NET THRU PUT FOR RUN	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	1142	0.73	208	151	A 1	1145.0	30.47	0.57	29.66
2	1	2	2	2	1091	0.37	60	22	A 2	2048.0	-24.36	0.32	-26.18
3	1	3	3	3	1203	0.61	208	126	A 3	1747.6	-6.12	0.42	-3.47
4	2	1	2	3	1018	0.16	270	43	B 1	1483.8	9.90	0.42	-2.80
5	2	2	3	1	2539	0.37	260	96	B 2	1839.1	-11.67	0.45	3.53
6	2	3	1	2	2587	0.44	260	114	B 3	1617.7	1.77	0.43	-0.73
7	3	1	3	2	2292	0.39	268	104	C 1	1972.0	-13.67	0.59	36.24
8	3	2	1	3	1887	0.62	79	49	C 2	1057.1	35.81	0.26	-40.30
9	3	3	2	1	1063	0.26	82	21	C 3	2011.4	-22.13	0.45	4.06
									D 1	1581.5	3.97	0.45	3.16
									D 2	1989.9	-20.83	0.40	-8.91
			TOTAL		14822	3.93	1695	726	D 3	1359.2	16.86	0.46	5.75
			AVERAGE		1646.8	0.44	188.3	80.7		1646.8	0.00	0.44	0.00
			MAXIMUM		2587.03	0.73	270	151		2048.0	35.81	0.59	36.24
			MINIMUM		1017.62	0.16	60	21		1057.1	-24.36	0.26	-40.30

8.6.2 STATISTICAL SYSTEM PERFORMANCE MEASURES

The SA-ALC/MDMSC Technology Insertion team collected data on current MATPSI operations by interviewing operators, inspectors, supervisors, planners, and engineers. The data was for profiling 12 end items (PCNs) for characterization in the UDOS 2.0 simulation model. The data were loaded into a "flat file" which could be run with the model to uniquely represent this RCC. This flat file was validated on the model at SA-ALC as reported in the validation minutes submitted by MDMSC to HQ AFLC in letter NKE-E016-xx-1, dated 19 July 1989.

The quality characteristics tested in the model are throughput and flow time, and the independent variables for the stochastic model simulation are manpower and equipment. For the validation throughput was measured by comparing the number of end items completed by the UDOS model to actual FY 88 output. Criteria for successful validation were established by SA-ALC and AFLC and were agreed to by MDMSC. Those criteria were (1) throughput variance not to exceed 10% compared to the established benchmark, and (2) flow time variance not to exceed 15% compared to the established benchmark. The benchmark was intended to be historical data, but historical data (provided via WCDs) was hopelessly inadequate. ~~As discussed above~~ WCDs were reviewed and PAC stamp dates for induction, sell and operations were entered into MDMSC's computer data base. However, review of the WCD's revealed that (1) some WCDs were missing, some had no induction and/or sell dates, and most had been gang-stamped. It was very apparent that the resulting flow times would be highly suspicious and inaccurate. This assessment was shared by SA ALC engineering, planning and management, and was corroborated by the AFLC representative (Trixie Brown) during the July validation.

Flow times (based on a 24-hour period) from the simulation were compared history and, when history data was judged inadequate, G019C Report average flow times (days converted to hours) and supervisors' estimates were used. Since the G019C flow times are mathematically computed times, and are not historical, supervisors estimates were used as the more realistic benchmark for much of the validation. Results of the validation are discussed further in section 8.0

Following the validation of all three Block I RCCs, a joint brainstorming session was held in which representatives from all three RCCs participated. The session was conducted by MDMSC on site at SA-ALC. Participants provided a list of concerns or things they wanted to see improved within their respective RCCs — factors which could be tested by the model. Specific focus studies or quick fixes were not specifically addressed during the factor listing process. The approach was to have experienced personnel ~~[illegible]~~ identify key problems or concerns in their respective operations area as candidates for experimentation.

The control factors chosen are shown in the Taguchi orthogonal array in Table 8.6.2-1, ~~[illegible]~~. Although the cleaning area is a known production problem area (bottleneck, unclean environment), it was not addressed by the SA-ALC attendees. Also, the proposed new cleaning area in Bldg 329 and the imminent material movement systems ~~[illegible]~~ and storage relocation and modification were not discussed. During process characterization it was noted that there was a shortage of trained inspectors in MATPSC, so this was one manpower control factor that the brainstorming participants chose to experiment with. Induction strategy was a control factor SA-ALC wanted to experiment with because of the queuing and storage of WIP. Workload, more of a noise factor, was looked at to test capacity.

The surge workload figures were provided by HQ AFLC to assess performance capability under wartime conditions. The experiment results indicate that this RCC is already working near capacity and that it would be incapable of meeting surge workload requirements in its present configuration. Only approximately 45% of required throughput was obtained in the experiment, the most critical factor being the availability and adequacy of cleaning and sandblasting personnel. Fluorescent penetrant dye inspection personnel and limited fluorescent penetrant inspection (FPI) equipment availability also pose bottleneck problems. (See a summary of experimentation results in Table 8.6.2-2

The factor of leveled inductions produced significantly better (shorter) flow times, but severely decreased throughput. This effect continued through 130% and surge workload runs.

Bi... cont'd

The factor adding 20 ~~additional~~ inspectors (trained or untrained) resulted in no significant improvements, disproving the claim that new inspectors would improve operations. The model results do not indicate this area to be a bottleneck. ~~though that in itself, does not say new inspectors are not needed, or the~~ If existing inspectors, or those who are temporarily borrowed for inspection, meet acceptable standards of training and job knowledge, the current workforce in this area should suffice.

The most heavily used resources in the experimentation were the cleaning and sandblasting personnel with a normal utilization rate of 90%. Under surge and 130% workloads the rate increases to 100%, ~~and~~ queues form, and throughput drops rapidly. This area is a bottleneck. MDMSC does not have sufficient information to determine whether the reorganization of the cleaning facility will change this problem. (At last discussion on the topic, the facility modification was scheduled for fourth quarter FY89.)

On the basis of the experimentation results, MDMSC offers the following comments:

- The cleaning and sandblasting area staffing should be reviewed, as should the respective equipment. Operating second and/or third shift would most likely improve throughput. In surge conditions additional personnel and equipment will most likely be required. Also, some personnel in other RCC's in MAT and in other areas of MATPSI should be crosstrained to provide backup assistance.

- Further experimentation should be conducted with the new cleaning facility equipment, process and personnel capabilities. The current model flat file for MATPSI will have to be modified accordingly. The experimentation should show whether improvement in resource use, flow time and throughput improve.

- Further experimentation should be performed with the UDAS 2.0 model to assess the impact of training and shiftwork discussed above. This experimentation should include work-in-process limits to optimize induction rates and ensure balanced flow and maximum throughput capacity.

9.1 GENERAL DESCRIPTION OF FACTORS AND LEVELS

FACTOR NAME	LEVELS 1	LEVELS 2	LEVELS 3
A) WORKLOAD	FY88	FY88 +30%	SURGE
B) INSPECTOR MANPOWER	AS IS	+20 INSPECTORS TRAINED	+20 INSPECTORS UNTRAINED
C) INDUCTION SCHEDULE	PARTS INDUCTED INTO FULL SHOP	LEVEL INDUCTION: WORK-IN-PROCESS HELD TO 25% OF SMALLEST FY88 QTR'S INDUCTIONS	PARTS INDUCTED INTO AN EMPTY SHOP
D) CHANGE OF MODEL RANDOM SEED	SEED 1	SEED 2	SEED 3

MATPSI

10.0 EXPERIMENTATION

The Factors and levels developed in the brainstorming session were fit into a Taguchi L(9) Orthogonal array for model experimentation. The use of this array reduced the number of runs required from 81 to 9. Because of the extremely volatile response of the UOOS model for this RCC (first observed during validation) an additional level of noise was added to the experiment. This was accomplished by varying the random seed (which drives the model) among three seeds. This was included in the array as factor D.

10.1 Table 10.1 is the orthogonal array used to design the experimentation for this RCC.

	A	B	C	D
EXP #	WORKLOAD	INSPECTORS	INDUCTIONS	NOISE
1	FY 88	AS IS	FULL	SEED 1
2	FY 88	+20 TRAINED	LEVEL	SEED 2
3	FY 88	+20 UNTRAINED	EMPTY	SEED 3
4	130%	AS IS	LEVEL	SEED 3
5	130%	+20 TRAINED	EMPTY	SEED 1
6	130%	+20 UNTRAINED	FULL	SEED 2
7	SURGE	AS IS	EMPTY	SEED 2
8	SURGE	+20 TRAINED	FULL	SEED 3
9	SURGE	+20 UNTRAINED	LEVEL	SEED 1

TABLE 10.1

10.2 CONDUCT OF THE EXPERIMENTS

APPENDIX —— provides the detailed results of the experiments. THE variance caused by changing random seeds was so significant that it invalidated the response for factor B (Throughput and Flowtime) and factor C (Flowtime only). Because of the very low signal to noise ratio found in this experiment, no optimal configuration of factors was calculated.

10.2.1 SURGE

Surge figures for PCN inductions were based on data provided by HQ-AFLC. This experiment revealed significant problems within MATPS2 that will allow only 45% of the required throughput under wartime surge conditions. This is described in ~~Paragraph~~ Paragraph 10.4

10.3 Results Summary - Normal work load

- Leveling the inductions (Factor C / Level 2) produced significantly improved Flowtimes but severely decreased throughput. This indicates that <u>the RCC is currently operating very near total capacity.</u> The effect continued through 130% and surge (approximately 160%) workload levels.

10.3 cont

- The addition of extra inspectors (trained or untrained) produced no significant improvements. The utilization of these workers was low. This area is not a bottleneck at any work load level.

- The single most utilized resource was cleaning and sandblasting personnel with utilization rates of over 90%. These personnel are the most significant bottleneck in this RCC. At 130% workload, their utilization rate reaches 100% and throughput begins to drop rapidly.

10.4 Results summary – Surge workload

- Under surge conditions, only 45% of required throughput was obtained. The most significant limiting factor was cleaning & sandblasting personnel, with NDI personnel running a close second. The NDI equipment was heavily taxed as well.

10.5 RECOMMENDATIONS

- MATPSI management should immediately consider shift work for cleaning and sandblasting workers. Any new additions to the work force should be in these skill areas.

- MATPSI management should consider an aggressive cross-training program between mechanics, cleaning and sandblasting workers, and NDI workers. An aggressive program to upgrade the skills of the "helper" workers should be mounted, or, a redesign of work assignments to increase the utilization of these workers should be undertaken.

- Further experimentation should be performed, using the UDOS 2.0 model, to assess the impact of the training and shift work described above. This experimentation should include work-in-process limits at several levels to optimize the rate of inductions and ensure a balanced flow and maximum capacity.

925-5764

9.0 MATPSI

Brainstorming

After completing validation of UDOS 2.0 simulation model for RCC MATPSI, a brainstorming session was conducted with personnel from SA-ALC and MDMSC. This session was facilitated by MDMSC -- and was designed to help SA-ALC personnel select those areas of the RCC which they would like as factors in model experimentation.

9.1 GENERAL DESCRIPTION OF FACTORS AND LEVELS

FACTOR NAME		LEVELS 1	2	3
A) WORKLOAD	:	FY88	FY88 + 30%	SURGE
B) INSPECTOR MANPOWER	:	AS IS	+ 20 INSPECTORS TRAINED	+ 20 INSPECTORS UNTRAINED
C) INDUCTION SCHEDULE	:	PARTS INDUCTED INTO FULL SHOP	LEVEL INDUCTION: WORK-IN-PROCESS HELD TO 25% OF SMALLEST FY88 QTR'S INDUCTIONS	PARTS INDUCTE INTO AN EMPTY SHOP
D) CHANGE OF MODEL RANDOM SEED	:	SEED 1	SEED 2	SEED 3

MATPSI

10.0 EXPERIMENTATION

The Factors and levels developed in the brainstorming session were fit into a Taguchi L(9) Orthogonal array for model experimentation. The use of this array reduced the number of runs required from 81 to 9. Because of the extremely volatile response of the UDOS model for this RCC (first observed during validation) an additional level of noise was added to the experiment. This was accomplished by varying the random seed which drives the model among three seeds. This was included in the array as factor D.

10.1 Table 10.1 is the orthogonal array used to design the experimentation for this RCC.

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3	FY 88	+20 UNTRAINED	EMPTY	SEED 3
4	130%	AS IS	LEVEL	SEED 3
5	130%	+20 TRAINED	EMPTY	SEED 1
6	130%	+20 UNTRAINED	FULL	SEED 2
7	SURGE	AS IS	EMPTY	SEED 2
8	SURGE	+20 TRAINED	FULL	SEED 3
9	SURGE	+20 UNTRAINED	LEVEL	SEED 1

TABLE 10.1

10.2 CONDUCT OF THE EXPERIMENTS

APPENDIX — provides the detailed results of the experiments. THE variance caused by changing random seeds was so significant that it invalidated the response for factor B (Throughput and Flowtime) and factor C (Flowtime only). Because of the very low signal to noise ratio found in this experiment, no optimal configuration of factors was calculated.

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Surge figures for PCN inductions were based on data provided by HQ-AFLC. This experiment revealed significant problems within MATPS2 that will allow only 45% of the required throughput under wartime surge conditions. This is described in Paragraph 10.4

10.3 Results Summary - Normal work load

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10.3 cont

- The addition of extra inspectors (trained or untrained) produced no significant improvements. The utilization of these workers was low. This area is not a bottleneck at any work load level.

- The single most utilized resource was cleaning and sandblasting personnel with utilization rates of over 90%. These personnel are the most significant bottleneck in this RCC. At 130% workload, their utilization rate reaches 100% and throughput begins to drop rapidly.

10.4 Results summary – Surge workload

- Under surge conditions, only 45% of required throughput was obtained. The most significant limiting factor was cleaning + sandblasting personnel, with NDI personnel running a close second. The NDI equipment was heavily taxed as well.

10.5 RECOMMENDATIONS

- MATPSI management should immediately consider shift work for cleaning and sandblasting workers. Any new additions to the work force should be in these skill areas.

- MATPSI management should consider an aggressive cross-training program between mechanics, cleaning and sandblasting workers, and NDI workers. An aggressive program to upgrade the skills of the "helper" workers should be mounted, or, a redesign of work assignments to increase the utilization of these workers should be undertaken.

- Further experimentation should be performed, using the UDOS 2.0 model, to assess the impact of the training and shift work described above. This experimentation should include work-in-process limits at several levels to optimize the rate of inductions and ensure a balanced flow and maximum capacity.

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

CONTROL NO. [illegible]-001

TYPE PROPOSAL

- ☒ QUICK FIX
- ☐ FOCUS STUDY
- ☐ OTHER ______

ALC SA DATE 5/8/89
RCC MATPSI ITEM NO. ______
NOUN INSPECTION

CURRENT METHOD = THERE ARE MANY PARTS THAT FLOW THRU INSPECTION REQUIRING ONLY A [illegible] (WG 7's & 12's) REMOVE [illegible] THE INSPECTORS (WG 9's & 10's) REMOVE VISUAL INSPECTION. THE WCD ALSO REQUIRES THAT THE NICKS AND BURRS AND CORROSION TREATS.

PROPOSED METHOD ESTABLISH ONE OR MORE INSPECTION STATIONS WHERE THIS INSPECTION AND REWORK WOULD BE ACCOMPLISHED BY LOWER GRADE INSPECTORS WITHIN THE INSPECTION AREA

BENEFIT OF CHANGE WOULD ELIMINATE THESE PARTS FROM BEING INSPECTED BY HIGHER GRADE LEVEL/HIGHER SKILL LEVEL/HIGHLY TRAINED INSPECTORS. COULD BE CONSIDERED AS AN ENTRY LEVEL/TRAINING POSITION FOR NEW INSPECTORS. WOULD REMOVE THIS TYPE OF INSPECTION AND REWORK FROM THE INSPECTION STATIONS/EQUIPMENT WHICH SHOULD BE DEVOTED TO MORE COMPLEX TYPE INSPECTIONS AND INCREASE THE THRU-PUT CAPACITY OF THESE STATIONS. SHOULD REDUCE THE FLOW TIME THRU THE INSPECTION PROCESS.

PRODUCTIVITY IMPROVEMENT SUMMARY

REDUCE INSPECTION COST AS A RESULT OF LOWER LABOR CLASSIFICATIONS, INCREASE THRU-PUT CAPACITY, AND REDUCE CYCLE TIMES.

