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# ANALYSIS OF THE 80/20 LISTING

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QGDEN 80/20 SORTED BY TOTAL HRS

N S N	P C N	O B E R S	P G P P	P G W S	P G W P	P N N A A S P	P R A S	P R A P	P R B S	P R B P	P R C S	P R C P	P W S	P W P	L T D T	U M
000F0004F	A4141N					82 0.0026									55.22	0.0002725
1560012452818WF	M1069K					70 0.0033									70.09	0.0006183
4210P8633369	M1641K														87.24	0.0010487
1450010618477AB	M3009K														305.20	0.0025545
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53150007575890LE	M8055K					226 0.0005									115.08	0.0096100
1430ND028568GAH	M6118K														93.49	0.0100713
1620012352270	M8276K					43 0.0054									271.39	0.0114102
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	T7576A														1906.80	0.0761307











# BREAKDOWN OF PCNS FOR 80/20 LIST

<u>TYPE OF WORK</u>	<u>NO. OF PCNS</u>	<u>NO. OF WCDS</u>
MISTR ITEMS OWNED BY FCCS TO BE PROCESS CHARACTERIZED	117	1095
TEMPORARY	37	37
MANUFACTURE	15	15
PDM	13	13
MISTR ITEMS OWNED BY ARMAMENT	10	52
MISTR ITEMS OWNED BY HYDRAULICS	23	42
TDY	1	1

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
16019A	27	F-4 N.L.G.	20	6	2	7
17565A	19	C-141 M.L.G.	26	20	25	34
74524A	12	C-141 M.L.G.	24	8	20	6
16283A	12	C-141 M.L.G.	30	18	31	34
74553A	1	C-141 M.L.G.	25	8	3	30
74516A	1	C-141 M.L.G.	23	28	4	13
69136A	1	C-141 M.L.G.	53	32	69	67
74527A	12	C-141 M.L.G.	25	14	34	37
90101A	9	C-5A&B WHEEL (M)	230	300	265	294
72898A	7	C-5A&B WHEEL (M)	45	26	34	31
17567A	8	KC-135 N.L.G.	-	-	-	1
69354A	6	KC-135 N.L.G.	30	37	42	38
17357A	4	KC-135 N.L.G.	26	26	35	25
17467A	1	KC-135 N.L.G.	26	26	35	25
15359A	4	KC-135 M.L.G.	93	18	584	144
15468A	2	KC-135 M.L.G.	532	100	226	481
15592A	3	KC-135 M.L.G.	132	73	13	81
15387A	4	T-38 BRAKE ASSY	24	17	27	10
15162A	5	KC-135 BRAKE ASSY	74	94	78	48
15054A	5	KC-135 BRAKE ASSY	44	66	55	13
15603A	1	KC-135 BRAKE ASSY	109	100	154	60
19844A	11	C-130 N.L.G.	33	10	10	30
<b>TOTAL</b>	<b>155</b>		<b>1624</b>	<b>1027</b>	<b>1746</b>	<b>1509</b>
22	(62)					
(23)		NOT ON 80/20 BUT PART OF AS-IS TO THE ACTUAL WORKLOAD				

## 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
26337A	30	F-15 M.L.G.	6	4	9	9
26338A	30	F-15 M.L.G.	12	5	9	5
74568A	5	A-7 BRAKE ASSY	34	18	-	18
25425A	3	A-10 MAIN WHEEL ASSY	53	45	33	20
15686A	3	A-10 NOSE WHEEL ASSY	48	70	19	19
15139A	3	B-52 MAIN WHEEL ASSY	33	3	17	61
15526A	3	B-52 MAIN WHEEL ASSY	38	-	50	38
69595A	3	B-52 MAIN WHEEL ASSY	108	11	274	237
15746A	3	C-141 NOSE WHEEL ASSY	21	23	105	114
62922A	3	C-141 NOSE WHEEL ASSY	14	20	29	22
62923A	3	C-141 NOSE WHEEL ASSY	44	50	104	126
62927A	3	C-141 NOSE WHEEL ASSY	183	146	107	129
19588A	4	F-15A&B NOSE WHEEL ASSY	98	100	124	211
26183A	4	F-15A&B NOSE WHEEL ASSY	94	94	42	1
69794A	4	F-15A&B NOSE WHEEL ASSY	35	16	76	-
15641A	2	F-4 BRAKE HOUSING	122	58	21	163
17402A	24	F-15 N.L.G.	9	17	31	23
17142A	26	B-52 M.L.G.	19	14	19	20
17143A	26	B-52 M.L.G.	19	19	20	32
69855	1	B-52 M.L.G.				
16836	25	F-4 M.L.G.	41	29	68	69
16837	25	F-4 M.L.G.	44	22	46	70
<b>TOTAL</b>	<b>230</b>		<b>1090</b>	<b>765</b>	<b>1212</b>	<b>1412</b>
22	(141)	NOT ON 80/20 BUT PART OF AS-IS TO THE ACTUAL WORKLOAD				
(27)						

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
74521A	21	C-141 N.L.G.	15	23	18	9
74528A	1	C-141 N.L.G.	12	4	10	10
17575A	59	C-5A M.L.G.	5	3	6	3
17576A	59	C-5A M.L.G.	4	4	7	5
17577A	59	C-5A M.L.G.	3	3	2	5
17578A	59	C-5A M.L.G.	3	2	4	1
74652A	6	C-5A M.L.G.	12	-	1	-
74692A	26	C-5A M.L.G.	6	13	-	1
72877A	38	C-5A N.L.G.	2	2	3	2
15295A	4	F-111 BRAKE	46	42	44	65
15519A	1	F-111 BRAKE	22	94	57	35
15583A	6	F-111 BRAKE	8	1	6	9
68521A	3	C-130 NOSE WHEEL (NAVY)	94	38	37	45
62405A	3	C-130 NOSE WHEEL (NAVY)	50	16	32	115
15757A	3	C-130 NOSE WHEEL (NAVY)	48	60	31	48
16123A	10	C-130 BALL SCREW ASSY	24	51	35	35
17527A	14	A-70 M.L.G.	17	6	12	19
17595A	14	A-70 M.L.G.	-	1	-	-
25874A	4	F-16 M.L.G. BRAKE ASSY	81	205	110	49
26411A	1	F-16 M.L.G. BRAKE ASSY	200	240	400	202
15161A	5	C-141 BRAKE ASSY	19	18	63	63
<b>TOTAL</b>			665	826	878	721
21	359					
(30)	(81)	NOT ON 80/20 BUT PART OF AS-IS TO THE ACTUAL WORKLOAD				

# 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
26642A	23	F-16 N.L.G.	7	11	-	2
42626A	23	B-52 TIP	5	3	2	5
83317A	6	F-16 NLG UPPER DRAG BRAKE ASSY	8	4	-	21
17478A	19	T-38 N.L.G.	26	20	10	30
17451A	9	KC-135 M.L.G.	24	12	21	14
17313A	10	KC-135 M.L.G.	11	14	30	18
17259A	11	KC-135 M.L.G.	25	16	24	26
17327A	10	KC-135 M.L.G.	28	23	32	30
17347A	4	KC-135 M.L.G.	15	27	55	33
17348A	4	KC-135 M.L.G.	35	26	38	34
17245A	1	KC-135 M.L.G.	74	47	88	100
17407A	1	KC-135 M.L.G.	59	33	47	46
69554A	1	KC-135 M.L.G.	45	28	1	-
69657A	12	KC-135 M.L.G.	15	10	1	1
16915A	6	KC-135 M.L.G.	20	25	-	1
69549A	1	KC-135 M.L.G.	40	50	1	50
69354A	14	KC-135 M.L.G.	30	37	42	38
17357A	10	KC-135 M.L.G.	26	26	35	25
15359A	5	KC-135 M.L.G.	93	18	584	144
15468A	4	KC-135 M.L.G.	532	100	266	481
15523A	3	FB-111 MAIN WHEEL ASSY	13	19	-	-
25737A	13	F-16 M.L.G.	29	29	22	35
26111A	1	F-16 M.L.G.	10	24	4	24
<b>TOTAL</b>	<b>191</b>		<b>1174</b>	<b>602</b>	<b>1303</b>	<b>1158</b>

## 80/20 MATRIX OGDEN, UTAH

PCN	NO. OF WCDS	NOUN	NO. OF COMPLETIONS			
			FY89-1	FY89-2	FY88-3	FY88-4
25874A	9	F-16 HOUSING BRAKE ASSY	81	205	110	49
26413A	1	F-16 HOUSING BRAKE ASSY	300	360	600	303
26411A	1	F-16 BRAKE ASSY	200	240	400	202
15752A	7	A-10 BRAKE ASSY	36	54	50	21
15068A	5	B-52 BRAKE ASSY	48	74	129	113
36192A	1	B-52 BRAKE ASSY	59	40	122	80
17474A	22	T-38 M.L.G.	10	4	2	-
17476A	21	T-38 M.L.G.	6	7	8	-
17568A	2	T-38 M.L.G.	100	-	-	-
15327A	7	C-130 BRAKE ASSY	35	29	48	64
15728A	2	C-130 BRAKE ASSY	62	19	2	3
26560A	1	F-15 A/B BRAKE ASSY	444	210	162	120
26559A	1	F-15 A/B BRAKE ASSY	592	280	216	160
15485A	9	F-4 MAIN WHEEL ASSY	50	225	216	54
16267A	3		57	8	88	39
16266A	3		129	6	79	62
17354A	24	F-111 N.L.G.	9	9	4	7
19937A	21	A-10 N.L.G.	16	10	12	8
15752A	2	A-10 N.L.G.	36	54	50	21
15698A	9	C-5A M.L.G. BRAKE ASSY	7	20	22	5
72896A	1	C-5A M.L.G. BRAKE ASSY	199	60	-	-
<b>TOTAL</b> 16	95		2567	1914	2320	1311

OPEN TEMPORARY JOBS

PCN	DESCRIPTION	QTY	DATE PLANNED
T6254A		30	880930
T7601I		778	880530
T6295I		117	880404
T6912A		30	880930
T5736I		1000	880601
T5797J		2500	880331
T5811J		3206	871231
T5822J		600	880331
T5330		1000	880401
T5733N		1280	880330
T4989Q		400	881231
T4452Q		480	890331
T4582Q		400	890331
A4141N		56	880930
T2733I		50	841231
T1384I		55	841231
T2532A		20000	862701

CLOSED TEMPORARY JOBS

PCN	QTY	DATE OUT	PLANNED CLOSED DATE
T1385Q	2	15-Nov-88	3-Feb-89
T1386Q	2	15-Nov-88	3-Feb-89
T1434A	450		
T5493I	200	1-Aug-88	30-Jan-89
T5773J	2385	27-Nov-87	30-Jan-89
T5802J	1000	17-Oct-88	10-Jan-89
T5817J	1000		27-Feb-89
T5821J	2500	17-Dec-87	
T7576G	1	17-Jan-87	18-Nov-89
T7582I	2	23-Nov-87	17-Feb-89
T9355I	20	23-Sep-88	27-Dec-89



**PERCENT OF OTHER WORKLOAD FOR RCC**  
 (80/20 LISTING)  
 RCCs

JOB TYPES	MANPGP	MANPGW	MANPNA	MANPRA	MANPRB	MANPRC	MANPWW
TEMPORARY	13.72	2.35	15.11	1.40	1.05	1.35	1.05
MANUFACTURE	0.00	0.00	0.92	0.00	4.51	2.74	12.50
PDM	1.00	0.00	22.79	0.04	0.07	4.39	22.44
ARMAMENT	0.00	0.23	1.26	0.04	0.03	4.18	2.38
HYDRAULICS	0.00	0.05	7.00	1.11	2.67	3.88	13.99
MISCELL. (Hooks, Brakes, Landing Gears)	85.28	97.37	52.92	97.41	91.67	83.46	47.64

DISTRIBUTION: NAME (4)

SEQUENCE: PU/PTC/CH/JD/OPENR/RCC/FC

PAGE BREAK: PU/PTC/CH/JD

AG004L-L3A-DI-MAA

TEMPORARY JOB RECORD

AS OF 88-08-23 PAGE 001

REQUEST CUST ID

END ITEM IDENTITY

DATE NO P NEED MI SC PRI AUTHORITY

CTRL J JON D UD OTHER DIR P

ZI PRICE OR RATE

EMNS1148 EBMSP 000F0004E

98 MBEFEM 84228 890230 M 3 02 EG-D-EFY/001

608J A1141 M 84A N EA 2381.00 A

88.00

F OPER BS T SK

ORIG TOT STD ROC

BLC

OPERATION DESCRIPTION

STD EXP STD INV

RCC C NR PI 00 IC CD

93M 0CL HOURS RATE

PART NUMBER

MANUF CODE MI QUANT

STOCK C EXPENSE INV MAT COST

MPMA 2 00001 S 1 DS 1.00 56

88 41.940 2348.64

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.00

PMN COPY SIGNATURE:

SCHEDULER SIGNATURE:

QUALITY SIGNATURE:

JOB SUMMARY: CUST EST

18125 PLN'D COST \$4780

TOT PLN'D HOURS: 56.00

PLAN PT

MAIL

PHONE BLOS

LOCATION

RCC

MAIL

PHONE BLS

LOCATION

PANEL P PARKER DAVID

NAME 73387 507 ROOM 210-E

MPMP

MPMB M MOEPEL RICH

PHONE BLS

LOCATION

## PROCESS CHARACTERIZATION OF RCCS

1. MODEL LANDING GEAR, BRAKES, AND WHEELS AS THE MAJOR COMPONENTS THRU THE SEVEN RCCS AS MAJOR FAMILY GROUPINGS
2. TREAT ALL OTHER WORKLOADS T, M, & PDM JOBS THRU THE SHOPS AS A MANPOWER CONSTRAINT -- MANPOWER IS NOT AVAILABLE AS A PERCENT XX TO WORK ON BRAKES, WHEELS, AND LANDING GEAR BECAUSE THEY ARE WORKING OTHER JOBS.
3. IDENTIFY ANY OTHER WORKLOAD THAT MAY REQUIRE EQUIPMENT AND CONSTRAINT THE EQUIPMENT FOR THE TIME NEEDED TO PERFORM THE OTHER WORKLOAD AS A PERCENT XX THAT THE EQUIPMENT IS FOR OTHER USE.
4. WORKLOAD WILL BE CALCULATED FROM THE DATA FOR THE FAMILY GROUPINGS TO GENERATE THE "AS-IS" CONDITION OF THE WORKLOAD COMPLETED FOR EACH QUARTER.
5. PERFORM INDUSTRIAL ENGINEERING ASSESSMENT OF ALL RCC - OVERVIEW OF RCCS - PARA. 3.1.1.1 OF SOW.

## PROPOSED BRAKE GROUPINGS

<u>FAMILY NO</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
1	MAGNESIUM HOUSING - STEEL BRAKE	"B-52" A-37, F-106 T-33, F-100
2	ALUMINUM HOUSING - STEEL BRAKE	"KC-135" A-7D, T-38, T-39, F-111, F-5, A-10, C-130, C-141, E-3A
3	ALUMINUM HOUSING - BERYLLIUM BRAKE	C-5A
4	ALUMINUM HOUSING - CARBON BRAKE	C-5B, F-15, F-16

## **BRAKES**

- NOTES:**
- (1) FOREMAN, MAX BATE**
  - (2) C-130 HAS EITHER A SINGLE ROTOR OR MULTIPLE ROTOR BRAKES (MULTIPLE ROTOR BRAKES CAN BE GROUPED IN THE KC-135 GROUPING, SINGLE ROTOR BRAKE TO BE CHARACTERIZED AS A SEPARATE ENTITY)**
  - (3) KC-135 HAS EITHER FOUR ROTORS OR FIVE ROTORS**
  - (4) F-4 ONLY THE HOUSING IS REFURBISH**
  - (5) F-16 HAS SOME UNIQUE ASSEMBLY COMPLEXITIES AND LENGTHY TEST PROCEDURE**
  - (6) C-5A BRAKES ARE DISASSEMBLED IN A SPECIAL ROOM BECAUSE OF THE BERYLLIUM BRAKE**

## PROPOSED LANDING GEAR GROUPINGS

### ALUMINUM OUTER/STEEL INNER

NLG  
MLG

\* KC-135  
\* C-141  
+ F-111  
+ F-15  
+ F-16  
\* B-52 TIP  
+ A-10  
+ A-7  
+ T-38

### STEEL OUTER/STEEL INNER

NLG  
MLG

\* C-130  
\* F-4  
\* C-141  
\* KC-135  
+ F-111  
+ F-15  
+ A-7

+ F-16  
\* B-52  
\* A-10  
+ T-38

### C-5 M.L.G. & N.L.G. GROUPING

C-5 M.L.G. STRUT ASSY

C-5 M.L.G. BOGIE ASSY

C-5 N.L.G.

### ALUMINUM/STEEL

KC-135 NLG  
C-141 NLG  
B-52 TIP  
B-52 MLG  
A-10 MLG

### ALUMINUM/STEEL

F-111 NLG  
F-16 NLG  
F-15 NLG  
A-10 NLG  
A-7 NLG  
T-38 NLG

### STEEL/STEEL

C-130 NLG  
F-4 NLG  
KC-135 NLG  
C-141 NLG  
C-130 MLG

### STEEL/STEEL

F-111 MLG  
F-15 MLG  
A-7 MLG  
F-4 MLG

**LANDING GEAR GROUPINGS TO BE PROCESS CHARACTERIZED**

<b><u>FAMILY NO</u></b>	<b><u>FAMILY CHARACTERISTICS</u></b>	<b><u>AIRCRAFT</u></b>
7	C-5 MLG STRUT ASSY	C-5
8	C-5 MLG BOGIE ASSY	C-5
9	C-5 NLG	C-5

## LANDING GEAR GROUPING

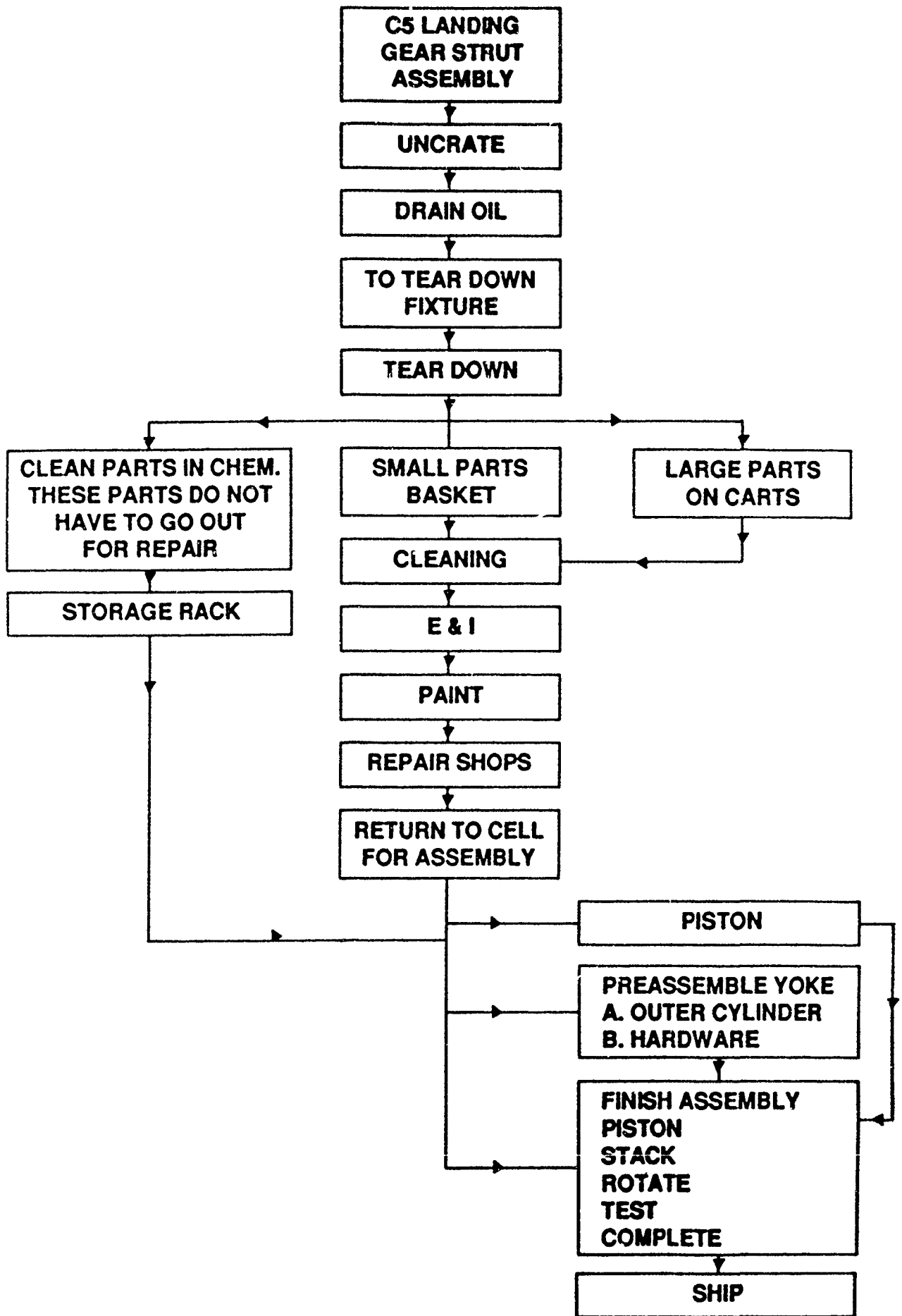
### NOTES:

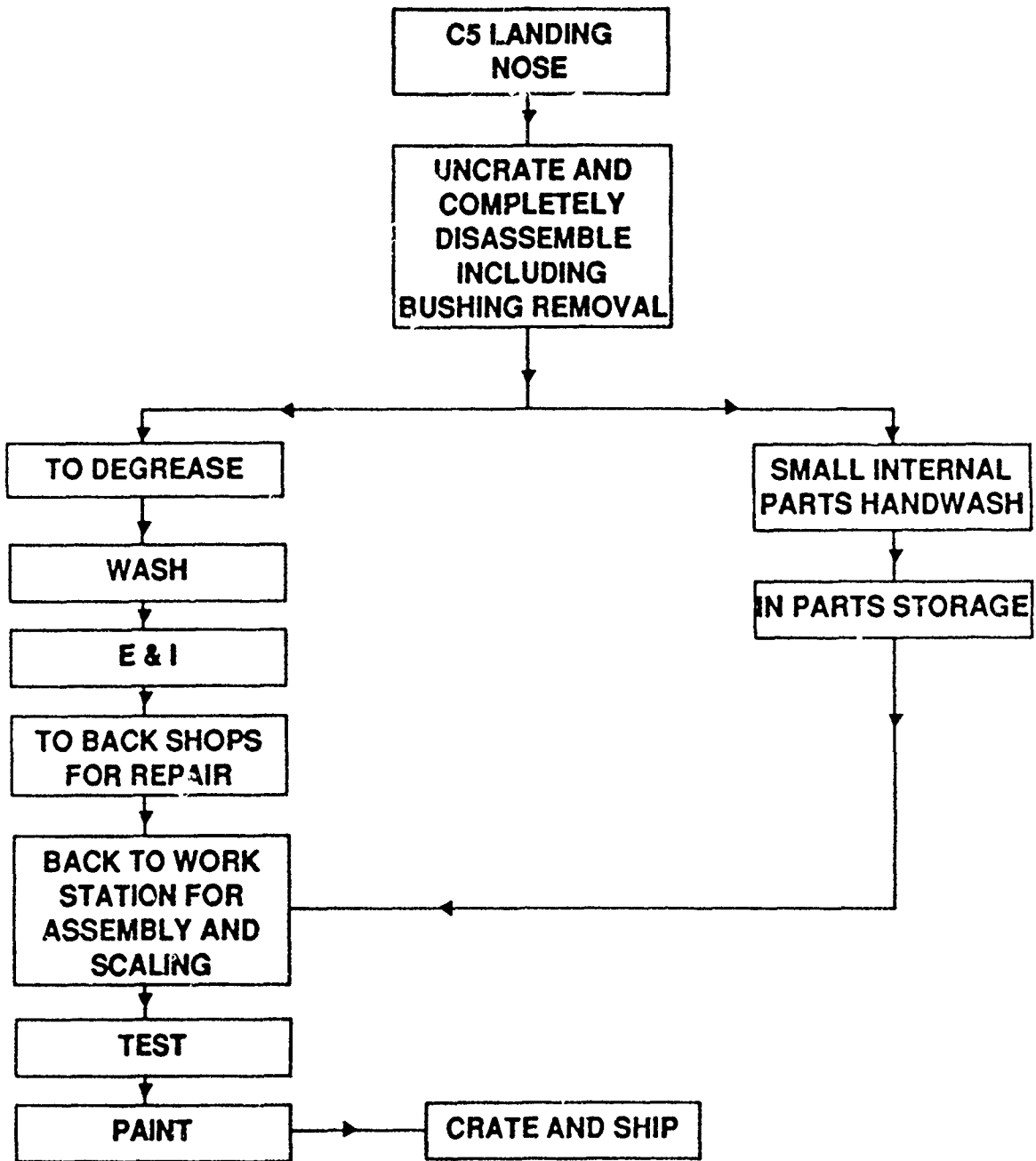
- (1) LANDING GEAR WAS BROKEN DOWN INTO 3 GROUPS
  - STEEL OUTER CYLINDER/STEEL INNER CYLINDER
  - ALUMINUM OUTER CYLINDER/STEEL INNER CYLINDER
  - C-5 M.L.G.
- (2) THE FIRST TWO GROUPS WERE SUBDIVIDED INTO SUBGROUPS BASED ON SIZE AND LIKENESS OF PROCESSES
- (3) THE GROUPS WERE VERIFIED BY COMPARING THE STANDARD HOURS USED BY MANPGP FOR THE ASSEMBLING PROCESS
- (4) FOREMAN IS DAVE BENNION

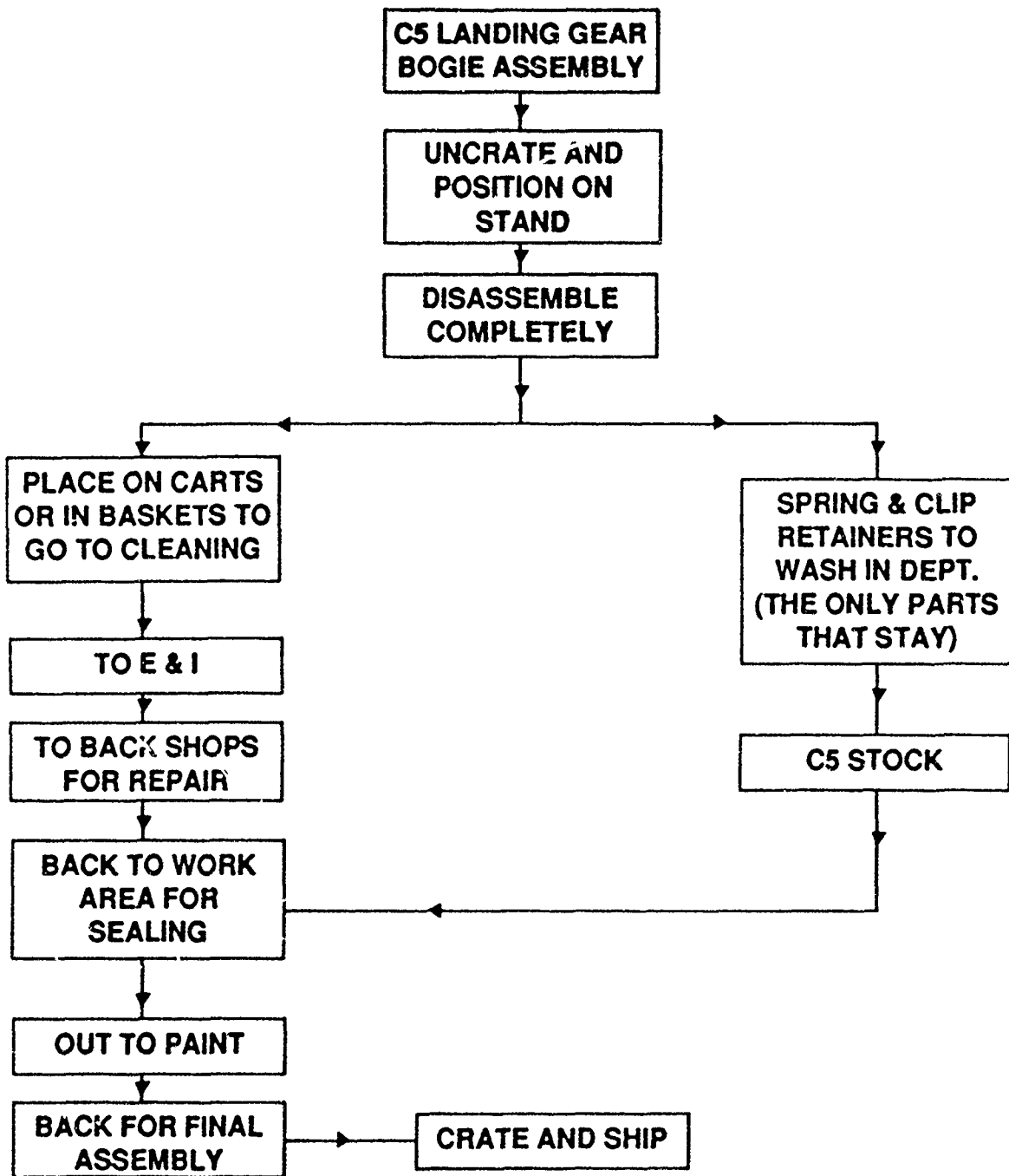


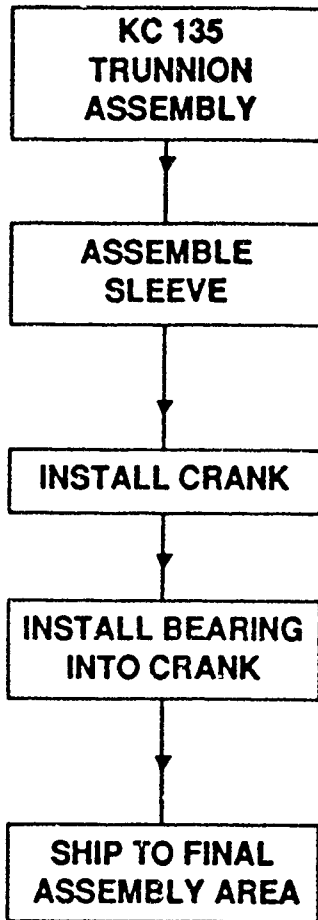
## PROPOSED WHEEL GROUPINGS

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
1	MAGNESIUM	KC-135N
2	ALUMINUM - LARGE	B-52M
3	ALUMINUM - MEDIUM	KC-135M
4	ALUMINUM - SMALL	T-38N
5	ALUMINUM - LARGE - SPECIAL BORES	C-5M
6	ALUMINUM - SMALL - SPECIAL BORES	C-5N









LSC-20124

**KC 135  
UPPER SIDE  
STRUT ASSEMBLY**



**INSTALL BEARING**



**INSTALL BEARING**



**INSTALL  
ENVIRONMENTAL  
COVERS**



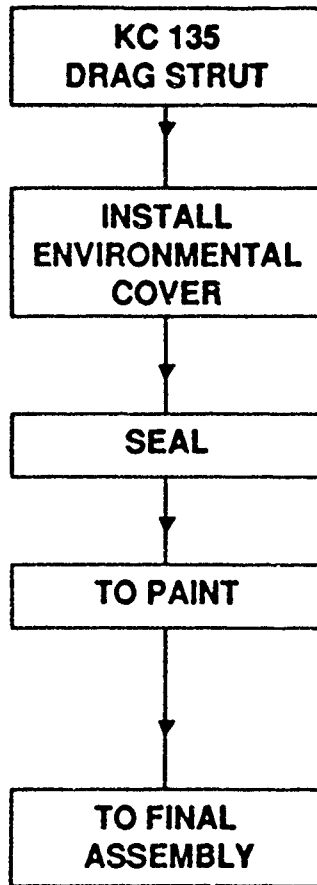
**SEAL**



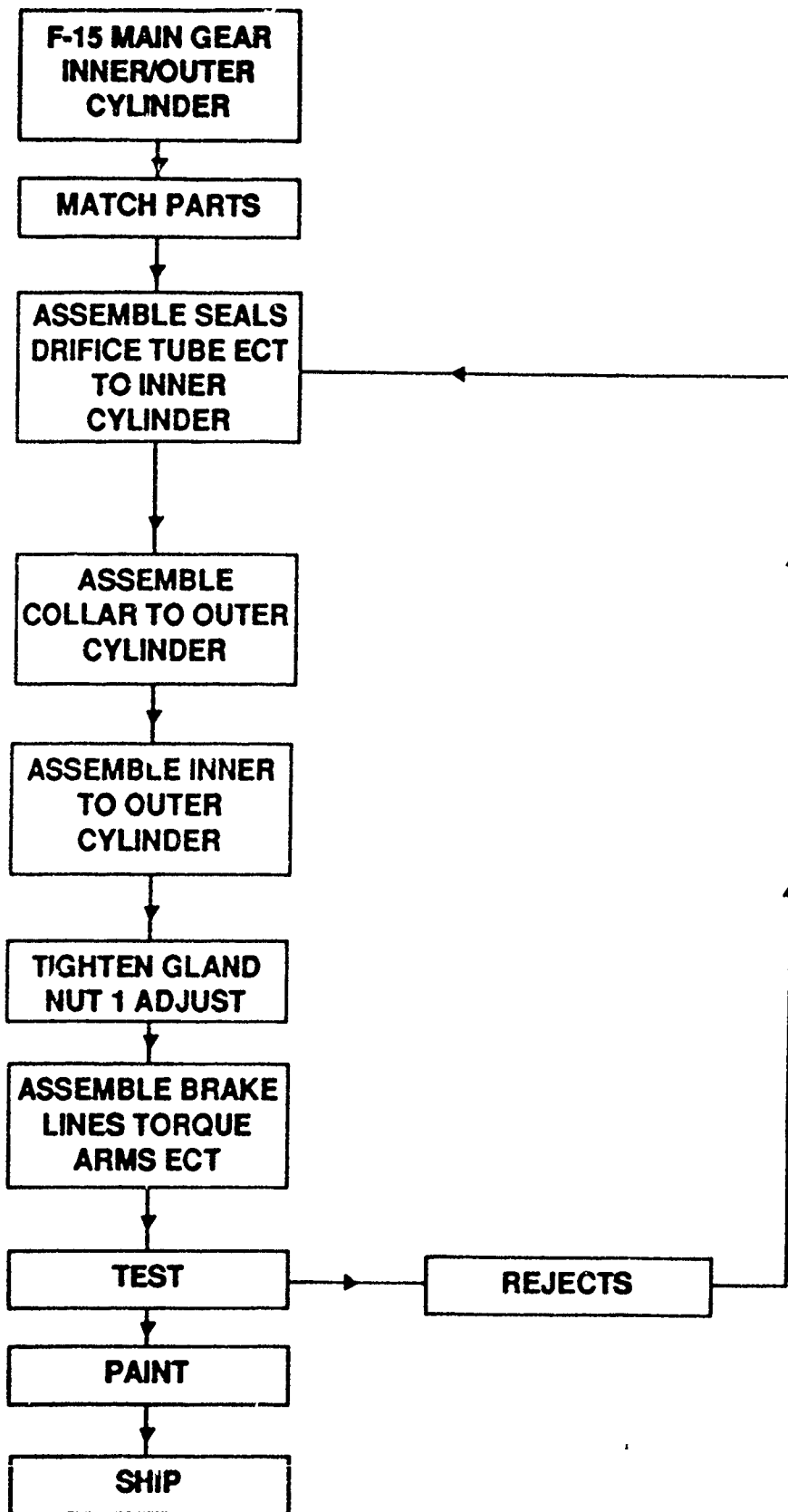
**TO PAINT**



**TO FINAL  
ASSEMBLY**



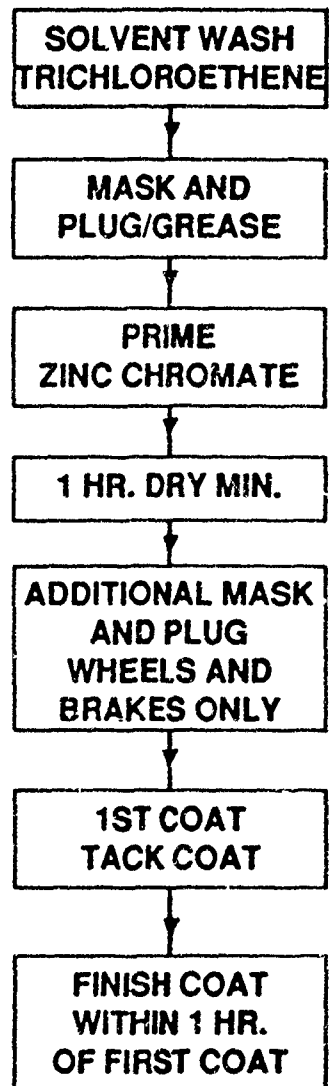
LSC-20122



LSC-20127

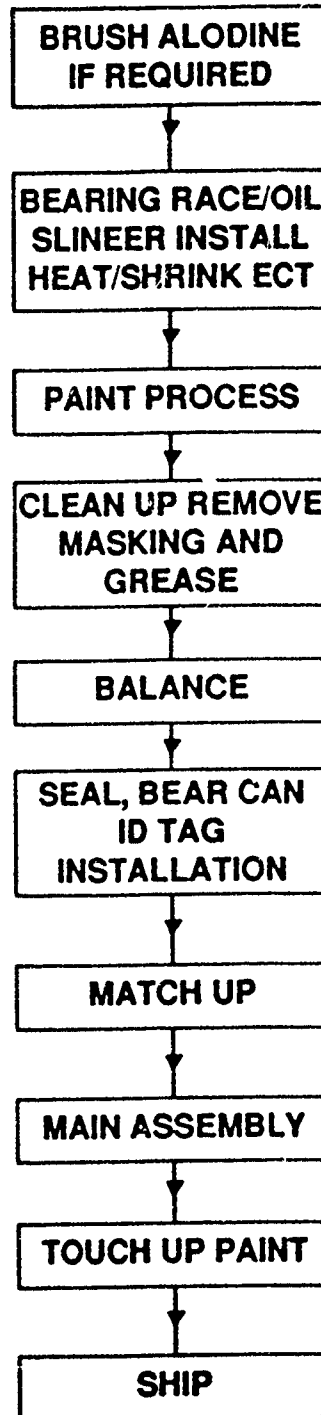


## PAINT PROCESS FLOW CHART

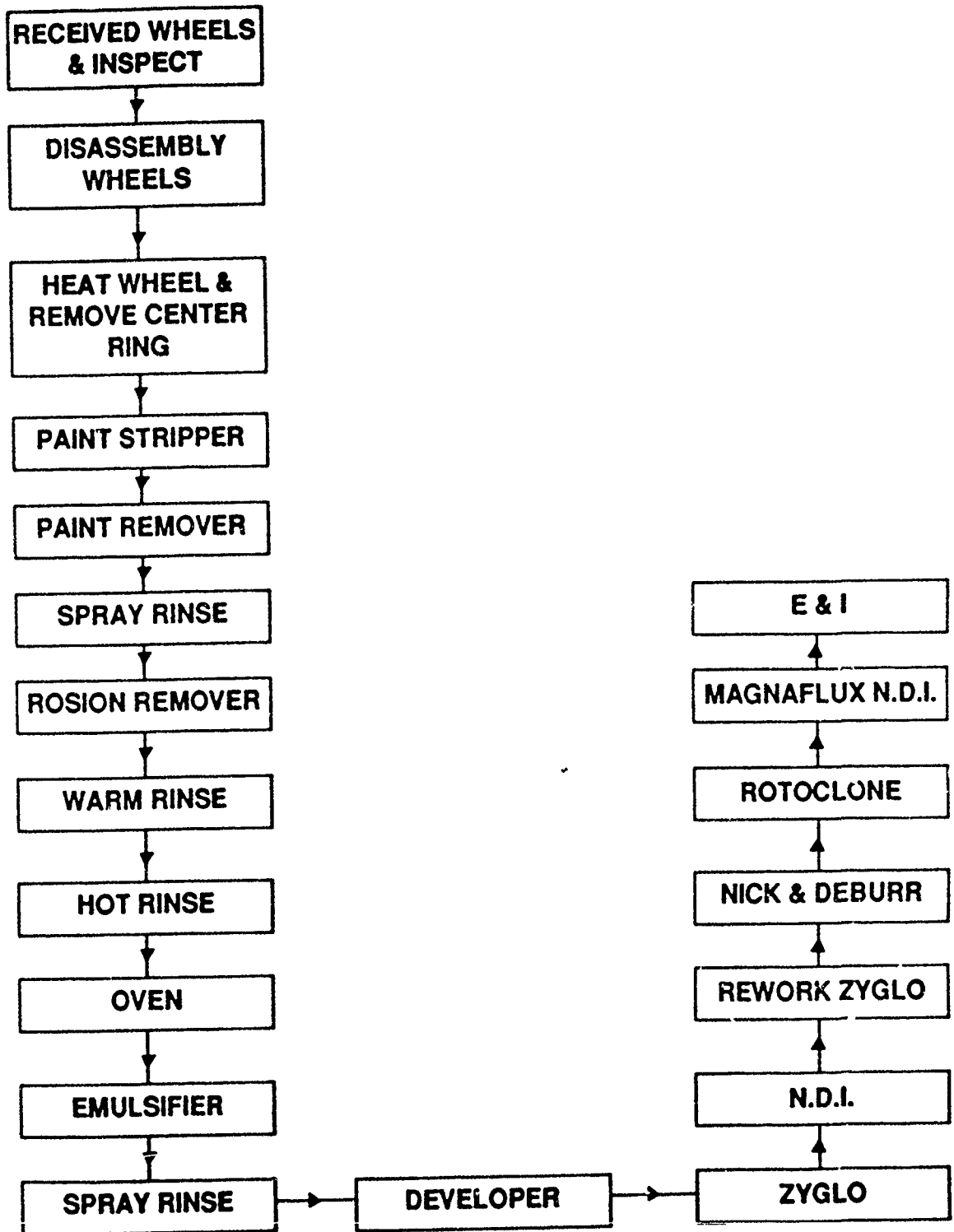


LSC-20128

## WHEEL ASSEMBLY FLOW CHART



LSC-20129



## BRAKE GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>STD. HRS. (MANPGP)</u>
1	MAGNESIUM HOUSING - STEEL BRAKE	"B-52" A-37, F-106 T-33, F-100	6.59 6.20
2	ALUMINUM HOUSING - STEEL BRAKE	"KC-135" A-7D, T-38 T-39, F-111 F-5, A-10 C-130, C-141 E-3A	6.69 4.78 6.65, 6.41 5.68, 4.38 6.63
3	ALUMINUM HOUSING - BERYLLIUM BRAKE	"C-5A"	13.41
4	ALUMINUM HOUSING - CARBON BRAKE	"C-5B" F-15	13.41
5	ALUMINUM HOUSING - CARBON BRAKE - SPECIAL ASSEMBLY CHARACTERISTICS	"F-16"	7.16
6	ALUMINUM HOUSING - STEEL BRAKE, SINGLE ROTOR	"C-130"	6.63

## LANDING GEAR GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>SID. HRS.</u> (MANPGP)
1	STEEL/STEEL	"F-15 MLG"	11.60
2	STEEL/STEEL	"C-1 <sup>4</sup> 101 NLG"	8.03
3	STEEL/STEEL	"KC-135 MLG" F-4 NLG C-130 NLG C-130 MLG F-111 MLG A-7 MLG F-4 MLG	6.09 5.44 4.81 3.29 5.29 3.35 4.75
4	ALUM/STEEL	"F-15 NLG" F-16 NLG A-7 NLG T-38 MLG T-38 NLG	4.35 3.84 4.92 3.40 4.67
5	ALUM/STEEL	"KC-135 NLG" C-141 NLG A-10 MLG F-111 NLG A-10 NLG	6.66 6.66 7.75 5.75 7.75
6	ALUM/STEEL	B-52 MLG B-52 TIP	11.20 12.00

# LANDING GEAR GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>
7	C-5 MLG STRUT ASSY	C-5
8	C-5 MLG BOGIE ASSY	C-5
9	C-5 NLG	C-5

## WHEEL GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>STD. HRS.</u> <u>(MANPGP)</u>
1	MAGNESIUM	KC-135N	2.67
2	ALUMINUM - LARGE	B-52M	2.47
3	ALUMINUM - MEDIUM (MAIN WHEELS)	"KC-135M" A-10M, C-5M C-130M, C-141M E-34M, F-4M F-5M, F-15M F-16M, F-100M F-106M, F-111M FB-111M	2.75
4	ALUMINUM - SMALL	"T-38N" A-10N, C-5N A-7N, C-130N E-3AN, F-4N	2.09

- NOTES:**
- (1) FOREMAN IS BOB BURGER ALTERNATE IS CHARLES POWERS.
  - (2) ALL OF THE MAIN WHEELS ARE VERY SIMILAR IN SIZE AND PROCESS TIMES EXCEPT THE B-52 MAIN WHEEL
  - (3) ALL OF THE NOSE WHEELS ARE SIMILAR EXCEPT THE KC-135N WHICH IS MADE OF MAGNESIUM.

ALC.SASCAN.CNTL(008020P)  
ODDEN 80/20 SORTED BY TOTAL NRS

P C N	O B S E R V E R S	F G P S	F G P P	F G W S	F G W P	F M A S	F M A P	F R A P	F R A S	F R B P	F R B S	F R C P	F R C S	F W S	F W P	L T O T	C U M			
00F0004F																55	22	0	0002725	
560012452810WF						82	0	0.0026								70	08	0	00006183	
10P8633389						70	0	0.0033								87	24	0	0010187	
50010818477A8													45	0	0.0055	305	20	0	0075545	
0P8852389-10														17	0	0.0151	239	52	0	0037382
0P8852389-20														18	0	0.0151	239	52	0	0049179
0P8518153														3	0	0.0416	659	88	0	0081736
0011515345														22	0	0.0111	178	07	0	0080A23
1500757580LE																115	08	0	0088100	
30ND028588GAN						226	0	0.0005								93	49	0	0100713	
20012352270						43	0	0.0054								271	39	0	0114102	
320000625518AM																115	80	0	0118815	
12001268755LE																172	05	0	0128304	
150ND028844GAN																244	28	0	0140356	
120P853930-03																79	88	0	0144287	
180POV10A									4	0	0.0451					890	61	0	0183185	
00-00008492028																447	02	0	0215240	
20PC141CA1PL6																53	10	0	0217880	
20PC141CA1PL6																125	18	0	0224035	
099000V0010A																125	18	0	0230008	
337008574811																122	64	0	0236260	
337011451832																118	85	0	0242129	
S-00003143002																150	81	0	0249568	
S-00005140323																87	84	0	0253858	
00PGP-TEST288																17	45	0	0258317	
00PGROUNDTEST																180	54	0	0267826	
00PGROUNDTEST																298	49	0	0282801	
00004463778																1558	04	0	0358520	
00005470118																150	89	0	0368854	
00005756750																238	36	0	0386898	
000284786																237	32	0	0408708	
000284316																80	71	0	0412688	
000284980																707	24	0	0447582	
000284326																275	26	0	0461162	
000261666																630	31	0	0492268	
000284316																251	23	0	0504860	
000824060																187	50	0	0513810	
002421514																238	36	0	0525720	
0006133512																247	34	0	0537923	
0006133512																263	30	0	0550813	
0010054182																183	58	0	0558882	
																234	58	0	0570555	
																618	24	0	0601057	
																341	83	0	0617922	
																499	67	0	0667226	
																1908	90	0	0761307	





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ORDEN 80/20 SORTED BY TOTAL MRS

Table with 24 columns: P C N, O P E R S, R, S, K, P, P, P, P, G, W, P, P, M, A, S, P, N, A, P, P, R, A, S, P, R, A, S, P, P, R, A, S, P, K, R, S, P, P, R, C, S, P, R, C, S, P, M, R, S, P, K, R, S, P, P, R, C, S, P, M, R, S, P, P, R, C, S, P, L, T, O, U, M. Contains numerical data for various categories.











8:12 FRIDAY, APRIL 7, 1981

ALC.SASCAN.CNTL(008820P)

ODDEN 80/20 SORTED BY TOTAL MRS

M N S	P C M	O P E R S	O B S E R	P G P P S	P G W S	P G W P	P M A S P	P R A S P	P R A P	P R R S P	P R R C C S P	P W W S	P W W P	L T A O T	U M	
1620000271182	72572A	S 12	19	91	133	0.0016	115	0.0017	134	0.0008	35	0.0074	50	0.8050	328	0.78887
1620004325851	72837A			49	81	0.0047	88	0.0025	134	0.0008	31	0.0080	85	0.8027	498	0.78892
1620004649182	72886A			85	28	0.0028	152	0.0010	38	0.0044	82	0.0020	95	0.8023	443	0.78810
1620002861878	72191A	67	7	141	85	0.0013	104	0.0020	18	0.0158	20	0.0148	82	0.8040	741	0.77778
1620001781082	74111A			44	21	0.0040	34	0.0066	13	0.0200	17	0.0182	34	0.8079	1050	0.77794
1620001877445	74112A														1894	0.78728
16200018877445	74113A														272	0.78831
1620002468005	74114A														341	0.78833
1620004427877	74115A														3235	0.80133
1620004718658	74116A														3785	0.82014
1620007487823	74117A														312	0.82153
1620004100858	74118A														340	0.82233
1620001486488	74119A														551	0.82505
1620001781425	74203A														348	0.82785
1605000586752	74805A														1475	0.83493
1620011827542	82717A	5	186	3	78	0.0031	126	0.0014	111	0.0011	57	0.0023	24	0.0108	1230	0.84100
1620011826267	80183A										38	0.0065	24	0.0278	344	0.84270
1620000222823	84332A										88	0.0017	112	0.0020	9803	0.87182
1650002183802LE	88828A										137	0.0004	87	0.0022	248	0.87303
											88	0.0028	88	0.0038	178	0.87390
											0.8758				0.8584	177130
											0.8758				0.8551	



8:12 FRIDAY, APRIL 7, 1989

ALC.SASCAN.CNTL(008020P)  
ODDEN 80/20 SORTED BY TOTAL MRS

P C M	O B E R S	P G P S	P G P P	P G W S	P G W P	P M A S P	P M A S	P R A P	P R B S	P R B P	P R C S	P R C P	P W W S	P W W P	L T D Y	U M
JF0004F															55	0.002725
J0012452818MF						82	0.0026								70	0.0006183
J0P8633389						70	0.0033								87	0.0010487
J0010818477AB											45	0.0055			305	0.0025545
J0P852389-10											35	0.0082			239	0.0037382
J0P852389-20											18	0.0151			239	0.0048178
J0P8518153											3	0.0416			659	0.0081736
J0011515345											22	0.0111			178	0.0080423
J0007575880LE						226	0.0005				89	0.0034			115	0.008100
J000285880AH											48	0.0051			93	0.0100713
J0012352270						43	0.0054				37	0.0073			271	0.0114102
J000625516AH											46	0.0056			115	0.0119815
J0012697858LE											46	0.0056			172	0.0128304
J000288440AH											86	0.0026			244	0.0140358
J003027804											81	0.0049			78	0.0144297
J0P85326-03											75	0.0033			98	0.0183185
J0P0VJ0A									4	0.0481					447	0.0215240
J00098492028															53	0.017890
JPC141CAIPLB						77	0.0028								125	0.0224035
JPC141CAIPLB						86	0.0025								122	0.0230208
JPC141CAIPLB						127	0.0014								118	0.0242128
JPC00V0010A						124	0.0014			148	0.0003				150	0.0248568
J000574611						32	0.0056								82	0.0253858
J000784230						85	0.0038								17	0.0254517
J011451983															88	0.0258816
J0005140002						60	0.0042								180	0.0267820
J0005140023						22	0.0035								289	0.0282601
J0GR-TEST28B						12	0.0141								155	0.0359520
JPGROUNDTEST						3	0.0734								150	0.0366954
JPGROUNDTEST															368	0.0385188
JPGROUNDTEST						8	0.0174								238	0.0386998
J004863778						43	0.0060								237	0.0408708
J005470116						118	0.0017								80	0.0412688
J3P-LGM118A															707	0.0461162
J005758750						48	0.0055								275	0.0461162
J0MD0284788						31	0.0089								630	0.0492260
J0MD0284658						13	0.0158								251	0.0504660
J0MD0284988						36	0.0063								187	0.0513910
J0C28432G						57	0.0047								239	0.0525720
J0C28168G						45	0.0060								247	0.0537923
J0C28168G						40	0.0062								263	0.0550913
J0C28168G						35	0.0066								183	0.0558982
J0C28168G						1	0.0041								234	0.0570555
J0C28168G						283	0.0001								818	0.0601057
J0C28168G						143	0.0012								341	0.0617922
J0C28168G						271	0.0002								499	0.0642574
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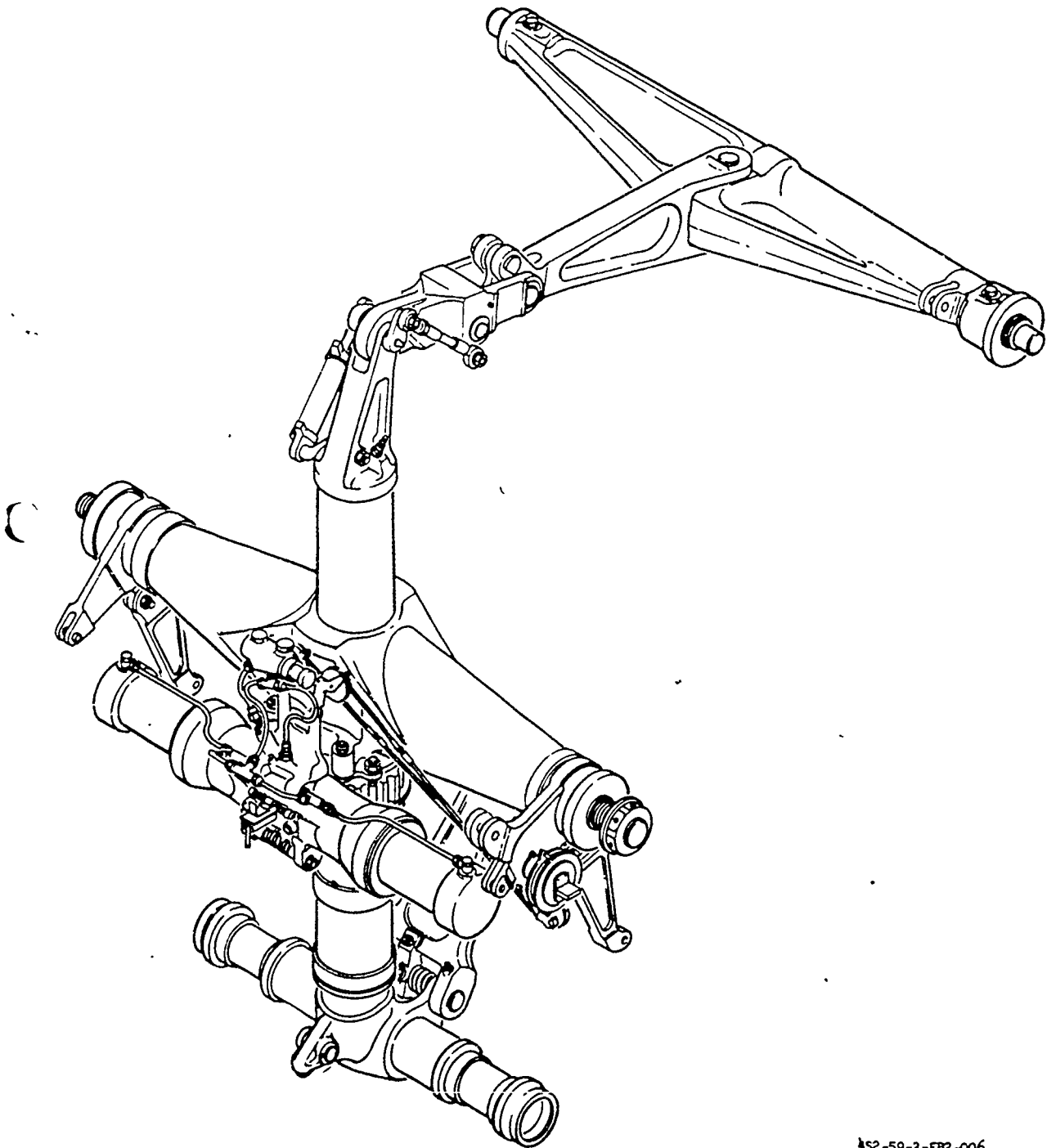


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OGDEN 80/20 SORTED BY TOTAL HRS

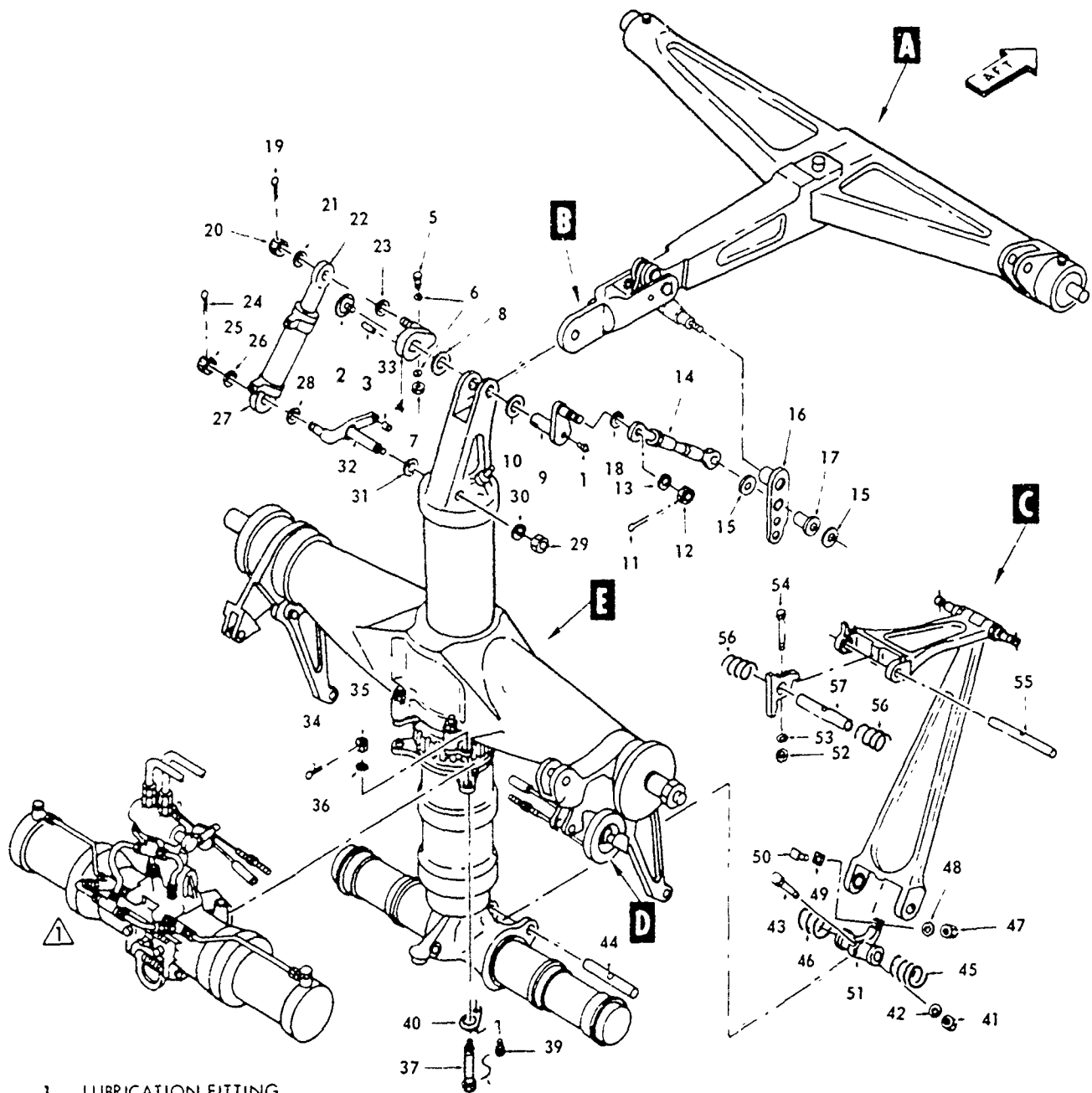
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1680010520816LS	63079A		11			218	0.0005	208	0.0006			81	0.0030			107	0.866722	
1630001132133	15518J					80	0.0030	52	0.0046							99	0.867210	
000F0004E	001188							54	0.0045							98	0.867692	
1560011358956WF	25584A															96	0.868164	
1005010086283	25638A													40	0.0080	95	0.868634	
1430ND0028568GAN	M8118K							60	0.0042			388	0.0001	43	0.0057	93	0.869095	
SYS-00005140023	T2733I							266	0.0003					48	0.0051	89	0.869535	
100500188698	68769A													45	0.0055	87	0.869366	
4210P8633368	M1641K							65	0.0039							87	0.870396	
1337011451963	T2532A							66	0.0038							83	0.870805	
9999P-LGM118A	T5733N															81	0.871203	
163000502299A	M8586K															80	0.871597	
431C0093713748F	68661A							67	0.0037							79	0.871985	
15600098343248F	18365A							74	0.0030	162	0.0002	426	0.0000	178	0.0003	72	0.872341	
1560012452818WF	M1069K							70	0.0033							70	0.872687	
15600017066718F	18863A		8	85				81	0.0027			427	0.0030	186	0.0003	62	0.872993	
15600095477528F	14729A							78	0.0028							59	0.873287	
000F0004F	A4141M							82	0.0026							55	0.873559	
LOG-00008482028	T1384I							86	0.0025							53	0.873821	
SYS-00005140002	T2709I														23	0.0011	17	0.873907
-----																		
177130																		