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM
SERVICES PROGRAM

TI PROGRAM
TI PROGRAM

COST BENEFIT ANALYSIS REPORT

CONTROL NO. S[illegible]001

TYPE PROPOSAL

- [x] QUICK FIX #1
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC SA DATE 9 May '89
RCC MATPJL ITEM NO. ______
NOUN Work Station

CURRENT METHOD

All Certified Inspectors perform a visual inspection task which includes condeming or routing a part to a backshop for rework as well as inspecting for nicks and burrs and then applying corrosion proofing to any area that was smoothed or filed.

PROPOSED METHOD

Establish one or more work stations as a "First Point" of inspection where the above tasks are accomplished by a lower grade and skill level employee who is not a Certified Inspector.

BENEFIT OF CHANGE

Permit employee progression, releave high grade and skill level employees of low grade tasks, free up time on the computer controlled "APIS" equipment.

PRODUCTIVITY IMPROVEMENT SUMMARY

Improve morale and reduce costs plus increase machine (APIS) production.

LSC-20131A

BUTLER, B.
011
TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. SA-034

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC ALL DATE 13 JUN 89
RCC ALL ITEM NO. 7
NOUN INSPECTION

CURRENT METHOD: QDRs ARE WRITTEN DESCRIBING KNOWN DISCREPANCIES ON PARTS IN STORAGE. THE STORES MANAGER DECIDES ON HIS OWN INITIATIVE IF A PART SO DESCRIBED AS POTENTIALLY DISCREPANT WILL OR WILL NOT BE INSPECTED (SCREENED) FOR THE NOTED QDR DISCREPANCY PRIOR TO RELEASING THESE PARTS FROM THE STORAGE AREA. THIS AFFECTS PRODUCTIVITY AS BAD PARTS ARE FIRST DISCOVERED ON THE PRODUCTION FLOOR.

PROPOSED METHOD: REQUIRE ALL PARTS IN STORES TO BE SCREENED FOR QDR NOTED DISCREPANCIES ACCORDING TO A SET CRITERIA RELATING TO THE NUMBER OF PARTS OR THE NUMBER OF TIMES A PART IS FOUND TO BE DISCREPANT ON THE PRODUCTION FLOOR.

BENEFIT OF CHANGE: PRODUCTIVITY WILL NOT BE IMPACTED IF DISCREPANT PARTS ARE REMOVED FROM STORES BEFORE SENDING THESE SCREENED PARTS TO THE PRODUCTION FLOOR.

PRODUCTIVITY IMPROVEMENT SUMMARY: DOWNTIME AND FLOWTIME WILL BE REDUCED BY REMOVING DISCREPANT PARTS FROM SUSPECT LOTS OF PARTS IN STORAGE PRIOR TO SENDING THESE PARTS INTO PRODUCTION.

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

306

CONTROL NO. SA - 36

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

☒ QUICK FIX
☐ FOCUS STUDY
☐ OTHER ______

ALC COMMAND WIDE DATE 24 MAY 89
RCC ______ ITEM NO. ______
NOUN QDR IMPROVEMENT (QUALITY DISCREPANCY REPORT)

CURRENT METHOD: USUALLY ONLY THE OUTER PACKAGE OF NEWLY RECEIVED PARTS CONTAINS CONTRACT NO., VENDOR CODE AND DATE OF MANUFACTURE, ONCE THE OUTER PACKAGE IS REMOVED THIS INFORMATION IS LOST. IF THE PART IS DEFECTIVE A QDR IS WRITTEN FOR SUPPLIER ACTION. SOME SUPPLIERS WILL NOT ACCEPT RESPONSIBILITY FOR THE DEFECT UNLESS THE ABOVE INFORMATION IS SUPPLIED

PROPOSED METHOD / INCLUDE IN THE GENERAL CONTRACT PURCHASE ORDER (P.O.) A REQUIREMENT THAT THE CONTRACT NUMBER, VENDOR CODE & DATE OF MANUFACTURE BE INCLUDED ON EACH PART ITSELF, EITHER BY RUBBER STAMP, TAG OR OTHER NON-CORROSIVE METHOD. SMALL PARTS AND EXSISTING PARTS IN THE SYSTEM SHOULD HAVE A TAG ATTACHED TO THE PART WITH THE ABOVE INFORMATION.

BENEFIT OF CHANGE; FULL CREDIT FOR ALC'S FROM SUPPLIERS DUE TO DISCREPANT PARTS UNDER WARRANTY, RESULTING IN COST & TIME SAVINGS.

PRODUCTIVITY IMPROVEMENT SUMMARY: LESS DOWNTIME FROM DISCREPANT NEW PARTS DUE TO SUPPLIERS REFUSING TO TAKE RESPONSIBILITY FOR LACK OF INFORMATION.

LSC 2011A

Control Number SA-027
Date: 26 May 89
Subject: Evaluation & Inspection (E&I) Coordinate Measurement Machine (CMM) Operation. Improve Accuracy and Integrity of the CMMs.

Proposed Method: Provide year round temperature, humidity and particulate controls within the E&I CMM room. 1. Restrict personnel access to room. 2. Provide a doorway airlock. 3. Improve personnel protective clothing. 4. Wipe trays with lint catching cloth. 5. Regulate and filter CMM room air.

Evaluation: 1. The E&I room is officially classified as a 300,000 class controlled environment as provided in T.O. 00-25-203. This covers all the items proposed including the following:

a. Room temperature should not exceed 80°F.
b. Humidity should not exceed 50%.
c. Room should have positive pressure.
d. The particle tolerance count shall be no more than 300,000 particles 0.5 micron and per cubic foot of air or no more than 1,000 particles 5.0 microns and larger per cubic foot of air when measured with automatic particle counters.
e. The Air Handling Unit (AHU) should be designed to provide 10 air changes per hour.

A clean room officer has been monitoring this room at least once a month for compliance. We have also recently added diffusers and increased the capacity of the AHU blower for better control of the room temperature. In the past three years of operation, there has only been one APIS shut down directly attributable to the environmental condition of the room.

2. In addition, there is an existing SARPMA project (SA-89-0390) that would correct any deviation from the 300,000 class environment dictated by T.O. 00-25-203.

3. The CMMs of the APIS is considered by the metrology industry as being one of the most accurate and most repeatable that the market can offer. It has a linear accuracy of +/- 0.0002" and repeatable to 0.0001". Any CMM that would have a better accuracy certification would require laboratory type conditions and would not be ideal for a production type environment.

POC: Manuel R. Diego, MATEA, 54323

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

CONTROL NO. S, 027

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC SA DATE 26 MAY 89
RCC MAT PSI ITEM NO. CMM
NOUN E&I CMM OPERATIONS (EVALUATION AND INSPECTION) (COORDINATE MEASURING MACHINE)

CURRENT METHOD: ACTUAL E&I CMM OPERATIONS ARE VERY GOOD. THE OPERATIONS OF THE CMM ARE SUSPENDED OR DELAYED AT TIMES ESPECIALLY DURING THE SUMMER BECAUSE ENVIRONMENTAL CONDITIONS RENDER THE CMM RESULTS UNRELIABLE.

PROPOSED METHOD: PROVIDE YEAR ROUND TEMPERATURE, HUMIDITY AND PARTICULATE CONTROLS WITHIN THE E&I CMM ROOM. 1 RESTRICT PERSONNEL ACCESS TO ROOM 2 PROVIDE A DOORWAY AIRLOCK 3 IMPROVE PERSONNEL PROTECTIVE CLOTHING. 4 WIPE TRAYS WITH LINT-CATCHING CLOTH 5 REGULATE & FILTER CMM ROOM AIR.

BENEFIT OF CHANGE: 1 BETTER UTILIZATION OF E&I PERSONNEL 2 INCREASE PRODUCTIVITY DUE TO LESS DOWNTIME 3 MAINTAIN CONSISTANT AND ACCURATE CMM READINGS.

PRODUCTIVITY IMPROVEMENT SUMMARY: LESS E&I DOWNTIME FROM ENVIRONMENTAL CONDITIONS WILL INCREASE PRODUCTIVITY.

LSC 70131A

Subject: Control Number SA-028
Date: 25 May 89
Noun: Auto Prompting Inspection System (APIS) Operations

Proposed Methods: Add a mouse to the APIS display terminal so that inspector can mark on the display and store the information. During an engineering review, the information can be recalled and combined with the stored information of other parts to reveal where any consistent failures in the part may be occurring. Engineering could then buttress the part in the areas of consistent failures.

Evaluation: 1. The APIS software is not currently storing the graphics portion of each part being inspected. The APIS is storing text data gathered during the inspection. Should the software be changed to be able to store the graphics data, then the APIS will need a significant increase in cost for added memory capacity, additional workstation hardware and software modification. Estimated cost is at least $500,000.

2. The APIS inspector will require added skill to mark the feature. This would require added training and added time for the labor standard.

3. Present text data stored can reveal consistent failure rate on a feature if a trend does occur. The APIS has a statistical process control program that does charting (pie and bar) of any feature that engineering may need to review. It also makes available the failure rate according to part numbers, end items, stock numbers, bar code numbers by inspector or workstation number. The data can go as far back as a year. Although the graphics data is not stored, the result is still the same as recommended.

POC: Manuel R. Diego, MATEA, 54323

620

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 51. 028

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☒ QUICK FIX
- ☐ FOCUS STUDY
- ☐ OTHER ________

ALC SA-ALC DATE 25MAY89
RCC ~~ALC~~ MATPI ITEM NO. APIS
NOUN APIS OPERATIONS
(AUTOMATED PROMPTING INSPECTION STATION)

CURRENT METHOD: THE APIS PICTORIALLY DISPLAYS EACH FIELD RETURNED PART AFTER IT IS MEASURED. AN INSPECTOR THEN COMPARES THE PART WITH ITS VISUAL REPRESENTATION. THE APIS THEN PROMPS THE INSPECTOR TO ANSWER A SERIES OF QUESTIONS IN ORDER TO EVALUATE THE PART FOR AREAS OF REPAIR. FINALLY A WCD IS GENERATED FOR THE REPAIR OF THE PART

PROPOSED METHOD: 1 ADD A MOUSE TO THE APIS DISPLAY TERMINALS SO INSPECTORS CAN MARK THE LOCATION OF NEEDED REPAIRS ON THE DISPLAY. AND STORE THE INFORMATION DURING AN ENGINEERING REVIEW, ~~THE~~ INFORMATION COULD BE RECALLED AND COMBINED WITH STORED INFORMATION OF OTHER PARTS TO REVEAL WHERE ANY CONSISTENT FAILURES IN THE PART MAY BE OCCURRING. ENGINEERING COULD THEN BUTTRESS THE PART IN THE AREAS OF CONSISTENT FAILURES.

BENEFIT OF CHANGE FEWER REPAIRS AND IMPROVED PARTS WITH LESS EQUIPMENT AND MATERIAL USAGE RESULTS IN COST SAVINGS. IMPROVEMENTS IN PART DEFECT IDENTIFICATION + PART DESIGN AND/OR REPAIR WILL IMPROVE QUALITY

PRODUCTIVITY IMPROVEMENT SUMMARY: 1 LESS REPETITIVE FAILURES WILL RESULT IN GREATER OVERALL REFURBISHMENT OUTPUT WITHOUT INCREASING THE WORKFORCE 2 E&I IMPROVEMENT WILL RESULT FROM FEWER REPETITIVE FAILURES. 3

28 APR 89 @ SA-ALC 619 ✓ PAGE 2

IMPROVEMENT RECOMMENDATIONS

— AS IS CONDITION: PLANNING PROCEDURES FOR THE SAME OR SIMILAR PARTS ARE WRITTEN DIFFERENTLY BY DIFFERENT PLANNERS. THIS MAKES A REVIEW OF THESE OPERATIONS DIFFICULT AND COMPLEX WHEN TRYING TO CHARACTERIZE THE EQUIPMENT, MANPOWER, AND CYCLE TIMES.

— RECOMMENDATION — PLANNING SEQUENCES SHOULD BE AS STANDARDIZED AND CONSISTANT AS POSSIBLE FOR LIKE PROCESSES AND OPERATIONS. PLANNERS NEED TO BE COORDINATED THROUGH TRAINING AND SUPERVISED DIRECTION AND WORK REVIEW UNTIL PLANNING SEQUENCE STANDARDIZATION IS ACHIEVED.

5/22/89

J. Eaton

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

CONTROL NO. SA-26

TYPE PROPOSAL

- [x] QUICK FIX #9
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC SA DATE 15 May 89
RCC MATPSL ITEM NO. ______
NOUN Carts

CURRENT METHOD

4 Wheel carts with 3 shelves (18"x30"x30") are used throughout the MATPSL area for moving parts and/or plastic boxes. There is a shortage of these carts.

PROPOSED METHOD

Procure additional carts.

BENEFIT OF CHANGE

Expedite parts movement saving time lost by Inspectors in walking around looking for a cart to use.

PRODUCTIVITY IMPROVEMENT SUMMARY

Increase production by saving wasted manhours.

LSC 20131A

5/20/89

J. Eaton

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

CONTROL NO. SA- 5

TYPE PROPOSAL

- ☒ QUICK FIX #8
- ☐ FOCUS STUDY
- ☐ OTHER ______

ALC SA DATE 12 May 89
RCC MATRSL ITEM NO. ______
NOUN Temp Parts Storage

CURRENT METHOD

Incoming and outgoing parts in the Inspection & Cleaning areas are placed in 24"x 24"x 10" plastic boxes and stacked on each other throughout each area. Workers can not easily locate their desired part but must shuffle the plastic boxes around so they can locate the necessary part.

PROPOSED METHOD

Purchase or locally manufacture racks for temporary storage of boxes. Also, designate areas for certain parts to be in temporary storage so they can easily be located.

BENEFIT OF CHANGE

Area is neat and time saved by workers in locating parts.

PRODUCTIVITY IMPROVEMENT SUMMARY

Area improvement plus increased production at minimal cost.

LSC 7013A

5/22/89

J. Eaton

CONTROL NO. SA- 14

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX #7
- [ ] FOCUS STUDY
- [ ] OTHER

ALC SA DATE May 12 '89
RCC MATRSI ITEM NO.
NOUN Sonic Cleaner

CURRENT METHOD

A sonic cleaner is located approximately 50 feet away from the basic cleaning area. The equipment receives a lot of usage and requires the operator to constantly walk back and forth.

PROPOSED METHOD

Relocate the sonic cleaner to a point within the basic cleaning area.

BENEFIT OF CHANGE

Reduce employee fatigue due to walking and carrying or pushing parts.
Reduce transit time.

PRODUCTIVITY IMPROVEMENT SUMMARY

Easier and faster way to clean certain parts.

LSC 20131A

5/22/89

J. Eaton
6/12

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. SA-1 2

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX #5
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC SA DATE 10 May '89
RCC MATRSI ITEM NO. ______
NOUN SJT

CURRENT METHOD

The individual assigned as the Eddy Current Inspector is not familiar with those Work Control Documents (WCD) that specify eddy current inspection.

PROPOSED METHOD

Suggest his supervisor review appropriate WCDs with the designated Eddy Current Inspector and one or two alternates.

BENEFIT OF CHANGE

Increase operator efficiency.

PRODUCTIVITY IMPROVEMENT SUMMARY

Reduce operator time and increase production.

LSC 2013.1A

— PERHAPS HALF OR MORE OF THE TOTAL WORK BEING PERFORMED BY THE MATPSI GRADE LEVELS 09 & 10 INSPECTORS IS VISUALLY INSPECTING PARTS FOLLOWED BY REMOVING NICKS & BURRS, FOLLOWED BY A SPOT CORROSION TREATMENT. SOME PARTS (~20%) ARE VISUALLY CONDEMNED. A QUICK FIX OPPORTUNITY WOULD BE TO HAVE THIS WORK PERFORMED ON THESE PARTS BY GRADES 05, 06, OR 07 LEVEL INSPECTORS IMMEDIATELY FOLLOWING CLEANING, THUS FREEING THE 09 & 10 LEVEL INSPECTORS TO JUST PERFORM THE HIGH SKILL LEVEL DIMENSIONING WORK, FOR WHICH ONLY THEY ARE SPECIALLY QUALIFIED TO DO.