9



4S2-59-3-FB2-006

Figure 1-1. Nose Landing Gear Assembly

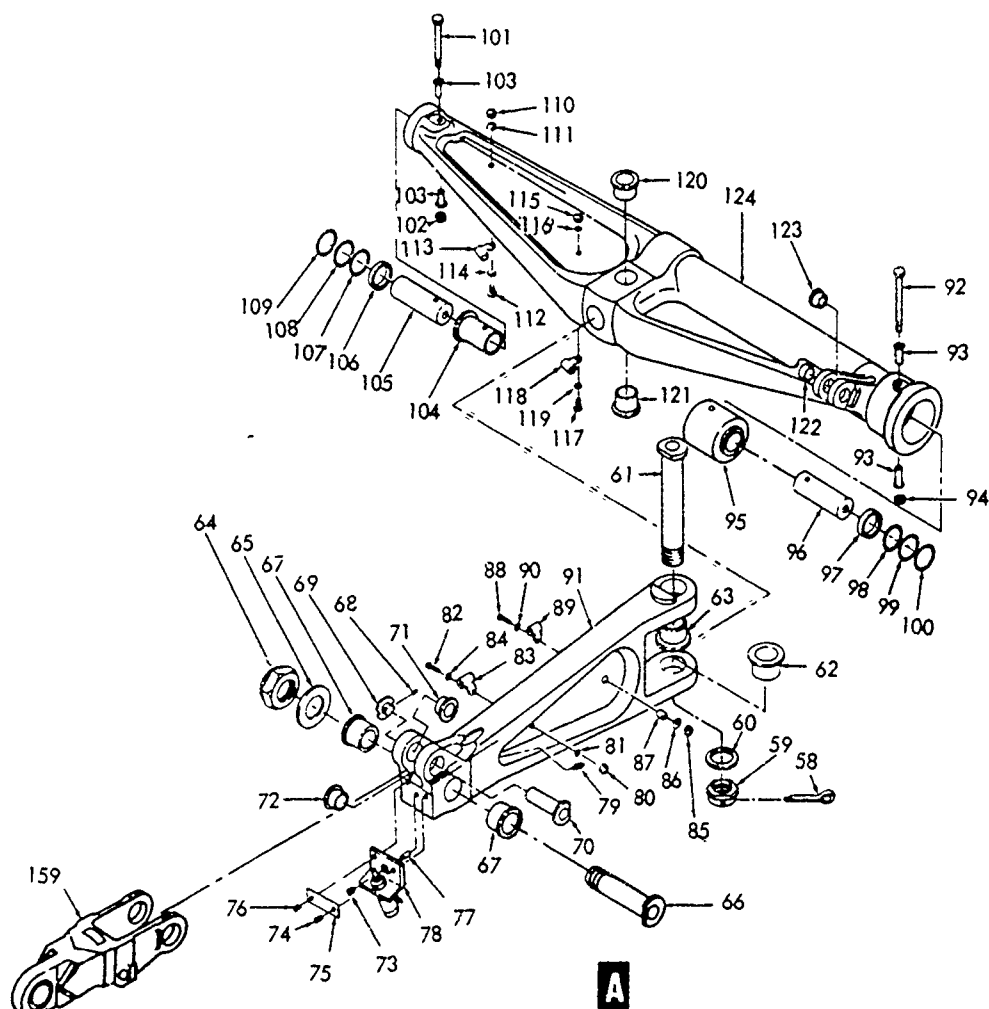


- |                        |                |                              |                 |
|------------------------|----------------|------------------------------|-----------------|
| 1. LUBRICATION FITTING | 18. WASHER     | 31. WASHER                   | 45. SPRING      |
| 2. NUT                 | 19. COTTER PIN | 32. CAM                      | 46. SPRING      |
| 3. LOCKPIN (2 PLACES)  | 20. NUT        | 33. BUSHING                  | 47. NUT         |
| 4. CAM                 | 21. WASHER     | 34. COTTER PIN (2 PLACES)    | 48. WASHER      |
| 5. BOLT                | 22. ROD END    | 35. NUT (2 PLACFS)           | 49. SPACER      |
| 6. WASHER              | 23. WASHER     | 36. WASHER (2 PLACES)        | 50. BOLT        |
| 7. NUT                 | 24. COTTER PIN | 37. BOLT (2 PLACES)          | 51. SPRING LOCK |
| 8. WASHER              | 25. NUT        | 38. LOCKWIRE (2 PLACES)      | 52. NUT         |
| 9. CAM                 | 26. WASHER     | 39. SCREW (2 PLACES)         | 53. WASHER      |
| 10. WASHER             | 27. ROD END    | 40. LOCKING PLATE (2 PLACES) | 54. BOLT        |
| 11. COTTER PIN         | 28. WASHER     | 41. NUT                      | 55. PIN         |
| 12. NUT                | 29. NUT        | 42. WASHER                   | 56. SPRING      |
| 13. WASHER             | 30. WASHER     | 43. BOLT                     | 57. SPACER      |
| 14. ROD ASSEMBLY       |                | 44. PIN                      |                 |
| 15. WASHER             |                |                              |                 |
| 16. HANDLE             |                |                              |                 |
| 17. BUSHING            |                |                              |                 |

452-59-3-FB3-024-1

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 1 of 7)

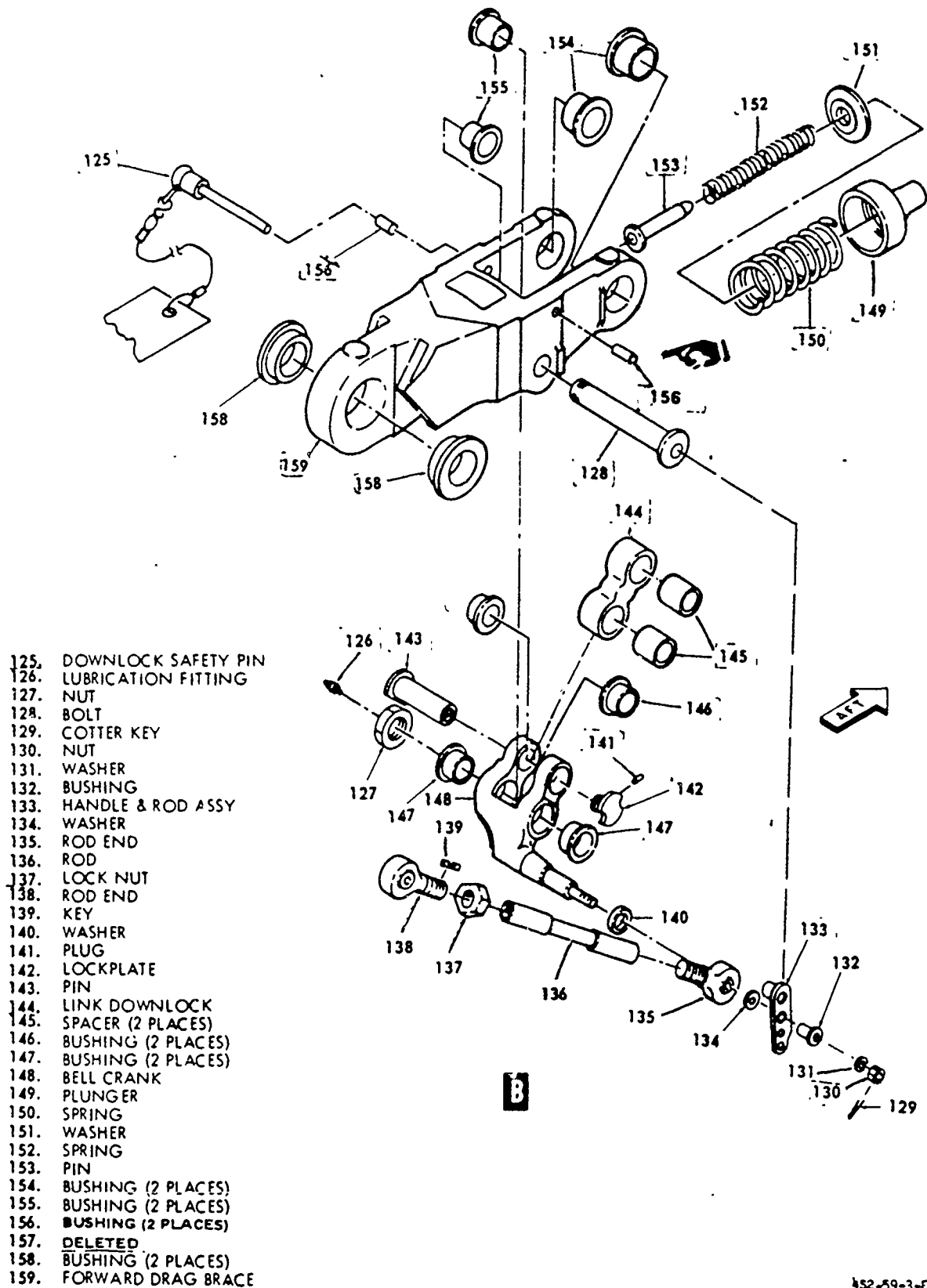




- |                        |                         |              |                         |
|------------------------|-------------------------|--------------|-------------------------|
| 58. COTTER PIN         | 76. SCREW               | 94. NUT      | 110. NUT                |
| 59. NUT                | 77. SPACER              | 95. SPACER   | 111. WASHER             |
| 60. WASHER             | 78. BRACKET             | 96. PIN      | 112. SCREW              |
| 61. BOLT               | 79. LUBRICATION FITTING | 97. SPACER   | 113. CLAMP              |
| 62. BUSHING            | 80. NUT                 | 98. SHIM     | 114. WASHER             |
| 63. BUSHING            | 81. WASHER              | 99. SHIM     | 115. NUT                |
| 64. NUT                | 82. SCREW               | 100. SHIM    | 116. WASHER             |
| 65. WASHER             | 83. CLAMP               | 101. BOLT    | 117. SCREW              |
| 66. BOLT               | 84. WASHER              | 102. NUT     | 118. CLAMP              |
| 67. BUSHING (2 PLACES) | 85. NUT                 | 103. BUSHING | 119. WASHER             |
| 68. PIN                | 86. WASHER              | 104. BUSHING | 120. BUSHING            |
| 69. NUT                | 87. BUSHING             | 105. PIN     | 121. BUSHING            |
| 70. PIN                | 88. SCREW               | 106. SPACER  | 122. BUSHING            |
| 71. BUSHING            | 89. CLAMP               | 107. SHIM    | 123. BUSHING            |
| 72. BUSHING            | 90. WASHER              | 108. SHIM    | 124. DRAG LINK TRUNNION |
| 73. SCREW              | 91. AFT DRAG BRACE      | 109. SHIM    |                         |
| 74. SCREW              | 92. PIN                 |              |                         |
| 75. SHIM               | 93. BUSHING             |              |                         |

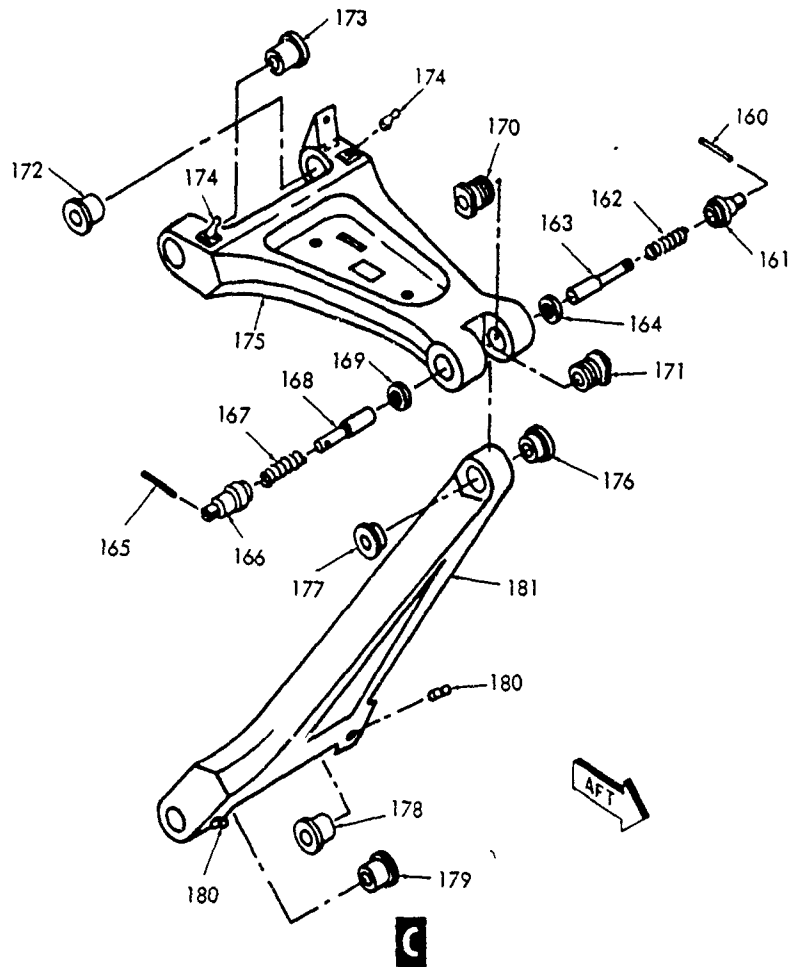
4S2-59-3-FB1-024-2

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 2 of 7)



4S2-59-3-FB3-024-3

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 3 of 7)



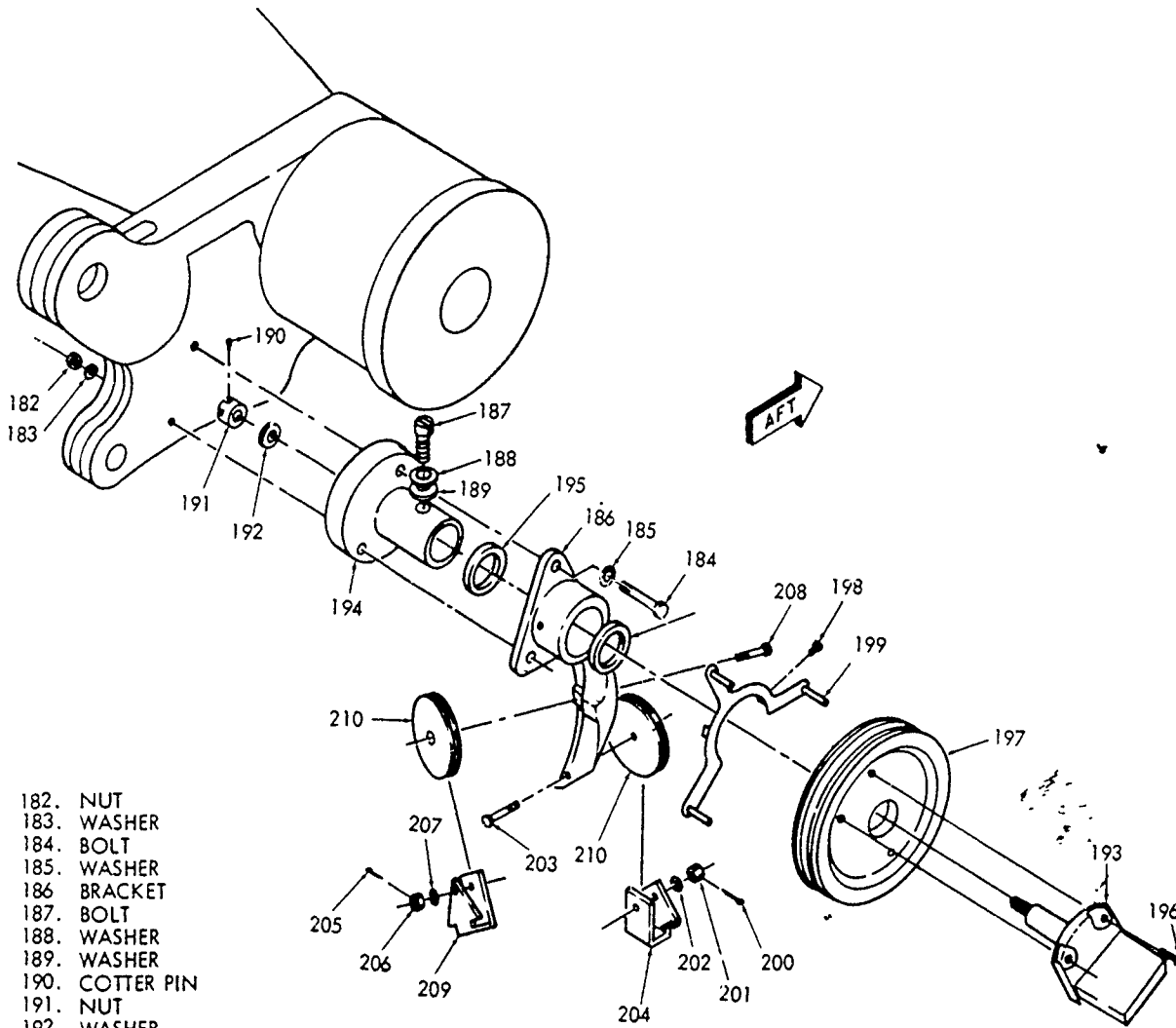
- |              |                          |                          |
|--------------|--------------------------|--------------------------|
| 160. PIN     | 168. PIN                 | 176. BUSHING             |
| 161. HOUSING | 169. WASHER              | 177. BUSHING             |
| 162. SPRING  | 170. NUT                 | 178. BUSHING             |
| 163. PIN     | 171. NUT                 | 179. BUSHING             |
| 164. WASHER  | 172. BUSHING             | 180. LUBRICATION FITTING |
| 165. PIN     | 173. BUSHING             | 181. LOWER TORQUE ARM    |
| 166. HOUSING | 174. LUBRICATION FITTING |                          |
| 167. SPRING  | 175. UPPER TORQUE ARM    |                          |

### NOTES

1. DISASSEMBLY AND OVERHAUL OF THE STEERING ACTUATOR ASSEMBLY IS COVERED IN T.O. 45A2-43-3.
2. THE TRUNNION IS INSTALLED ON THE STRUT WITH A TIGHT INTERFERENCE FIT AND SHOULD NOT BE REMOVED UNLESS DAMAGED TO THE EXTENT THAT REPLACEMENT IS NECESSARY. (SEE PARAGRAPH 2-34)
3. THE AXLE IS INSTALLED WITH A VERY TIGHT INTERFERENCE FIT AND WILL REQUIRE A 100-TON HYDRAULIC PRESS FOR REMOVAL AND INSTALLATION.

452-59-3-FB1-024-4

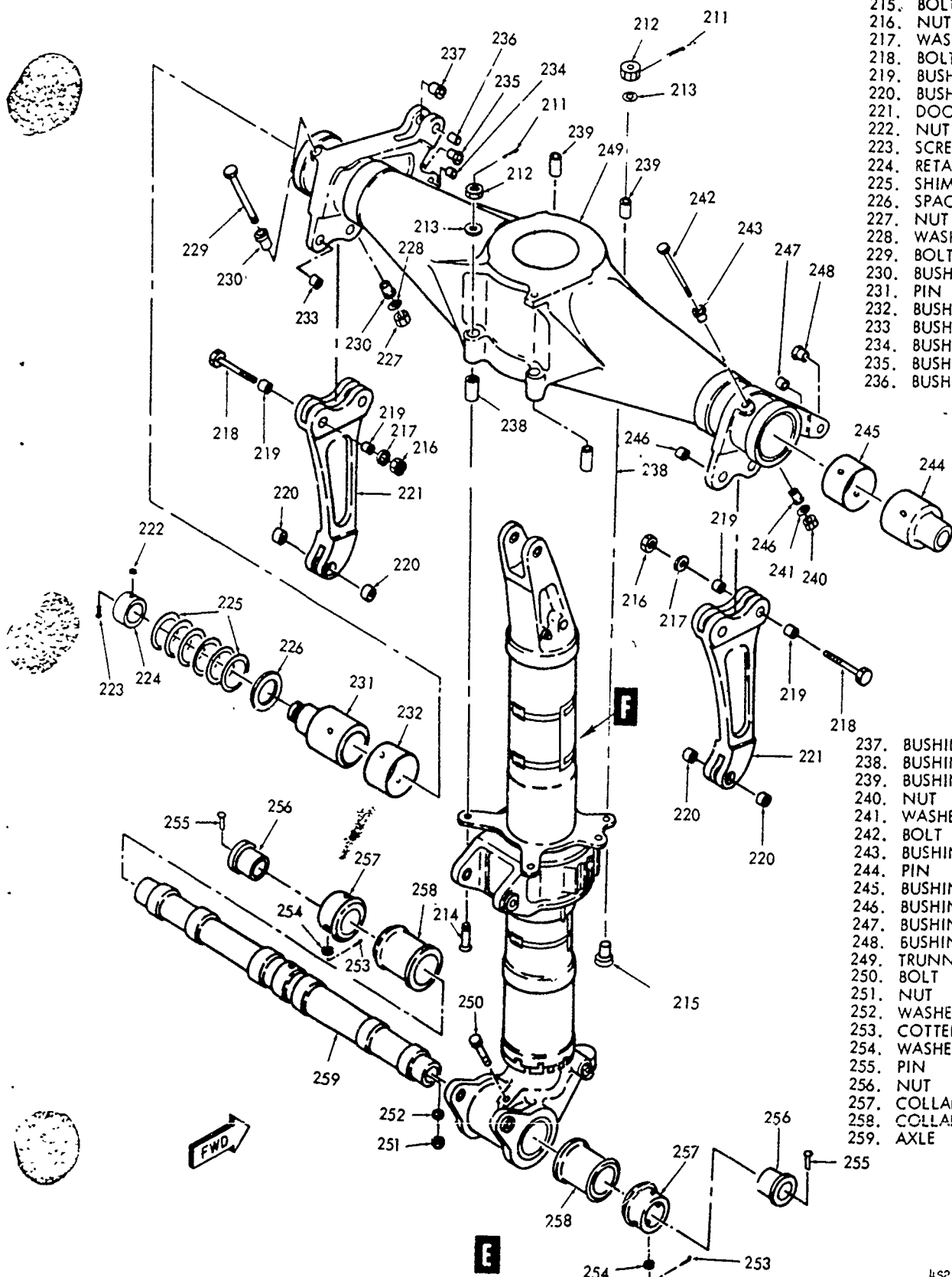
Figure 2-1. Nose Landing Gear - Exploded View (Sheet 4 of 7)



- 182. NUT
- 183. WASHER
- 184. BOLT
- 185. WASHER
- 186. BRACKET
- 187. BOLT
- 188. WASHER
- 189. WASHER
- 190. COTTER PIN
- 191. NUT
- 192. WASHER
- 193. PADDLE
- 194. BRACKET
- 195. BEARING
- 196. BOLT
- 197. PULLY
- 198. BOLT
- 199. BRACKET
- 200. COTTER PIN
- 201. NUT
- 202. WASHER
- 203. BOLT
- 204. GUARD
- 205. COTTER PIN
- 206. NUT
- 207. WASHER
- 208. BOLT
- 209. GUARD
- 210. PULLY

**D**

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 5 of 7)

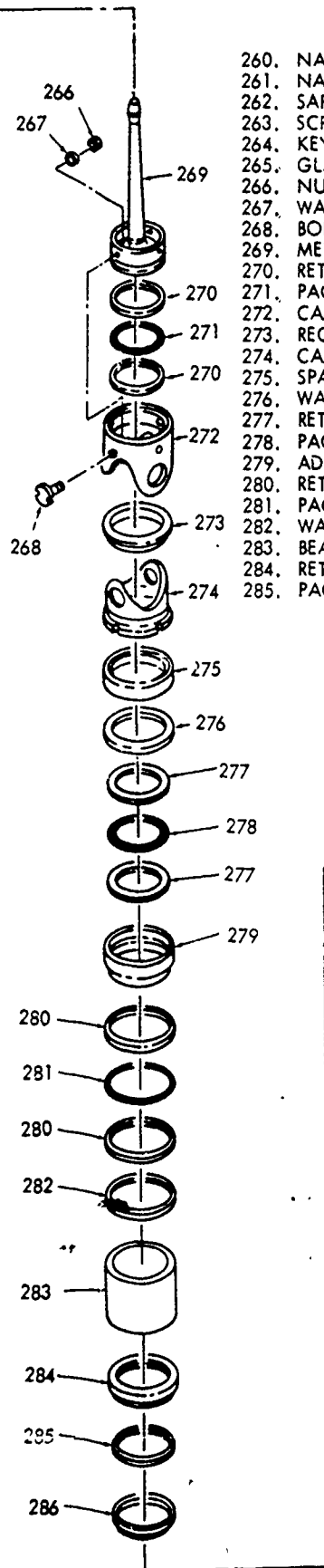
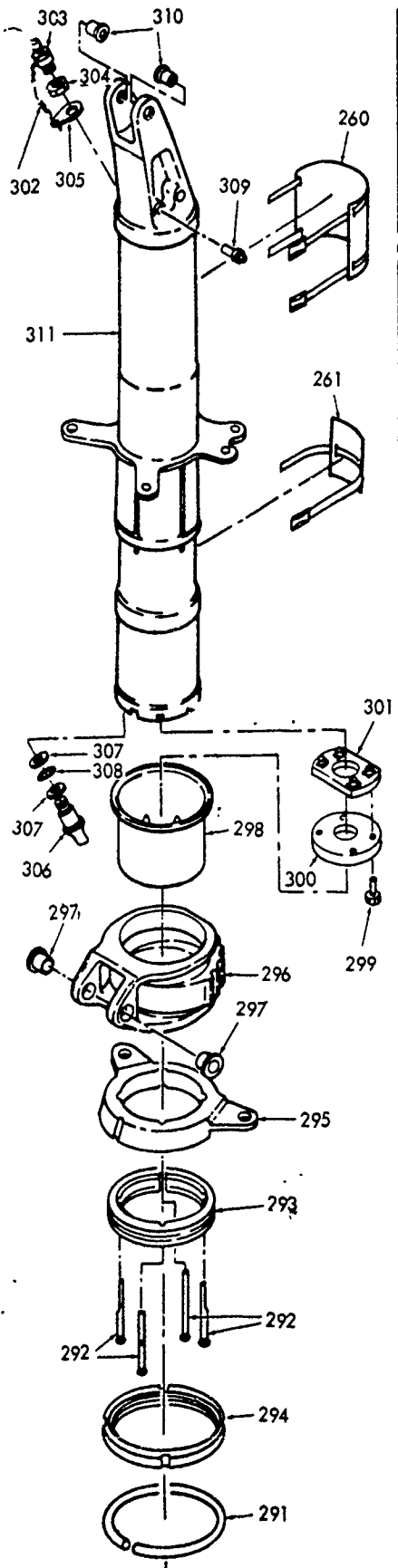


- 211. COTTER PIN (4 PLACES)
- 212. NUT (4 PLACES)
- 213. WASHER (4 PLACES)
- 214. BOLT (2 PLACES)
- 215. BOLT (2 PLACES)
- 216. NUT (2 PLACES)
- 217. WASHER (2 PLACES)
- 218. BOLT (2 PLACES)
- 219. BUSHING (4 PLACES)
- 220. BUSHING (4 PLACES)
- 221. DOOR ARM
- 222. NUT
- 223. SCREW
- 224. RETAINER
- 225. SHIMS
- 226. SPACER
- 227. NUT
- 228. WASHER
- 229. BOLT
- 230. BUSHING
- 231. PIN
- 232. BUSHING
- 233. BUSHING
- 234. BUSHING
- 235. BUSHING
- 236. BUSHING

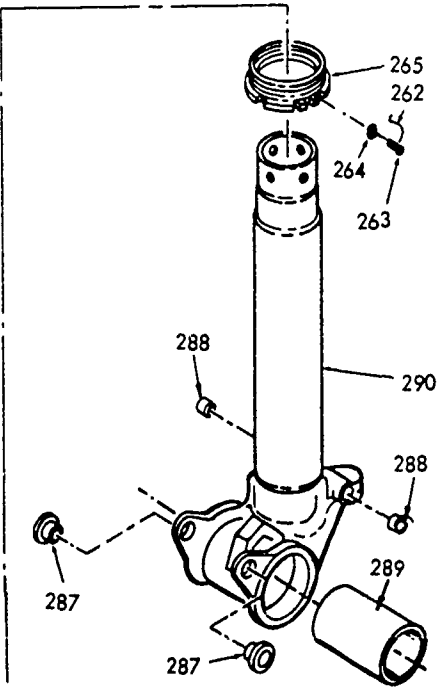
- 237. BUSHING
- 238. BUSHING
- 239. BUSHING
- 240. NUT
- 241. WASHER
- 242. BOLT
- 243. BUSHING
- 244. PIN
- 245. BUSHING
- 246. BUSHING (2 PLACES)
- 247. BUSHING
- 248. BUSHING
- 249. TRUNNION
- 250. BOLT
- 251. NUT
- 252. WASHER
- 253. COTTER KEY
- 254. WASHER
- 255. PIN
- 256. NUT
- 257. COLLAR
- 258. COLLAR
- 259. AXLE

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 6 of 7)

†. 4S2-59-3



- |                             |                      |
|-----------------------------|----------------------|
| 260. NAME PLATE             | 286. SCRAPER         |
| 261. NAME PLATE             | 287. BUSHING         |
| 262. SAFETY WIRE (2 PLACES) | 288. BUSHING         |
| 263. SCREW (2 PLACES)       | 289. BUSHING         |
| 264. KEY (2 PLACES)         | 290. PISTON          |
| 265. GLAND NUT              | 291. RING            |
| 266. NUT (4 PLACES)         | 292. PIN             |
| 267. WASHER (4 PLACES)      | 293. INSERT          |
| 268. BOLT (4 PLACES)        | 294. NUT             |
| 269. METERING PIN           | 295. PLATE           |
| 270. RETAINER               | 296. STEERING COLLAR |
| 271. PACKING                | 297. BUSHING         |
| 272. CAM HEAD               | 298. BUSHING         |
| 273. RECOIL VALVE           | 299. BOLT (4 PLACES) |
| 274. CAM                    | 300. ORIFICE         |
| 275. SPACER                 | 301. PLATE           |
| 276. WASHER                 | 302. SAFETY WIRE     |
| 277. RETAINER               | 303. AIR VALVE       |
| 278. PACKING                | 304. NUT             |
| 279. ADAPTER                | 305. RETAINER        |
| 280. RETAINER               | 306. TUBE            |
| 281. PACKING                | 307. RETAINER        |
| 282. WASHER                 | 308. PACKING         |
| 283. BEARING                | 309. PIN             |
| 284. RETAINER               | 310. BUSHING         |
| 285. PACKING                | 311. CYLINDER        |



4S2-59-3-FB2-024-7

Figure 2-1. Nose Landing Gear - Exploded View (Sheet 7 of 7)

## FAMILY 2

### CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	Q01 FLC DAY
JENS	RIGB	72895A	-J	C-5A MLG	BRAKE STATOR-BERYLLIUM	M 1630-00-464-9160LH	244-292	4B1-2-1063	30
JENS	RIGB	72896A	-G-J	C-5A MLG	BRAKE ROTOR-BERYLLIUM	M 1630-00-464-9162LH	244-293	4B1-2-1063	30
JENS	RIGB	72897A	-J	C-5A MLG	BRAKE END-PLATE-BERYLLIUM	1630-00-464-9165LH	244-294	4B1-2-1063	30
JENS	PRIC	72898A	-G-J	C-5A MLG	WHEEL	1630-00-286-1879	3-1258-2	4W3-4-413	17
JENS	PRIC	72899A	-G-J	C-5A MLG	WHEEL	M 1630-00-188-4084	3-1268-2	4W1-4-493	20
MART	SHEL	73041A	-G	B-52	BOOSTER 50 CAL	1005-00-300-5136	102450-2	11F46-16-3	8
MART	SHEL	73087A	-G	F-4E	CONTROL UNIT	1005-00-938-4572	53-790053-1	11F13-29-5-2	6
COOP	POLL	74506A	-J	C-141 MLG	DRAG BRACE	1620-00-932-2368	3F31001-114	4SA6-19-3	40
COOP	POLL	74516A	-G-J	C-141 MLG	DRAG BRACE	M 1620-00-179-1083	3F31004-123	4SA6-19-3	41
COOP	POLL	74518A		C-141 MLG	DRAG BRACE	1620-00-179-1087	3F31007-121	4SA6-19-3	47
COOP	POLL	74521A	-G	C-141 MLG	STRUT ASSY	M 1620-00-187-7445	366005-141	4S2-59-3	51
COOP	POLL	74524A	-G	C-141 MLG	BOGIE BEAM	M 1620-00-246-0005	3610010-105	4S1-73-3	48
COOP	POLL	74525A		C-141 MLG	ROOT PIN	5315-00-259-2512LE	3611512-107	4S1-73-3	25
COOP	POLL	74527A	-G	C-141 MLG	DRAG BRACE	M 1620-00-442-7877	3610009-113	4S1-73-3	54
COOP	POLL	74528A	-J	C-141 MLG	DRAG BRACE TRUNNION	1620-00-471-9659	3661096-117	4S2-59-3	34
COOP	POLL	74535A	-G-J	C-141 MLG	DRAG BRACE	1620-00-869-9889	3661098-105	4S2-59-3	35
COOP	POLL	74551A	-G-J	C-141 MLG	AFT SUPPORT SHAFT ASSY	1620-00-867-0810	3F31000-111	4SA6-19-3	40
COOP	POLL	74552A	-G-J	C-141 MLG	PIVOT PIN	1620-00-927-0298	3611112-107	4S1-73-3	31
COOP	POLL	74553A	-G-J	C-141 MLG	DRAG BRACE	1620-00-974-6793	3F31001-113	4SA6-19-3	35
DELE		74555A		A-7D MLG	AXLE BEAM ASSY	1620-00-052-3296	01/11/88	4A4-27-3	
TOLM	COOP	74561A	-G	A-7D MLG	STRUT ASSY	1620-00-135-7877	215-24030-31	4S1-71-3	
JENS	PRIC	74565A	-G-J	A-7D MLG	WHEEL	1630-00-075-2003	3-1193	4W3-7-1313	20
JENS	RIGB	74568A	-G-J	A-7D MLG	BRAKE ASSY	1630-410-0858MA	2-1215-2	4B1-2-1083	24
COOP	POLL	74571A	-G-J	C-141 MLG	TORQUE ARM ASSY	1620-00-931-7355	3660008-107	4S2-59-3	50
COOP	POLL	74575A	-J	C-141 MLG	DRAG BRACE ASSY	1620-00-929-9692	3661097-107	4S2-59-3	50
MART	SHEL	74579A		B-52	BOX END	1005-00-898-8672	571542-409	11F8-3-7-3	12
MART	SHEL	74588A		B-52	AMMO CAN	1005-00-623-6435	254771-518	11F8-3-8-2	13
DELE		74626A		C-5A MLG	INNER CYLINDER	1620-00-417-6249	01-11-88	4S1-93-3	
MONR	ANDE	74644A		C-5A MLG	SPLINED TUBE	1620-00-115-7393	4612432-101A	4S1-93-3	60
JENS	ANDE	74652A		C-5A	BALLSCREW	1620-00-148-6466	8155768	1663-2-00-3	45
MONR	ANDE	74653A	-G	C-5A MLG	ROLL PIN	1620-00-319-0461	4611437-107B	4S1-93-3	30
MONR	ANDE	74692A		C-5A MLG	BOGIE BEAM	M 1620-00-179-1425	46110114-101A	4S1-94-3	28
JENS	RIGB	74709A	-J	C-5A MLG	BRAKE HOUSING	1630-00-464-9167	266-36	4B1-2-1063	20
MART	SHEL	74802A		A-7	ENTRANCE UNIT	1005-00-043-1167	175F830	11W1-7-11-3	10
MART	SHEL	74803A			DRUM/FEED & STORAGE	2010-00-043-1175	MAUSA	11W1-7-1-3	11
MART	SHEL	74805A	-G		GUN 20MM M61A1	M 1005-00-056-6753	7791641	11W1-12-4-33	3
MART	SHEL	74806A		XM18	POD SUU-16	1005-00-072-6612	11013605	11W1-31-2-2	35
MART	SHEL	74808A	-G	F-14/A-7	EXIT UNIT	1005-00-105-1083	175F846	11W1-7-103	7
MART	SHEL	74815A		C-130	CONTROL ASSY	1005-00-221-3126	175F857	11W1-34-3-1	6
MART	SHEL	74817A		C-130	FEEDER ASSY	1005-00-221-3325	175F869	11W1-7-9-2	7
MART	SHEL	74818A	-G	A-7D	CONTROL ASSY	1005-00-235-8299	188F683	11W1-7-9-2	6
MART	SHEL	74821A	-G	B-52	BOOSTER ASSY	1005-006-347-2304	2-00003-501	11F46-16-3	8
MART	SHEL	74823A	-G	A-7D	LOADER ASSY	1005-00-419-5074	176F415	11W1-7-1-103	5
MART	SHEL	74828A		F-4	AMMO HANDLING SYSTEM	1005-00-462-6523	175F938	11W1-7-11-3	45
MART	SHEL	74829A		F-4E	DRIVE ASSY	1005-00-848-2746	175F938	11W1-7-11-3	12
MART	SHEL	74831A		A-7	TRANSFER UNIT	1005-00-498-5359	175F632	11W1-7-7-1-103	12
MART	SHEL	74834A	-G	F-4	GUN M61 20MM AIR FORCE	1005-00-528-2620	7268702	11W1-12-3-22	20
MART	SHEL	74835A	-G		GUN A39A	1005-00-566-0045	8410951	11W1-12-3-22	7
MART	SHEL	74836A	-G	B-52	BOOSTER	1005-00-569-9715	2-00003-500	11F46-16-3	7
MART	SHEL	74837A		B-52	BOOSTER	1005-00-573-8197	39002-2	11W1-3-6-3	5

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED
								STAND HOURS
74521A FAMILY 2 C-TAI NLG	MNP GP	00010	N	HS	5	2.57	1.00	6.67
		PP502	E	SS	5	.55	1.00	55
		PP503	E	SS	5	.55	1.00	55
		PP504	E	SS	5	1.09	1.00	1.09
		PP505	E	SS	5	.37	1.00	37
		PP530	N	SS	5	2.26	1.00	2.26
-----								11.49
*								
	MNPGW	P4530	E	DJ	5	1.46	1.00	1.46
		W0001	E	KI	5	1.71	1.00	1.71
		W0001	E	H3	5	5.43	1.00	5.43
		WES01	N	DI	5	.95	1.00	95
		WES02	E	DI	5	.99	1.00	99
		WES03	E	DI	5	1.74	1.00	1.74
		WES04	E	DI	5	.95	1.00	98
		WES05	N	DI	5	.45	1.00	45
		WES10	E	DI	5	.37	1.00	37
		WES11	N	DI	5	.40	1.00	40
		WES12	E	DI	5	.33	1.00	38
		WES20	E	DI	5	.07	1.00	7
		WES24	E	DI	5	.37	1.00	37
		XNPGW	X	H3	5	2.97	1.00	2.97
-----								18.27
*								
	MNPNA	NA501	E	DB	2	1.51	.82	1.23
		NA502	E	DB	2	.97	.67	54
		NA503	E	DB	2	.74	.96	71
		NA504	E	DB	2	.43	1.00	43
		NA505	E	DB	2	.22	1.00	22
		NA510	E	DB	2	.05	.05	
		NA511	E	DB	2	.64	.96	61
		NA512	E	DB	2	.15	.96	15
		XNPNA	X	DB	2	4.92	1.00	4.92
-----								8.91
*								
	MNPRA	RA501	E	JA	1	12.94	.36	11.12
		RA502	E	JA	1	9.70	.89	8.63
		RA503	E	JA	1	2.12	.36	76
		RA504	E	JA	1	26.67	.21	6.02
		RA510	E	JA	1	2.04	.29	59
		RA511	E	JA	1	2.27	.96	2.17
		RA512	E	JA	1	2.79	.96	2.67
		RA520	E	JA	1	.73	1.00	78
		RA524	E	JA	1	.34	1.00	34
-----								33.08
*								
	MNPRS	RS501	E	JA	3	15.78	.75	11.83
		RS502	N	JA	3	3.04	.50	2.52
		RS503	E	JA	3	4.04	.33	1.33



PRGD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
-------------	-----	-------------	------------	----	-----	----------------	------------	----------------------------

74521A	MNPR	R4505	E	JA	3	3.19	.05	15
		R4506	E	JA	3	3.19	.05	15
		R4511	E	JA	3	2.49	.14	1.32
		R4512	E	JA	3	.97	.25	21

17.51

MNPRC	C9999	E	UP	B		.54	1.00	64
	RC501	N	UP	B		3.59	1.00	3.59
	RC502	E	UP	B		3.22	.62	1.99
	RC503	E	UP	B		2.42	.93	2.25
	RC504	E	UP	B		1.14	.05	5
	RC505	N	UP	B		1.77	.38	67
	RC510	E	UP	B		.74	1.00	34
	RC511	N	UP	B		2.05	.90	1.84
	RC512	N	UP	B		1.43	.89	1.27
	XNPRC	X	UP	B		1.24	1.00	1.24

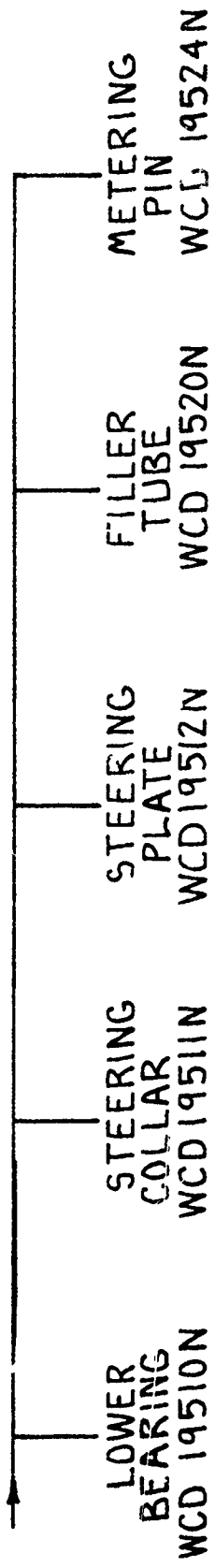
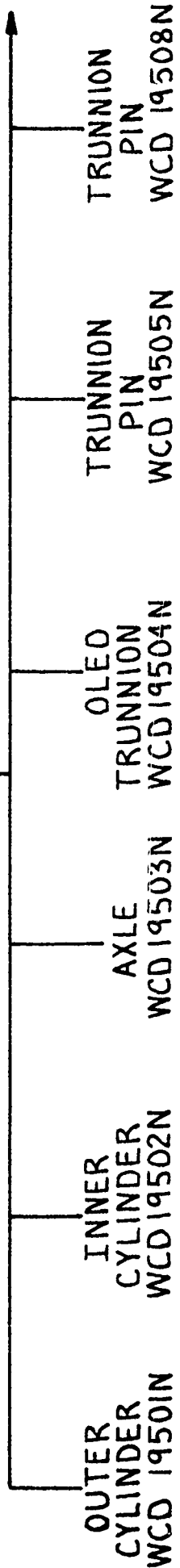
13.88

MNPWW	WF501	N	WF	9		3.44	.25	86
	WF502	N	WF	9		4.31	.21	90
	WF504	N	WF	9		5.51	.07	38
	WF510	N	WF	9		1.55	.21	32
	XNPRW	X	WF	A		.06	1.00	6

2.52

105.66

C-141 NOSE  
LANDING GEAR ASSEMBLY  
PCN 74521A  
WCD 19530N





BLDG 505/507

C-141 M/G

BILL OF MATERIALS

74521A

ROUTED / LOW LEVEL ITEMS CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS	PER OF	YIELD	SCRAP	PART #	MIC	REV	EFFECTIVITY	TECH	ORD	PENDING	PENDING	PENDING	PENDING	
					ASSEMBLY	ASSEMBLY	ASSEMBLY	ASSEMBLY	A, P, C			CONTROL	NUMBER	ACTION	ACTION	ACTION	ACTION	ACTION	
	3120010691003LE	98747		... BUSHING (CYLINDER LUG) (REPAIR)	12	AREA													
	1620000110320	98897		... STEERING PLATE	11	AREA													
	IN. S.L.			... AXLE ASSY	11	AREA													
	162000493226	98897		... BUSHING (CROSS BOLT) (REPAIR)	11	AREA													
	IN. S.L.			... AXLE	11	AREA													
	162000927299	98897		... PISTON ASSEMBLY	11	AREA													
	1620004517081LE	98897		... BUSHING (TOW LUG)	12	AREA													
	1620004533851LE	98897		... BUSHING (TORQUE ARM)	12	AREA													
	1620004510794LE	98897		... BUSHING (AXLE ATTACH) (REPAIR)	11	AREA													
	IN. S.L.			... BUSHING (AXLE ATTACH) (REPAIR)	11	AREA													
	1312001094931LE	98897		... BUSHING (CROSS BOLT) (REPAIR)	11	AREA													
	IN. S.L.			... PISTON SUBASSY	11	AREA													
	1620004164732	98897		... PISTON ASSEMBLY	11	AREA													
	1620004517081LE	98897		... BUSHING (TOW LUG)	12	AREA													
	13120004033851LE	98897		... BUSHING (TORQUE ARM)	12	AREA													
	13120004510794LE	98897		... BUSHING (AXLE ATTACH) (REPAIR)	11	AREA													
	IN. S.L.			... BUSHING (AXLE ATTACH) (REPAIR)	11	AREA													
	1312001094931LE	98897		... BUSHING (CROSS BOLT) (REPAIR)	11	AREA													
	IN. S.L.			... PISTON	11	AREA													
	1620009198299	98897		... PARTS KIT	11	AREA													
	5330009753724	96906		... RETAINER (BACK-UP RING) (KIT)	12	AREA													
	533000793165	96906		... PACKING (O-RING) (KIT)	11	AREA													
	5330008017717	96906		... RETAINER (BACK-UP RING) (KIT)	12	AREA													
	5330011604329	96906		... PACKING (O-RING) (KIT)	11	AREA													
	5330008473862	96906		... PACKING (O-RING) (KIT)	11	AREA													
	5330000711877LE	98897		... RETAINER (BACK-UP RING) (KIT)	12	AREA													
	IN. S.L.			... FELT (WIPER) (KIT)	11	AREA													
	5330006518441	96906		... PACKING (O-RING) (KIT)	11	AREA													
	53300065857723	96906		... PACKING (O-RING) (O.S.)	11	AREA													
	5330007203652	96906		... RETAINER (BACK-UP RING) (KIT)	11	AREA													
	5330006389773	96906		... RETAINER (BACK-UP RING) (O.S.)	11	AREA													
	IN. S.L.			... DECAL (IDENTIFICATION)	11	AREA													
	1620000271196	98897		... PIN (TRUNNION) (RIGHT)	11	AREA													
	5306001431766	80205		... BOLT, SHEAR	11	AREA													
	5310010164871	88044		... WASHER, FLAT	12	AREA													
	1620007375889	98897		... PIN (TRUNNION) (LEFT)	11	AREA													
	IN. S.L.			... BOLT, SHEAR	11	AREA													
	5305000587840	98897		... BOLT (TRUNNION TO OUTER)	12	AREA													
	5305007067561LE	98897		... BOLT (TRUNNION TO OUTER)	12	AREA													
	53310001670839	88044		... WASHER, FLAT	14	AREA													
	53310001768112	88044		... NUT, CASTLE	14	AREA													
	53315008161794	96906		... PIN, COTTER	14	AREA													
	473000504203	96906		... FITTING (GREASE)	11	AREA													
	487000556487	96906		... VALVE (PUSHING)	11	AREA													

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C-141 NEG

BILL OF MATERIALS

74521A

ST-STEEL  
AL-ALUMINUM  
W-WOOD  
TI-TITANIUM  
SS-SS STEEL  
SYN-SYNTHETIC  
LD-LEAD

ITEM	QTY	UNIT	DESCRIPTION	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	ASSEMBLY	PER UNIT	REV	EFFECTIVE DATE	CONTROL NUMBER	PENDING ACTION	PENDING ACTION	PENDING ACTION
1STL	1	EA	RING (RETAINING) (COLLAR)	5365004437406	98897			1						PENDING
1STL	1	EA	INSERT (LOCK-NUT)	5365007438326	98897			1						PENDING
1STL	1	EA	PIN (LOCKING) (COLLAR)	1620007582266	98897			1						PENDING
1STL	1	EA	DECAL (INSTRUCTION)	9905007214862	LOC MFG			1						PENDING
1STL	1	EA	KEY LOCK (GLAND NUT)	1620009228467	98747			1						PENDING
1STL	1	EA	SCREEN, MACHINE	5305005598145	96906			1						PENDING
1STL	1	EA	PLATE (ANCHOR)	1620000071195	99999			1						PENDING
1STL	1	EA	BOLT, SHEAR	5306009296384	80205			1						PENDING
1STL	1	EA	PLATE (DRIFICE)	1620002040453	98897			1						PENDING
1STL	1	EA	BOLT (SHEAR)	5306009474252	80205			1						PENDING
1STL	1	EA	BOLT (SHEAR)	5306009946968	80205			1						PENDING
1STL	1	EA	WASHER (AXLE BOLT)	5310000514269	98897			1						PENDING
1STL	1	EA	NUT (LOCKING)	5310004492381	99999			1						PENDING
1STL	1	EA	NUT (GLAND)	536500007341336	98747			1						PENDING
1STL	1	EA	SCRAPER (RING)	162001217612	72902			1						PENDING
1STL	1	EA	SCRAPER (RING)	1620005168223	96906			1						PENDING
1STL	1	EA	SCRAPER (RING)	N.S.L.				1						PENDING
1STL	1	EA	RETAINER (RING)	53300006922056	98897			1						PENDING
1STL	1	EA	BEARING (LOWER)	1620001257860	13002			1						PENDING
1STL	1	EA	BEARING (LOWER)	1620001257860	98897			1						PENDING
1STL	1	EA	WASHER (RETAINER)	536500071188396	98897			1						PENDING
1STL	1	EA	ADAPTER (PACKING)	533000070289736	98897			1						PENDING
1STL	1	EA	SPACER	536500070236806	98897			1						PENDING
1STL	1	EA	CAM (CENTERING) (LOWER)	1620009086133	98897			1						PENDING
1STL	1	EA	KEY (CAM)	53130000590849	98897			1						PENDING
1STL	1	EA	RIVET (CAM)	5330002334637	96906			1						PENDING
1STL	1	EA	BOLT (PISTON HEAD CAM)	5306103677466	98747			1						PENDING
1STL	1	EA	WASHER (PISTON HEAD CAM)	5310000514270	98897			1						PENDING
1STL	1	EA	NUT (LOCKING)	5310006101786	96906			1						PENDING
1STL	1	EA	PISTON HEAD CAM	N.S.L.				1						PENDING
1STL	1	EA	PISTON HEAD CAM	1620009188532	98897			1						PENDING
1STL	1	EA	VALVE (REC'DIL RING)	1620009086134	98897			1						PENDING
1STL	1	EA	PIN (METERING)	1620006676271	98897			1						PENDING

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1 DATE 89045

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2. JOB ORDER NO. 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNPBP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3660005-141	8. TECH DATA 4S-1-182 452-59-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C-141 NLG	11. STOCK NUMBER 1620001877445	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN: STRUT ASSEMBLY	74521A
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES & HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER & T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O. & SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. "WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	3660005-141			
	010	MATCH-UP NLG STRUT ASSY *****ROUTED COMPONENTS***** NEW REWORKED NO SERVICEABLE 958 REWORK		001 MNPBP 002 06 003 SA03	
		PISTON -19502N OUTER 19501N			
		STR7COLLAR -19511N TRUNNION (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19530N
		B	D	

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STRUT ASSEMBLY
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		19504N AXLE 19503N STR/PLATE			
--	--	---------------------------------------	--	--	--

		19512N TRUN/PIN 19505N LW/BEARING			
--	--	--	--	--	--

		19510N METERING/PIN 19524N FILLER/TUBE			
--	--	---	--	--	--

		19520N TRUN. PIN 19509N			
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	490 *REQU*	PRE-TEST OF FILLER TUBE AREA *C/P MOVE		001 MNP/CP 002 06 003 1L07	
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	501 *REQU*	OK TO CLOSE AND/OR ASSEMBLE *C/P MOVE		001 MNP/CP 002 06 003 SA03	
--	---------------	--	--	----------------------------------	--

	503 *REQU*	REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY IDENTIFY COMPONENT PARTS USED AND RECORD. NOUN   P/N   SERIAL#   NEW/REP		001 MNP/CP 002 06 003 SA03	
--	---------------	--	--	----------------------------------	--

		PISTON 13G61089-1153			
		CYL 13G61090-1173			

		STRG 13G61092-1113			
		GEAR 3 3 3			

		TRUN 33G61094-1093			
		AXLE 13G61032-1033			

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19530N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1988-648-113

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STRUT ASSEMBLY
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15. DISPATCH STATION	16. PERFORM NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		*C/P MOVE			
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	505	REASSEMBLE *****NOTE***** *REQD* INSTALL BUSHING P/N 3G61007-101 WITH SEALANT PER MIL-S-81733, TYPE IS OPTIONAL.		001 MNP GP 002 06 003 SA03	
--	-----	--	--	----------------------------------	--

	506	SLOTS FOR PINS 3G61026-101 WILL BE FILLED WITH SEALANT PRIOR TO INSTALLATION OF PINS.			
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	507	PRIOR TO INSTALLING LOCK RING P/N 3G61028-101 FILL GROOVE WITH SEALANT			
--	-----	--	--	--	--

	508	INSTALL AXLE CHECK ROTATION OF STEERING COLLAR COLLAR SHOULD ROTATE FROM CENTER 60 DEGREES MIN IN BOTH DIRECTIONS.			
--	-----	--	--	--	--

	509	ASSEMBLE AXLE AND BOLT TO PISTON BECAUSE OF LUG REWORK TWO BOLTS ARE AUTHORIZED P/N NAS1110-15 AND NAS 1110-16 SEE PARA. 2-62 D. PAGE 2-93			
--	-----	--	--	--	--

	510	TORQUE ALL NUTS AND BOLTS LAW T.O. *C/P MOVE		001 MNP GP 002 06 003 TL07	
--	-----	---	--	----------------------------------	--

	512	PRESSURE TEST *C/P MOVE			
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	515	MASK - PRIME - PAINT *C/P MOVE		001 MNP GP 002 09 003 WB03	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	19530N	
		B	D		

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-048-183



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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STRUT ASSEMBLY
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	516	TRUNNIONS REWORKED IAW DRWG 8241229 WILL HAVE A BLUE ONE INCH BAND PAINTED ON THE ENTIRE CIRCUMFERENCE 10 INCHES INBOARD FROM THE LEFT END			
		ANOTATE AFTO 95 TO SHOW COMPLIANCE WITH DRWG 8241229 LIMITED LIFE COMPONENT *C/P MOVE			
	518 *REQD*	AFTER COMPLETION OF ALL OTHER PAINTING, PAINT TURN LIMITS I.A.W. 452-59-3 PAGE 2-71. *C/P MOVE		001 MNP GP 002 09 003 WB03	
	520 *REQD*	DECALS *C/P MOVE		001 MNP GP 002 09 003 WB03	
	525 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE		001 MNP GP 002 09 003 WB03	
	530 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19530N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-846-110

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19501N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89045

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2. JOB ORDER NO. 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3G61090-119	8. TECH DATA 45-1-182 452-59-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C141 NOSE	11. STOCK NUMBER 1620004419763	12. OPTIONAL <b>74521A</b>
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		***** UNIT COST: \$15418.07 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 F.M.P.I. IAW MIL-STD-1949 P/D NO1561			
		ALODINE IAW MIL-C-5541 STRIP CHROME IAW MIL-STD-871 TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 & P/D N61891			
		FPI IAW MIL-STD-6866			
		GRIND IAW MIL-STD-866 CAD PLATE IAW MIL-STD-870 GRIT BLAST IAW MIL-STD-1504 FLAME SPRAY IAW MIL-STD-869			
		BAKE IAW MIL-1-182 MAOI 74-12 VAC IVD ALUM PLATE IAW MIL-C-83488A ***300 M STEEL 280,00/300,000 PSI**			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19501N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-540-110

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## WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3661090-119							
		DISASSEMBLE *C/P MOVE						001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745235	
	*REQD*								
		CHEM CLEAN *C/P MOVE						001 MNP GW 002 03 003 SL01	
	*REQD*								
		BLAST CLEAN *C/P MOVE						001 MNP GW 002 03 003 BL01	
	*REQD*								
		BAKE 4 HRS AT 350-400F *C/P MOVE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____						001 MNP GW 002 03 003 BK03	
	*REQD*								
		*C/P MOVE				M		001 MNP NA 002 05 003 ML04	
	*REQD*								
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19501N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-646-103

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNR/GW		
		LOWER BORE I.D. 5.750/5.752					002 04		
		WEAR 5.753					003 EIO1		
		UPPER BORE I.D. 5.358/5.360							
		WEAR 5.361							
		UPPER CHAMBER I.D. 5.350/5.360							
		WEAR 5.370							
		DRAG ATTACH LUG ID 1.4375/1.4386							
		DRAG ATTACH LUG BUSHING I.D.							
		1.2465/1.2475 WEAR 1.2540							
		TRUNNION JOURNAL OD 6.134/6.136							
		COLLAR JOURNAL OD 6.2477/6.248							
		WEAR 6.2455							
		FILLER PLUG HOLE ID .938/.939							
		ACTUATOR LUG HOLE ID 1.060/1.061							
		WEAR 1.064							
		TORQUE LUG HOLES (4 EA) .626/.627							
		WEAR .631							
		STEERING LUG (2) EA .812/.813							
		WEAR .815							
		LINK PIN OD .305/.310							
		LINK PIN HOLE ID .469/.470							
		*C/P MOVE							
		***** N D T E *****							
		* A MINIMUM OF 2 FMPI OPERATIONS *							
		* MUST BE ACCOMPLISHED *							
		*****							
26	055	VAPOR DEGREASE				*C/P MOVE		001 MNR/RC	
								002 03	
								003 DG01	
26	060	STRIP CAD				*C/P MOVE		001 MNR/RC	
								002 02	
								003 CS01	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE		A	C		19501N			
			B	D					

U.S. GOVERNMENT PRINTING OFFICE: 1968-448-12

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	065	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26 ✓	071	BLAST TO REMOVE METAL SPRAY FROM TRUNNION JOURNAL O.D. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26B ✓	072	BAKE 4 HRS AT 350 TO 400F  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNPRC 002 06 003 ML04	
26 ✓	076	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26 ✓	078	STRIP CHROME FROM TRUNNION JOURNALS THIS IS THE AREA ON THE UPPER SIDE OF FLANGE *C/P MOVE		001 MNPRC 002 02 003 SC02	
26 ✓	080	STRIP CHROME FROM COLLAR JOURNAL THIS IS THE AREA ON THE LOWER SIDE OF THE FLANGE. CAUTION: MAKE SURE THAT THE FILLER PLUG HOLE IS MASKED. DO NOT STRIP CHROME FROM FILLER HOLE PLUG *C/P MOVE		001 MNPRC 002 02 003 SC02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19501N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1985-68-18