— 25% OF ALL PARTS NOW GO DIRECTLY TO THE PARTS POOL WITHOUT ANY INSPECTION AFTER CLEANING. THESE PARTS ARE ONLY INSPECTED JUST PRIOR TO INSTALLATION BY 09 & 10 GRADE LEVEL MECHANICS WHO SPEND MUCH OF THEIR TIME IN CONDEMNING PARTS THAT ARE UNACCEPTABLE.
A QUICK FIX OPPORTUNITY IS TO FIRST HAVE THESE PARTS VISUALLY INSPECTED BY LOWER GRADE INSPECTORS (AS ABOVE) IMMEDIATELY FOLLOWING CLEANING & SEND ONLY SERVICEABLE PARTS DIRECTLY TO THE PARTS POOL. THIS WILL FREE THE HIGHER GRADE MECHANICS TO SPEND THEIR TIME INSTALLING PARTS WITHOUT HAVING TO ADDITIONALLY USE THEIR TIME TO CONDEMN THEM AS WELL.

PIO QF

DATE: 5-15-89

ENGINEERING DATA (PIO)

PRODUCT: F15 AMAD LH + RH
RCC CODE: MATP3S
WCD: TA007K + TA278K
PCN: 08004A + 08005A
DISP./FS STATION:

These Disassembly WCD's on the AMAD need to be revised to place the present operation no. 40 at the start of the process. This would eliminate useless work on units which are subsequently condemned during that operation. Approximately one half hour of effort per condemned unit would be saved. Note: The more experienced operators are generally doing this now.

APH

A. Holm Same [illegible]

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. SH-039

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☐ FOCUS STUDY
- ☐ OTHER ________

ALC SA DATE 05-15-8[illegible]
RCC MMTP[illegible] ITEM NO. PCN# [illegible] 4A & #D80[illegible]5A
NOUN WCD# TA0[illegible]7K & TA278K

CURRENT METHOD
AMADs are currently being worked on and sometimes being condemned at step 40, an inspection step.

PROPOSED METHOD Disassembly WCD's on the AMAD need to be revised to place the present operation #40 at the start of the process. Inspect before working on unit.

BENEFIT OF CHANGE This would eliminate useless work on units which are subsequently condemned during that operation. Approximately one-half (1/2) hour of effort per condemned unit would be saved. NOTE: The more experienced operators are generally doing this now.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

E. TOTTEL CONTROL NO. SA- 49 SA049

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☒ QUICK FIX
- ☐ FOCUS STUDY
- ☐ OTHER ______

ALC SA DATE 8/10/89
RCC MATPSI ITEM NO. VARIOUS
NOUN PARTS HANDLING DAMAGE

CURRENT METHOD PREVENTABLE MINOR DAMAGE OCCURS WITH VARIOUS PARTS DUE TO MISHANDLING. PARTS WERE OBSERVED BEING THROWN APPROXIMATELY SIX FEET INTO A PLASTIC BASKET ON THE FLOOR AFTER REMOVAL FROM CLEANING VATS. PARTS INCUR DENTING AND/OR NICKING WHICH DEGRADES PART AND MAY REQUIRE MINOR REPAIR.

PROPOSED METHOD
ELIMINATE CARELESS HANDLING PRACTICES VIA SUPERVISORY TRAINING OF MECHANICS, UNANNOUNCED WALK-THROUGH INSPECTIONS BY SUPERVISOR, AND POSTING OF NOTICES ENCOURAGING CONCERN FOR QUALITY THROUGH PROPER HANDLING

BENEFIT OF CHANGE
- REDUCTION OF TIME REQUIRED TO REPAIR DAMAGE IN INSPECTION AND BACKSHOPS.
- PREVENTING DAMAGE WHICH MIGHT GO UNDETECTED AND WHICH COULD CONTRIBUTE TO SUBSEQUENT EQUIPMENT MALFUNCTION OR FAILURE
- NO COST TO IMPLEMENT

PRODUCTIVITY IMPROVEMENT SUMMARY
- REDUCE FLOW TIME
- POTENTIALLY INCREASE OUTPUT DUE TO LESS REJECTS/SCRAP.

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

EARL MARY
CONTROL NO. SA-050

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC SA **DATE** 8/13/89
RCC MATPSE **ITEM NO.** WCD
NOUN DESIGNATE CERTAIN PLANNERS TO SPECIALIZE IN INSPECTION PROCESSES.

CURRENT METHOD Presently there are (9) Planners responsible for preparing WCD's for MATPSI Inspection area. As a result, WCD's written to specify the inspection processes are written differently to accomplish the same inspections

PROPOSED METHOD Recommend that certain Planners be designated to specialize in inspection techniques, instruments and equipment and become experts in inspection processes.

BENEFIT OF CHANGE Standardization of WCD's which will reduce the number of different WCD's specifying same inspection processes. Reduction in planning support as a result of specialization by a few as opposed to generalization by many. Reduced cycle time to provide planning. Better utilization of inspection instruments, equipment and manpower. Standardization of inspection processes between the (3) inspection lines.

PRODUCTIVITY IMPROVEMENT SUMMARY
Reduce indirect planning support, reduce planning cycle times, achieve standardization of WCD's, and improve equipment utilization. These improvements will ultimately result in increased thru-put capacity.

LSC-20131A

8.6.v E TOTTEN

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. SA-C 2 SA052

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC SA **DATE** 8/13/89
RCC MATPSI **ITEM NO.** GTE AND STARTER PARTS
NOUN CHEMICAL CLEANING (FROM ENGRG NOTES)

CURRENT METHOD MANY ALUMINUM AND STAINLESS STEEL PARTS DISASSEMBLED FROM GTE'S, STARTERS AND OTHER END ITEMS ARE SENT BY MATPSI IN BLDG 329 TO MAEICN IN BLDG 360 FOR CHEMICAL CLEANING AND PAINT REMOVAL. MAEICN IS IN ENGINE DIVISION AND ASIGNS HIGHER PRIORITY TO AIRCRAFT ENGINE CLEANING THAN TO MATPSI WORK. EXCESS FLOW TIME RESULTS DUE TO TRANSIT AND QUEUE TIME. SOME PARTS CLEANED AT BLDG 360 ARE RETURNED TO BLDG 329 WHERE THEY SIT IN WEATHER OUTSIDE. RECLEANING AND SANDBLASTING IS OFTEN REQUIRED BECAUSE OF DRIED RESIDUE, RUST OR CORROSION.

PROPOSED METHOD

CONSTRUCT A SMALLER SCALE CHEMICAL CLEANING FACILITY IN BLDG 329 (CONCURRENT WITH LIFT PLAN CLEANING FACILITY MODIFICATION, IF POSSIBLE) TO CLEAN MAT PARTS. INSTALL PROPER TOXIC WASTE COLLECTION AND DISPOSAL CAPABILITY TO COMPLY WITH EPA REQUIREMENTS. INSTALL PROPER VENTILATION SYSTEM FOR CHEMICAL FUMES.

BENEFIT OF CHANGE

1) CONTROL OF CLEANING PROCESSES REQUIRED FOR MAT PARTS; HIGHER PRIORITY, REDUCED FLOW TIME
2) REDUCE RECLEANING/REWORK HOURS
3) PARTS REMAIN IN FLOW AT RATE CLOSER TO OTHER PARTS FROM ORIGINAL END ITEM.

PRODUCTIVITY IMPROVEMENT SUMMARY

1) REDUCED FLOW TIME
2) REDUCED WORK IN PROCESS INVENTORY, HENCE REDUCED COST
3) BETTER QUALITY CONTROL - LESS REWORK COST
4) SHORTEN OR REMOVE QUEUES.

LSC-20131A

GENERAL: BLDG 329 & 375

1. Operations of fork lift equipment needs to be reviewed for safety reasons. Observed careless and imprudent operation. Provide additional mirrors at aisle (blind) intersections.

   Pedestrian traffic aisles should be provided and marked to allow efficient flow of traffic for both employees and vehicular traffic.

2. WCD's are based on the TO Manuals and don't necessarily reflect what actually is being done in Production.
   - TO should be used as a reference document only when WCD is being written but Planner needs to review floor operations to establish proper sequence of operations and proper tool usage.
   - Tools should be called out on WCD to aide operator and eliminate unnecessary research of TO's by operators.
   - "Planner is responsible for accomplishing the think time so that operator only has to read and do."
   - In some cases, TO's are out of date calling for non-existent tools and processes and do not agree with tools that are being used.
   - WCD's are responsibility of Planners and do not appear to be dedicated to accurracy and reliability. WCD's are inconsistant in detail from Planner to Planner. One calls out tool and other will refer to TO by paragraph.

3. Mechanics time observed to be not fully utilized.
   - Allowed to spend too much time away form work station.
   - Chasing parts they need.
   - Long discussions between operators that didn't pertain to work (non-related subjects to work).
   - If they didn't have an item to work on they sat around.

Opinion: Most supervision has been elevated from mechanics force/ranks and continue to foster above problems; due to lack of management training or "don't rock the boat syndrome".

4. WCD - Inaccurate History - When an operation was completed the operator didn't stamp it off as complete at that time but waited until job was complete and then stamped operations at that time. Would give a false reading as to when work was actually completed.

F.S.#3 5. Inspection Area - Large backlog of work stored in tote boxes.

6. Parts System -

- While in Building 329, part of the Parts Pool was relocated. (GTE PARTS)
- Generally, parts storage and retrieval systems appeared to be antiquated and very inefficient. Many tote boxes sitting around.
- Appeared to have very little organization.
- Did not spend much time investigating this area therefore above observations are first impressions.
- In all RCC's it was mentioned that part shortages are one of their biggest problems.
- Many kits supplied to production with part shortages and shortages not identified and weren't discovered until mechanic started assembly.
- THIS AREA WOULD MAKE A GOOD FOCUS STUDY.
- Have plans for carousel but don't think funding approved at this time.

F.S.#1

7. WCD's should specify labor grades by operation. WCD's do not specify lowest labor grade required to perform an operation. Therefore, many instances observed where highest mechanic grade is performing the lowest labor grade work.

FS # 1 8. Improper handling and kitting of parts by material system has caused damage to parts therefore, mechanic inspects all parts before using part in assembly.

FS #3 9. Cleaning of Parts - Even though parts are sent to Building 360 for cleaning, many parts are recleaned in Building 329. Either provide Building 329 with their own total cleaning facility or make sure parts are cleaned thoroughly in Building 360 and eliminate cleaning facility in Building 329.

10. Sheltered work shops could be used to sort small expensive parts and also do simple inspections.

11. Training - It appears there are Journeymen Mechanics that are not fully qualified to perform all aspects of their job classification. There seems to be a perponderance of WG-10's verses other labor grades. Is there justification for this situation?

FS # 12. Tools - Mechanics stated that bad/worn tools are turned in to tool crib and replacement tools issued are just as bad/worn as tools turned in. Its quite a hassle to get a good/useable tool.

- Many tools are poor quality.
- Operators prohibited from bringing own tools in.

13. Facility Layout - Each major part has its own room/area (air conditioned). It appears better utilization of space and manpower could be achieved if some of these were combined.

- Not overly impressed with general flow and movement of material.

14. Setting up equipment and room with new equipment for purpose of doing their own balancing of rotating components. Is this redundant with existing capabilities?

QE #5 15. There's a lot of material movement accomplished by WG-10 mechanics that could by handled by a lower grade material handling personnel if these people existed.

16. Time Standards - In most cases observed, standards are in gross terms and can not be identified by operation sequence.

17. Parts Pool - Observed material personnel kititting parts. Totes boxes on floor and personnel was placing parts in eaeach tote box. This area apppears to need investigation to improve productivitity. (Comments made about carousels, reference paragraph 6).

18. Material - Engineer responsible to review rerejected parts for possiblee rework of rejected parts. This area is undederstaffed, therefore therere appears to be a large number of parts in thihis area. This is area Binn C Condemned Parts. MM Engineer can dispositicion to rework in house, sennd outside for rework or condemn.

TECHNOLOGY INSERTION ENGINEERING SERVICES
ENGINEERING NOTES

ALC

PAGE 1

RCC: GENERAL

NAME: E. L. MARTY

1. 3/31/89
Toured Bldg 329 with TI Team members for their familiarization of the facility.

2. Requested Workload requirements for FY 88? and latest facility layouts available from Juan Garza and Dan Gonzales MATEA. (x54667)

3. 4/3/89
Conducted TI Program briefing requested by Don Pyeka MAT Division Chief at 3:00 PM. He wanted to know what the purpose of our trip and what was to be accomplished.

Conway gave a synopsis of what has happened with the contract to date from the ACC point of view.

I gave my presentation as to what had transpired from MDMSC point of view and a detailed run down of the effort we are to put forth.

Attendees:
- Don Pyka - Division Chief - MAT
- Col. Blackwell - Deputy to Division Chief - MAT-1
- Vern Javer - Deputy Chief - MAT
- Jerry Kear - Engineering Branch Chief - MATE
- John Pike - Section Chief - MATEA
- Angelo Perez - Deputy Production - MATTP
- Juan Garza - Unit Chief Planning - MATEEA/G
- Danny Gonzales - Engineer - MATEA/G
- Bill Conway - TI Liaison - MAWFT
- Earl Mary - Site Leader - MDMSC
- Allen Holm - I.E.
- Kamal Attaria - I.E.
- Pat Chambers - I.E.
- Bill Morgan - I.E.

4. We have been provided a Conference Room to set up as our office in the sub assembly area of MATPGB.

A/C doesnt work.

A phone installed but doesn't have an outside line. We have to go thru operator or use Class A phone in Danny Gonzales' office.

5. 4/5/89
Ed Gill, Planner, MATEA came to office and informed us that he was assigned by Mike Beres, Function Chief, MATEA to support MAATPSI and MATPSS.

4/5/89 (Continued)
I gave him a brief indoctrination about the TI Program.

First info I requested from Ed Dill was info about skill codes and level.

6. 4/6/89
Problem with Badges for Restricted Area Bldg 375. CPI people and K. Attaria do not have Secret Clearances. It won't be a problem for A Holm and R Buttry because their Secret Clearances have been forwarded to Kelly AEC Security. Conway and Rudy Garcia working on this problem.

Jim Briers, Security Manager X54826.

7. 4/10/89
Got Contractors badges resolved.

Have to fill out Form 496 again. Originals can't be found. This form is required to get Base Badges.

Form 1199 Badges which permit access to Restricted Area Bldg 375 will not be issued to Morgan, Attaria and Chambers.

8 Requested G017 & G011 reports for MTTR and MTBF from Dan Gonzales.

9 4/20/89
Trixie Brown, Bill Conway and Earl Mary met with Ray Rangan, Section Chief Planning MATEA Bldg 375.

Trixie briefed Rangan on TI Program.

Ray stated he has people vs workload problems.

Ed Himes is candidate to support Taguchi and simulation and modeling.

Ken Janda took Trixie on tour of MABPSA, SB, SC & SP.

Trixie Brown briefed Ed Vander Pooten Branch Chief MATEA to solicite his support for TI Program.

10 4/21/89
The lack of a Class A telephone is creating a hardship.

11 6/10/89
General observation for Bldg 329 material handling and Parts Pool.

- Mechanics chase down parts shortages.
- Mechanics move parts and assemblies.
- Parts in tote boxes stacked on one another and in disorder.
- Some areas have racks for tote boxes and other areas don't.
- Some parts and tote boxes setting around and don't appear to have a home.
- Mechanics spend much time inventorying kits to ascertain if they have all parts and to identify part shortages before starting work.
- Parts Pool doesn't appear to be neat and orderly or organized and leads you to doubt the efficiency and accuracy of the work that is being accomplished.
- Without exception, all Mechanics interviewed stated that their biggest problem is part shortages.
- A Carousel material storage system would greatly enhance the Parts Pool operation. More parts would be concentrated in much less floor space and make parts retrieval/kitting less labor intensive. It would also provide a simple "First In - First out" system if so desired.

Note: Comments have been made by ALC personnel that a Carousel System has been considered for Bldg 329.

- Conditions as described above would require extensive analysis to validate and should be considered for a Focus Study.

TECHNOLOGY INSERTION ENGINEERING SERVICES
ENGINEERING NOTES

SA-ALC

PAGE 1

RCC: MATPSI

NAME: E.R. MARY

1 4/6/89
Jerry Keller - Unit Chief, MATPSSI & MATPSS informed of changes to RCC workload assignments and facility. MATPSI is being expanded to include all disassembly of PCN's appearing on 80/20 list for MATPS.

Note: The disassembly for (3) of the (9) PCN's was already assigned to MATPSI and the remaining (6) are being transferred at this time.