19501N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
8	150	FIRST GRIND UPPER BORE FOR CHROME. GRIND TO CLEANUP MAX. ID 5.373 MAINTAIN .005 CONCENTRICITY WITH LOWER BORE RADIUS .160/.220 AT BOTTOM OF BORE FIG. 2-10. 32 RMS *C/P MOVE					001 MNP RB 002 01 003 GI01 005 X8745231		
8	160	FIRST GRIND LOWER BORE FOR CHROME. GRIND TO CLEANUP MAX. ID 5.765 .005 CONCENTRICITY WITH UPPER BORE RADIUS .770/.830 AT BOTTOM OF BORE FIGURE 2-10 32 RMS COMPLETED MAX THICKNESS OF CHROME .0075 *C/P MOVE					001 MNP RB 002 01 003 GI01 005 X8745231		
69	165	REMOVE LINK PIN *C/P MOVE					001 MNP RA 002 04 003 BE01		
69	170	EXTERNAL DEFECT REPAIR .010 DEEP BLEND TO PARENT METAL WITH 1 INCH RADIUS .020 DEEP IN THREADS MUST HAVE FOUR PERFECT THREADS OF EVERY 4 1/2 CONSECUTIVE THREADS FIG 2-10. *C/P MOVE					001 MNP RA 002 04 003 BE01		
69	180	POLISH O.D. AREA OF CYLINDER IAW PARA 2-34 T.O. 4S2-59-3 *C/P MOVE					001 MNP RA 002 04 003 BE01		
69	190	ATTACH LOG OVERSIZE REPAIR CLEANUP HOLES DO NOT EXCEED MIN. LOG WALL THICKNESS IN GRAPH FIG 2-10 (CONTINUED)					001 MNP RA 002 04 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		19501N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1969-04-10

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
25 ✓	090	STRIP CHROME UPPER BORE +C/P MOVE		001 MNPRC 002 O2 003 SC02	
26 ✓	100	STRIP CHROME LOWER BORE +C/P MOVE		001 MNPRC 002 O2 003 SC02	
BG ✓	110	FIRST GRIND TRUNNION JOURNAL (FOR CHROME) GRIND TO CLEANUP, DO NOT EXCEED OD 6.121. MAINTAIN EXISTING RADIUS & CONCENTRICITY FIG 2-10 32 RMS *C/P MOVE		001 MNPRB 002 O3 003 GG01 005 X8745198	
BG ✓	120	GRIND TRUNNION JOURNAL FOR FLAME SPRAY GRIND TO CLEANUP TO 6.090 MIN O.D. .190 TO .210 RADIUS AND BLEND SMOOTH TO GRIND SURFACE L.A.W FIG. 2-10 & FIG 2-13 32 RMS +C/P MOVE		001 MNPRB 002 O3 003 GG01 005 X8745198	
BG ✓	130	FIRST GRIND COLLAR JOURNAL FOR CHROME GRIND TO CLEANUP, DO NOT EXCEED MIN DIAMETER OF O.D. 6.233 MAINTAIN EXISTING RADIUS AND CONCENTRICITIES FIGURE 2-10. 32 RMS +C/P MOVE		001 MNPRB 002 O3 003 GG01 005 X8745198	
BG ✓	140	FIRST GRIND COLLAR JOURNAL FOR FLAME SPRAY GRIND TO CLEANUP WITHIN O.D 6.217 INCREASE .120 RADIUS TO .135 AND BLEND SMOOTH TRANSITION TO GROUND SURFACE PARA 2-46 32 RMS DEFECT REMOVAL OF PITTING TO MAX OF 6.187 BY LOCAL POLISHING ONLY (CONTINUED)		001 MNPRB 002 O3 003 GG01 005 X8745198	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19501N
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		125 RMS *C/P MOVE			
69 ✓	195	ACTUATOR LUG O/S REPAIR. CLEANUP LUG MIN ID 1.120 DONT EXCEED WALL THICKNESS IAW FIG 2-10 GRAPH 125 RMS *C/P MOVE		001 MNPRA 002 04 003 MH02	
69 ✓	200	TORQUE LUG (4 EA) OVERSIZE REPAIR MACHINE HOLES WITHIN ID .687/.707 DO NOT EXCEED MIN LUG WALL IN GRAPH FIG 2-10 125RMS *C/P MOVE		001 MNPRA 002 04 003 DR01 005 X8633681	
69 ✓	205	FILLER TUBE HOLE. MACHINE IAW 4S2-59-3 STAMP WITH LETTER "F" AND NUMBER OF REWORK. 1-2-3-4-5 125 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	210	STEERING LUG (2 EA) OVERSIZE REPAIR MACHINE HOLES DO NOT EXCEED MIN LUG GRAPH WALL FIG 2-10 125RMS *C/P MOVE		001 MNPRA 002 04 003 DR01 005 X8633681	
69 ✓	215	LINK PIN HOLE OVERSIZE REPAIR CLEANUP HOLE. DO NOT EXCEED MIN WALL THICKNESS OF .100 FIG 2-10 DETAIL (D) 125 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	220	STEERING FLANGE RADIUS REPAIR MACHINE TO REMOVE CORROSION IAW FIG 2-10 & 2-13 (THIS IS FOR TRUNNION SIDE ONLY) 125 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	225	REMOVE PITTING ON STEERING FLANGE FACE BY THE TORQUE LUGS AND STEERING LUGS IAW GRAPH ON PAGE 2-49 FIG 2-10 125 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	228	MACHINE VERTICAL SLOTS FOR KEYWAYS TO CLEAN UP CORROSION NOT TO EXCEED 6.010 MAINTAIN 0.1385 RADIUS		001 MNPRA 002 04 003 MH02 005 X8633681	
		***NOTE REMOVE ONLY MIN AMOUNT OF MATERIAL REQUIRED TO REMOVE CORROSION *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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69 ✓	230	RELOCATE & MACH NEW KEY SLOTS IAW FIG 2-10 & 2-11 IF DAMAGED WORN OR CORRODED BEYOND LIMITS IF GROUND FOR CHROME *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8633681	
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69 ✓	235	REMOVE CORROSION IN RING GROOVE IAW T.O. *C/P MOVE		001 MNPRA 002 04 003 LE12	
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		[REDACTED]	M	001 MNPRA 002 06 003 TE03	
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		TIME OUT _____ DATE OUT _____ ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE			
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26B ✓	290	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH DATE: _____ TIME IN: _____		001 MNPRA 002 02 003 AK01	
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		DATE: _____ TIME OUT: _____ *C/P MOVE			
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		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNPRA 002 06 003 ML04	
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26 ✓	305	VAPOR DEGREASE *C/P MOVE		001 MNPRA 002 03 003 DG01	
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26 ✓	310	SHOT PEEN ALL SURFACES THAT HAS BEEN NICK AND BURRED INTENSITY OF .008/.012 A2 EXCEPT THREADS AND LUG (CONTINUED)		001 MNPRA 002 01 003 SP02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	19501N	
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		HOLES *C/P MOVE							
26 23 ✓	315	SHOT PEEN FILLER PLUG HOLE INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 24 ✓	320	SHOTPEEN TRUNNION JOURNAL INTENSITY OF .008/.012 A2 SHOT PEEN RADIUS ALSO *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 25 ✓	330	SHOT PEEN FLANGE RADIUS BOTH SIDES INTENSITY OF .008/.012 A2 100 PERCENT SATURATION. THIS IS MANDATORY DURING OVERHAUL. STAMP LETTER "S" 1AW 452-59-3 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 26 ✓	335	SHOT PEEN STEERING FLANGE AREA THAT HAS BEEN REWORKED. INSTNSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 27 ✓	340	SHOT PEEN COLLAR JOURNAL JAW MIL-S-13165 INTENSITY OF .008/.012 A2. SHOT PEEN RADIUS ALSO *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 28 ✓	350	SHOT PEEN UPPER BORE INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 29 ✓	360	SHOT PEEN LOWER BORE INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 30 ✓	370	SHOT PEEN UPPER CHAMBER AREA INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
21. FINAL DESTINATION		22. COORDINATION//INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19501N			
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	373	PREPARE TRUNNION JOURNAL O.D. FOR CHROME PLATE. FIXTURE/MASK/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED		001 MNPRC 002 02 003 BE01 005 X7929105	
26 ✓	377	PREPARE TRUNNION JOURNAL FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 ✓	380	CHROME PLATE TRUNNION JOURNAL SUFFICIENT TO GRIND O.D. BACK TO 6.134/6.136 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE		001 MNPRC 002 02 003 CP01 005 X7929105 008 C0010	
26 ✓	383	PREPARE COLLAR JOURNAL OD FOR CHROME PLATE, FIXTURE/MASK/ETC. *C/P MOVE		001 MNPRC 002 02 003 BE01 005 X7929105	
26 ✓	387	PREPARE COLLAR JOURNAL FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 ✓	390	CHROME PLATE COLLAR JOURNAL SUFFICIENT TO GRIND O.D. BACK TO 6.247/6.248 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE		001 MNPRC 002 02 003 CP01 005 X7929105 008 C0020	
26B ✓	395	BAKE 4HRS AT 3 400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	397	PREPARE UPPER BORE ID FOR CHROME PLATE. FIXTURE/MASK/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X7432858		
26 ✓	398	PREPARE UPPER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	400	CHROME PLATE UPPER BORE SUFFICIENT TO GRIND I.D. BACK TO 5.358/5.360 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7432858 008 CI010		
26 ✓	403	PREPARE LOWER BORE ID FOR CHROME PLATE. FIXTURE/MASK/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X7432858		
26 ✓	407	PREPARE LOWER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	410	CHROME PLATE LOWER BORE SUFFICIENT TO GRIND I.D. BACK TO 5.750/5.752 TYPE II CLASS III DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7432858 008 CI020		
26B ✓	420	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME DATE: _____ TIME IN: _____ DATE: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19501N				
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	13. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		[REDACTED] *C/P MOVE		001 MNP WW 002 08 003 DG02	
		[REDACTED] JOURNAL TO BE SPRAYED PRIOR TO FLAME SPRAY *C/P MOVE		001 MNP WW 002 08 003 BL01	
		[REDACTED] TRUNNION JOURNAL .004/.007 BOND COAT METCO 405. SPRAY WITH METCOLOY #2 TO ALLOW GRINDING BACK TO DIA OF 6.134/6.136 *C/P MOVE		001 MNP WW 002 08 003 FS03	
		[REDACTED] COLLAR JOURNAL .004/.007 BOND COAT METCO 405. SPRAY WITH METCOLOY #2 TO ALLOW GRINDING BACK TO DIA OF 6.247/6.248		001 MNP WW 002 08 003 FS03	
		***NOTE: DO NOT FILL LOCK RING GROOVES OR KEY SLOT WITH FLAME SPRAY. *C/P MOVE			
BG ✓	470	FINISH GRIND TRUNNION JOURNAL AFTER FLAME SPRAY. GRIND TO OD 6.134/6.136 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNP RB 002 03 003 GG01 005 X8745198	
BG ✓	480	FINISH GRIND COLLAR JOURNAL AFTER FLAME SPRAY. GRIND TO OD 6.247/6.248 REMOVE FLAME SPRAY FROM GROOVE 32RMS REIDENTIFY AFTER FLAME SPRAY IAW T/D PARA 2-46 SUBPARAGRAPH R RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CUASE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNP RB 002 03 003 GG01 005 X8745198	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19501N
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
BG	490	FINISH GRIND TRUNNION JOURNAL AFTER CHROME PLATE FINISH DIA OD 8.1347 6.136. BLEND EXISTING RADIUS AND CORNERS. CHROME RUN OUT MAX IS 3/8 INCH FROM START OF RADIUS. 32RMS *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X8745198	

BG	500	FINISH GRIND COLLAR JOURNAL AFTER CHROME PLATE FINISH DIA OD 6.247/6.248. BLEND EXISTING RADIUS AND CORNERS. CHROME RUN OUT MAX IS 3/8 INCH FROM START OF RADIUS. 32RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X8745198	
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B	520	FINISH GRIND UPPER BORE. FINISH DIA ID 5.358/5.360 BLEND EXISTING RADIUS & CORNERS FIG 2-10 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8745231	
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B	530	FINISH GRIND LOWER BORE. FINISH DIA ID 5.750/5.752. BLEND EXISTING RADIUS AND CORNERS FIG 2-10 32RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8745231	
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26B	540	BAKE 4HRS AT 350-400F DATE IN _____ TIME IN _____ (CONTINUED)		001 MNPRC 002 02 003 BK01	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
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DISPATCH	FUNCTIONAL CODE	A	C	19501N
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 ML04	
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26	555	VAPOR DEGREASE *C/P MOVE		001 MNPFC 002 03 003 DC01	
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		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 ZS01	
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69	565	RELOCATE & MACH NEW KEYWAYS IAW FIG 2-10 & 2-11 *C/P MOVE		001 MNPRA 002 04 003 MH02 004 X8433681	
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		NEW KEYSLOTS *C/P MOVE	M	001 MNPFC 002 02 003 BP01	
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26	568	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPFC 002 01 003 BL02	
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26	570	CAD PLATE CLASS II TYPE II 5.1 SQ FT AT 255-357 AMPS TIME OUT _____ DATE OUT _____ (CONTINUED)		001 MNPFC 002 03 003 CA02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		***NOTE: STEERING COLLAR GROOVES SHOULD BE PLATED. *C/P MOVE							
26B ✓	580	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF PLATING  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC 002 02 003 BK01	
26 ✓	585	IRIDITE *C/P MOVE						001 MNPRC 002 02 003 IR01	
26 ✓	590	BLAST TO REMOVE CORROSION IN THE UPPER CHAMBER I.D. *C/P MOVE						001 MNPRC 002 01 003 BL02	
	65	*C/P MOVE ***** NOTE ***** M IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						001 MNPRC 002 06 003 ML04	
26 ✓	603	VAC IVD ALUM PLATE CLASS 2 TYPE 11 NOTE: OPERATION 580 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION.						001 MNPRC 002 03 003 IVD1	
26 ✓	607	ALDINE IVD ALUM PLATE CLASS 1A *C/P MOVE						001 MNPRC 002 03 003 TA01	
69 ✓	609	MACHINE DRAG ATTACH LOG BUSHING PRESS FIT .0025/.005 FINISH ID SIZE 1.2465/1.2475 FACE TO FACE 1.501/ (CONTINUED)						001 MNPRC 002 04 003 LE00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		1.505 125 RMS *C/P MOVE			
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69 ✓	610	DRAG ATTACH LUG BUSHING INSTALLATION P/N 3G61005-101 TO 3G61603-115 USE MIL-S-81733, FINISH I.D. 1.2465/ 1.2475 125 RMS		001 MNPRA 002 04 003 BE01	
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		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
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		*C/P MOVE P/N 3G61005-101 P/N 3G61603-115			
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69 ✓	615	MACHINE ACTUATOR LUG BUSHING .001/ .002 PRESS FIT. ID FINISH SIZE 1.060/1.061 125 RMS *C/P MOVE		001 MNPRA 002 04 003 LE00	
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69 ✓	620	ACTUATOR LUG BUSHING INSTALLATION P/N 66C33001-71ST USE MIL-S-81733 BUSHING SHOULD NOT PROTRUDE FROM HOLE. FINISH I.D. 1.060/1.061 IAW		001 MNPRA 002 04 003 BE01	
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		FIG 2-10 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING			
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		REWORK LIMITS *C/P MOVE P/N 66C33001-71ST			
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69 ✓	625	MACHINE TORQUE LUG BUSHINGS .001/ .0015 PRESS FIT FINISH ID SIZE .626/.627 125 RMS *C/P MOVE		001 MNPRA 002 04 003 LE00	
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69 ✓	630	TORQUE LUG 4 EA BUSHING INSTALLATION P/N 66C33001-8197 USE MIL-S-81733 RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)		001 MNPRA 002 04 003 BE01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	19501N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1980-446-103

19501N WORK CONTROL DOCUMENT (MEDS)

DATE 89025

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			

		P/N 66C33001-81ST			
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69 ✓	635	TORQUE LUG FINISH I.D. .626/.627 125 RMS *C/P MOVE		001 MNPRA 002 04 003 DR01 005 X833694	
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69 ✓	640	MACHINE OR MFG 7530983-01 O/S TUBE IAW 452-59-3 OR STD 3G61089-101 *C/P MOVE P/N 7530983-01		001 MNPRA 002 04 003 LE00	
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69 ✓	645	O/S TUBE INSTALLATION *C/P MOVE		001 MNPRA 002 04 003 BE01	
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69 ✓	648	MACHINE STEERING LUG BUSHING .001/ .0015 PRESS FIT FINISH SIZE ID .812/.813. NOTE: KEEP DIM TO TOP TOLERANCE OF .813 IF POSSIBLE 125 RMS *C/P MOVE		001 MNPRA 002 04 003 LE00	
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69 ✓	650	STEERING LUG BUSHING INSTALLATION EA. P/N 66C33001-79ST USE MIL-S- 81733 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 04 003 BE01	
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		P/N 66C33001-79ST			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	19501N	
		B	D		

\* U.S. GOVERNMENT PRINTING OFFICE: 1968-648-102

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69 ✓	655	FINISH ID .812/.813 125 RMS KEEP DIM TO TOP TOLER. IF POSSIBLE *C/P MOVE		001 MNRRA 002 04 003 DR01 005 X8633694	
69 ✓	660	MACHINE LINK PIN P/N 3G61163-101 MACHINE TO OBTAIN .0003/.0010 PRESS FIT. IAW FIG. 2-10- MAX FLANGE WIDTH OF .040. USE MIL-S-81733 IAW FIG 2-10 125 RMS *C/P MOVE P/N 3G61163-101		001 MNRRA 002 04 003 LE00	
69 ✓	665	LINK PIN INSTALLATION *C/P MOVE		001 MNRRA 002 03 003 BE01	
	745	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE		001 MNRGP 002 06 003 MU01	
	750	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNRGP 002 06 003 MU01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19501N
		B	D	

\* U.S. GOVERNMENT PRINTING OFFICE: 1989-048-128

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19502N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 01 PAGES

2. JOB ORDER NO. 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3G61089-111	8. TECH DATA 4S-1-182 4S2-59-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C141 NOSE	11. STOCK NUMBER 1620004983226	12. OPTIONAL <b>74521A</b>
13. SERIAL NUMBER	14. NOUN INNER CYLINDER	

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		***** UNIT COST: \$2129.00 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 F.M.P.I. IAW MIL-STD-1949			
		P/O NO1561 ALOOINE IAW MIL-C-5541 STPIP CHROME IAW MIL-STD-871 TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 FPI IAW MIL-STD-6866 CAD PLATE IAW MIL-STD-870			
		VACUUM CAD IAW MIL-C-8837 BRUSH PLATE IAW MIL-STD-865 4S-1-182 FLAME SPRAY IAW MIL-STD-869			
		GRIND IAW MIL-STD-866 BAKE IAW 4S-1-182 MAOI 74-12 VAC IVD ALUM PLATE IAW MIL-C-83488A			
		***4340 STEEL 260,000/280,000 PSI** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19502N
		B	D	

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\* U.S. GOVERNMENT PRINTING OFFICE: 1980-06-163

19502N WORK CONTROL DOCUMENT (MEDS)

DATE 05/04/80

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	3651089-111			
		DISASSEMBLE *C/P MOVE		001 MNP GW	
	*REQD*			002 02	
				003 LG 02	
				005 X8745233	
				006 X8745235	
		CHEM CLEAN *C/P MOVE		001 MNP GW	
	*REQD*			002 03	
				003 SL 01	
		BLAST CLEAN *C/P MOVE		001 MNP GW	
	*REQD*			002 03	
				003 BL 01	
		BAKE 4 HRS AT 350-400F		001 MNP GW	
	*REQD*	DATE IN _____ TIME IN _____		002 03	
		DATE OUT _____ TIME OUT _____		003 BK 03	
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19502N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1978-548-110

19502N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
	*REQD*	*C/P MOVE					M	001 MNRNA	
	*REQD*	E AND I INSPECTION INNER CYLINDER O.D. 4.995/4.997 WEAR 4.994						002 05	
		INNER CYLINDER UPPER END O.D. 4.559/4.563						003 ML04	
		AXLE ATTACH LUG I.D. 3.999/4.000							
		AXLE CROSS BOLT HOLE I.D. .625/.628 WEAR .634							
		NOTE: IF AXLE LUG IS NOT FLAME SPRAYED O/S CROSS BOLT HOLE ON OPERATION 080. IF AXLE LUG IS FLAME SPRAYED O/S CROSS BOLT HOLE ON OPERATION 355.							
		TORQUE ARM ATTACH LUG 1.6875/1.6886 AXLE LUG WEB AREA MINIMUM WALL .030 PISTON SEAL AREA I.D. IF I.D. SEAL AREA DOES NOT EXCEED 4.258 AND CORROSION IS LESS THAN .002 DEEP GLASS BLAST AND ROUTE TO SHOT PEEN.							
		TORQUE ARM ATTACH LUG BUSHING I.D. 1.4973/1.5001 WEAR 1.5006							
		TOW LUG 0.750/0.755 *C/P MOVE ***** NOTE ***** * A MINIMUM OF 2 FMPI OPERATIONS * * MUST BE ACCOMPLISHED * *****							
	035	VAPOR DEGREASE *C/P MOVE						001 MNRRC	
								002 03	
								003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1989-648-103

19502N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN INNER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	037	STRIP CAL *C/P MOVE		001 MNPFC 002 02 003 CS01	
26 ✓	040	STRIP RUST *C/P MOVE		001 MNPFC 002 02 003 CS02	
69 ✓	045	NICK & BURR LOCAL REWORK LIMITS TO 5% OF INVOLVED AREA IAW T.O. *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	050	TORQUE ARM ATTACH LUG OVERSIZE REPAIR STANDARD HOLE SIZE I.D. 1.6875/1.6886. OVERSIZE TO CLEANUP 125 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	060	AXLE ATTACH LUG REPAIR (FLAME SPRAY) MACHINE I.D. 4.030/4.080. HOLE MAY BE RELOCATED .050 OFF CENTER TO MAINTAIN LUG WALL THICKNESS. (MIN .690) (WEB AREA MIN .030) 125 RMS *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8833691	
69 ✓	070	AXLE ATTACH LUG REPAIR (BUSHING) MACHINE FOR MIN BUSHING WALL OF .040 NOT TO EXCEED LUG WALL OF .690 MIN AND WEB AREA MIN .030. RELOCATE .050 IF NECESSARY 125 RMS *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8833691	
69 ✓	080	CROSS BOLT HOLE OVERSIZE (BUSHING REPAIR) MACHINE OVERSIZE TO CLEANUP I.D. .686/.707 125 RMS NOTE: THIS OPERATION WILL ONLY BE DONE IF AXLE LUG IS NOT GOING TO BE FLAME SPRAYED. IF AXLE LUG IS TO BE REWORKED THE CROSS BOLT LUG O/S (CONTINUED)		001 MNPRA 002 04 003 MV03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19502N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1988-540-125

19502N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WILL BE DONE ON OPERATION 355. *C/P MOVE							
69 ✓	090	TOW LUG OVERSIZE REPAIR REAM OVERSIZE TO CLEANUP IAW T.O. 125 RMS *C/P MOVE						001 MNFRA 002 04 003 BE01	
26 ✓	095	VAPOR DEGREASE *C/P MOVE						001 MNFRC 002 03 003 DG01	
26 ✓	100	STRIP CHROME PISTON O.D. *C/P MOVE						001 MNFRC 002 02 003 SC02	
26 ✓	104	STRIP CHROME PISTON UPPER END O.D. *C/P MOVE						001 MNFRC 002 02 003 SC02	
26 ✓	108	STRIP CHROME METERING PIN I.D. SEAL AREA. *C/P MOVE						001 MNFRC 002 02 003 SC02	
8 ✓	110	FIRST GRIND PISTON O.D. FOR CHROME MINIMUM O.D. 4.980 32 RMS *C/P MOVE						001 MNFRB 002 03 003 GF06	
8 J	120	FIRST GRIND PISTON UPPER END O.D. FOR CHROME MINIMUM O.D. 4.547 32 RMS *C/P MOVE						001 MNFRB 002 03 003 GE06	
8 ✓	125	POLISH METERING PIN I.D. SEAL AREA NOT TO EXCEED 4.258 - IF CORROSION IS LESS THAN .002 DEEP SEND TO GLASS BLAST AND SHOT PEEN - IF CORROSION EXCEEDS .002 - ROOT TO OPER. #130 *C/P MOVE						001 MNFRB 002 01 003 BE01	
31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE				33. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1988-548-128



2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN INNER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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B	130	FIRST GRIND METERING PIN I.D. SEAL AREA GRIND TO CLEAR MAX I.D. 4.267 32 RMS *C/P MOVE		001 MNP RB 002 01 003 G101 005 X8745255	
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		DATE OUT: _____ ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNP NA 002 06 003 TE03	
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		DATE: _____ TIME IN: _____ DATE: _____ TIME OUT: _____ *C/P MOVE			
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26B	150	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH		001 MNP RC 002 02 003 BK01	
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		DATE: _____ TIME IN: _____ DATE: _____ TIME OUT: _____ *C/P MOVE			
--	--	--	--	--	--

		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNP NA 002 06 003 ML04	
--	--	---	---	----------------------------------	--

		DATE: _____ TIME IN: _____ DATE: _____ TIME OUT: _____ *C/P MOVE			
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26	163	VAPOR DEGREASE *C/P MOVE		001 MNP RC 002 03 003 DG01	
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26	165	GLASS BLAST PISTON SEAL AREA I.D. *C/P MOVE		001 MNP RC 002 01 003 BL03	
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26	170	SHOT PEEN O.D. INTENSITY OF .010/.012 A2 *C/P MOVE		001 MNP RC 002 01 003 SP02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	19502N	

		B	D		
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U.S. GOVERNMENT PRINTING OFFICE: 1989-548-183

19502N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN INNER CYLINDER							
15. DISPATCH STATION	16. PERFORMANCE RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"	
26	180	SHOT PEEN PISTON UPPER END O.D. INTENSITY OF .010/.012 A2 *C/P MOVE						001 MNPRC	002 01	003 SP02
26	190	SHOT PEEN METERING PIN I.D. SEAL AREA INTENSITY OF .010/.012 A2 *C/P MOVE						001 MNPRC	002 01	003 SP02
26	200	SHOT PEEN AXLE ATTACH LUG INSIDE INTENSITY OF .010/.012 A2 *C/P MOVE						001 MNPRC	002 01	003 SP02
26	215	SHOT PEEN ALL SURFACES THAT HAVE BEEN NICK AND BURRED .010/.012 A2 *C/P MOVE						001 MNPRC	002 01	003 SP02
26	218	PREPARE FOR CHROME PLATE OF PISTON (LONG AREA O.D.) MASK/FIXTURE/ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED						001 MNPRC	002 02	003 BE01
26	220	CHROME PLATE PISTON (LONG AREA O.D.) TO ALLOW GRINDING BACK TO O.D. 4.995/4.997 CLASS III TYPE II. TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC	002 02	003 CP01 008 CC010
26B	225	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC	002 02	003 BK01
26	228	PREPARE FOR CHROME PLATE OF PISTON (UPPER SHORT AREA O.D.) MASK/FIXTURE ETC. *C/P MOVE (CONTINUED)						001 MNPRC	002 02	003 BE01

\* U.S. GOVERNMENT PRINTING OFFICE: 1989-548-123

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	19502N	
		B	D		

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19502N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
11. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MECHANIC SIGN OFF REQUIRED							
26	230	CHROME PLATE PISTON (UPPER SHORT AREA O.D.) TO ALLOW GRINDING BACK TO O.D. 4.562/4.563 CLASS III TYPE II TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 008 CD020		
		MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B	235	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	238	PREPARE FOR CHROME PLATE OF METERING PIN I.D. SEAL AREA, MASK/FIXTURE/ ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X8343061		
26	240	CHROME PLATE METERING PIN I.D. SEAL AREA TYPE II CLASS III TO GRIND BACK TO 4.258/4.252 TIME OUT _____ DATE OUT _____					001 MNPRC 002 02 003 CP01 005 X8343061		
		MECHANIC SIGN OFF REQUIRED *C/P MOVE					008 CI010		
26B	250	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN				
DISPATCH	FUNCTIONAL CODE	A	C		19502N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1968-548-113

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "C"	
B ✓	260	FINISH GRIND INNER CYLINDER (LONG AREA O.D.) GRIND TO O.D. 4.995/4.997 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 03 003 GE06		
B ✓	270	FINISH GRIND INNER CYLINDER (UPPER SHORT AREA). GRIND TO O.D. 4.562/4.563 32 RMS *C/P MOVE					001 MNPRB 002 03 003 GE06		
B ✓	280	FINISH GRIND METERING PIN I.D. SEAL AREA GRIND TO I.D. 4.258/4.252 4S2-59-3 PAGE 2-90 32 RMS *C/P MOVE					001 MNPRB 002 01 003 G101 005 X8745255		
26B ✓	290	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE				M	001 MNPRB 002 06 003 ML04		
26 ✓	305	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED (CONTINUED)				M	001 MNPRB 002 06 003 ZS01		
31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE				33. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		19502N				
		B	D						

U.S. GOVERNMENT WITNESS OFFICE: 1985-448-110

19502N WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		HERE, TAKE PRODUCTION COUNT *C/P MOVE							
		AXLE ATTACH LUG AREA I.D. *C/P MOVE						001 MNPWW 002 08 003 DG02	
		AXLE ATTACH LUG AREA INSIDE 45 TO 55 PSI PRESSURE *C/P MOVE						001 MNPWW 002 08 003 BL01	
		AXLE ATTACH LUG INSIDE .004/.007 BOND COAT. SPRAY WITH METCOLOY #2 SUFFICIENT TO ALLOW MACHINING TO 3.999/4.000 APPLY AF SEALER 50-50 WITH APT THINNER *C/P MOVE						001 MNPWW 002 08 003 FS11	
69	350	AXLE ATTACH LUG FLAME SPRAY. MACHINE TO I.D. 3.990/3.992 BREAK SHARP EDGES. CHAMFER .060/.090 X 45 125 RMS *C/P MOVE						001 MNPRA 002 04 003 MH02 005 X8632691	
69	355	CROSS BOLT HOLE OVERSIZE (BUSHING REPAIR) MACHINE OVERSIZE TO CLEANUP I.D. .686/.707 125 RMS *C/P MOVE						001 MNPRA 002 04 003 MV03	
8	358	HONE AXLE ATTACH LUG FOR FINAL SPRAY ONLY. 3.999/4.000 64 RMS POROSITY ACCEPTABLE. *C/P MOVE						001 MNP RB 002 01 003 HV02 005 X8120573	
26	360	VAPOR DEGREASE *C/P MOVE						001 MNP RC 002 03 003 DG01	
26	363	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE						001 MNP RC 002 01 003 BL02	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	B	C	D	19502N.			