4/7/89
Talked to L. Mavros, MDMSC St. Louis, and he stated that above changes need to be documented.

2 4/13/89
Meeting with Dan Gonzales, MATEA, Ed Dill MATQA, Bill Conway MANF, Bob Buttery MDMSC, and Karl Mary MDMSC, to discuss possible ways to characterize "AS IS" condition of the inspection portion of MATPSI.

(500) parts not including (3) GTE'S.

Ed Dill still working on determining number of parts that are inspected on APIS and visual.

Instead of profiling individual parts, it was agreed we could group like items into families and profile the process for each family.

3 5/3/89
Chuck Gonzales MDMSC developed another concept for characterization of Inspection Area of MATPSI.

Chuck made presentation to ALC concurrence.
attendees: John Pike
Ed Dill
Bill Conway
Dan Gonzales
Juan Saliga
Bob Buttery
Jim Eaton
Chuck Gonzales
Karl Mary

Engineering Notes

5/22/89

4. During the "as is" characterization of the Inspection portion of MATPSI, the following problem has been recognized.

Approximately (75% or 600 parts) of the detail parts from the disassembly of (12) PCN's pass thru the Inspection area of MATPSI.

These (12) PCN's are the responsibility of (9) different Planners. as a result, WCD's written to specify the inspection processes are written differently to accomplish the same inspections. (see addition on next page).

Inspection is a technology/discipline requiring certain background/expertise and Shouldn't be the responsibility of multiple Planners that do not possess the detailed background required to properly define inspection processes. In addition, there are considerable tools and equipment utilized to accomplish inspection processes, much of which is technically complex and requires expertise to properly utilize.

Recommendation: To alleviate above problem, it is suggested that certain Planners be designated to specialize in inspection techniques and equipment and become experts in inspection processes.

Several things will be gained. Standardization of WCD's which will reduse the volume of different WCD's accomplishing same inspection processes. Reduction in support due to specialization by a few as opposed to generalization by many. Reduced cycle time to provide planning (WCD's). Better utilization of inspection equipment and manpower standardization of inspection processes between the (3) inspection lines.

attached are samples of WCD's to indicate the inconsistencies between WCD's to accomplish same inspection process

ADD TO PARA 1.2

Presently the Inspection Area is divided into (3) areas: GAS TURBINE ENGINES
STARTERS
F155/F16

Each area is supported by multiple Planners and each area has different planning to accomplish same inspections

MAG, VIS, DIM.

* WORK CONTROL DOCUMENT TTG686D * 1.DATE 87237 PAGE 1 OF 2 PAGES

2.PSSD/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
MTPSI	STEEL				89104	

9.MODEL/DESIGN/SERIES	10.NOUN	11.ITEM SERIAL NR
GTCP85-180	GEAR ASSEMBLY,GENERATOR DRIVE	

12.BCN 12A. SER NO.________	13.TECH DATA/OPTIONAL
	2G-GTCP85-43-6/-7

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN	BASKET NO. 14
75331-4	302000401118569YP	13095A	827193	<-5> ENGINE
75331-4	302000401118569YP	07604A	842513	<-7> ENGINE

18.DISP-STATION	19.PDN/OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
PSI6	010 MTPSI	MAGNETIC PARTICLE INSPECT IAW WP 005 00	N		
PSI6	020 MTPSI	VISUALLY INSPECT IAW WP 004 00, PARA. 6E, & FIGURE 1. (1) CRACKS (2) CORROSION (3) CHIPPED,BROKEN,WORN GEAR TEETH. (4) NICKS,SCORING,GOUGING OR BURRS. (5) LOOSENESS BETWEEN GEARS B & C, WITH PINS AND SCREWS INSTALLED. (6) PIN HOLES FOR ENLARGEMENT.	M		
PSI6	030 MTPSI	DIMENSIONALLY INSPECT IAW WP 004 00, PARA. 6E, & FIGURE 1. (1) DIAMETER -A- (2) DIAMETER -D- (3) GEAR -C- TEETH (4) GEAR -B- TEETH	M		
PSI6	040 MTPSI	CORROSION TREAT SERVICEABLE GEARS BY OIL DIPPING. N/R IF REPAIR IS NEEDED	M		
C8 T19	050 MATSE	ROUTE TO STA. B7, BLDG. 324.			
B7	060 MATSN	RECEIVE AND ROUTE.			
B12 T29	070 MTPNC	REPLACE DAMAGED GEARS,DRILL AND REAM PIN HOLES IF EITHER GEAR IS REPLACED IAW WP 004 00, PARA. 7.	M		
B12	075 MTPNC	CORROSION TREAT GEARS AFTER REPAIR BY SPRAYING WITH OIL.	M		
B7 T07	080 MATSN	ROUTE TO STA. C8, BLDG. 329.			
C8 T19	090 MATSE	RECEIVE AND ROUTE TO PARTS POOL			
B4 T57	100 MATSE	PARTS POOL			
		MATEG DAN HAYWARD 03 SEPT. 87____ MTPSI JOHN H. CASTILLO 03 SEPT. 87_			

8.DISP-19.PDN/ TATION	OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
		MATSE__ALMA R. MENDEZ 03 SEPT. 87_			
		MAQTC_GILBERT F. HERRERA 03 SEPT 87_			
		MASTER ON FILE IN MATEG / 54667			

MAG, VIS, DIM

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*  WORK CONTROL DOCCUMENT TG881A  *      1.DATE 87270   PAGE  1 OF  1 PAGES
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2.PSSD/RCC	3.MATEERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
MTPG9E	STEEL				89104	

9.MODEL/DESIGN/SERRIES	10.NOUN	11.ITEM SERIAL NR
GTC85-56,70A,71 --72,116.	GEARSHAFT, BEVEL	

12.BCN   12A. SER NNO.________________

13.TECH DATA/OPTIONAL
2G-GTC85-33-6

14.PART NUMBER	155.STOCK NR.	16.PDN	17.BCN				
693120	28335000731238	13494A	827940	-	5	6	
693120	28335000731238	03081A	827942	-	7	0	
693120	28335000731238	13111A	827944	-	7	1	
693120	28335000731238	13495A	827946	-	7	2	
693120	28335000731238	13496A	827948	-	1	1	6
693120	28335000731238	13255A	827950	ACC CASE MISTR			

18.DISP-STATION	19.PDN/OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
		BASKET 13			
PSI6	001 MTPSI	CIRCLE PROPER P/N, NSN, C/N ABOVE	M		
PSI6	005 MTPSI	MMAG. PART.INSPECT IAW WP 005 00.	N		
PSI6	010 MTPSI	VVISUAL INSPECT IAW WP 004 00, #6,A.	M		
PSI6	020 MTPSI	DDIMENSIONALLY ISNPECT IAW WP 004 00, ##6,B, & FIG.1.	M		
PSI6	030 MTPSI	RREPAIR/DEBURR & TREAT IAW WP 003 00.	M		
B4 329	050 MATSE	RROUTE TO PARTS POOL			

MMATEG BRENT CASTLE   29 SEPT 87

MMTPSI ALBERT MUSQUIZ   30 SEPT 87

MMAQTC GARY E. BOECKER   2 OCT 87

MMATSE ESTER M. BUENTELLO   2 OCT 87

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VIS, DIM

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* WWORK CONTROL DOCUMENT TG834A * 1.DATE 87270 PAGE 1 OF 1 PAGES
****************************PSIB14****

2.EPSSD/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
MMTPG9E	STEEL				89104	

9.MMODEL/DESIGN/SERIES	10.NOUN	11.ITEM SERIAL NR
GGTE85-56,70,71, 72,116, 397.	RETAINER, BEARING	

12.BCN 12A. SER NO.

13.TECH DATA/OPTIONAL
2G-GTC85-33-6
2G-GTCP85-53-6 = 397

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN	
743517	2835007302154	13494A	827572	-56
743517	2835007302154	13081A	829380	-70A
743517	2835007302154	13111A	829381	-71
743517	2835007302154	13495A	829382	-72
743517	2835007302154	13496A	829383	-116
743517	2835007302154	13094A	829384	-397

18.DISP-STATION	19.PDN/OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
		BASKET NO 9			
PPSI6	005 MTPSI	CIRCLE PROPER P/N, NSN, C/N ABOVE.	M		
PPSI6	020 MTPSI	VISUAL INSPECT IAW WP 004 00,#6,A.	M		
PPSI6	030 MTPSI	DIMENSIONALLY INSPECT IAW WP 004 00 #6,FIG.1.	M		
PPSI6	040 MTPSI	REMOVE/REPAIR BURRS IAW WP 003 00,#7	M		
PPSI6	050 MTPSI	CORROSION TREAT (OIL DIP) IAW T.O. 1-1-2 IF SERVICEABLE.	M		
EB4	060 MATSE	ROUTE TO PARTS POOL			

MATEG BRENT CASTLE 29 SEPT 87

MTPSI JOHN H.CASTILLO 01 OCT 87

MAQTC GARY E.BOECKER 02 OCT 87

MATSE ESTER M.BUENTELLO 02 OCT 87

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VIS, DIM

WORK CONTROL DOCUMENT TG890A

1.DATE 87240 PAGE 1 OF 1 PAGES

2.PSSD/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
MTPG9E	STEEL				89104	

MODEL/DESIGN/SERIES	10.NOUN	11.ITEM SERIAL NR
GTC85-70A,71.	SHAFT ASSY, FAN IDLER GEAR	

12.BCN 12A. SER NO.________________

13.TECH DATA/OPTIONAL
2G-GTC85-33-6
2G-GTC85-33-7

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN
693522	2835000731237	13081A	829878 -70A
693522	2835000731237	13111A	829879 -71
693522	2835000731237	13255A	829880 ACC CASE MISTR

18.DISP-STATION	19.PDN/OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECE	22'P'	23'Q'
		BASKET NO. 13			
PSI6	010 MTPSI	CIRCLE PROPER P/N, NSN, C/N ABOVE	M		
PSI6	020 MTPSI	VISUALLY INSPECT IAW WP 004 00, #6,A	M		
PSI6	030 MTPSI	DIMENSIONALLY INSPECT IAW WP 004 00, #6,B.	M		
PSI6	040 MTPSI	CORROSION TREAT (OIL DIP) IAW T.O. 1-1-2. [VIS]	M		
B4 329	050 MATSE	ROUTE TO STA. B1, BLDG 301.			
B1 E40	060 MEIAA	APPLY DRY FILM LUBERICANT IAW WP 003 00, #7.	M		
B1 E40	070 MEIAA	ROUTE TO STA B4, BLDG 329.			
B4 329	080 MATSE	RECEIVE & ROUTE TO PARTS POOL.			

MATEG BRENT CASTLE 29 SEPT 87

MTPSI ALBERT MUSQUIZ 30 SEPT 87

MAQTC GARY E. BOECKER 2 OCT 87

MATSE ESTER M. BUENTELLO 2 OCT 87

MASTER COPY ON FILE MATEG/5-4667

VIS, DIM

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* WORK CONTROL DOCUMENT TG823F * 1.DATE 88217 PAGE 1 OF 1 PAGES

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2.PSSD/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
MTPG9E	ALUM				89104	

9.MODEL/DESIGN/SERIES	10.NOUN	11.ITEM SERIAL NR
GTC85-56,70A,71, -72,116,& -397.	HOUSING, BEARING AND SEAL	

12.BCN 12A. SER NO.____________

13.TECH DATA/OPTIONAL
2G-GTC85-33-6
2G-GTCP85-53-6 = 397

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN
693368	2835009393387	13494A	827510 -56
693368	2835009393387	13081A	830665 -70A
693368	2835009393387	13111A	830666 -71
693368	2835009393387	13495A	830667 -72
693368	2835009393387	13496A	830668 -116
693368	2835009393387	13094A	830669 -397

18.DISP-STATION	19.PDN/OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
		BASKET NO. 8			
PSI6	005 MTPSI	CIRCLE PROPER P/N, NSN, C/N ABOVE.	M		
PSI6	010 MTPSI	VISUALLY INSPECT IAW WP 004 00, #6,A.	M		
PSI6	020 MTPSI	DIMENSIONALLY INSPECT IAW WP 004 00, #6,B, & FIG. 1.	M		
PSI6	050 MTPSI	MINOR REPAIR IAW WP 003 00.	M		
C8 T19	060 MATSE	ROUTE TO STA B1, BLDG 301.			
B1 E40	070 MEIAA	RECEIVE & ROUTE TO SHOP (ANODIZE).			
B1 E40	080 MEIAA	APPLY ANODIZE COAT IAW MIL-A-8625D, TYPE II, AND WP 003 00, #7.	M		
B1 E40	090 MEIAA	ROUTE TO STA B4, BLDG 329.			
B4 T57	100 MATSE	RECEIVE & ROUTE TO PARTS POOL.			

MATEG BRENT CASTLE 3 AUG 1988
MTPSI ALBERT MUSQUIZ 4 AUG 1988
MEIAA DOUG KNEUPPER 9 AUG 1988
MAQTC GILBERT HERRERA 9 AUG 1988
MATSE ESTER BUENTELLO 9 AUG 1988
SIGNATURES ON FILE IN MATEG/54667.
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WORK CONTROL DOCUMENT TA003T * 1.DATE 88132 PAGE 1 OF 1 PAGES

2.FEED/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
1TFE95						

9.MODEL/DESIGN/SERIES | 10.NOUN | 11.ITEM SERIAL NR
ATSC100-97 -97A | ROD
(148-151, FIG 3-1)

12.BCN 12A. SER NO.________________ | 13.TECH DATA/OPTIONAL
2JA3-52-3 & APPL CHANGES

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN
3500915-11	2995010041759	10718A	815204
3500915-11	2995010041759	12851A	815205

18.DISP-STATION	19.FCN/OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22 P'	23'Q'
		STARTER P/N 3505124-2-2 NSN 2995010389092 P/N 3505124-3-1 NSN 2995011396642			
PSI6	010 MTPSI	VISUAL INSPECT IAW PARA 4-5	M		
	020 TMTPSI	DIMENSIONAL INSPECT IAW PARA 4-27.2 AND 4.27.3 RECORD DIMENSION RADIAL PLAY______ AXIAL PLAY________ SERVICEABLE______UNSERVICEABLE_____ IF SERVICEABLE ROUTE TO PARTS POOL	M		
		MATEAS R.A. GARCIA 25 JUL 86 MTPSI ROBERT HERNENDEZ 25 JUL 86 MATSS LUIS F. MERCADO 28 JUL 86 MAQT JOE DE LA CRUZ 29 JUL 86 ***** REV. 11 MAY 88 E. GARZA ******			

AFLC FORM 959 (COMPUTER GENERATED)

WORK CONTROL DOCUMENT TADSIA * 1.DATE ISSUE PAGE 1 OF 1 PAGES!

PSSD/RCC I3.MATERIAL I4.MIC I5.ERRC I6.QTY I7.SCHED DT I8.COMPL DT
MTPS9S I __STEEL I CL I N I

MODEL/DESIGN/SERIES I10.NOUN I11.ITEM SERIAL NR
A C100-87 I GEAR SPUR (3 EA)
(104, FIG 2-4)

.BCN 12A. SER NO.__________________ I13.TECH DATA/OPTIONAL
I 2JA3-2-38-3 & APPL CHANGES

.PART NUMBER 15.STOCK NR. 16.PDN 17.BCN
0269 3020008668034YC 10598A 815721

.DISP-19.PDN/ TATION	OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P	23'Q'
PSI6	010 MTPSI	MAGNETIC PARTICLE INSPECT IAW PARA. 2-24.	N		
	020 MTPSI	INSPECT IAW PARA. 2-12 SERVICEABLE_____UNSERVICEABLE_______ IF SERVICEABLE ROUTE TO PARTS POOL	M		
		MATEAS MOSES ESCOBEDO 30 NOV 88 MTPSI PRINCE H. AUTRY 30 NOV 88 MATSS TERRY B. QUINTERO 30 NOV 88 MAQT JEAN SHERWOOD 30 NOV 88			

AFLC FORM 959----------(COMPUTER GENERATED)

* WORK CONTROL DOCUMENT TA2370 * 1.DATE 88266 PAGE 1 OF 1 PAGES

B14

2.PSSD/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DDT
MTPS9S	STEEL					

MODEL/DESIGN/SERIES	10.NOUN	11.ITEM SERIAL NR
CPS-02 MOD	GEARSHAFT, SPUR (4, FIG 7-2)	

12.BCN 12A. SER NO.________________

13.TECH DATA/OPTIONAL
2JA3-22-3

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN
692218-1	3040000667887YQ	04542A	B16610

18.DISP-19.PDN/ STATION	OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
B14		STARTER P/N 701175C NSN 2995001727659			
PSI6	010 MTPSI	MAGNETIC PARTICLE INSPECT IAW FIG 7-2 INDEX 4, AND PARA 2-48.	N		
PSI6	020 MTPSI	VISUAL INSPECT IAW FIG 7-2, NOTE 11 C & D, AND PARA 2-57.	M		
PSI6	025 MTPSI	DIMENSIONAL INSPECT IAW FIG 7-2,NOTE 11 A & B.	M		
PSI6	030 MTPSI	REMOVE NICKS AND BURRS.	M		
PSI6	040 MTPSI	DIP IN MIL-L-7808 OIL AND PUT IN PLASTIC BAG IAW PARA 2-77.	M		
PSI6	045 MTPSI	ROUTE TO STA C-2, BALANCING ROOM.			
C-2	060 MTPSS	FOR REASSEMBLY, PART OF TURBINE ROTOR ASSEMBLY.			
		MATEA EDWARD GILL 26 SEP 88			
		MTPSI D.V. BORREGO 26 SEP 88			
		MATSS TERRY B. QUINTERO 26 SEP 88			
		MAQT GILBERT F. HERRERA 26 SEP 88			
		*********MASTER WCD ON FILE*********			

--AFLC FORM 959--(COMPUTER GENERATED)--

V13-MNG. DTM

* WORK CONTROL DOCUMENT TA036L * 1.DATE 89087 PAGE 1 OF 1 PAGES

2.PSSD/RCC	3.MATERIAL	4.MIC	5.ERRC	6.QTY	7.SCHED DT	8.COMP DT
MTPSS	STEEL					

.MODEL/DESIGN/SERIES	10.NOUN	11.ITEM SERIAL NR
[redacted]	[redacted]	

12.BCN 12A. SER NO.____________________

13.TECH DATA/OPTIONAL
2JA16-4-3

14.PART NUMBER	15.STOCK NR.	16.PDN	17.BCN
5005253	2835010537794	12712A	5560

18.DISP-STATION	19.PDN OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
		ACCESSORY DRIVE GEARBOX P/N 5004451H NSN 2835012355249			
		****** SENT TO HOLDING AREA ******* ***DO NOT CONDEMN*** *IF PART FAILS INSPECTION CRITERIA* *ANNOTATE REASON ON DD FORM 1577-2* *AND ROUTE PART TO MATERIAL REVIEW* *CAGE FOR MATE/MMPR REVIEW * *********************************			
PSI6	010 MTPSI	VISUALLY INSPECT IAW PARA 5-67.	M		
PSI6	020 MTPSI	MAGNETIC PARTICLE INSPECT IAW PARA 5-12.	M		
PSI6	030 MTPSI	DIMENSIONAL/VISUAL INSPECT IAW FIG 5-24. ROUTE TO F16 PARTS POOL.	M		
		MATE*S LOUIS P. QUINTANILLA 4-04-89 MTPII EDWARD M. GOMEZ 4-07-89 MATSS JESSE LOPEZ 4-05-89 MAQT D. S. HERNANDEZ 4-05-89 ******* MASTER WCD IS ON FILE ******			

AFLC ... COMPLETE ... TEST

'ORK CONTROL DOCUMENT TA059R * 1.DATE 87267 PAGE 1 OF 1 PAGES

SSD/RCI | 3.MATERIAL | 4.MIC | 5.ERRC | 6.QTY | 7.SCHED DT | 8.COMP DT
TPS9S | STL

'ODEL/DESIGN/SERIES | 10.NOUN | 11.ITEM SERIAL NR
ESPS | BEARING SHAFT 208
FIG. 3-1

BCN 12A. SER NO.________________ | 13B.TECH DATA/OPTIONAL
12JA16-2-3

PART NUMBER 15.STOCK NR. 16.PDN 17.EDCN
:221-1 28310003237799 08007A 0 18817

DISP-19.PDN/ TION	OP NO.	20.WORK TO BE ACCOMPLISHED	21.MECH	22'P'	23'Q'
.4		CENTRAL GEAR BOX P/N 3386720-4-1 NSN 12838-01-034-6948			
	010 MTPSI	VISUALLY INSPECT IAW PARA 5-69 A&C.	M		
	020 MTPSI	DIMENSIONALLY INSPECT IAW PARA 5-69B ROUTED TO F-15 PARTS POOL.	M		
		RATE E_DENNIS KOEHLER________02-JUN-86 MTPSI__EDWARD N GOMEZ________05-JUN-86 MATSE__ESTER BUENTELLO______05-JUN-86 MAIT___JOE DELACRUZ_________10-JUN-86			

VIS, DIM

WORK CONTROL DOCUMENT TA002K 1. DATE 8B7037 PAGE 1 OF 1 PAGES

2. PSSD/RCC	3. MATERIAL	4. MIC	5. ERRC	6. QTY	7. SCHED DT	8. COMP DT

9. MODEL/DESIGN/SERIES	10. NOUN	11. ITEM SERIAL NR
F15 SPS	LAYSHFT DR SPACER RING 349 FIG 3-1	

12. BCN 12A. SER NO. ____________	13. TECH DATA/OPTIONAL
	2JA16-33-3

14. PART NUMBER	15. STOCK NR.	16. PDN	17. BCN
365429-1	5365003291581	08004A	815177
365429-1	5365003291581	08005A	815178

18. DISP-19. PDN/ STATION	OP NO.	20. WORK TO BE ACCOMPLISHED	21. MECH	22 'P'	23 'Q'
		L/H AMAD P/N 386706-3-1 NSN 2835010207249 R/H AMAD P/N 486704-3-2 NSN 2835010881009 CIRCLE APPLICABLE BAR CODE			
PSI6	010 MTPSI	VISUALLY INSPECT FOR CRACKS, NICCKS, BURRS, CORROSION, AND DEFORMATIONN IAW PARA 5-107.A	M		
	020 MTPSI	DIMENSIONALLY INSPECT PIN IAW PARA 5-107.B	M		
	998 MATSE	ROUTE TO F-15 PARTS POOL			
		MATEAS YOLANDA RIOS 06 FEB 887 MATEAS ____________ MTPSI JOHN CASTILLO 13 FEB 887 MATSE JESSE LOPEZ 17 FEB 887 MAQTC GILBERT HERRERA 19 FEB 887			

WORK CONTROL DOCUMENT TA047H * 1.DATE 88097 PAGE 1 OF 1 PAGES

2.PSED/FCC | 3.MATERIAL | 4.MIC | 5.ERRC | 6.QTY | 7.SCHED DT | 8.COMP DT
MTPS9S | CRES17-4PH/STL | | N | | |

MODEL/DESIGN/SERIES | 10.NOUN | 11.ITEM SERIAL NO
F15 SPS,JET | RETAINING ASSY,INDEX | 3C
FUEL STARTER FIG.3-2

12.BCN 12A. SER NO.________________ | 13.TECH DATA OPTIONAL
| 2JA3-50-3

14.PART NUMBER 15.STOCK NR. 16.JCN 17.BCN
[illegible]37-1 3[illegible]323 08006A 315685
[illegible]37 1 31[illegible]36323 C9[illegible] 315686

18.DISP-19.PCN/
TION OP NO. | 20.WORK TO BE ACCOMPLISHED | 21.MECH | 22.[illegible] | 23.[illegible]

| JET FUEL STARTER
| C/N 08006A
| P/N 384238-4-1
| NSN 2835010712[illegible]
| SAE.CEN.ASSY
| [illegible] C9264A
| P/N 384902-11
| [illegible] 2[illegible]

[illegible]26 | [illegible] | VISUALLY INSPECT RETAINER FOR WEAR, CRACKS, BURRS, NICKS,DEFORMATION AND CORROSION [illegible] | M
[illegible] | [illegible] | DIMENSIONALLY INSPECT RETAINER IAW [illegible] (3) & FIG.[illegible]-DIM. | M
| DIM.[illegible]=___________.

[illegible] | [illegible] | [illegible] TO F15 [illegible] POOL

| [illegible] ROBERT HERNANDEZ 13 JUL 88
| [illegible] EDWARD GOMEZ [illegible] JUL 88
| [illegible] [illegible] 1[illegible] JUL 88
| [illegible] JOE DE LA CRUZ 1[illegible] JUL 88
| [illegible] ANDRIS DE LA ROSA 5 APR 88

The Resource Control Center (RCC) MAIPSI at the San Antonio Air Logistics Center is located in Building 329. This RCC has three distinct functions. One is the disassembly of certain aircraft starters and F-15 and F-16 end items, second is the cleaning of the parts from these end items after they are disassembled (plus parts from gas turbine engines) and lastly, the inspection of the cleaned parts. Some parts are sent direct to the Parts Pool without cleaning (nuts, bolts, spacers, etc.), some parts are sent through florescent penetrant inspection prior to inspection and other parts go direct from cleaning to inspection.

Building 329 is over sixty years old and was originally built for depot maintenance on gasoline driven radial aircraft engines. The building is in good physical shape and free standing air conditioned modules have been constructed within the building for operations such as offices, disassembly, assembly and inspection of various parts. Due to these free standing modules, working conditions are excellent for all functions of MAIPSI except for the parts cleaning function. This effort is located in an old section of Building 329 and is rather open and exposed to outdoor temperatures. It is of necessity a rather dirty, noxious operation with high temperatures due to the various cleaning vats.

Separate sections on each of the three functions with additional details follow this general overall discussion.

The cleaning function is located in the northeast end of Building 375. The physical area is approximately 18 feet wide by 300 feet in length and is not an airconditioned area. Working conditions are poor as the outdoor temperature in the summer is aggravated by the hot liquids in the cleaning vats and their attendent odors. In addition, all workers must wear rubber gloves and boots plus heavy aprons which increases the discomfort.. There are thirteen workers assigned, all in the grade of WG-05 including the supervisor. This is basically a "Helper" level type individual and is the starting grade when first employed. All assigned personnel were very courteous and helpful to the interviewer.

The equipment consists of vats containing various liquids and grit blasters. The vats have cleaning and degreasing solvents, decarbonizing and hot water rinses and washes. A paint stripping operation should be incorprated in the cleaning shop, and it is my understanding that it will be included in the planned new layout. Many of the vats are simple shop made though a number are factory built with tightly closing lids. Four of the grit blasters are recent purchases and are having maintenance difficulties. Apparantly they were not made for production line or high usuage type operations and are failing. These were not the grit blasters specified by the shop in the purchase order but were approved substitutes.

Parts requiring cleaning are brought into the cleaning area in plastic baskets and stacked on the floor. Each basket contains specific type metal parts as that dictates the cleaning process to be utilized. Work Control Documents (WCDs) are not used for the bulk of items requiring cleaning as it would be very difficult and costly in manhours to keep each document with its specific part. WCDs are assigned to each item when it passes through the flourescent penetrant inspection (FPI) station after cleaning so the document can receive the inspector s stamp. Parts not passing through FPI receive their WCD when they enter the inspection room to be given visual and dimensional inspections. Some parts such as nuts and bolts go straight to the Parts Pool from Disassembly as inspections are not necessary. Some of the WCDs assigned to the parts in the inspection room return the part to cleaning for degreasing, hot water rinsing and/or grit blasting after return from a backshop. These returned parts do pass through cleaning with a WCD..

The Cleaning function is going to be completely redone within the next few months. The same area will be utilized but new equipment will be installed and a new floor layout will be implemented. Material handling should be facilitated under the new layout and increased production should result from the improvements.

DISASSEMBLY FUNCTION OF RCC MATPSI SA-ALC

The disassembly function is located in an air conditioned free standing module constructed inside of the northeast corner of Building 329. The northern end of this module is where gas turbine engines are disassembled while the southern portion has disassembly for starters and F-15 and F-16 end items.

The area is now being remodeled so a basket conveyor system can be installed to move disassembled parts from individual work stations to the cleaning area which is located just outside the module. When the renovation is complete, there will be over thirty disassembly workstations. The flooring is of asphalt tile with recessed florescent overhead lighting. The wall surfaces are of metal which can result in a noisy environment. All in all, working conditions are very good.

Assembly and disassembly were formerly co-located but are now being separated. This is to preclude the possibility of assembly accidently installing parts direct from disassembly without passing through inspection and cleaning.

A typical workstation in disassembly consists of a workbench, a mounting stand or fixture for the item to be disassembled and a nearby cabinet for stored special tools.

The inspection function is located in a free standing module which is located inside the north end of Building 329 at Kelly AFB, Texas. The module is air conditioned with temperature and humidity maintained at approximately 72 degrees Fahrenheit and 68 per cent respectively due to the precision dimensional measurement equipment utilized in the shop. All parts brought into the shop for inspection are held for 24 hours prior to commencing any dimensional inspection. The purpose is to ensure the temperature of the part has stabilized at the room temperature so as to ensure accurate dimensional measurements. The room has asphalt tile floor covering and is kept neat and clean at all times. Florescent ceiling fixtures provide excellent lighting. The work environment is good and the equipment is first class. There are fiftyfour personnel assigned at this time. The lowest grade permitted for an individual to be a Certified Inspector is WG09. Those in a lower grade assigned to inspection do various inspection tasks however a Certified Inspector must check their work and "Sign Off" the Work Control Document.

The room has three inspection production lines based on the three basic types of items inspected. One is for Gas Turbine Engines (GTE), one is for Aircraft Starters and the third is for F 15-16 parts. Parts are delivered to the room by two methods. First, a double decker roller conveyor system enters the room from the cleaning and florescent penetrant work areas. The conveyor divides into three lines inside the room with each of the three conveyor lines passing through the middle of each of the three inspection lines, thereby creating a total of six inspection lines. Each of the six inspection lines has six to eight inspection stations, each manned by one inspector. The first few stations on each line have the Automated Production Inspection System (APIS) and the MICRO-4, both computer driven dimensional measurement machines. The remainder of the inspection stations are manual dimensional measurement stations. The second method of parts delivery is by four wheel carts manually pushed into the room for those parts assigned a critical priority. After inspection, parts leave the room via the upper roller conveyor line or the four wheel carts. Adequate backup tools and equipment is available to supplement the automated equipment if necessary.

The inspection function has a shortage of certified inspector personnel. This shortage has developed over several years as a result of hiring freezes implemented to save operating and maintenance funds. As a temporary expedient, personnel have been "loaned" to this function from other RCCs. Today, approximately one third of the assigned personnel are "loaners". These "loaned" personnel can only receive a certain amount of on-the-job training and can not be formally trained in the laboratory to receive certification as qualified inspectors. This results in lower productivity as the work performed by the "loaners" must be evaluated and certified by certified inspectors which borders on duplication of effort. Overtime must then be used to bring production up to the necessary level. Also, greater demand is placed on the florescent penetrant inspection section as the uncertified personnel rely too heavily on outside assistance in their inspection efforts. Another factor to consider is the higher condemn~~ed~~ation rate resulting from unknowledgeable inspectors. Some "loaners" have been in the inspection function for over one year while the majority have been assigned there for over six months. Since these temporary personnel are subject to recall to their prime RCC at any time, the supervisors tend to consider them for what they are - temporary workers who may leave at a monent's notice. As these personnel are working ~~out~~ of their Civil Service career field, they can not be issued inspector tool kits and can not receive proper cross-training into the inspection field. This also results in some degredation of these individual s motivation to learn and to apply ~~himself~~ with ~~his~~ best efforts. outside

themselves their

REV. A-25MAY89	SA-ALC TO# 1: PROCESS CHARACTERIZATION QUICK FIX PLAN OUTLINE
QUICK FIX #1	BOB BUTTRY - QUALITY & SAFETY SITE REVIEW, FROM 6-9 JAN 89

QUICK FIX OPPORTUNITY TO IMPROVE THE EVALUATION AND INSPECTION (E&I) OPERATION, KNOWN AS THE "AUTOMATED PROMPTING INSPECTION SYSTEM" (APIS), TO ELIMINATE OR REDUCE REPETITIVE FIELD RETURN PART DISCREPANCIES.