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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
26 ✓	365	CAO PLATE INNER CYL TYPE II CLASS I 2.4 SQ FT AT 120-168 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNP RC 002 03 003 CA01	
26B ✓	370	BAKE 23 HRS AT 350F TO 400F WITHIN HRS OF PLATING  DATE IN: _____ TIME: _____  DATE OUT: _____ TIME: _____ *C/P MOVE		001 MNP RC 002 02 003 BK01	
26 ✓	375	IRIDITE *C/P MOVE		001 MNP RC 002 02 003 IR01	
	.65	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE	M	001 MNP NA 002 06 003 ML04	
26 ✓	383	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 370 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MNP RC 002 03 003 IV01	
26 ✓	397	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNP RC 002 03 003 TA01	
69 ✓	389	MACHINE BURNING ARM ATTACHMENT BUSHING .0005/.0025 PRESS FIT. FINISH SIZE I.D. 1.4973/1.5001 (CONTINUED)		001 MNP RA 002 04 003 LE00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		125 RMS OVER-ALL FACE TO FACE 5.995/5.998 *C/P MOVE							
69 ✓	390	TORQUE ARM ATTACH LUG BUSHING INSTALLATION 3G61603-111 USE SEALANT MIL-S-81733 FINISH I.D. 1.4973/1.5001 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-111						001 MNFRA 002 04 003 BE01	
69 ✓	395	MACHINE TOW LUG BUSHING, PRESS FIT .0005/.0025 FINISH SIZE I.D. .750/ .755 125 RMS *C/P MOVE						001 MNFRA 002 04 003 LE00	
69 ✓	400	TOW LUG BUSHING INSTALLATION 3G61603-219 USE MIL-S- 81733 FINISH BUSHING I.D. .750/.755 125 RMS *C/P MOVE P/N 3G61603-219						001 MNFRA 002 04 003 BE01	
69 ✓	405	MACHINE AXLE ATTACH LUG BUSHING, PRESS FIT .002/.004 FINISH I.D. SIZE 3.992/3.995 CHAMFER BOTH ENDS. 125 RMS *C/P MOVE						001 MNFRA 002 04 003 LE00	
69 ✓	410	AXLE ATTACH LUG BUSHING INSTALLATION P/N 3G61603-201 USE SEALANT MIL-S- 81733, DRILL CROSS BOLT HOLE USING EXISTING HOLE IN AREAS WHERE BUSHING IS NOT BACKED BY BASE METAL, IT MAY BE UP TO .003 UNDERSIZE. 125 RMS *C/P MOVE						001 MNFRA 002 04 003 BE01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		P/N 3661603-201							
69 ✓	412	AXLE ATTACH LUG FINISH I.D. 3.992/ 3.993 125 RMS *C/P MOVE						001 MNPRA 002 04 003 MH02 005 X8633691	
69 ✓	415	COUNTER BORE AXLE ATTACH LUG HOLE 125 RMS *C/P MOVE						001 MNPRA 002 04 003 MV02	
69 ✓	418	MACHINE AXLE CROSS BOLT HOLE BUSHING, PRESS FIT .001/.003 I.D. FINISH SIZE .625/.628 125 RMS *C/P MOVE						001 MNPRA 002 04 003 LE00	
69 ✓	420	AXLE CROSS BOLT HOLE BUSHING INSTALLATION MANUFACTURE 4130/4330M STEEL HT 180,000/200,000 PSI. OR BUSH P/N 3661603-227 USE MIL-S-81733, FINISH BUSHING I.D. .625/.628 125 RMS. INSTALL BUSHING FLUSH TO .005 INCH BELOW SURFACE. RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE						001 MNPRA 002 04 003 BE01	
		P/N 3661603-227							
B ✓	430	HONE AXLE ATTACH LUG; HONE TO 3.999/ 4.000 64 RMS POROSITY ACCEPTABLE MAINTAIN 32 RMS *C/P MOVE						001 MNPRA 002 01 003 HV02 005 X8120573	
26 ✓	432	VAPOR DEGREASE *C/P MOVE						001 MNPRA 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19502N			
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN INNER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26BP ✓	435	BRUSH CAD PLATE I.D. OF AXLE ATTACH BUSHING IAW MIL-C-8837 TYPE II CLASS III OR MIL-STD-865 *C/P MOVE		001 MNP RC 002 02 003 BP01	
26 ✓	438	IRIDIUM *C/P MOVE		001 MNP RC 002 02 003 IR01	
26BP ✓	440	BRUSH NICKEL PLATE TORQUE ARM BUSHINGS. APPLY NICKEL TO FACE OF BUSHINGS. MAINTAIN FACE TO FACE OF 5.995/5.999. *C/P MOVE		001 MNP RC 002 02 003 BP01	
	447	PRE-PAINT *C/P MOVE		001 MNP GP 002 09 003 PP01	
	450	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD* *C/P MOVE		001 MNP GP 002 06 003 MU01	
	460	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE		001 MNP GP 002 06 003 MU01	

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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2. JOB ORDER NO. 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3G61032-107	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C141 NOSE	11. STOCK NUMBER 1620009272599	12. OPTIONAL AF IRWG 3G61032 AND SUPPLEMENTS 4S-1-182/4S2-59-3
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13. SERIAL NUMBER	14. NOUN AXLE	<b>74521A</b>
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 F.M.P.I. IAW MIL-STD-1949 P/O N01561			
--	--	--	--	--	--

		BAKE IAW 4S-1-182 MAOI 74-12 FPI IAW MIL-STD-6866 TEMPER ETCH IAW MIL-STD-867			
--	--	--	--	--	--

		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-150 CAD PLATE IAW MIL-STD-870 STRIP CHROME IAW MIL-STD-871			
--	--	--	--	--	--

		ALODINE IAW MIL-C-5541 VAC IVD ALUM PLATE IAW MIL-C-83488A *****UNIT COST \$2047.51***** 4340 STEEL 260,000/280,000 PSI			
--	--	--	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC-			
--	--	--	--	--	--

		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
--	--	--	--	--	--

		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING			
--	--	--	--	--	--

		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
--	--	---	--	--	--

		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
--	--	--	--	--	--

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN AXLE
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15. DISPATCH STATION	16. PERF FCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	3661032-107			
		DISASSEMBLE *C/P MOVE		001 MNP GW	
	*REQD*			002 02	
				003 LG02	
				005 X8745233	
				006 X8745235	
		CHECM CLEAN *C/P MOVE		001 MNP GW	
	*REQD*			002 03	
				003 SL01	
		BLAST CLEAN *C/P MOVE		001 MNP GW	
	*REQD*			002 03	
				003 BL01	
		BAKE 4 HRS AT 350-400F		001 MNP GW	
	*REQD*	DATE IN _____ TIME IN _____		002 03	
				003 BK03	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
				001 MNP NA	
	*REQD*		M	002 05	
				003 ML04	
		E AND I INSPECTION		001 MNP GW	
	*REQD*	AXLE CENTER JOURNALS (3 EA) O.D.		002 04	
		(CONTINUED)		003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19503N
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		4.001/4.002 AXLE JOURNALS LARGE (2 EA) O.D. 3.8113/3.8123							
		AXLE JOURNALS SMALL (2 EA) O.D. 3.7488/3.7498							
		CROSS BOLT HOLE I.D. 0.625/0.626 WEAR 0.627 CHECK THREADS ON I.D. *C/P MOVE							
		* * * * * N O T E * * * * * * A MINIMUM OF 2 FMPI OPERATIONS * * MUST BE ACCOMPLISHED * * * * * *							
26	035	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26	040	STRIP CAD *C/P MOVE						001 MNPRC 002 02 003 CS01	
26	045	STRIP RUST *C/P MOVE						001 MNPRC 002 02 003 CS02	
69	050	NICK AND BURR USE A 1 INCH BLEND RADIUS TO PARENT METAL IAW PARA 2-34 DO NOT EXCEED WALL THICKNESS IAW FIG. 2-22. *C/P MOVE						001 MNPRA 002 04 003 BE01	
69	060	RECENTER AXLE IF NECESSARY *C/P MOVE						001 MNPRA 002 04 003 LE08	
69	061	REGRIND THREADS IAW BLUE PRINT 3881032 *C/P MOVE						001 MNPRA 002 04 003 LE08	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19503N				
		B	D						

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN AXLE
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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69 ✓	070	CROSS BOLT HOLE OVERSIZE REPAIR FOR BUSHING MACHINE OVERSIZE TO CLEANUP WITHIN 0.745/0.802 125RMS *C/P MOVE		001 MNFRA 002 04 003 MV03	
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26 ✓	080	STRIP CHROME FROM CENTER JOURNALS (3 EA) *C/P MOVE		001 MNPRC 002 02 003 SC02	
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26 ✓	090	STRIP CHROME FROM LARGE JOURNALS (2 EA) *C/P MOVE		001 MNPRC 002 02 003 SC02	
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26 ✓	100	STRIP CHROME FROM SMALL JOURNALS (2 EA) *C/P MOVE		001 MNPRC 002 02 003 SC02	
------	-----	---	--	---------------------------------	--

8 ✓	110	FIRST GRIND AXLE CENTER JOURNALS (3 EA) GRIND TO CLEANUP NOT TO EXCEED MIN OD 3.986 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GE07	
-----	-----	--	--	---------------------------------	--

8 ✓	120	FIRST GRIND LARGE JOURNALS (2 EA) GRIND TO CLEANUP NOT TO EXCEED MIN OD 3.7963 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GE07	
-----	-----	---	--	---------------------------------	--

8 ✓	130	FIRST GRIND SMALL JOURNALS (2 EA) GRIND TO CLEANUP NOT TO EXCEED MIN OD 3.7338 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GE07	
-----	-----	---	--	---------------------------------	--

8 ✓	140	POLISH O.D. AREAS BETWEEN JOURNALS FOR CORROSION REMOVAL. REFER TO FIG 2-22 FOR LIMITATIONS MAINTAIN GIVEN RADIUS AND BREAK CORNERS		001 MNPRB 002 03 003 GE07	
-----	-----	---	--	---------------------------------	--

		.030/.060 R *C/P MOVE			
--	--	-----------------------	--	--	--

		TIME OUT _____ DATE OUT _____ (CONTINUED)	M	001 MNFRA 002 06 003 TE03	
--	--	--	---	---------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	19503N	
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B ✓	160	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH  DATE: _____ TIME IN: _____						001 MNP RC 002 02 003 BK01	
		DATE: _____ TIME OUT: _____ *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNP NA 002 06 003 ML04	
26 ✓	175	VAPOR DEGREASE *C/P MOVE						001 MNP RC 002 03 003 DG01	
26 WV	180	SHOTPEEN CENTER JOURNALS (3 EA) 0.008/0.012 A2 100% SATURATION *C/P MOVE						001 MNP RC 002 01 003 SP02	
26 WV	190	SHOTPEEN LARGE JOURNALS (2 EA) 0.008/0.012 A2 100% SATURATION *C/P MOVE						001 MNP RC 002 01 003 SP02	
26 WV	200	SHOTPEEN SMALL JOURNALS (2 EA) 0.008/0.012 A2 100% SATURATION *C/P MOVE						001 MNP RC 002 01 003 SP02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
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7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	210	SHOTPEEN OUTER REWORKED AREAS BETWEEN JOURNALS 0.008/0.012 A2 100% SATURATION *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	212	SHOTPEEN CROSS BOLT HOLES .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	215	PREPARE FOR CHROME PLATE MASK/FIXTURE/ETC  MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 BE01		
26 ✓	220	CHROME PLATE CENTER JOURNALS 3EA TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 4.001/4.002 TIME OUT DATE OUT  *MECHANIC SIGNOFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CD010		
26 ✓	230	CHROME PLATE LARGE JOURNALS 2EA TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 3.8113/3.8123 TIME OUT DATE OUT  *MECHANIC SIGNOFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CD020		
26 ✓	240	CHROME PLATE SMALL JOURNALS 2EA TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 3.7488/3.7498 TIME OUT DATE OUT  *MECHANIC SIGNOFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 CD010		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19503N				
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26B	250	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME  DATE: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE: _____ TIME OUT: _____ *C/P MOVE							
B	260	FINISH GRIND CENTER JOURNALS (3 EA) GRIND JOURNALS TO O.D. 4.001/4.002 32 RMS *C/P MOVE					001 MNPRH 002 03 003 GE07		
B	270	FINISH GRIND LARGE JOURNALS (2 EA) GRIND JOURNALS TO O.D. 3.8113/3.8123 32 RMS *C/P MOVE					001 MNPRH 002 03 003 GE07		
B	280	FINISH GRIND SMALL JOURNALS (2 EA) GRIND JOURNALS TO O.D. 3.7488/3.7498 32 RMS *C/P MOVE					001 MNPRH 002 03 003 GE07		
26B	290	BAKE 4 HRS AT 350-400F  DATE: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE: _____ TIME OUT: _____ *C/P MOVE							
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNPRH 002 06 003 ML04		
26	305	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 IG01		
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE		A	C		19503N			
			B	D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-04-12



19503N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		[REDACTED] MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNP NA 002 06 003 ZS01		
26	315	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNP RC 002 01 003 PL02		
26	320	CAD PLATE AXLE TYPE II CLASS II 1.1 SQ FT AT 55-77 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNP RC 002 03 003 CA01		
26B	330	BAKE 23 HRS AT 350 TO 400F WITHIN 4 HRS OF PLATING DATE: _____ TIME IN: _____					001 MNP RC 002 02 003 BK01		
		DATE: _____ TIME OUT: _____ *C/P MOVE							
26	335	IRIDITE *C/P MOVE					001 MNP RC 002 02 003 IR01		
		[REDACTED] MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNP NA 002 06 003 ML04		
26	343	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 330 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)					001 MNP RC 002 03 003 IV01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19503N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1989-548-113

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19503N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN AXLE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		IS DONE, BEFORE USING IVD OPTION. *C/P MOVE							
26	347	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE						001 MNP RC 002 03 003 TA01	
69	349	MACHINE CROSS BOLT HOLE BUSHING .0005/.002 PRESS FIT						001 MNP RA 002 04 003 LE00	
69	350	CROSS BOLT HOLE BUSHING INSTALLATION P/N 3661603-277 USE MIL-S-81733 IAW FIG 2-22 DETAIL C & B. FINISH I.D. 0.32570.326 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3661603-277						001 MNP RA 002 04 003 BE01	
	357	PRE-PAINT ALL SURFACES NOT CHROMED IAW DRWG 3661032 *C/P MOVE						001 MNP GP 002 09 003 PP01	
	360	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 358 *REQD* *C/P MOVE						001 MNP GP 002 06 003 MU01	
	370	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE						001 MNP GP 002 06 003 MU01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19503N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1988-546-103

19504N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 48-1-182 482-59-3 & DRWG 8241229	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES C141 NOSE	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OLEO TRUNNION	79521A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
8340783-10	1620001947597	79521A			
8340783-30	N.S.L.	79521A			
	AAA		H		
	001	8340783-01 8340783-30			
	*REQD*	DISSASSEMBLY/REMOVE BUSHINGS *C/P MOVE		001 MNP GW 002 O2 003 LG02 005 X8745233 006 X8745235	
	*REQD*	CHEM CLEAN *C/P MOVE		001 MNP GW 002 O3 003 AC02	
	*REQD*	BLAST CLEAN *C/P MOVE		001 MNP GW 002 O3 003 BL01	
	*REQD*	STRIP ANODIZE *C/P MOVE		001 MNP GW 002 O3 003 AN03	
	*REQD*	*C/P MOVE	M	001 MNP NA 002 O5 003 ZY05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19504N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1985-508-110

19504N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OLED TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IAW 452-59-3 PARA 4-3 TO DETERMINE PART NUMBER. N O T E: OLD TRUNNIONS WERE MADE FROM 7079 T6 ALUMINUM NEW TRUNNIONS WERE MADE OF 7049 T73 ALUMINUM OLD TRUNNIONS WILL BE USED UNTIL NEW OLED TRUNNIONS ARE AVAILABLE. *C/P MOVE					001 MNP NA 002 05 003 EC04		
	*REQD*	E AND J INSPECTION					001 MNP GW 002 04 003 EI01		
		CENTER CYLINDER ATTACH HOLE ID 6.1365/6.138							
		END TRUNNION SOCKET BUSHING I.D. 3.8130/3.815							
		END TRUNNION SOCKET HOLES ID 3.9985/4.000							
		CROSS BOLT HOLE (SMALL) ID .500/.501							
		CROSS BOLT HOLE (LARGE) BUSHING I.D. .625/.628 WEAR .6293							
		CROSS BOLT HOLE (LG) ID .8125/.8135							
		MOUNTING FLANGE HOLES ID .750/.751							
		MOUNTING FLANGE BUSHING I.D. .625/.6272 WEAR .628							
		AFT DOOR LEVER LUG HOLES ID .750/.751							
		AFT DOOR LEVER BUSHING ID .625/.627 WEAR .628							
		FWD DOOR LEVER LUG HOLES ID .625/.626							
		FWD DOOR LEVER BUSHING ID .500/.502 (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1969-0-348-183

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLED TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WEAR .5038 ACTUATOR LUG HOLE ID 1.000/1.001 ACTUATOR LUG BUSHING ID .8745/.8770 WEAR .8795							
		LOCAL NICK AND BURR ON CENTER HOLE ID .050 OVER 10% OF AREA *C/P MOVE NOTE: ANY OLED TRUNNIONS EXCEEDING T.O. CRITERIA WILL BE IDENTIFIED TO ENGINEER ON AFLC FOR 103 STAT'NG CONDITION OF ITEM. ENGINEER WILL DETERMINE IF ITEM IS TO BE REWORKED PER DRWG 8241229.							
		***** NOTE ***** * A MINIMUM OF 2 FPI OPERATIONS * * MUST BE ACCOMPLISHED * *****							
69	030	REMOVE BUSHINGS THAT CANT BE REMOVED AT STATION 34 *C/P MOVE						001 MNRRA	002 04
								003 BE01	
69	033	LOCALLY POLISH I.D. OF TRUNNION TO REMOVE CORROSION DO NOT EXCEED MINIMUM WALL DIMENSIONS. *C/P MOVE						001 MNRRA	002 04
								003 BE01	
69	035	LOCALLY POLISH I.D. OF TRUNNION ENDS TO REMOVE CORROSION. *C/P MOVE						001 MNRRA	002 04
								003 BE01	
69	040	NICK AND BURR EXTERNAL UP TO .075 DEEP IN A 2 INCH SQUARE AREA. CENTER HOLE ID CAN BE REWORKED IN LOCAL AREAS UP TO .020 DEEP NOT TO EXCEED 10% OF SURFACE *C/P MOVE						001 MNRRA	002 04
								003 BE01	
69	045	TRUNNION CENTER HOLE REWORK INCREASE I.D. OF TRUNNION TO 6.1410/6.1440. IF THIS OPERATION COMPLIED (CONTINUED)						001 MNRRA	002 04
								003 MH02	005 X833699
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		19504N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-103

19504N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WITH F.P.I., SHOTPEEN, ANODIZE AND PAINT PER FIGURE 2-20 FLAG NOTE (33) (OPER. 400) SHOULD BE COMPLIED WITH IF REWORK EXCEEDS ABOVE DIMENSIONS							
		CANCELL OPERATION 400. *C/P MOVE							
69 ✓	050	END TRUNNION SOCKET (LEFT END) OVERSIZE REPAIR. OVERSIZE TO CLEANUP DO NOT EXCEED THE MINIMUM WALL THICKNESS 125 RMS *C/P MOVE						001 MNPRA 002 04 003 MH02 005 X8633699	
69 ✓	060	END TRUNNION SOCKET (RIGHT END) OVERSIZE REPAIR. OVERSIZE TO CLEANUP DO NOT EXCEED THE MINIMUM WALL THICKNESS 125 RMS *C/P MOVE						001 MNPRA 002 04 003 MH02 005 X8633699	
69 ✓	070	END CROSS BOLT HOLE (SMALL) OVERSIZE REPAIR. O/S TO CLEANUP *C/P MOVE						001 MNPRA 002 04 003 DR01	
69 ✓	075	ROLL BURNISH END CROSS BOLT HOLE (SMALL) .0005/.001 COMPRESSION. DONT EXCEED MAX ID .551 125 RMS *C/P MOVE						001 MNPRA 002 04 003 BE01	
69 ✓	080	END CROSS BOLT HOLE (LARGE) OVERSIZE REPAIR. O/S TO CLEANUP *C/P MOVE						001 MNPRA 002 04 003 DR01	
69 ✓	085	ROLL BURNISH END CROSS BOLT HOLE (LARGE) .0005/.001 COMPRESSION. DONT EXCEED MAX ID .8635 125 RMS *C/P MOVE						001 MNPRA 002 04 003 BE01	
69 ✓	090	MOUNTING FLANGES BOLT HOLES (FWD END REPAIR) OVERSIZE TO CLEANUP *C/P MOVE						001 MNPRA 002 04 003 MV03	
69 ✓	095	ROLL BURNISH MOUNTING FLANGES BOLT HOLES (FWD END), DONT EXCEED MIN WALL IN GRAPH 125 RMS (CONTINUED)						001 MNPRA 002 04 003 BE01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C						19504N
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1989-0-66-123

19504N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OLEO TRUNNION
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		*C/P MOVE			
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69 ✓	100	MOUNTING FLANGE BOLT HOLES (AFT END) REPAIR O/S TO CLEANUP DO NOT EXCEED MINIMUM WALL IN GRAPH 125 RMS *C/P MOVE		001 MNFRA 002 O4 003 MV03	
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69 ✓	105	ROLL BURNISH MOUNTING FLANGE BOLT HOLES (AFT END) *C/P MOVE		001 MNFRA 002 O4 003 BE01	
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69 ✓	110	AFT DOOR LEVER LUG HOLE (RIGHT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE		001 MNFRA 002 O4 003 MH02	
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69 ✓	115	ROLL BURNISH AFT DOOR LEVER LUG HOLE (RIGHT SIDE) *C/P MOVE		001 MNFRA 002 O4 003 BE01	
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69 ✓	120	AFT DOOR LEVER LUG HOLE (LEFT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE		001 MNFRA 002 O4 003 MH02	
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69 ✓	125	ROLL BURNISH AFT DOOR LEVER LUG HOLE (LEFT SIDE) *C/P MOVE		001 MNFRA 002 O4 003 BE01	
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69 ✓	130	FWD DOOR LEVER LUG HOLE (RIGHT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE		001 MNFRA 002 O4 003 MH02	
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69 ✓	135	ROLL BURNISH (FWD) DOOR LEVER LUG HOLE (RIGHT SIDE) *C/P MOVE		001 MNFRA 002 O4 003 BE01	
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69 ✓	140	FWD DOOR LEVER LUG HOLE (LEFT SIDE) REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW (CONTINUED)		001 MNFRA 002 O4 003 MH02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	19504N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1968-0-348-123

19504N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLED TRUNNION						
18. DISPATCH STATION	18. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		GRAPH 125 RMS *C/P MOVE							
69	145	ROLL BURNISH FWD DOOR LEVER LUG HOLE (LEFT SIDE) *C/P MOVE						001 MNFRA	002 04
								003 BE01	
69	150	ACTUATOR LUG HOLE OVERSIZE REPAIR O/S TO CLEANUP DO NOT EXCEED MIN WALL THICKNESS IAW GRAPH 125 RMS *C/P MOVE						001 MNFRA	002 04
								003 MH02	
69	155	ROLL BURNISH ACTUATOR LUG HOLE *C/P MOVE						001 MNFRA	002 04
								003 BE01	
69	160	CENTER ATTACH HOLE REPAIR FOR FLAME SPRAY (FIRST REPAIR) O/S TO CLEANUP WITHIN ID 6.158/6.218 IF REPAIR REQUIRES MORE THAN .040 FLAME SPRAY REPAIR WITH BUSHING 125 RMS *C/P MOVE						001 MNFRA	002 04
								003 MH02	005 X8633699
69	170	CENTER ATTACH HOLE REPAIR FOR BUSHING (SECOND REPAIR). OVERSIZE TO CLEANUP IAW FIGURE 2-20, FLAG 21, THERE ARE 3 ALTERNATE METHODS GIVEN 125 RMS *C/P MOVE						001 MNFRA	002 04
								003 MH02	005 X8633699
26	180	VAPOR DEGREASE *C/P MOVE						001 MNFRA	002 03
								003 DG01	
		*C/P MOVE ***** NOTE ***** (CONTINUED)					M	001 MNFRA	002 06
								003 ZA02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1965-448-100



19504N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER		14. NOUN OLEO TRUNNION

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
26	200	SHOTPEEN TRUNNION REWORKED AREAS *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	202	SHOT PEEN CENTER ATTACH HOLE *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	204	SHOT PEEN END TRUNNION SOCKET (RIGHT SIDE) *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	206	SHOT PEEN END TRUNNION SOCKET (LEFT SIDE) *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	210	POLISH LARGE CENTER, HOLE AFTER SHOTPEEN ONLY IF BUSHING IS REQUIRED REMOVE SHOTPEEN ROUGHNESS BUT NOT MORE THAN .002 MATERIAL *C/P MOVE		001 MNPRC 002 03 003 BE01	
26	220	POLISH TRUNNION END SOCKET (RT SIDE) AFTER SHOTPEEN. LIGHTLY POLISH TO REMOVE SHOTPEEN ROUGHNESS DO NOT REMOVE MORE THAN .002 MAT *C/P MOVE		001 MNPRC 002 03 003 BE01	
26	230	POLISH TRUNNION END SOCKET (LFT SIDE) AFTER SHOTPEEN. LIGHTLY POLISH TO REMOVE SHOTPEEN ROUGHNESS. DO NOT REMOVE MORE THAN .002 MAT *C/P MOVE		001 MNPRC 002 03 003 BE01	
		[REDACTED] A FOR FLAME SPRAY *C/P MOVE		001 MNPRC 002 08 003 DG02	
		[REDACTED] TO BE SPRAYED *C/P MOVE		001 MNPRC 002 08 003 BL01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SM
DISPATCH	FUNCTIONAL CODE	A	C	19504N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-548-103

19504N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OLEO TRUNNION	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TRUNNION CENTER HOLE SPRAY HOLE WITH METCO SF ALUMINUM SUFFICIENT TO ALLOW MACHINING TO ID OF 6.1365/6.138		001 MNHWW 002 08 003 FS09	
		***NOTE: DO NOT FLAME SPRAY I.D. CROSSBORE AREA. NO OVERSPRAY ALLOWED ON I.D. OF THE ARMS. *C/P MOVE			
69	250	CENTER CYLINDER ATTACH HOLE MACHINING OF SPRAY FINISH MACHINE TO ID 6.1365/6.138 62 RMS FIG 2-20 & SUPPLEMENTS *C/P MOVE		001 MNHRA 002 04 003 MH02 005 X8633699	
26	260	DEGREASE TRUNNION PRIOR TO ANODIZE *C/P MOVE		001 MNHRC 002 03 003 DG01	
26	270	ANODIZE TRUNNION COMPLETE TYPE II *C/P MOVE		001 MNHRC 002 03 003 AS03	
69	273	MACHINE CENTER ATTACH HOLE BUSHING PRESS FIR .0025/.005 USE MIL-S-81733 CHAMFER 45 DEG 125 RMS		001 MNHRA 002 04 003 LE00	
69	275	CENTER ATTACH HOLE BUSHING INSTALLATION P/N 3061603-203 INSTALL FLUSH TO .015 BELOW CHAMFER *C/P MOVE P/N 3061603-203		001 MNHRA 002 04 003 RE01	
69	276	FINISH ID 6.1365/6.138 125 RMS *C/P MOVE		001 MNHRA 002 04 003 MH02 005 X8633699	
69	279	MACHINE END TRUNNION SOCKET SIDE BUSHING .001/.0035 PRESS FIT		001 MNHRA 002 04 003 LE00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19504N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-0-488-103

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA			9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	280	END TRUNNION SOCKET (RT SIDE) BUSHING INSTALLATION P/N 3661603-205 USE SEALANT. MIL-S-81733 DRILL CROSS BOLT HOLE. P/N 3661603-205					001 MNPRA	002 04	003 BE01
69 ✓	285	FINISH BUSHING ID 3.813/3.815 32 RMS PAGE 2-63 FIG 2-20 *C/P MOVE					001 MNPRA	002 04	003 BE01
69 ✓	289	MACHINE END TRUNNION SOCKET (LEFT SIDE) BUSHING .0014/.0035 PRESS FIT 32 RMS					001 MNPRA	002 04	003 LE00
69 ✓	290	END TRUNNION SOCKET (LEFT SIDE) BUSHING INSTALLATION P/N 36616-3-205 USE SAE LANT MIL-S-81733 DRILL CROSS BOLT HOLE. REWORK LIMITS P/N 3661603-205					001 MNPRA	002 04	003 BE01
69 ✓	295	FINISH BUSHING ID 3.813/3.815 32 RMS PAGE 2-63 FIG 2-20 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA	002 04	003 BE01
69 ✓	298	MACHINE END CROSS BOLT HOLE (SHAEL) BUSHING .0005/.002 PRESS FIT 125 RMS USE MIL-S-81733					001 MNPRA	002 04	003 LE00
69 ✓	300	END TRUNNION SOCKET (LEFT SIDE) BUSHING INSTALLATION P/N 8121212-15 FINISH LINE REAM ID .375/.3765 (CONTINUED)					001 MNPRA	002 04	003 BE01
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	B	C	D	19504N			