SA-028

1. CURRENT OPERATION: THE APIS PICTORIALLY DISPLAYS EACH FIELD RETURNED PART ON COMPUTER TERMINALS WHERE EACH INSPECTOR COMPARES AN ACTUAL PART WITH ITS VISUAL REPRESENTATION. THE APIS THEN GOES THROUGH A SERIES OF QUESTIONS FOR THE INSPECTOR TO ANSWER IN ORDER TO EVALUATE EACH PART FOR POSSIBLE AREAS OF REPAIR. THIS PROCESS, IN TURN, GENERATES A WCD FOR EACH PART.

2. OVERALL ASSESSMENT OF CURRENT OPERATION: THE USE OF APIS IS AN EXCELLENT METHOD TO E&I A FIELD RETURN FOR REPAIR SO AS TO REMOVE MUCH OF THE HUMAN ERROR HISTORICALLY ASSOCIATED WITH E&I ACTIVITY.

3. RATIONALE FOR CHANGE:

DETERMINING EXACTLY WHERE A FIELD RETURNED PART CONSISTENTLY FAILS IS A PRACTICAL APPROACH TO IMPROVING THE DESIGN OR THE REPAIR OF A PART TO ELIMINATE OR REDUCE THE FAILURE RECURRENCE RATE.

4. DESCRIPTION OF NEW PROCESS:

ADD A MOUSE TO THE APIS DISPLAY TERMINALS SO THAT THE INSPECTORS MAY THEN MARK THE LOCATIONS OF THE NEEDED REPAIRS ON THE DISPLAY. AT SOME APPROPRIATE PERIOD OF TIME LATER, AN ENGINEERING REVIEW COULD PROGRAM A RECALL OF ANY APIS PART TO SHOW A COMPOSITE OVERLAY FAILURE HISTORY. THIS APIS REVIEW WOULD PICTORIALLY DISPLAY THE FIELD RETURNS OF A PARTICULAR PART, INDICATE THE QUANTITY OF A PARTICULAR PART OVER THE SPECI. TIME FRAME UNDER REVIEW, AND REVEAL WHERE ANY CONSISTENT FAILURES IN THE PART MAY BE OCCURRING. ENGINEERING COULD THEN BUTTRESS THE PART IN THE AREAS OF CONSISTENT FAILURES, EITHER IN THE DESIGN OR IN THE REPAIR PROCESS, WHICH WOULD REDUCE OR ELIMINATE REPETITIVE FIELD FAILURES.

EXAMPLE: MARK THE WELD FAILURE AREAS ON THE APIS SCREEN FOR EACH FIELD RETURNED PART. A COMPOSITE COMPUTER OVERLAY DISPLAY WOULD BE ABLE TO SHOW IF FAILURES IN THE SAME WELD AREA FOR ANY PART ARE CONSISTENTLY OCCURRING. ENGINEERING COULD THEN DETERMINE WHETHER REDESIGN OR IMPROVED REPAIR IS THE MOST COST EFFECTIVE MEANS OF ELIMINATING THE FAILURE RECURRENCE.

A. PRODUCTIVITY IMPROVEMENTS

- LESS REPETITIVE FAILURES WILL RESULT IN GREATER OVERALL

REFURBISHMENT OUTPUT WITHOUT INCREASING THE PRESENT WORKFORCE.

- E&I PRODUCTIVITY IMPROVEMENTS WILL RESULT FROM FEWER REPETITIVE FAILURES. THIS IS BECAUSE E&I DOCUMENTATION WOULD NOT BE REQUIRED FOR PARTS HAVING UNDERGONE IMPROVED DESIGN AND REPAIR IMPLEMENTATION.

B. QUALITY IMPROVEMENTS
- IMPROVEMENT OF THE PART DESIGN OR THE REPAIR METHOD IS AN INHERENT QUALITY IMPROVEMENT.

5. BENEFITS (COST SAVINGS):
A. PRODUCTIVITY IMPROVEMENTS ALLOW REFURBISHMENT OF MORE PARTS - WITH THE SAME WORKFORCE RESULTING IN LESS COST PER UNI REPAIRED.

B. FEWER REPAIRS PER PART RESULT IN LESS EQUIPMENT AND MATERIAL COSTS PER PART.

6. IMPLEMENTATION COST/SCHEDULE:
A. IMPLEMENTATION COSTS
- INSTALL SCREEN MARKING AND COMPOSITE OVERLAY RECALL FEATURES TO APIS.

B. SCHEDULE IMPACT: (NONE)

7. SAFETY IMPROVEMENTS: (NONE)

8. ENVIRONMENTAL HAZARDS/IMPROVEMENTS: (NONE)

9. RELIABILITY/MAINTAINIBILITY CHARACTERISTICS:
   A. IMPROVED DESIGN CHARACTERISTICS AND REPAIR METHODS WILL RESULT IN MORE RELIABLE AND MAINTAINABLE PARTS IN THE FIELD.

10. HUMAN FACTORS:
   A. GREATER PART RELIABILITY AND MAINTAINIBILITY WILL RESULT IN MORE SYSTEM CONFIDENCE AND HIGHER MORALE FOR ALC AND FIELD PERSONNEL.

A/ 11. COST IMPROVEMENT DATA:

PRESENT CONDITION COST FOR LAST 12 MO.

- COST TO REPAIR PARTS THAT FAILED, DURING SURVICE, IN THE SAME PLACE AND IN THE SAME WAY AS PREVIOUSLY REPAIRED PARTS = ________.

- COST TO SCRAP PARTS THAT FAILED, DURING SURVICE, IN THE SAME PLACE AND IN THE SAME WAY AS PREVIOUSLY SCRAPPED PARTS = ________.

PROPOSED IMPLEMENTATION COST

- COST TO ADD A "MOUSE" TO EACH APIS TERMINAL = ________.

- COST TO IMPROVISE THE EXISTING APIS SOFTWARE TO ACCEPTING THE "MOUSE" AND GENERATE THE COMPOSITE OVERLAY, AS DESCRIBED IN PARA. 4 = ________.

FIRST YEAR COST SAVINGS:

[PRESENT CONDITION COST] - [PROPOSED IMPLEMENTATION COST] = ________.

REV. A-26 MAY 89

SA-ALC TO # 1: PROCESS CHARACTERIZATION

FOCUS STUDY ~~QUICK FIX~~ #2

QUICK FIX PLAN OUTLINE

BOB BUTTRY - QUALITY & SAFETY

SITE REVIEW, FROM 6-9 JAN 89

QUICK FIX OPPORTUNITY TO ESTABLISH AN ENVIRONMENT WITHIN THE EVALUATION AND INSPECTION (E & I) COORDINATE MEASURING MACHINE (CMM) OPERATIONS THAT WILL ALLOW THE CMM HARDWARE TO OPERATE IN A RELIABLE, ACCURATE, AND REPRODUCIBLE MANNER.

SA-0247

1. CURRENT OPERATION: E & I INSPECTORS EVALUATE CRITICALLY DIMENSIONED PARTS USING CMM OPERATIONS FOR WCD GENERATION AND PART REFURBISHMENT, AS REQUIRED, FOR THE ENGINE REPAIR FACILITY. SOMETIMES, ESPECIALLY IN SUMMER, ENVIRONMENTAL CONDITIONS IN THE CMM ROOM ARE OUT OF CONTROL, AND CMM OPERATIONS HAVE TO BE SUSPENDED AS THE CMM RESULTS BECOME UNRELIABLE.

2. OVERALL ASSESSMENT OF CURRENT OPERATION: CMM OPERATIONS ALMOST ELIMINATE THE POSSIBILITY OF HUMAN ERROR BY AUTOMATIC COMPUTER SYSTEM MEASUREMENTS OF THE CRITICAL DIMENSIONS OF FIELD RETURNED ENGINE PARTS. ALTHOUGH HUMAN ERROR IS ELIMINATED, CMM ERRORS

OCCUR BECAUSE TEMPERATURE, HUMIDITY, AND PARTICULATE FACTORS IN THE CMM ROOM ENVIRONMENT ARE NOT SUFFICIENTLY CONTROLLED.

3. RATIONALE FOR CHANGE: IN ORDER TO HAVE CONFIDENCE IN THE RESULTS OF THE CMM OPERATIONS, THE CRITICAL ENVIRONMENTAL FACTORS AFFECTING THESE CMMS NEED TO BE CONTROLLED.

4. DESCRIPTION OF NEW PROCESS: YEAR ROUND TEMPERATURE, HUMIDITY, AND PARTICULATE REQUIREMENTS SHOULD BE CONTROLLED WITHIN THE E&I CMM ROOM BY IMPLEMENTING THE FOLLOWING REQUIREMENTS AND PROCEDURES:

- RESTRICT PERSONNEL ACCESS TO AND FROM THE CMM ROOM BY THE USE OF ONLY ONE LARGE DOORWAY. (OTHER DOORWAYS MAY REMAIN IN PLACE FOR EMERGENCY USE ONLY)
- THE DOORWAY SHOULD HAVE AN AIRLOCK TO THE OUTSIDE OF THE CMM ROOM. THE AIRLOCK SHOULD HAVE OUTER DOORS TO AND FROM THE OUTSIDE PLANT ENVIRONMENT. POSITIVE AIR PRESSURE SHOULD FLOW FROM THE CMM ROOM (HIGHEST PRESSURE), INTO THE AIRLOCK (INTERMEDIATE PRESSURE), AND THEN INTO THE SHOP ENVIRONMENT (LOWEST PRESSURE).

SA-Q.F #2 (REV. A)

- ALL AIR ENTERING THE CMM ROOM AND THE AIRLOCK SHOULD PASS THROUGH HEPA FILTERS IN ORDER TO CONTROL PARTICULATES.

- THE AIRLOCK SHOULD BE CARPETED WITH A LINT-CATCHING SURFACE.

- PERSONNEL ENTERING THE CMM ROOM SHOULD WEAR CLEAN SMOCKS AND HATS. (THESE MAY BE STORED IN THE AIRLOCK.)

- TRAYS CONTAINING PARTS SHOULD BE WIPED WITH A LINT-CATCHING CLOTH BEFORE PASSING INTO THE CMM ROOM.

- THE AIR IN THE CMM ROOM SHOULD BE REGULARLY AND ADEQUATELY MONITORED FOR CORRECT TEMPERATURE, HUMIDITY, AND PARTICULATE REQUIREMENTS BASED ON CMM MANUFACTURER'S RECOMMENDATIONS.

A. <u>PRODUCTIVITY IMPROVEMENTS</u>
- LESS E&I CMM DOWNTIME FROM INADEQUATE CMM ROOM ENVIRONMENTAL CONDITIONS.

B. <u>QUALITY IMPROVEMENTS</u>
- CMM RESULTS WILL BE RELIABLE, ACCURATE, AND REPRODUCIBLE YEAR ROUND

5. BENEFITS (COST SAVINGS):
   A. LESS E & I CMM DOWNTIME WILL ALLOW GREATER UTILIZATION OF ALL E & I PERSONNEL AND CMM EQUIPMENT.

6. IMPLEMENTATION COST/SCHEDULE:
   A) IMPLEMENTATION COSTS
   - INSTALL AIRLOCK, WITH LINT-CATCHING FLOORING AND INTERMEDIATE PRESSURE HEPA FILTER SYSTEM.
   - PURCHASE OF SMOCKS AND HATS FOR ALL PERSONNEL REQUIRED TO BE IN THE CMM ROOM.
   - INSTALL HIGHEST PRESSURE HEPA FILTER SYSTEM FOR CMM ROOM.
   - PURCHASE OF AIR PARTICULATE MEASURING MACHINE FOR CMM ROOM.
   - PURCHASE OF TEMPERATURE AND HUMIDITY CONTROL SYSTEM FOR CMM ROOM.

7. SAFETY IMPROVEMENTS: (NONE)

8) ENVIRONMENTAL: (NONE)

9) RELIABILITY/MAINTAINABILITY:
   A) CMM MEASUREMENTS WILL BE RELIABLE YEAR ROUND WITH ENVIRONMENTAL CONTROLS.
   B) CMM EQUIPMENT WILL BE BETTER MAINTAINED IN A CONTROLLED ENVIRONMENT.

10) HUMAN FACTORS:

A. E & I CMM INSPECTORS WILL HAVE CONFIDENCE IN THE RESULTS OF THEIR EFFORTS IF THE CMM EQUIPMENT IS MAINTAINED UNDER PROPER ENVIRONMENTAL CONTROLS.

A/ 11. COST IMPROVEMENT DATA:

PRESENT CONDITION COSTS FOR LAST 12 MO.

— LABOR COSTS ASSOCIATED WITH THE SHUTDOWNS OR MALFUNCTIONS OF ELECTRONIC MEASURING EQUIPMENT IN THE LAST 12 MONTHS DUE TO INABILITY TO CONTROL THE TEMPERATURE, HUMIDITY, OR PARTICULATES IN THE MATPSI INSPECTION ROOM = ________.

— MACHINE AND SOFTWARE COSTS ASSOCIATED WITH THE ABOVE SHUTDOWNS AND MALFUNCTIONS OF ELECTRIC MEASURING EQUIPMENT = ________.

PROPOSED IMPLEMENTATION COSTS

— COST TO SEAL (LOCK) ALL DOORS LEADING INTO THE MATPSI INSPECTION ROOM, BUT LEAVE ALARM ACTIVATED EMERGENCY EXITS, AS NECESSARY = ________.

— COSTS TO CONSTRUCT ONE LARGE POSITIVE PRESSURE AIRLOCK/DOORWAY FOR ENTRY & EXIT, PER PARA. 4, LARGE ENOUGH TO ACCOMMODATE A HANDTRUCK FOR PARTS. THE AIRLOCK SHOULD HAVE SMOCKS, HATS, DISPOSIBLE PLASTIC SHOECOVER BOOTIES, SHELVES, HANGERS, LINT FREE DISPOSIBLE WIPES TO DUST OFF TOTE TRAYS, AND THE AIRLOCK/DOORWAY CARPETED WITH A LINT-CATCHING SURFACE = ________.

- COST TO INSTALL MONITORING EQUIPMENT IN THE MATPSI INSPECTION ROOM TO CONTROL TEMPERATURE, PRESSURE, HUMIDITY, AND PARTICULATES = ________.

- COST TO INSTALL HEPA FILTERS IN ALL AIR INLETS TO THE MATPSI INSPECTION ROOM AND AIRLOCK. = ________.

FIRST YEAR COST SAVINGS:

[PRESENT CONDITION COST] - [PROPOSED IMPLEMENTATION COST] = ________.

(R)

REV. A—18 MAY 89
REV. B—24 MAY 89

COMMAND WIDE

T.O. # 1: PROCESS CHARACTERIZATION

QUICK FIX PLAN OUTLINE

COMMAND WIDE QUICK FIX #2

BOB BUTTRY—QUALITY & SAFETY SITE REVIEW, DURING JAN 89

QUICK FIX OPPORTUNITY TO FACILITATE THE QDR (QUALITY DISCREPANCY REPORT) EFFORT BY

B/ HAVING SUPPLIERS ALWAYS TAKE RESPONSIBILITY FOR THE REPAIR, REPLACEMENT, REIMBURSEMENT, AND CORRECTIVE ACTION FOR DISCREPANT SUPPLIER PARTS STILL UNDER WARRENTY.

SA 036

1. CURRENT OPERATION: USUALLY, ONLY THE OUTER PACKAGE OF NEWLY RECEIVED PARTS HAS THE CONTRACT NUMBER, THE VENDOR CODE, AND THE DATE OF MANUFACTURE IMPRINTED ON IT BY THE SUPPLIER. IF A PART IS REMOVED FROM THIS OUTER PACKAGE IN ORDER TO BE STAGED FOR INSTALLATION, THESE 3 PIECES OF IDENTIFICATION MAY THEN BE LOST. THIS METHOD OF STAGING IS USUALLY ASSOCIATED WITH ELECTRICAL PARTS, BECAUSE INSTALLATION CLEANLINESS REQUIREMENTS NORMALLY DO NOT PERMIT THE DIRTY OUTER PACKAGE TO REMAIN WITHIN THE CLEANER AREAS WHERE

THE PARTS ARE HELD PRIOR TO INSTALLATION. ALSO, SOME PARTS ARE STORED IN SUPPLY AFTER REMOVING AND DISCARDING THE OUTER PACKAGE PRIOR TO BEING REQUISITIONED FOR USE BY THE SHOP.