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-648-102

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		125 RMS *C/P MOVE P/N 8121212-15							
69	305	MACHINE END CROSS BOLT HOLE (LARGE) BUSHING. USE MIL-S-81733, .002/.005 PRESS FIT 125 RMS						001 MNPRA 002 04 003 LE00	
69	310	END CROSS BOLT HOLE (LARGE) BUSHING INSTALLATION P/N 3G61603-137 FINISH LINE REAM TO ID .625/.628 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-137						001 MNPRA 002 04 003 BE01	
69	315	MACHINE MOUNTING FLANGE BOLT HOLE (FWD END) BUSHING .0005/.002 PRESS FIT 125 RMS						001 MNPRA 002 04 003 LE00	
69	320	MOUNTING FLANGE BOLT HOLE (FWD END) BUSHING INSTALLATION P/N 3G61603-221. NO PROTRUSION OF BUSHING ALLOW ON TOP SURFACE. USE MIL-S-81733. FINISH REAM I.D. .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-221						001 MNPRA 002 04 003 BE01	
69	325	MACHINE FLANGE BOLT HOLE (FWD END) BUSHING .0005/.002 PRESS FIT 125 RMS						001 MNPRA 002 04 003 LE00	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/IN			
DISPATCH	FUNCTIONAL CODE	A	C		19504N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-103

19504N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "O"	
69	330	<del>MOUNTING FLANGE BOLT HOLE (AFT END)</del> <del>BUSHING INSTALLATION</del> 3G61603-221 .0005/.002 PRESS FIT. NO PROTRUSION OF BUSHING ALLOW ON TOP SURFACE. USE MIL-S-81733 . FINISH REAM I.D. .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-221					001 MNPRA 002 04 003 BE01		
69	335	MACHINE AFT DOOR LEVER LUG HOLE (RIGHT SIDE) BUSHING .0005/.002 PRESS FIT 125 RMS ID FINISH SIZE .625/.627					001 MNPRA 002 04 003 LE00		
69	340	AFT DOOR LEVER LUG HOLE (RIGHT SIDE) BUSHING INSTALLATION 3G61603-225 USE MIL-S-81733 FINISH REAM ID .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-225					001 MNPRA 002 04 003 BE01		
69	345	MACHINE AFT DOOR LEVER LUG HOLE (LEFT SIDE) BUSHING .0005/.002 PRESS FIT 125 RMS FINISH SIZE .625/.627					001 MNPRA 002 04 003 LE00		
69	350	AFT DOOR LEVER LUG HOLE (LEFT SIDE) BUSHING INSTALLATION 3G61603-225 USE MIL-S-81733 FINISH REAM ID .625/.627 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED (CONTINUED)					001 MNPRA 002 04 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1958-0-283-783

19504N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETE	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NUMBER	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-225							
69	355	MACHINE FWD DOOR LEVER LUG HOLE BUSHING .0005/.002 PRESS FIT 125 RMS FACE TO FACE .688/.693 ID FINISH SIZE .500/.502						001 MNPRA	002 04
								003 LE00	
69	360	FWD DOOR LEVER LUG HOLE (RIGHT SIDE) BUSHING INSTALLATION OR 3G61603-135 OR 3G61603-225. USE MIL-S-81733						001 MNPRA	002 04
								003 BE01	
		FINISH LINE REAM ID .500/.502 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61603-135							
69	365	MACHINE FWD DOOR LEVER LUG FACE (LEFT SIDE) BUSHING .0005/.002 PRESS FIT FINISH ID SIZE .500/.502 125 RMS FACE TO FACE .6881/.693						001 MNPRA	002 04
								003 LE00	
69	370	FWD DOOR LEVER LUG HOLE (LEFT SIDE) BUSHING INSTALLATION 3G61603-135 USE MIL-S-81733 FINISH ID .500/.502, 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED						001 MNPRA	002 04
								003 BE01	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 3G61601-135							
69	375	MACHINE ACTUATOR LUG BUSHING .0005/.002 PRESS FIT FINISH ID SIZE .8745/.877 125 RMS (CONTINUED)						001 MNPRA	002 04
								003 LE00	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1949-648-124

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OLEO TRUNNION						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		FACE TO FACE .875/.880							
69 ✓	380	ACTUATOR LUG BUSHING INSTALLATION REPLACE. USE MIL-S-81733 FINISH ID .8745/.877						001 MNPRA 002 04 003 BE01	
		125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 8121212-17							
69 ✓	390	TRUNNIONS REWORKED FOR DRUG 8241229 WILL BE REIDENTIFIED AS FOLLOWS! STAMP P/N 8241229-30 ON THE RAISED AREA OF THE TRUNNION USING 1/8 INCH ROUND BOTTOM STAMP. *C/P MOVE						001 MNPRA 002 04 003 BE01	
26 ✓	395	ALODINE CENTER LUG BUSHING AFTER MACHINE *C/P MOVE						001 MNPRA 002 03 003 TA01	
	400	ONLY IF OPERATION 045 HAS BEEN ACCOMPLISHED. PAINT CENTER TRUNNION I.D. WITH TWO COATES OF EPOXY PRIMER *C/P MOVE						001 MNP GP 002 09 003 PP01	
	410	PAINT TRUNNION END I.D. WITH EPOXY PRIMER. *C/P MOVE						001 MNP GP 002 09 003 PP01	
	425	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 (CONTINUED) *REQD*						001 MNP GP 002 06 003 MU01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19504N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1968-6-65-183

19504N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETE
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OLEO TRUNNION	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		*C/P MOVE			
	430 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 06 003 MU01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19504N
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19505N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2 JOB ORDER NO. 74521A	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7. PART NUMBER 3G61014-101	8. TECH DATA 4S-1-182 4S2-59-3	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES C141 NOSE	11 STOCK NUMBER 1620000271196	12 OPTIONAL  <b>74521A</b>
13. SERIAL NUMBER	14 NOUN TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 F.M.P.I. IAW MIL-STD-1949			
		P/O NO1561 STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 FPI IAW MIL-STD-6866 CAD PLATE IAW MIL-STD-870 BAKE IAW 4S-1-182 MAOI 74-12 VAC I.V.D. ALUM IAW MIL-C-83488 ALODINE IAW MIL-C-5541			
		***4140 STEEL 180,000/200,000 PSI** ***UNIT COST 3G61014-101 \$189.43** *** UNIT COST 3G61039-101 \$115.30** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK B OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19505N
		B	D	

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19505N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13. SERIAL NUMBER	14 NOUN TRUNNION PTN
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	3661014-101			
	*REQD*	DISASSEMBLE *C/P MOVE		001 MNP GW	
				002 02	
				003 LG02	
				005 X8745235	
				006 X8745233	
	*REQD*	CHEM CLEAN *C/P MOVE		001 MNP GW	
				002 03	
				003 SL01	
	*REQD*	BLAST CLEAN *C/P MOVE		001 MNP GW	
				002 03	
				003 BL07	
	*REQD*	BAKE 4 HRS AT 350-400F		001 MNP GW	
				002 03	
				003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19505N
		B	D	

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE				M		001 MNP NA 002 05 003 MS03	
		[REDACTED] E AND I INSPECTION						001 MNP GW 002 04 003 EI01	
		PIN LARGE DIAMETER O.D. 3.8105/3.8125 WEAR 3.8098							
		PIN SMALL DIAMETER O.D. 2.3097/2.3112 WEAR 2.3092 *C/P MOVE							
26	032	VAPOR DEGREASE *C/P MOVE						001 MNP RC 002 03 003 DG01	
26	034	STRIP CAD *C/P MOVE						001 MNP RC 002 02 003 CS01	
26	036	STRIP RUST *C/P MOVE						001 MNP RC 002 02 003 CS02	
26	040	STRIP CHROME FROM LARGE DIAMETER *C/P MOVE						001 MNP RC 002 02 003 SC02	
26	050	STRIP CHROME FROM SMALL DIAMETER *C/P MOVE						001 MNP RC 002 02 003 SC02	
26		[REDACTED] MINIMUM O.D. 3.800 32 RMS P/N 3G61014-101 (CONTINUED)						001 MNP RB 002 02 003 GE01	

\* U.S. GOVERNMENT PRINTING OFFICE: 1969-548-103

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19505N
		B	D	

19505N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE							
8	070	FIRST GRIND SMALL DIAMETER CLEANUP MINIMUM O.D. 2.280 32 RMS P/N 3661014-101 *C/P MOVE						001 MNPRB 002 O2 003 GE01	
8	085	GRIND PIN HOLE TO DIA OF .375/.376 CONCENTRIC & PERPENDICULAR TO CENTER LINE 2.285/2.305 FROM END TO CENTER OF HOLE 32 RMS *C/P MOVE						001 MNPRB 002 O2 003 BE01	
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE						001 MNPRB 002 O6 003 TE03	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B	100	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH  DATE IN _____ TIME IN _____						001 MNPRC 002 O2 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]							
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****					M	001 MNPRB 002 O6 003 ML04	
26	115	VAPOR DECREASE *C/P MOVE						001 MNPRC 002 O3 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C			19505N			
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1980-546-183

19505N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN TRUNNION PIN
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15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	120	SHOT PEEN LARGE DIA INTENSITY .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26 ✓	122	SHOT PEEN SMALL DIA INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26 ✓	125	PREPARE FOR CHROME PLATING OF LARGE O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED		001 MNPRC 002 02 003 BE01	
26 ✓	130	CHROME PLATE LARGE O.D. SUFFICIENT TO GRIND BACK TO 3.8105/3.8125 TYPE II CLASS III MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNPRC 002 02 003 CP01 008 CO010	
26 ✓	135	PREPARE FOR CHROME PLATING OF SMALL O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED		001 MNPRC 002 02 003 BE01	
26 ✓	140	CHROME PLATE SMALL O.D. SUFFIC- IENT TO GRIND BACK TO FINISHED DIM- ENSION OF 2.3097/2.3112 TYPE II CLASS III		001 MNPRC 002 02 003 CP01 008 CO020	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE			
26B ✓	150	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19505N
		B	D	

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NCUN TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8 ✓	160	FINISH GRIND LARGE DIAMETER O.D. 3.8105/3.8125. CONCENTRIC WITHIN .001 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNP RB 002 02 003 GE01	
8 ✓	170	FINISH GRIND SMALL DIAMETER O.D. 2.3097/2.3112. CONCENTRIC WITHIN .001 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNP RB 002 02 003 GE01	
26B ✓	180	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNP RC 002 02 003 BK01	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NOJ OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****	M	001 MNP NA 002 06 003 ML04	
26 ✓	195	VAPOR DECREASE *C/P MOVE		001 MNP RC 002 03 003 DG01	
		[REDACTED] *C/P MOVE ***** NOTE ***** (CONTINUED)	M	001 MNP NA 002 06 003 ZS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
21A. DISPATCH	21B. FUNCTIONAL CODE	22A. A	22B. C	19505N
		22C. B	22D. D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-546-123

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN TRUNNION PIN							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****								
26	205	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE						001 MNPRC	002 01	003 BL02
26	210	CAD PLATE TYPE I CLASS II .5 SQ FT AT 25-35 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE						001 MNPRC	002 03	003 CA01
26B	220	BAKE 24 HRS AT 350 TO 400F WITHIN 4 HRS OF CAD  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC	002 02	003 BK01
26	221	IRIDITE *C/P MOVE						001 MNPRC	002 02	003 IR01
	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****					M	001 MNPRC	002 06	003 ML04
26	224	VAC I.V.D. ALUM OPTIONAL NOTE: 24 HR BAKE AND F.M.P.I. MUST BE ACCOMPLISH ED PRIOR TO THIS OPTION *C/P MOVE						001 MNPRC	002 03	003 IV01
26	225	ALDINE I.V.D. ALUM *C/P MOVE						001 MNPRC	002 03	003 TA01
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN				
DISPATCH	FUNCTIONAL CODE	A		C		19505N				
		B		D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-548-113

19505N WORK CONTROL DOCUMENT (MEDS):

1 DATE 89045

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PAGE OF PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P"	20. "Q"	
	227	PRE-PAINT *C/P MOVE *REQD*					001 MNP GP	002 09	
							003 PP01		
	230	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 950 *C/P MOVE *REQD*					001 MNP GP	002 06	
							003 SA03		
	240	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNP GP	002 06	
							003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19505N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1968-846-183



2. JOB ORDER NO. 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3G61039-101	8. TECH DATA 4S-1-182 4S2-59-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C141 NOSE	11. STOCK NUMBER 1620007575889	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN TRUNNION PIN (THREADED)	<b>74521A</b>
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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GOVERNING DIRECTIVES: AFLCR 66-51  
MANOI 66-3

F.M.P.I. IAW MIL-STD-1949

P/O N01561

STRIP CHROME IAW MIL-STD-871

GRIND IAW MIL-STD-866

TEMPER ETCH IAW MIL-STD-867

SHOT PEEN IAW MIL-S-13165

CHROME PLATE IAW MIL-STD-1501

FPI IAW MIL-STD-6866

CAD PLATE IAW MIL-STD-870

BAKE IAW 4S-1-182  
MAOI 74-12

VAN I.V.D. ALUM IAW MIL-C-83488A

ALODINE IAW MIL-C-5541

\*\*\*4140 STEEL 180,000/200,000 PSI\*\*  
\*\*\*UNIT COST 3G61014-101 \$189.43\*\*  
\*\*\* UNIT COST 3G61039-101 \$115.30\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

WARNING  
MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/8N
DISPATCH	FUNCTIONAL CODE	A	C	19508N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-540-113

19508N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
-------------------------	------------------	--------------

13. SERIAL NUMBER	14. NOUN TRUNNION PIN (THREADED)
-------------------	-------------------------------------

15. DISPATCH STATION	16. PERFORM RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL, ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQUI* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	3661039-101			
		DISASSEMBLE	C/P MOVE		
	*REQUI*			001 MNP GW	
				002 02	
				003 LG02	
				005 X8745235	
				006 X8745233	
		CHEM CLEAN	C/P MOVE		
	*REQUI*			001 MNP GW	
				002 03	
				003 SL01	
		BLAST CLEAN	C/P MOVE		
	*REQUI*			001 MNP GW	
				002 03	
				003 BL07	
		TAKE 4 HRS AT 350-400F			
	*REQUI*	DATE IN _____ TIME IN _____		001 MNP GW	
				002 03	
				003 BK03	
		DATE OUT _____ TIME OUT _____			
		C/P MOVE			
				001 MNP NA	
	*REQUI*	C/P MOVE	M	002 05	
				003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19508N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1968-646-113

19508N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
----------------	--------------	--------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13. SERIAL NUMBER	14 NOUN TRUNNION PIN (THREADED)
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
----------------------	--------------------	-----------------------------	--------------	---------	---------

		E AND I INSPECTION		001 MNRGW	
				002 04	
				003 EI01	

	*REQD*	PIN LARGE DIAMETER O.D. 3.8105/3.8125 WEAR 3.8098			
		PIN SMALL DIAMETER O.D. 2.3097/2.3112 WEAR 2.3092			
		PIN I.D. LARGE AREA 3.452 MAX			
		PIN I.D. SMALL AREA 1.600 MAX			
		PIN I.D. THREADED AREA 1.030 MAX			
		CROSS BOLT HOLE I.D. 0.625/0.626			
		*C/P MOVE			

26	032	VAPOR DEGREASE	*C/P MOVE		001 MNRRC
					002 03
					003 DC01

26	034	STRIP CAD	*C/P MOVE		001 MNRRC
					002 02
					003 CS01

26	036	STRIP RUST	*C/P MOVE		001 MNRRC
					002 02
					003 CS02

26	040	STRIP CHROME FROM LARGE DIAMETER	*C/P MOVE		001 MNRRC
					002 02
					003 SC02

26	050	STRIP CHROME FROM SMALL DIAMETER	*C/P MOVE		001 MNRRC
					002 02
					003 SC02

B	060	FIRST GRIND LARGE DIAMETER CLEANUP			001 MNRBR
		MINIMUM O.D. 3.800 32 RMS			002 02
		3G61039-101			003 GE01
		*C/P MOVE			

B	060	FIRST GRIND SMALL DIAMETER CLEANUP			001 MNRBR
		MINIMUM O.D. 2.285 32 RMS			002 02
		P/N 3G61039-101 THREADED PIN			003 GE01
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	19508N
		B	D	

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-548-103

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19508N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE							
8	085	GRIND CROSS BOLT HOLE TO CLEAN UP NOT TO EXCEED .0641" MAX *C/P MOVE						001 MNPRB 002 02 003 BE01	
		[REDACTED]					M	001 MNPNA 002 06 003 TE03	
		TIME OUT _____ DATE OUT _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B	100	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH						001 MNPRC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]					M	001 MNPNA 002 06 003 ML04	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26	115	VAPOR DEGREASE						001 MNPRC 002 03 003 IG01	
		*C/P MOVE							
26	120	SHOT PEEN LARGE DIA INTENSITY .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN		
DISPATCH		FUNCTIONAL CODE	A		C		19508N		
			B		D				

U.S. GOVERNMENT PRINTING OFFICE: 1988-548-124

19508N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	122	SHOT PEEN SMALL DIA INTENSITY OF .008/.012 A2 *C/P MOVE					001 MNPRC	002 01 003 SP02	
26 ✓	125	PREPARE FOR CHROME PLATING OF LARGE O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC	002 02 003 BE01	
26 ✓	130	CHROME PLATE LARGE O.D. SUFFICIENT TO GRIND BACK TO 3.8105/3.8125 TYPE II CLASS III MECHANIC SIGN OFF REQUIRED					001 MNPRC	002 02 003 CP01 008 CD010	
		*C/P MOVE							
26 ✓	135	PREPARE FOR CHROME PLATING OF SMALL O.D. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC	002 02 003 BE01	
26 ✓	140	CHROME PLATE SMALL O.D. SUFFICIENT TO GRIND BACK TO FINISHED DIMENSION OF 2.3097/2.3112 TYPE II CLASS III					001 F C	002 C 003 CP01 008 CD020	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED							
		*C/P MOVE							
26B ✓	150	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME					001 MNPRC	002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		<del>CHROME PLATE LARGE DIAMETER O.D. 3.8105/3.8125. CONCENTRIC WITHIN .001 32 RMS</del>					001 MNPRC	002 02 003 GE01	
		(CONTINUED)							
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN		
DISPATCH	FUNCTIONAL CODE	A	C		19508N				
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1989-548-115

19508N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION P.IN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
8	170	FINISH GRIND SMALL DIAMETER D.D. 2.3097/2.3112. CONCENTRIC WITHIN .001. 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE						001 MNP RB 002 02 003 GE01	
26B	180	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNP RC 002 02 003 BK01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****					M	001 MNP NA 002 06 003 ML04	
26	195	VAPOR DEGREASE *C/P MOVE						001 MNP RC 002 03 003 DG01	
		*C/P MOVE ***** NOTE ***** (CONTINUED)					M	001 MNP NA 002 06 003 ZS01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19508N				
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1969-06-18

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19508N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN (THREADED)						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 "P"	20 "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26 ✓	205	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	210	CAD PLATE TYPE I CLASS II .5 SQ FT AT 25-35 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE						001 MNPRC 002 03 003 CA01	
26B ✓	220	BAKE 24 HRS AT 350 TO 400F WITHIN 4 HRS OF CAD  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC 002 02 003 BK01	
26 ✓	221	IRIDITE *C/P MOVE						001 MNPRC 002 02 003 IR01	
	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****					M	001 MNPNA 002 06 003 ML04	
26 ✓	224	VAC I.V.D. ALUM OPTIONAL NOTE: 24 HR BAKE AND F.M.P.I. MUST BE ACCOMPLISH ED PRIOR TO THIS OPTION *C/P MOVE						001 MNPRC 002 03 003 IV01	
26 ✓	225	ALODINE I.V.D. ALUM *C/P MOVE						001 MNPRC 002 03 003 TA01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19508N				
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1980-548-183

19508N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN TRUNNION PIN (THREADED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
[REDACTED]	227	PRE-PAINT *C/P MOVE *REQD*						001 MNRGP	
[REDACTED]	230	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE *REQD*						001 MNRGP 002 06 003 SA03	
[REDACTED]	240	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*						001 MNRGP 002 06 003 SA03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		19508N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1969-64-110

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19510N WORK CONTROL DOCUMENT (MEDS)

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3. JOB ORDER NO.		9. QUANTITY		4. PRODUCTION SEC/RCC MNPPG		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER			8. TECH DATA 4S-1-192 4S2-59-3			9. ITEM SERIAL NO.				
10. MODEL-DESIGN-SERIES C141 NOSE			11. STOCK NUMBER			12. OPTIONAL <b>74521A</b>				
13. SERIAL NUMBER			14. NOUN LOWER BEARING							
15. DISPATCH STATION P/N 3G61224-101 115689A		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED NSN C/N 1620001257860 74521A		18. MECHANIC		19. "P"		20. "Q"
				***** UNIT COST: \$114.30 *****						
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOT 66-3						
				F.P.I. IAW MIL-STD-6866						
				STRIP ANODIZE IAW MIL-STD-871						
				ANODIZE IAW MIL-A-8625						
				ALODINE IAW MIL-C-5541						
				DRY FILM LUBE IAW MIL-L-46010						
				FLAME SPRAY IAW MIL-STD-869						
				*****ALUMINUM*****						
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.						
				* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C-P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.						
				WARNING						
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.						
				(CONTINUED)						
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN				
DISPATCH		FUNCTIONAL CODE	A		C	19510N				
			B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1969-546-103

19510N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89047

PAGE 01 OF 01 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	3661226-101 115687A							
		DISASSEMBLE *C/P MOVE						001 MNRGW 002 02 003 LG02 005 X8745235 006 X8745233	
	*REQD*								
		DEGREASE ONLY *C/P MOVE						001 MNRGW 002 02 003 LG02	
	*REQD*								
		*C/P MOVE				M		001 MNRNA 002 05 003 ZY05	
	*REQD*								
		E AND I INSPECTION						001 MNRGW 002 04 003 EI01	
	*REQD*	BEARING O.D. 5.7450/5.7480 WEAR 5.7440							
		BEARING I.D. 5.000/5.003 WEAR 5.006 *C/P MOVE * * * * * N O T E * * * * *							
		E & I INSPECTION MACHINING AND FLAME SPRAY REPAIR EXCEEDS THE COST OF THIS ITEM DO NOT REWORK THIS PART IF OUT OF TOLERANCE. IF BEARING HAS BEEN FLAME SPRAYED AND IS WITHIN DIMEN. SPECIFIED A DRY FILM LUBE AND ALO-							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19510N				
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-248-183

19510N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		LINE REPAIR IS AUTHORIZED. *C/P MOVE							
26	022	APPLY DRY FILM LUG TO FLAME SPRAYED I.D. MIL-L-46010 *C/P MOVE							
26	024	ALSO LINE O.D. MIL-C-5541 *C/P MOVE RETURN TO STATION 34A FOR ASSEMBLY.							
69	025	IF FABROID I.D. IS DAMAGED REMOVE FABROID AND REPAIR WITH FLAME SPRAY							
69	030	MACHINE I.D. TO REMOVE FLAME SPRAY. DO NOT EXCEED 5.148 125/250 RMS *C/P MOVE						001 MNFRA 002 04 003 LE00 005 X8745165	
26	000	STRIP OLD ANODIZE *C/P MOVE						001 MNFRC 002 03 003 AN04	
26A		<p style="text-align: right;">*C/P MOVE</p> <p>***** NOTE ***** IF LAST NDJ OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****</p>						001 MNFRA 002 06 003 Z002	
26	050	ANODIZE BEARING TYPE II CLASS I COMPLETE *C/P MOVE						001 MNFRC 002 03 003 AS03	
69		<p>REPAIR BEARING I.D. TO REMOVE ANODIZE 5.140/5.150, MAINTAIN [REDACTED] CONCENTRICITIES AND 125/250 RMS (CONTINUED)</p>						001 MNFRA 002 04 003 LE00	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	B	C	D	19510N			

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19510N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 Nos 5			11. STOCK NUMBER			12. OPTIONAL 74521A			
13. SERIAL NUMBER			14. NOUN LOWER BEARING						
15. DISPATCH STATION	16. PERFORM ACC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BREAK SHARP EDGES *C/P MOVE							
		[REDACTED] *C/P MOVE						001 MNPWW	
		[REDACTED] ALUMINUM OXIDE OR A 50/50 MIXTURE OF G-16 AND G-25) NOTE: MASK ALL SURFACES EXCEPT I.D. REMOVE ALL GRID FROM I.D. *C/P MOVE						001 MNPWW	
		[REDACTED] FLAME SPRAY I.D. .004/.007 BOND COAT FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE						001 MNPWW	
		[REDACTED] FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE						002 08	
		[REDACTED] FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE						003 DG02	
		[REDACTED] ALUMINUM OXIDE OR A 50/50 MIXTURE OF G-16 AND G-25) NOTE: MASK ALL SURFACES EXCEPT I.D. REMOVE ALL GRID FROM I.D. *C/P MOVE						001 MNPWW	
		[REDACTED] ALUMINUM OXIDE OR A 50/50 MIXTURE OF G-16 AND G-25) NOTE: MASK ALL SURFACES EXCEPT I.D. REMOVE ALL GRID FROM I.D. *C/P MOVE						002 08	
		[REDACTED] ALUMINUM OXIDE OR A 50/50 MIXTURE OF G-16 AND G-25) NOTE: MASK ALL SURFACES EXCEPT I.D. REMOVE ALL GRID FROM I.D. *C/P MOVE						003 BL01	
		[REDACTED] FLAME SPRAY I.D. .004/.007 BOND COAT FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE						001 MNPWW	
		[REDACTED] FLAME SPRAY I.D. .004/.007 BOND COAT FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE						002 08	
		[REDACTED] FLAME SPRAY I.D. .004/.007 BOND COAT FLAME SPRAY METCO SPRAYBRONZE A-A 4.825/4.925 USE 15 GAGE WIRE *C/P MOVE						003 FS07	
	080	FINISH MACHINE FLAME SPRAY INSIDE. FINISH BEARING DIAMETER I.D. 5.000/5.003. MAINTAIN A 64 RMS OR BETTER SURFACE FINISH. RADIUS BEARING INSIDE EDGES TO .040/.060 AFTER MACHINING. HEAT BEARING TO .110/130F AND APPLY GRAPHITE GREASE MIL-G-7187 TO FLAME SPRAYED SURFACE LET BEARING COOL TO ROOM TEMPERATURE AND WIPE OFF EXCESS GREASE. RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED						001 MNPRA	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE						002 04	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE						003 LE00	
	090	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 (CONTINUED)						001 MNPRA	
	*REQD:	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 (CONTINUED)						002 06	
		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 (CONTINUED)						003 SA03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19510N				
		B	D						

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19510N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN LOWER BEARING
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		*C/P MOVE			
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	100 *REQDY	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNR GP 002 06 003 SA03	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	19510N	
		B	D		

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19511N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

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2. JOB ORDER NO. 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3G61092-111	8. TECH DATA 4S-1-182 4S2-59-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C141 NOSE	11. STOCK NUMBER <del>1320000000</del>	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STEERING COLLAR	74521A
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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	AAA		#		
	001	3G61092-111			

		DISASSEMBLE	*C/P MOVE		001 MNP GW 002 02 003 LG02 005 X8745235 006 X8745233
	*REQD*				

		CHEM CLEAN	*C/P MOVE		001 MNP GW 002 03 003 SL01
	*REQD*				

		BLAST CLEAN	*C/P MOVE		001 MNP GW 002 03 003 HL01
	*REQD*				

		BAKE 4 HRS AT 350-400F			001 MNP GW 002 03 003 BK03
	*REQD*	DATE IN _____ TIME IN _____			

		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			

		*C/P MOVE	M		001 MNP NA 002 05 003 MS03
	*REQD*				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	19511N
		B	D	

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19511N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NAME STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNPBW		
	*REQD*	COLLAR I.D. 6.500/6.502 WEAR 6.506					002 04	003 EI01	
		COLLAR FACE TO FACE 5.245/5.255							
		COLLAR TORQUE ARM HOLES I.D. 1.4375/1.4386							
		COLLAR TORQUE ARM BUSHING I.D. 1.2474/1.2500 WEAR 1.2505 *C/P MOVE							
		***** N O T E ***** * A MINIMUM OF 2 FMPI OPERATIONS * * MUST BE ACCOMPLISHED * *****							
26	032	VAPOR DECREASE *C/P MOVE					001 MNPFC	002 03 003 DG01	
26	035	STRIP CAD *C/P MOVE					001 MNPFC	002 02 003 CS01	
26	040	STRIP RUST *C/P MOVE					001 MNPFC	002 02 003 CS02	
29	045	EXTERNAL DEFECT REMOVAL UP TO 0.02 DEEP BLEND WITH 1 INCH MIN RADIUS EXCEPT BUSHING HOLE & GEAR TEETH *C/P MOVE					001 MNPRA	002 04 003 BE01	
29	046	TORQUE ARM HOLE REPAIR CLEANUP HOLES WITHIN MIN WALL DIMENSIONS PER FIGURE FIGURE 2-25 125 RMS *C/P MOVE					001 MNPRA	002 04 003 BE01	
26	055	STRIP CHROME FROM INSIDE *C/P MOVE					001 MNPFC	002 02 003 SC02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19511N				
		B	D						

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1. DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	060	STRIP CHROME FROM FACES *C/P MOVE						001 MNPRC 002 02 003 SC02	
8 ✓	070	FIRST GRIND COLLAR INSIDE TO REMOVE CHROME OR TO LAMINATE. MAX DIAMETER I.D. 6.517 BREAK CORNERS .090 16 RMS *C/P MOVE						001 MNPRB 002 02 003 GI01 005 X8852125	
8 ✓	080	FIRST GRIND COLLAR FACES TO REMOVE CHROME OR TO LAMINATE. MINIMUM ID. 5.230 32 RMS *C/P MOVE						001 MNPRB 002 02 003 GS01 005 XB745179	
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M		001 MNPRNA 002 06 003 TE03	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26B ✓	100	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH						001 MNPRC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]							
		*C/P MOVE				M		001 MNPRNA 002 06 003 ML04	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26 ✓	115	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN				
DISPATCH	FUNCTIONAL CODE	A	C		19511N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-114



19511N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
26 ✓	120	SHOT PEEN I.D. .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	125	SHOT PEEN FACES .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26 ✓	128	PREPARE COLLAR ID FOR CHROME PLATE FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC 002 02 003 BE01	
26 ✓	130	CHROME PLATE COLLAR I.D. 2 EA JOURNALS SUFFICIENT TO GRIND BACK TO DIMENSION OF 6.500/6.502 TYPE II CLASS II DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC 002 02 003 CP01 008 CI010	
26B ✓	150	BAKE 4 HRS AT 350 - 400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC 002 02 003 BK01	
26 ✓	153	PREPARE COLLAR FACE FOR CHROME PLATE OR FLASH CHROME PLATE, MASK/FIXTURE/ ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED						001 MNPRC 002 02 003 BE01	
26 ✓	155	CHROME PLATE OR FLASH CHROME PLT COLLAR FACE 1EA ONLY TYPE II CLASS II DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC 002 02 003 CP01 008 CO010	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN				
DISPATCH	FUNCTIONAL CODE	A	C		19511N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1969-548-110