2. OVERALL ASSESSMENT OF CURRENT OPERATION: IF ANY OF THESE PARTS ARE LATER DETERMINED TO BE DISCREPANT AT THE TIME OF INSTALLATION THEN A QDR WILL BE WRITTEN FOR SUPPLIER ACTION. IT MAY BE IMPOSSIBLE TO REQUIRE THE SUPPLIER TO ACCEPT RESPONSIBILITY FOR THE DISCREPANCY, HOWEVER, WITHOUT REFERENCING THE CONTRACT NUMBER, THE VENDOR CODE, AND THE DATE OF MANUFACTURE WITHIN THE QDR. THIS INFORMATATION ESTABLISHES THE PART CONFIGURATION, THE SUPPLIER, AND WHETHER THE PART IS STILL UNDER WARRENTY, RESPECTIVELY. SOME SUPPLIERS ARE NOT ACCEPTING RESPONSIBILITY DUE TO THE ABSENCE OF ANY OF THIS INFORMATION. THIS CAUSES THE ALC TO ACCEPT THE COSTS ASSOCIATED WITH SUPPLIER RELATED. PART DISCREPANCIES.

3. RATIONALE LEADING TO CHANGE: IT IS NEITHER A COST EFFECTIVE NOR AN ACCEPTABLE BUSINESS PRACTICE TO ALLOW A SUPPLIER NOT TO BE RESPONSIBLE AND ACCOUNTABLE FOR DISCREPANT PARTS THAT ARE STILL UNDER WARRENTY.

4. DESCRIPTION OF NEW PROCESS: MANDATE A GENERAL CONTRACT PURCHASE ORDER (P.O.) REQUIREMENT THAT THE CONTRACT NUMBER, THE VENDOR CODE, AND THE DATE OF MANUFACTURE

BE IDENTIFIED ON EACH PART BY RUBBER STAMP, OR BY ANOTHER NON-ABRASIVE AND NON-CORROSIVE METHOD. IF THE PART IS TOO SMALL TO IDENTIFY IN THIS WAY, IT WOULD BE PERMISSIBLE TO SO IDENTIFY THE INNER PACKAGE CONTAINING THE PART(S). A THIRD METHOD OF PROVIDING THIS IDENTIFICATION WOULD BE TO REQUIRE A METAL, PLASTIC, OR CARDBOARD I.D TAG BE TIED TO EACH PART WITH A PLASTIC COATED METAL TIE. THE P.O. SHOULD ALSO STIPULATE THAT THE PART(S) MAY BE RETURNED TO THE SUPPLIER WHENEVER THE OUTER PACKAGE IS OPENED AND THE NOTED I.D. INFORMATION IS MISSING. THIS ADDED STIPULATION WOULD ELIMINATE THE NEED (AND EXPENSE) TO VERIFY THE NEW PART I.D. REQUIREMENT BY NOT HAVING TO OPEN THE OUTER PACKAGE UPON RECEIPT.

A. PRODUCTIVITY IMPROVEMENTS
- LESS DOWNTIME FROM RECURRING DISCREPANT PARTS DUE TO SUPPLIERS ACCEPTING RESPONSIBILITY TO TAKE CORRECTIVE ACTION FOR ALL PARTS ON QDR.

B. QUALITY IMPROVEMENTS
- ALL SUPPLIER RELATED QDRs WILL BE ANSWERED IN A TIMELY MANNER
- CORRECTIVE ACTION WILL BE TAKEN FOR EVERY QDR SUPPLIER RELATED DISCREPANCY

C. RESOURCE UTILIZATION
- FEWER PARTS WILL HAVE TO BE SCRAPPED

5. BENEFITS/TRADEOFFS (REF. PARA. 11):
   A) FULL CREDIT WILL BE RECEIVED FOR SUPPLIER RELATED DISCREPANT PARTS
   B) THE REPETATIVE NATURE OF DISCREPANT PARTS FROM SELECTED SUPPLIERS WILL BE ELIMINATED

6. IMPLEMENTATION COST/SCHEDULE (REF. PARA. 11):
   A) THERE WILL BE NO SCHEDULE IMPACT.
   B) ADDITIONAL COST MAY BE IMPOSED BY THE SUPPLIER TO PROVIDE THE NOTED PART I.D. INFORMATION.
   C) THE 2 NEW P.O. REQUIREMENTS WILL NEED TO BE ADDED AT SOME COST TO THE ALCS.

7. SAFETY IMPROVEMENTS: (NONE)

8. ENVIRONMENTAL HAZARDS/IMPROVEMENTS: (NONE)

9. RELIABILITY/MAINTAINABILITY CHARACTERISTICS:
   A) PARTS RECEIVED FROM SELECTED SUPPLIERS WILL NOT CONTINUE TO HAVE REPETATIVE DEFECTS OF THE SAME KIND AS THESE SUPPLIERS TAKE RESPONSIBILITY AND CORRECTIVE ACTION FOR THEIR DISCREPANT PARTS

10. HUMAN FACTORS DESIGN CRITERIA:
   A. THE ELIMINATION OF UNRESOLVED, REPETATIVE PROBLEMS FROM SELECTED SUPPLIERS WILL IMPROVE THE MORALE OF QUALITY AND PRODUCTION PERSONNEL

A/ 11. COST IMPROVEMENT DATA:

PRESENT CONDITION COST

B/

- COST TO REPLACE ALL NEW PURCHASED PARTS THAT WERE SCRAPPED OVER THE LAST 12 MONTHS AT THE EXPENSE OF THE ALC DUE TO THE LACK OF NECESSARY SUPPLIER IDENTIFICATION (CONTRACT NUMBER, VENDOR CODE, OR DATE OF MANUFACTURE) AT INSTALLATION = ________.

- COST TO REPAIR ALL NEW PURCHASED PARTS OVER THE LAST 12 MONTHS AT THE EXPENSE OF THE ALC DUE TO THE LACK OF NECESSARY SUPPLIER I.D. AT INSTALLATI = ________.

PROPOSED IMPLEMENTATION COST

- COST INCURRED BY ALC PURCHASING OFFICE TO INSERT THE NOTED P.O. REQUIREMENT (REF. PARA. 4) = ________.

- ESTIMATED ADDITIONAL ANNUAL COST BY ALL ALC NEW PARTS SUPPLIERS TO IMPLEMENT THE NOTED I.D. REQUIREMENT AS SPECIFIED (REF. PARA. 4) = ________.

ANNUAL COST SAVINGS (FIRST YEAR):

[PRESENT CONDITION COST] − [PROPOSED IMPLEMENTATION COST] = ________.

PAGE 1

11 APR 89 (TUE) @ SA-ALC

- ARRIVED ON SITE. GETTING BADGED. WENT THROUGH SA ALC DISC SECURITY CLASS. GETTING ORIENTED TO WORK SITE & WORK AREA.

— OUR OFFICE PHONE: [92]5-3514

12 APR 89 (WED) @ SA-ALC

- FURTHER SA-ALC ORIENTATION.

- DETERMINED THAT SEVERAL HUNDRED DIFFERENT PARTS GO THROUGH THE MAT PSI [E & I INSPECTION]. EACH PAINT HAS ITS OWN WCD.

13 APR 89 (THURS) @ SA-ALC

8:00 A.M. MEETING

- ED GILL – PLANNER
  DANNY GONZALES – ENGINEER
  BILL DANIELS – DESIGNATED COORDINATOR
  [illegible] MARY – [illegible]
  [illegible] BUTTRY [illegible]

- HAD A MEETING TO DETERMINE HOW TO CHARACTERIZE THE MATPSI COMPONENTS INSPECTED FROM THE BREAKDOWN OF THE 80/20 END ITEM PARTS. IT WAS DECIDED TO GROUP THE 80/20 END ITEM COMPONENTS INTO PART FAMILIES AND USE 2 TYPICAL LWCDs WITHIN EACH FAMILY OF PARTS TO DETERMINE THE "AS IS" CONDITION FOR MEDS + ARIS INSPECTION OPERATION PROFILES.

2:30 P.M. MEETING

- D.K. [illegible], MATPSI FOREMAN, TO BE MY INTERVIEWEE FOR THE E+I MANPOWER PROFILE SHEET. JUAN LANDEROS, INSPECTOR, TO BE MY INTERVIEWEE FOR THE EQUIPMENT PROFILE SHEET.

- CONTINUING INTERVIEWS TO PROFILE THE MATPJI EQUIPMENT. INTERVIEWED JUAN LANDEROS AND RON JOHNSON, APIS INSPECTORS.

<u>14 APR 89 (FRI) @ SA-ALC</u>

- INTERVIEWED D.V. BARREGO, [illegible] IN MATPSI. COMPLETED MANPOWER PROFILE FOR THE STARTERS. [PHONE: 59253].

- COMPLETED THE MANPOWER PROFILE SHEET FOR MATPSI STARTERS.

- INTERVIEWED ALBERT MUSQUIZ, [illegible] MATPSI. COMPLETED MANPOWER PROFILE FOR THE GAS TURBINE ENGINES (GTEs).

- COMPLETED THE MANPOWER PROFILE SHEET FOR MATPSI GTEs.

- INTERVIEWED JUAN LANDEROS + PROJECT AUTRY, INSPECTORS IN MATPSI. BOTH FAMILIAR WITH THE EQUIPMENT THROUGHOUT THE MATPSI RCC.

- <u>EARL</u> <u>MARY</u> DECIDED THAT "OFF THE SHELF" MEASURING EQUIPMENT WILL NOT BE PROFILED. SPECIAL FIXTURES, TOOLING, ETC. THAT COULD CAUSE PRODUCTION SHUTDOWNS IF LOST OR DAMAGED WILL BE PROFILED.

- EARL MARY DECIDED NOT TO INCLUDE/EXTEND THE DOWNTIME TO THE SPECIAL FIXTURES AND TOOLING THAT ARE ASSOCIATED WITH TESTING EQUIPMENT THAT DO HAVE DOWNTIME. EACH PIECE OF LISTED EQUIPMENT WILL STAND ALONE REGARDING DOWNTIME.

- ED HILL, PLANNING, COMPILING THE COMPONENT LISTS THAT HAVE TO BE PROFILED AFTER ED GROUPS THE COMPONENTS INTO "PART FAMILIES". ED WILL PROVIDE BOTH A "VISUAL" AND AN "APIS" WCD WHICH WILL BE TYPICAL FOR EACH PART FAMILY FROM WHICH TO CONDUCT INTERVIEWS.

- INTERVIEWING ALBERT MUSQUIZ, NDI INSPECTION FOREMAN FOR GTE, AND JUAN LANDEROS FOR THE GTE EQUIPMENT PROFILE.

- MET AL NEBGEN, SUPERVISOR OF THE MATPSI FOREMEN, TO SET UP INTERVIEWS WITH F-15 & F-16 NDI INSPECTION FOREMEN EDWARD GOMEZ (DAY SHIFT) AND JOHN CASTILLO (NIGHT SHIFT)

- INTERVIEWED 1ST SHIFT NDI INSPECTION FOREMAN, EDWARD GOMEZ, FOR MANPOWER & EQUIPMENT PROFILE FOR THE F111 & F16 NDI INSPECTIONS. JUAN LANDEROS, NDI INSPECTOR, ASSISTED.

- ED GILL, PLANNER, AND JUAN LANDEROS WORKING TO OBTAIN "FAMILY OF PARTS" GROUPINGS FOR THE OPERATION PROFILE INTERVIEWS.

- INTERVIEWED 2ND SHIFT NDI INSPECTION FOREMAN, EDWARD GOMEZ, TO VERIFY MANPOWER REQUIREMENTS & TO ADD OTHER ITEMS TO THE EQUIPMENT PROFILE SHEET.

- TRIXIE BROWN TOURED THE NDT AREA. I ASSISTED IN THE TOUR, ALONG WITH [illegible], J. LANDEROS, B. CONWAY, & E. GILL.

20 APR 89 (THU) @ SA-ALC

- OBSERVED THE APIS OPERATION WITH JUAN LANDEROS, MATPSI NDI INSPECTOR.

- OBSERVED THE MICRO-4 OPERATION WITH RON JOHNSON, MATPSI NDI INSPECTOR.

- FINISHING/REWRITING/CLARIFYING THE EQUIPMENT PROFILE SHEETS FOR MATPSI.

- SUBMITTED THE EQUIPMENT PROFILE TO EARL MARY FOR REC MATPSI

- FINISHING/REWORKING 'CLARIFYING THE MANPOWER PROFILE' FOR MATPSI

- TALKED WITH DAVID CHRISTOPHER IN THE APIS COMPUTER SECTION. HE HAS COLLECTED DATA SINCE OCT 88 ON THE REPAIR/CONDEMNATION RATES FOR ALL PARTS INSPECTED IN MATPSI. I WILL REVIEW THE COST OF THE COMPONENTS GOING THROUGH THIS MATPSI FROM ONE OF THE 80/20 AND ITEMS WITH ED HILL TO TRY TO IDENTIFY A CANDIDATE COMPONENT FOR PREVENTIVE MAINTENANCE OR IMPROVED DESIGN.

24 APR 89 (MON) @ SA-ALC

- COMPLETED MY EXPENSE REPORT
- WORKING ON MATPSI MANPOWER PROFILE
- ED GILL COMPILING PART FAMILIES
- 11:30 TO 3:30 PM TOOK EYE EXAM TO REMAIN QUALIFIED FOR MAG PARTICLE + PENETRANT INSPECTION SURVEYS

- ED GILL FINISHED GROUPING A FEW OF THE PART FAMILIES. BEGAN INTERVIEWS ON THE "TUBE" FAMILY OF PARTS, WITH AL HOLM GUIDING ME THROUGH THE FIRST "OPERATION PROFILE" SHEET.

- INTERVIEWING NDI INSPECTORS GEORGE CACON (GTEs), JUAN LAVDEROS (STARTERS), & XAVIER PUENTE (F15 & F16s) FOR TUBE FAMILY OPERATION PROFILE FOR ... PSI INSPECTION REC. THE OPERATION PROFILE CHARACTERIZATION BREAKS DOWN IN THE DIMENSIONAL INSPECTION OPERATIONS — THE DATA IS SPREAD TOO FAR APART REGARDING TIME, METHODS, & OPERATIONS FROM ONE TUBE TO THE NEXT AND WITHIN THE 3 INSPECTION LINES. HAVE TO REVIEW "FAMILY" APPROACH WITH E. MARY, M. McCOY, & L. MAVROS. NO ANSWERS YET.

- TO CONSULT WITH ED GILL TOMORROW.

26 APR 89 (WED) @ SA-ALC

- ED GILL IN CLASS TODAY, MAY BE TOMORROW BEFORE WE CAN REVIEW THE PART FAMILY APPROACH WITH HIM.

- FINISHED THE MANPOWER PROFILE FOR MATPSI INSPECTION AREA.

- REVIEWED THE MAT PSI WITH CPI ENGINEER, JIMMY EATON.

- SEPARATED THE MATPSI WCDs INTO PROCESS FAMILIES FOR INTERVIEWS.

- MET JIMMY EATON WHO IS WORKING WITH ME TO CHARACTERIZE THE MATPSI INSPECTION AREA.

- DIVIDING THE WCD EFFORT INTO PROCESSING FAMILIES TO TRY TO EXPEDITE THE INTERVIEWING EFFORT.

- COMPLEATING SOME INTERVIEWS, BUT HAVING TO RE-DO THEM, A LEARNING PROCESS.

- JIMMY EATON INTERVIEWING XAVIER QUENTE FOR F15/F16 COMPONENT INSPECTIONS. I AM INTERVIEWING JUAN [illegible] FOR SIMILAR COMPONENTS.

- I COMPLEATED 7 OPERATIONAL PROFILE SHEETS FOR THE "VISUAL" INSPECTION FAMILY.

- FAMILIARIZED CHUCK GONZALES WITH THE MATPSI AND THE INSPECTION PROCESS CHARACTERIZATION PROBLEM FOR MATPSI.

- DECISION MADE TO CONSTRUCT A GENERIC MATPSI INSPECTION WCD TO PROFILE THE 3 INSPECTION LINE OPERATIONS. I COMPLETED "GENERIC" LINE INTERVIEWS FOR VISUAL INSPECTIONS.* THE TOTAL INSPECTION INTERVAL TIME OVER ALL LINES IS FROM 5 TO 12 MINUTES FOR SERVICEABLE & REPAIRABLE PARTS, AND FROM 3 TO 5, 4 TO 12, AND 10 TO 12 MINUTES FOR ENGINES, STARTERS, AND F15/F16 LINES, RESPECTIVELY, FOR THE CONDEMNED PARTS. FOLLOW-UP ULTRASONIC, MAGNETIC PARTICLE, PENETRANT, HYDROSTATIC, AND EDDY CURRENT INSPECTION PROCESSES WILL BE DONE BY INTERVIEWS TO ESTABLISH THE "GENERIC" WCDS INVOLVING THESE PROCESSES. IN ALL, 12 GENERIC WCDS WILL BE CONSTRUCTED TO SIMULATE THE INFORMATION NEEDED TO CHARACTERIZE THE 12 80/20 END ITEMS WHOSE COMPONENTS FLOW THROUGH THE MATPSI INSPECTION RCC.

04 MAY 89

- HELD MEETING WITH 3. [illegible], L. [illegible], C. GONZALES, D. GONZALES, AND TO DISCUSS THE "GENERIC" WCD APPROACH. THIS APPROACH WAS ACCEPTED, BUT 3 TO 4 CRITICAL COMPONENTS FROM EACH OF THE 12 END ITEMS WILL BE CHARACTERIZED, IN DEPTH, VIA INTERVIEWS, IN ADDITION.

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* F15/16 LINE INTERVIEWED MIKE TAPIA
STARTER " — " JUAN LAN[illegible]
GTE " — " GEORGE CHA[illegible]
— ALL ARE NDI INSPECTORS —

— TEAM MEETING OF ALL FROM CPI & MDMSC REGARDING OUR SCHEDULE AND THE QUALITY OF OUR I.E. RCC ASSESSMENTS. EARL MARY LEADING THE DISCUSSION. NEED TO KEEP OUR ENGINEERING NOTEBOOKS CURRENT.

— DEVELOPING THE GENERIC APPROACH CONCEPT TO MAKE 12 WCDS FOR THE COMPONENTS FROM THE 37/70 END ITEM LIST FOR THE MATPSI INSPECTION AREA.

— ED GILL COMPLETED WCDs FOR 28 OF THE 48 CRITICAL PARTS WE HAVE TO CHARACTERIZE VIA OPERATION PROFILE SHEETS IN THE MATPSI INSPECTION AREA.

— I AM TRAINING JIMMY EATON TO TAKE MY PLACE IN CHARACTERIZING THE MATPSI INSPECTION RCC WHEN I RETURN TO ST. LOUIS ON 12 MAY 89.

- STARTED THE PROCESS TO BEGIN INTERVIEWING FOR THE 48 CRITICAL ITEMS BILL CONWAY~~ED~~ WILL WANT FOR THE CHARACTERIZATION OF THE MATPSI INSPECTION ANAL. ALL WCDS ARE BEING COMPILED TO BEGIN INTERVIEWS.

- THE APPROACH TO WRITING THE 12 GENERIC OPERATION PROFILES FOR EACH OF THE 12 END ITEMS IN THE MATPSI INSPECTION ACC WILL REQUIRE INTERVIEWS TO DEVELOP AVERAGE OCCURRENCE FACTORS FOR THE GROUP OF PARTS THAT ARE INVOLVED IN THE BUILD UP OF EACH END ITEM IN THE VISUAL, DIMENSIONAL, MAGNETIC PARTICLE, PENETRANT, HYDROSTATIC, EDDY CURRENT, & FUNCTIONAL TEST INSPECTION OPERATIONS. ~~FROM THESE 12 GENERIC WCDS, 12 GENERIC OPERATION PROFILE SHEETS WILL BE WRITTEN.~~ THIS WILL ALSO INCLUDE GFI BACK SHOP TIMES. INTERVIEWS FOR THE CLEANING OPERATION WILL ALSO BE DONE TO DEVELOP GENERIC OPERATION PROFILE SHEETS.

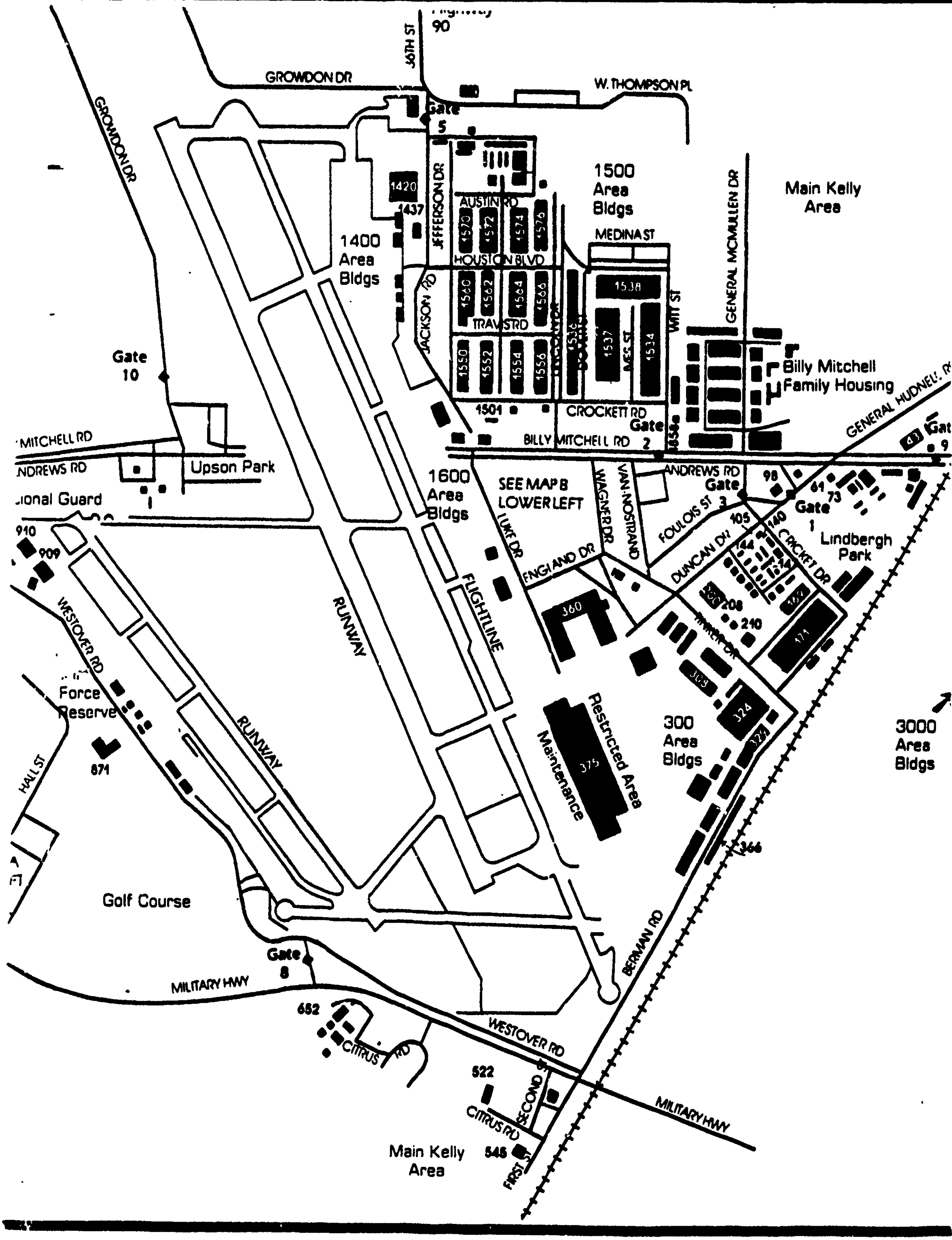
- RICARDO BOLANOS (MDMSC) AND ROGER MILLER (SM-ALC TI COORDINATOR) VISITED THE SA-ALC SITE TO HELP FACILITATE OUR EFFORT TO CHARACTERIZE THE MATPSI CLEANING & INSPECTION AREA.

- IT IS ACCEPTABLE TO ROGER MILLER TO LIST THE PROCESSES & EQUIPMENT OPERATING TIMES VS. THE OCCURRENCE FACTORS FOR THE 12 END ITEMS, ALL GROUPED INTO THE 3 MATPSI END PRODUCTS — GTE, STARTERS, F15/F16. ED GILL IS COMPILING THE END ITEM PARTS LIST FOR ALL END ITEMS, SO INTERVIEWS TO DEVELOP GENERIC OPERATION PROFILE SHEETS FOR EACH OF THE 3 END MATPSI PRODUCT LINES MAY PROCEED AT THAT TIME.

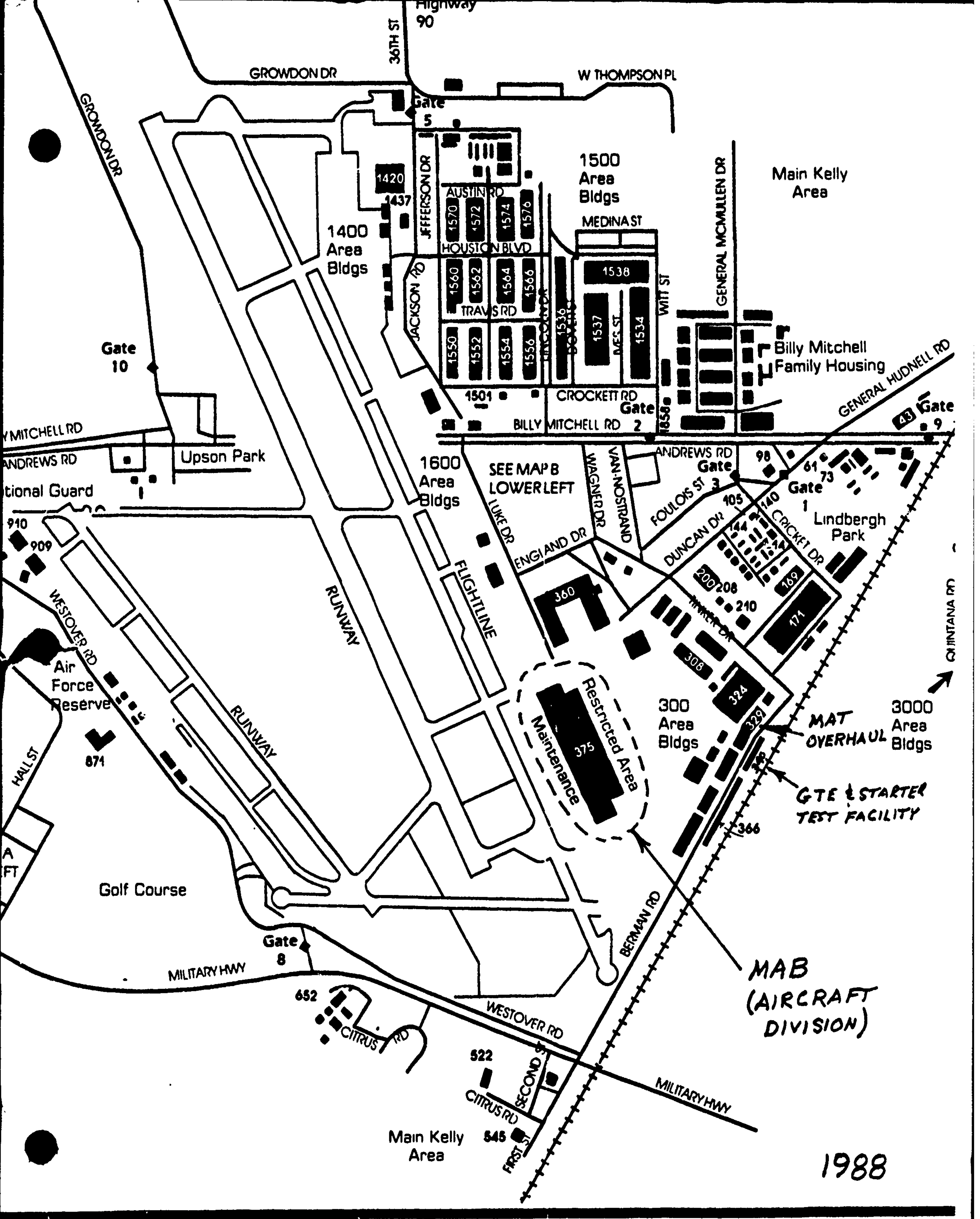
- INTERVIEW SHEETS ARE BEING COMPILED/DEVELOPED FOR THE ABOVE BY MDMSC.

- STILL DEVELOPING GENERIC MATPSI END ITEM INTERVIEW SHEETS.
- ED GILL HAS SUPPLIED MDMSC WITH THE 48 CRITICAL DETAIL PART WCDs (4 PER END ITEM) FOR 48 INTERVIEWS.
- ED GILL STILL COMPILING THE DETAIL PARTS LIST FOR ALL THE 12 END ITEMS.

— MDMSC HAS COMPLETED THE GENERIC PROCESS INTERVIEW SHEETS FOR THE 7 INSPECTION PROCESSES FOR THE 3 INSPECTION END ITEM PRODUCT LINES. ED IS COMPLETING THE DETAIL PARTS LIST FOR EACH OF THE 12 END ITEMS, AND THE 25% OF THE DETAIL PARTS THAT GO DIRECTLY TO THE PARTS POOL WILL BE ELIMINATED FROM THIS LIST BY ED. ALSO, THE 4 CRITICAL PARTS TO BE CHARACTERIZED IN DETAIL WILL BE ELIMINATED BEFORE INTERVIEWS WILL BEGIN. ED WILL ALSO ADD PARTS TO THIS LIST THAT WERE OMITTED. ONCE ED HAS FINISHED THIS, MDMSC INTERVIEWS FOR THE 3 GENERIC MATPSI END ITEM PRODUCT LINES MAY BEGIN.



90
GROWDON DR
36TH ST
W. THOMPSON PL
GROWDON DR
Gate 5
1420
1437
1500 Area Bldgs
Main Kelly Area
JEFFERSON DR
AUSTIN RD
1570
1572
1574
1576
GENERAL MCMULLEN DR
MEDINA ST
1400 Area Bldgs
HOUSTON BLVD
1538
1560
1562
1564
1566
JACKSON RD
WITT ST
TRAVIS RD
1536
1537
1534
Gate 10
1550
1552
1554
1556
Billy Mitchell Family Housing
1501
CROCKETT RD
GENERAL HUDNELL RD
MITCHELL RD
Gate 2
BILLY MITCHELL RD
43
Gate 9
ANDREWS RD
Upson Park
ANDREWS RD
1600 Area Bldgs
SEE MAP B LOWER LEFT
Gate 3
98
61
73
Gate 1
ional Guard
FOULOIS ST
105
140
910
909
LUKE DR
WAGNER DR
VAN NOSTRAND
DUNCAN DR
144
CROCKETT DR
Lindbergh Park
ENGLAND DR
WESTOVER RD
FLIGHTLINE
RUNWAY
360
208
210
171
Force Reserve
RUNWAY
308
Restricted Area
Maintenance
375
324
300 Area Bldgs
3000 Area Bldgs
871
HALL ST
366
Golf Course
BERMAN RD
Gate 8
MILITARY HWY
652
WESTOVER RD
CITRUS RD
522
SECOND
MILITARY HWY
CITRUS RD
Main Kelly Area
545
FIRST



Highway 90
36TH ST
GROWDON DR
W THOMPSON PL
Gate 5
1500 Area Bldgs
Main Kelly Area
1420
1437
1400 Area Bldgs
JEFFERSON DR
AUSTIN RD
MEDINA ST
HOUSTON BLVD
GENERAL MCMULLEN DR
1538
JACKSON RD
TRAVIS RD
WITT ST
Billy Mitchell Family Housing
Gate 10
1501
CROCKETT RD
Gate 2
BILLY MITCHELL RD
GENERAL HUDNELL RD
Gate 9
MITCHELL RD
ANDREWS RD
Upson Park
tional Guard
1600 Area Bldgs
SEE MAP B LOWER LEFT
WAGNER DR
VAN-NOSTRAND
Gate 3
Gate 1
FOULOIS ST
DUNCAN DR
CRICKET DR
Lindbergh Park
LUKE DR
ENGLAND DR
FLIGHTLINE
RUNWAY
360
308
324
171
WESTOVER RD
Air Force Reserve
Restricted Area
Maintenance
375
300 Area Bldgs
MAT OVERHAUL
3000 Area Bldgs
QUINTANA RD
HALL ST
871
GTE & STARTER TEST FACILITY
366
Golf Course
BERMAN RD
Gate 8
MILITARY HWY
652
MAB (AIRCRAFT DIVISION)
CITRUS RD
WESTOVER RD
522
SECOND ST
MILITARY HWY
CITRUS RD
Main Kelly Area
545
FIRST ST
1988