19511N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
-------------------------	------------------	--------------

13. SERIAL NUMBER	14. NOUN STEERING COLLAR
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26B	157	BAKE 4 HRS AT 350 - 400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	

		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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8	160	FINISH GRIND COLLAR INSIDE DIA. JOURNAL FINISH DIA I.D. 6.500/6.502 16 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED		001 MNPRB 002 02 003 GI02 005 X8852125	
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		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
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8	170	FINISH GRIND COLLAR FACE 1 EA ONLY 125 RMS *C/P MOVE		001 MNPRB 002 02 003 GS01 005 X8745179	
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26B	180	BAKE 4 HRS AT 350F TO 400F DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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26	200	PREPARE COLLAR FACE FOR CHROME PLATE OR FLASH CHROME PLATE MASK/FIXTURE/ ETC. *C/P MOVE MECHANIC SIGN OFF REQUIRED		001 MNPRC 002 02 003 BE01	
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26	210	CHROME PLATE OR FLASH CHROME COLLAR FACE 1EA SUFFICIENT TO GRIND BACK TO 5.245/5.255 TYPE II CLASS I DATE OUT _____ TIME OUT _____		001 MNPRC 002 02 003 CP01 008 C0020	
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		MECHANIC SIGN OFF REQUIRED *C/P MOVE			
--	--	---	--	--	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
				19511N
		B	D	

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19511N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26B	220	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE						001 MNP RC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
B	240	FINISH GRIND COLLAR FACE TO FACE 5-245/5-255 125° RMS *C/P MOVE						001 MNP RB 002 02 003 GS01 005 X8745179	
26B	250	BAKE 4 HRS AT 350-400F						001 MNP RC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE				M		001 MNP NA 002 06 003 ML04	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26	265	VAPOR DECREASE						001 MNP RC 002 03 003 DG01	
		[REDACTED] *C/P MOVE				M		001 MNP NA 002 06 003 ZS01	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19511N			
		B		D					

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1 DATE 89045

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	275	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	280	CAD PLATE TYPE II CLASS II 1.1 SO FT AT 55-77 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B ✓	290	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		<div style="background-color: black; width: 150px; height: 15px; margin-bottom: 5px;"></div> *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****				M	001 MNPNA 002 06 003 ML04		
26 ✓	304	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26 ✓	307	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 290 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION *C/P MOVE					001 MNPRC 002 03 003 IVD1		
26 ✓	310	DRY FILM LUBE GEAR TEETH ONLY *C/P MOVE					001 MNPRC 002 03 003 EL01		
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE		A	C		19511N			
			B	D					

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN STEERING COLLAR							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"	
26B	315	BAKE 1 HR AT 400F AFTER DRY FILM LUBE DATE IN _____ TIME IN _____						001 MNP RC	002 02	003 BK02
		DATE OUT _____ TIME OUT _____ *C/P MOVE								
26	318	IRIDITE *C/P MOVE						001 MNP RC	002 02	003 IR01
26	319	ALODINE IVI ALUM PLATE CLASS 1A *C/P MOVE						001 MNP RC	002 03	003 TA01
69	320	MACHINE TORQUE ARM LUG BUSHING FACE TO FACE 5.737/5.742 *C/P MOVE						001 MNP RA	002 04	003 LE00
69	325	TORQUE ARM LUG BUSHING INSTALLATION PRESS #1 .0005/.0025. FINISH ID 1.2474/1.250 125 RMS USE SEALANT MIL-S-81733						001 MNP RA	002 04	003 BE01
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS								
		*C/P MOVE P/N 8121212-33								
	340	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD* *C/P MOVE						001 MNP GP	002 06	003 MU01
	350	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE						001 MNP GP	002 06	003 MU01
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C			19511N				
		B	D							

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2. JOB ORDER NO. 74521A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 3G61027-101				8. TECH DATA 4S-1-182 4S2-59-3				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C141 NOSE			11. STOCK NUMBER 1620000110320			<b>74521A</b>			
13. SERIAL NUMBER			14. NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		<p>***** UNIT COST: \$626.70 *****</p> <p>GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 F.M.P.I. IAW MIL-STD-1949</p> <p>BAKE IAW 4S-1-182 MADI 74-12</p> <p>SHOT PEEN IAW MIL-S-13165</p> <p>SULFAMATE NICKEL IAW MIL-STD-868</p> <p>FPI IAW MIL-STD-6866</p> <p>TEMPER ETCH IAW MIL-STD-867</p> <p>*****STEEL 180,000/200,000 PSI*****</p> <p>ALL PERSONNEL INVOLVED IN THE WORK PROCESSES IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED &amp; ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES &amp; HAZARDS CONTAINED IN THE BASIC TECH ORDER (T.O.) AND T.O. SUPPS. REFERENCED. THE APPLICABLE T.O.S &amp; SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.</p> <p>*COMPONENTS WILL BE THOROUGHLY CLEANED &amp; PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. ***W A R N I N G***</p> <p>MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES &amp; CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS &amp; PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURY.</p> <p>*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.</p>							
	001	3G61027-101							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C	B	D	19512N			

U.S. GOVERNMENT PRINTING OFFICE: 1989-44-183

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19512N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 2 OF 3 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN STEERING PLATE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DISASSEMBLE *C/P MOVE		001 MNRGW	
	*REQD*			002 02	
				003 LFG2	
				005 X8745233	
				006 X8745235	
		CHEM CLEAN *C/P MOVE		001 MNRGW	
	*REQD*			002 03	
				003 SL01	
		BLAST CLEAN *C/P MOVE		001 MNRGW	
	*REQD*			002 03	
				003 BL07	
		BAKE 4 HRS AT 350-400F		001 MNRGW	
	*REQD*	DATE IN _____ TIME IN _____		002 03	
		DATE OUT _____ TIME OUT _____		003 BK03	
		*C/P MOVE			
			M	001 MNRNA	
	*REQD*	*C/P MOVE		002 05	
				003 MS03	
		E & I INSPECTION		001 MNRGW	
	*REQD*	LARGE I.D. 6.250/6.252 WEAR 6.254		002 04	
		NOTE: PITTING PERMISSIBLE 1AW		003 EI01	
		492-59-3 IN LARGE II			
		CYLINDER ATTACH HOLES I.D.			
		.9375/.9385 WEAR .9397			
		*C/P MOVE			
		***** NOTE *****			
		* A MINIMUM OF 2 FMPI OPERATIONS *			
		* MUST BE ACCOMPLISHED *			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19512N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1988-548-128

19512N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*****							
26	030	VAPOR DEGREASE *C/P MOVE						001 MNPRC	
								002 03	
								003 DG01	
26	035	STRIP ELECTROLESS NICKEL PLATE *C/P MOVE						001 MNPRC	
								002 03	
								003 SN01	
		C/P MOVE						001 MNPRC	
		***** NOTE *****				M		002 06	
		IF LAST NDI OPERATION IS COMPLETED*						003 ML04	
		HERE, TAKE PRODUCTION COUNT. *							
		*****							
8	039	IF REQUIRED REMOVE RAISED TURN BOSS AS OUTLINED IN T.O. PAGE 2-71 *C/P MOVE						001 MNPRC	
								002 02	
								003 BE01	
69	040	CYLINDER LUG HOLES OVERSIZE REPAIR MACHINE LUG HOLES O/S FOR A .040 MIN WALL BUSHING. MAX WALL THICKNESS IAW GRAPH IN 452-59-3 125RMS *C/P MOVE						001 MNPRC	
								002 04	
								003 MV02	
69	050	MACH KEYWAY SLOTS IAW T.O. 452-59-3 FIG 2-27 100% . USE FIXTURE TO DETERMINE THAT KEYWAYS ARE TRUE 32 RMS *C/P MOVE						001 MNPRC	
								002 04	
								003 MV02	
26	085	VAPOR DEGREASE *C/P MOVE						001 MNPRC	
								002 03	
								003 DG01	
26	095	SHOTPEEN LARGE ID *C/P MOVE						001 MNPRC	
								002 01	
								003 SP02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		19512N				
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-549-112

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19512N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045 PAGE 4 OF 4

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERFORM NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19.	20.	
26 ✓	150	PREPARE FOR SULFAMATE NICKEL PLATE, GLASS BLAST *C/P MOVE						001 MNPRC 002 01 003 BLO3	
26 ✓	160	SULFAMATE NICKEL COMPLETE CLASS I NICKEL PLATE I.D. ENOUGH TO GRIND BACK TO 6.250/6.252 INCH DIM *C/P MOVE						001 MNPRC 002 03 003 NP01 008 N0010	
26B ✓	165	BAKE 23HRS AT 350-400F WITHIN 4 HRS OF PLATE DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
B ✓	166	MEASURE I.D. 6.250/6.252 *C/P MOVE						001 MNPRC 002 02 003 RE01	
B ✓	167	GRIND I.D. AS NECESSARY TO MEET DIMENSIONS OF 6.250/6.252 INCHES *C/P MOVE						001 MNPRC 002 02 003 GJ02	
26B ✓	168	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		*C/P MOVE						001 MNPRC 002 06 003 ML04	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M			
		*****							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		19512N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-103

19512N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

PAGE 5 OF 5 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STEERING PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	170	MACHINE CYLINDER LUG HOLES BUSHINGS MIN WALL .0040, PRESS FIT .001/.0015. FINISHED ID .9375/.9385 NOTE: KEEP DIM TO TOP TOLERANCE OF .93858 IF POSSIBLE. 125 RNS						001 MNHRA 002 04 003 LE00	
69 ✓	175	CYLINDER LUG HOLES BUSHING INSTALL- ATION. P/N 66C33001-69ST RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 66C33001-69ST						001 MNHRA 002 04 003 BE01	
	180	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *RECD* OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE						001 MNHGP 002 06 003 MU01	
	190	FINAL PRODUCT VISUAL INSPECTION *RECD* *C/P MOVE						001 MNHGP 002 06 003 MU01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		19512N			
		B		D					

\* U.S. GOVERNMENT PRINTING OFFICE: 1989-548-12

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19520N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 1 OF 1 PAGES

2 JOB ORDER NO. 74521A	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER 7530	8 TECH DATA 4S-1-182 4S2-59-3 & 4	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES C-141 NOSE	11 STOCK NUMBER LE	12 OPTIONAL
--------------------------------------	-----------------------	-------------

13 SERIAL NUMBER	14 NOUN FILLER TUBE	74521A
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BRUSH CAD PLATE IAW MIL-STD-865			
		***** S T E E L ***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.  *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	7530983-01			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	19520N
		B	D	159

U.S. GOVERNMENT PRINTING OFFICE: 1988-540-182

19520N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN FILLER TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		DISASSEMBLE *C/P MOVE						001 MNP GW	
	*REQD*							002 02	
								003 LG02	
								005 X8745235	
								006 X8745223	
		CLEAN *C/P MOVE						001 MNP GW	
	*REQD*							002 02	
								003 IG02	
		BLAST OR CHEM CLEAN *C/P MOVE						001 MNP GW	
	*REQD*							002 03	
								003 BL07	
		E & I PER TECH DATA *C/P MOVE							
69	030	MACHINE FILLER TUBE FOR STANDARD SIZE OD .9347-.936 "O" RING GROOVE .834/.836 IAW 452-59-3 PAGE 2-49 FIG "O" USING EXISTING "O" RING GROOVE AS GUIDE *C/P MOVE						001 MNPRA	
								002 04	
								003 LE00	
69	040	BRUSH CAD PLATE IAW MIL-SIT-865 *C/P MOVE						001 MNPRA	
								002 04	
								003 BE01	
	050	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE						001 MNP GP	
	*REQD*							002 06	
								003 SA03	
	060	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE						001 MNP GP	
	*REQD*							002 06	
								003 SA03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C					19520N	
		B	D						

\* U.S. GOVERNMENT PRINTING OFFICE: 1968-56-103

19524N WORK CONTROL DOCUMENT (MEDS)

DATE 89045

PAGE 1 OF 1 PAGES

2. JOB ORDER NO 74521A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER 3661091	8. TECH DATA 45-1-182 452-59-3	9. ITEM SERIAL NO.
---------------------------	--------------------------------------	--------------------

10. MODEL-DESIGN-SERIES C-141 N.L.G.	11. STOCK NUMBER	12. OPTIONAL
---	------------------	--------------

13. SERIAL NUMBER	14. NOUN METERING PIN	74521A
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20. "Q"
		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3 *****A L U M I N U M***** *UNIT COST \$426.30*****			
		F.P.I. IAW MIL-STD-686 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *****"W A R N I N G"*****			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	3661091-103			

		DISASSEMBLE	*C/P MOVE	001 MNP GW	
	*REQD*			002 02	
				003 LG02	
				005 X8745235	
				006 X8745235	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		19524N
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

\* U.S. GOVERNMENT PRINTING OFFICE: 1969-646-102

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19524N WORK CONTROL DOCUMENT (MED)

DATE: 8/20/51 PAGE: 6

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN METERING PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DEGREASE ONLY *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 AC02		
		CHECK FOR CRACKS				M	001 MNP NA		
	*REQD*	*C/P MOVE					002 05		
							003 ZY05		
		E & I CHECK METERING PIN					001 MNP GW		
	*REQD*	I.D. 0.3800/0.3820					002 04		
		BASE O.D. 4.243/4.245 MAX WEAR 4.24					003 EI01		
		14.500 IN. LENGTH *C/P MOVE							
69	045	CHECK CONCENTRICITY					001 MNP RA		
	*REQD*	ALL DIAMETERS HAVING A COMMON AXIS					002 04		
		TO BE CONCENTRIC WITHIN .010 TIR					003 BE01		
		I.A.W. DRWG 3061091 *C/P MOVE							
	050	FINAL ACCEPTANCE OF WORK CONTROL					001 MNP GP		
	*REQD*	DOCUMENT FOR COMPLETENESS & ACCURACY					002 06		
		OF ALL PRECEDING OPERATIONS THIS 958					003 SA03		
		*C/P MOVE							
	060	FINAL PRODUCT VISUAL INSPECTION					001 MNP GP		
	*REQD*	*C/P MOVE					002 06		
							003 SA03		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE			19524N	

\* U.S. GOVERNMENT \*

441 NLG

74521A STRU, JSSY C-141 NLG

RCC MNFRA

4S2-59-3

ECH S S		W F PF A/R REV		SUB T K #R A FA SUPPORT		OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
RA501	S E	JA EA	1	J 84154	.86	PERCENT ENGR 98.8	REPAIR OUTER CYL C141N 405	12.93		11.12	
0001		JA 01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
						3661090-119	1620004419763				
0165		JA 01	15		.75		REMOVE TRUNNION LINK PIN	1.119	.126	.966	7
0010 E				RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HD		.42803		.492	
0020 E				RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E				RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E				RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E				RML-BD-AC	1.00	BORE HOLE 1 X 1 1/2 GROUP 4		.35762		.411	
0060 E				RRW-TR-S1	1.00	DRILL TAP & INSTALL SLIMSERTAP & REMOVE LINK PIN		.06879		.079	
0080 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0170		JA 01	15		.21		EXTERNAL DEFECT REPAIR	.359	.011	.087	1
0010 E				RRW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E				GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.00678		.007	
0030 E				RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077	
0050 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0180		JA 01	15		.08		POLISH O.D.	.359	.004	.033	0
0010 E				RRW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E				GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.00678		.007	
0030 E				RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077	
0050 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
		JA 01	15		.05		O/S DRAG ATTACH LUGS	1.887	.014	.109	1
0010 E				RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192	
0020 E				RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E				RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E				RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E				RML-BD-BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 42EA LUGS		.29250		.572	
0070 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0155		JA 01	15		.08		O/S ACTUATOR LUGS	1.918	.023	.177	1
0010 E				RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192	
0020 E				RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E				RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E				RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E				RML-BD-BF	1.00	BORE HOLE 1.5 X 3 GROUP 4		.61649		.708	
0070 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0200		JA 01	15		.25		O/S TORQUE ARM LUG 4EA	1.634	.061	.470	4
0010 E				RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HD		.42803		.492	
0020 E				RML-AL-CA	4.00	ALIGN HORIZ AXIS MAG BASE OCC FOR 4EA HOLES		.05917		.272	
0030 E				RML-AL-CB	4.00	ALIGN VERTICAL AXIS MAG BASE OCC FOR 4EA HOLES		.12351		.568	
0040 E				RML-AL-CC	4.00	ALIGN HOLE TO SPINDLE MAG BS OCC FOR 4EA HOLES		.07261		.334	
0050 E				RLA-RE-MB	4.00	REAM HOLE 1/2-; 5/8 DIA 1 DPOCC FOR 4EA HOLES		.04377		.201	
0070 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0205		JA 01	15		.21		O/S FILLER TUBE LUG	1.659	.052	.401	3
0010 E				RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192	
0020 E				RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E				RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E				RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E				RML-BD-AC	1.00	BORE HOLE 1 X 1 1/2 GROUP 4		.35762		.411	
0070 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0210		JA 01	15		.25		O/S STEER LUG 2EA.	1.042	.039	.300	2
0010 E				RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HD		.42803		.492	
0020 E				RML-AL-CA	2.00	ALIGN HORIZ AXIS MAG BASE		.05917		.136	
0030 E				RML-AL-CB	2.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.284	

0040 E	RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.167	
0050 E	RLA-RE-LC	2.00	REAM HOLE 1/4-1/2 DIA 1-1.5 2EA HOLES		.04715		.108	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
JA 01	15	.05	O/S LINK PIN HOLE		1.616	.012	.093	1
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E	RML-BD-AB	1.00	BORE HOLE 1 X 1 GROUP 4		.31431		.361	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0215	JA 01	15	.33	RADIUS STEERING FLANGE AREA	.847	.042	.322	2
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020 E	RLA-RC-NG	1.00	RECESS 6-6.5 DIA. 1/8 DP G4		.11655		.134	
0030 E	RLA-RC-NH	3.00	RECESS 6-6.5 DIA. ADD 1/8 IN		.07383		.254	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0225	JA 01	15	.33	REMOVE PITTING STEER-FLANGE	.083	.004	.032	0
0010 E	GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.0678		.007	
0020 E	RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0230	JA 01	15	.29	MACH 4 NEW KEY SLOTS	4.733	.206	1.579	12
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192	
0020 E	RML-AL-BA	4.00	ALIGN HORIZ AXIS CLAMP 4 SLOTS		.05541		.254	
0030 E	RML-AL-BB	4.00	ALIGN VERTICAL AXIS CLAMP 4 SLOTS		.11975		.550	
0040 E	RML-BD-AM	4.00	BORE HOLE 1 X 6 IN GROUP 4 4 SLOTS		.74741		3.438	
0060 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0235	JA 01	15	.33	REMOVE CORROSION RING GROOVE	.498	.025	.189	1
0010 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E	RLG-RS-P3	1.00	POLISH PLATED SURF OUTER CYL		.21297		.244	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0245	JA 01	15	.13	MACH NEW KEYWAYS	4.737	.092	.708	5
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192	
0020 E	RML-AL-BA	4.00	ALIGN HORIZ AXIS CLAMP 4 SLOTS		.05541		.254	
0030 E	RML-AL-BB	4.00	ALIGN VERTICAL AXIS CLAMP 4 SLOTS		.11975		.550	
0040 E	RML-BD-AM	4.00	BORE HOLE 1 X 6 IN GROUP 4 4 SLOTS		.74741		3.438	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0609	JA 01	15	.24	MACH BUSH DRAG ATTACH LUGS	.860	.031	.237	2
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS		.09095		.209	
0030 E	KML-TB-DC	2.00	DIA 1.00-1.50 REM .033-.250 2EA BUSHINGS		.08429		.193	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0610	JA 01	15	.24	INSTALL BUSH DRAG ATTACH LUG	.776	.028	.214	2
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES OCC FOR 2 MEN		.23835		.548	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORESCHAMFER BUSHINGS 2EA		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0615	JA 01	15	.24	MACH BUSH ACTUATOR LUGS	.727	.026	.201	2
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0002 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0006 E	KML-TB-DC	1.00	DIA 1.00-1.50 REM .033-.250		.08429		.096	
0008 E	KML-TB-DD	2.00	DIA 1.5 REM .250 ADD INCH OCC FOR 2 ADD. INCHES		.02140		.049	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0620	JA 01	15	.24	INSTALL BUSH ACTUATOR LUGS	1.244	.045	.344	3
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E	RBW-BU-C1	.50	CHAMFER SET OF BUSHING BORESCHAMFER 1EA BUSHING		.10435		.060	
0040 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL S/U PORTABLE HOME		.27525		.316	
0050 N		1.00	HONE BUSHINGS		.50000		.575	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0625	JA 01	15	.88	MACH BUSH TORQUE ARM LUGS 4E	1.165	.154	1.180	9
0002 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	



0004 E	RLA-HP-C3	4.00	CHUCK SYMET PART IN 4 JAW	OCC FOR 4EA BUSHINGS	.09095		.418	
0008 E	KML-TB-CC	4.00	DIA .501-1.00 REM .033-.250	OCC FOR 4EA BUSHINGS	.07308		.336	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	.88	INSTALL BUSH TORQUE ARM LUG	.848	.112	.859	7
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-B2	2.00	REBUSH A SET OF 2 BOSSES	OCC FOR 4EA HOLES	.22231		.511	
0030 E	RBW-BU-C1	2.00	CHAMFER SET OF BUSHING BORES	OCC FOR 4EA HOLES	.10435		.240	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0635	JA 01	15	1.00	HONE TO FINISH SIZE	.443	.066	.509	4
0010 E	RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HDPRORATE S/U	OVER 4 PARTS	.42803		.492	
0020 N			1.00	HONE TO FINISH SIZE	.00500		.005	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0640	JA 01	15	.79	MFG & INSTALL FILLER TUBE	.573	.068	.521	4
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020 E	RLA-TD-DC	1.00	REMOVE .033 -.250 DIA OVER 1		.06341		.072	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0645	JA 01	15	.79	INSTALL FILLER TUBE BUSHING	.267	.032	.243	2
0030 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0040 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0050 E	RBW-BU-C1	.50	CHAMFER SET OF BUSHING BORES	OCC FOR 1EA	.10435		.060	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0648	JA 01	15	.92	MACH BUSH STEERING LUGS	.972	.134	1.029	8
0002 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	2EA BUSHINGS	.09095		.209	
0008 E	KML-TD-DC	2.00	DIA 1.00-1.50 REM .033-.250	2EA BUSHINGS	.14068		.323	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0650	JA 01	15	.92	INSTALL BUSH STEERING LUG	.521	.072	.552	4
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0655	JA 01	15	1.00	HONE STEERING LUG BUSHING	.443	.066	.509	4
0010 E	RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HDPRORATE S/U	OVER 4 PARTS	.42803		.492	
0020 N			1.00	HONE TO FINISH SIZE	.00500		.005	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0660	JA 01	15	1.00	MACHINE LINK PIN BUSHING	.667	.100	.768	6
0002 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0008 E	KML-TB-BC	1.00	DIA .251-.500 REM .033-.250		.06699		.077	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0665	JA 01	15	1.00	INSTALL LINK PIN	.267	.040	.308	2
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RBW-BU-C1	.50	CHAMFER SET OF BUSHING BORES	OCC FOR 1EA BUSHING	.10435		.060	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0900				THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901				FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902				ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
0903				<				
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				PRIOR HISTORY ON 00-ALC 494 FORM				
0020				24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1				
0030				ELEMENTS <OLD STD> 13.80				
0031				27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 13.59				
0032				30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG				
0899				J.CALDWELL TECH MANEAA				
0900				MANEL CLINTON BENTLEY MRP II 7-3255				

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

452-59-3

TECH S S W F F F A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A		
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C	
RA502	S	E	JA	EA 1	J	84154	.89 PERCENT ENGR 99.9	REPAIR INNER CYL C141N 405	9.69		8.63	
0001			JA	01	00		.00	PART NUMBER/NSN	.000	.000	.000	0
						0010		3661089-111			1620004983226	
0045			JA	01	15		.08	NICK & BURR	.472	.006	.043	0
						0010 E	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
						0020 E	1.00	NICK & BURR V/L STRUT PARTS	.18732		.215	
						0040 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0050			JA	01	15		.16	O/S TORQUE ARM LUG	1.823	.044	.335	3
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	
						0040 E	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261		.083	
						0050 E	2.00	BORE HOLE 2 X 1 GROUP 4	.40027		.920	
						0070 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0060			JA	01	15		.40	O/S AXLE ATTACH LUG F/SPRAY	3.322	.199	1.528	16
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	
						0040 E	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261		.083	
						0050 E	1.00	BORE HOLE 4 X 6 GROUP 4	2.29979		2.644	
						0070 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
70			JA	01	15		.12	O/S AXLE ATT LUG FOR BUSHING	3.322	.060	.458	5
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	
						0040 E	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261		.083	
						0050 E	1.00	BORE HOLE 4 X 6 GROUP 4	2.29979		2.644	
						0070 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0080			JA	01	15		.05	O/S CROSS BOLT LUGS	1.293	.010	.074	1
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	
						0040 E	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261		.083	
						0050 E	1.00	BORE HOLE 1 X 1/2 GROUP 4	.27100		.311	
						0070 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0090			JA	01	15		.08	O/S TOW LUGS	1.510	.018	.139	1
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	
						0040 E	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261		.083	
						0050 E	1.00	BORE HOLE 1 X 3 GROUP 4	.48755		.560	
						0070 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0350			JA	01	15		.40	MACH AXLE ATTACH LUG F/SPRAY	1.998	.120	.919	9
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	
						0040 E	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261		.083	
						0050 E	1.00	BORE HOLE 4 X 6 GROUP 2	.97611		1.122	
						0070 E	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0355			JA	01	15		.16	O/S CROSS BOLT LUGS	1.293	.031	.238	2
						0010 E	1.00	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
						0020 E	1.00	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
						0030 E	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351		.142	

0040	E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E	RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4		.27100		.311	
0360	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
	JA 01	15	.96	MACHINE TORQUE LUG BUSHING		.882	.127	.974	10
0002	E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004	E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	2EA BUSHINGS	.09095		.209	
0008	E	KML-TB-EC	2.00	DIA 1.50-2.00 REM .033-.250	2EA BUSHINGS	.09539		.219	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0390	JA 01	15	.96	INSTALL TORQUE LUG BUSHING		.523	.075	.578	6
0010	E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0020	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030	E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0395	JA 01	15	1.00	MACHINE TOW LUG BUSHING		.701	.105	.806	8
0002	E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004	E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0008	E	KML-TB-CC	1.00	DIA .501-1.00 REM .033-.250		.07308		.084	
0009	E	KML-TB-CD	2.00	DIA 1.0 REM .250 ADD INCH	OCC FOR 2 ADD. INCHES	.01367		.031	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0400	JA 01	15	1.00	INSTALL TOW LUG BUSHING		.521	.078	.600	6
0010	E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030	E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0405	JA 01	15	.20	MACHINE AXLE ATTACH LUG BUSH		1.100	.033	.253	3
0001	E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0002	E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0004	E	KML-TB-HC	1.00	DIA 4.00-5.00 REM .033-.250		.15394		.177	
0005	E	KML-TB-HD	5.00	DIA 5.0 REM .250 ADD INCH	OCC FOR 5 ADD. INCHES	.06928		.398	
0070	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0410	JA 01	15	.20	INSTALL AXLE ATTACH LUG BUSH		.252	.008	.058	1
0055	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0060	E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0070	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0412	JA 01	15	.20	BUSH AXLE ATTACH LUGS		3.322	.100	.764	8
0010	E	RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E	RML-BD-GM	1.00	BORE HOLE 4 X 6 GROUP 4		2.29979		2.644	
0070	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0415	JA 01	15	.20	COUNTER BORE AXLE ATTACH BUS		3.322	.100	.764	8
0010	E	RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732		.870	
0020	E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E	RML-BD-GM	1.00	BORE HOLE 4 X 6 GROUP 4		2.29979		2.644	
0070	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
0418	JA 01	15	.72	MACH CROSS BOLT LUG BUSHING		.884	.095	.732	3
0002	E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0004	E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0006	E	RSG-JP-T1	1.00	JOB PREP GENERAL FOR S & M		.22079		.253	
0008	E	RLA-TB-CC	1.00	DIA .501-1.00 REMOVE .033-.250		.06285		.072	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	
	JA 01	15	.72	INSTALL CROSS BOLT LUG BUSHI		.521	.056	.432	4
0010	E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0030	E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.011	

0901  
0902  
903

FOR THIS OPERATION WERE DETERMINED EITHER FROM  
ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE  
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JA 01 15

.01

LABOR STANDARD HISTORY

.000 .000 .000 0

0010  
0020  
0030  
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0032  
0899  
0900

PRIOR HISTORY ON OO-ALC 494 FORM  
24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPPWF1  
ELEMENTS <OLD STD> 3.14  
27DEC84 2 YR REVIEW W/OCC CHANGES > OLD STD < 3.05  
29JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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TECH S S W F PF A/R REV	SUB T K #R A FA SUPPORT OCC	DESCRIPTION	BASE HOURS	FPD TIME	STD HOURS	DLY PCT
STEP D L K C DC ELEMENT FACT	STORED	SUPPLEMENTAL				
RA503 S E JA EA 1 J 84154	.36 PERCENT ENGR 96.4	REPAIR AXLE C141 NLG	405	2.12	.76	
0001 JA 01 00	.00	PART NUMBER/NSN		.000	.000	0
0010	3G61032-107	1620009272599				
0050 JA 01 15	.10	NICK & BURR		.331	.005	.038
0010 E	RRW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316
0020 E	RLG-RS-N4	1.00 NICK & BURR SMALL STRUT PART		.04595		.052
0040 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0060 JA 01 15	.20	RECENTER AXLE 2EA ENDS		1.200	.036	.276
0010 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574
0020 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2 OCC FOR 2 AXLE ENDS		.09095		.209
0030 N		1.00 S/U STEADY RESET		.13300		.152
0040 E	RLA-HM-T2	1.00 INSTALL & ADJUST TOOL KDK BAR		.02972		.034
0050 E	RLA-RC-GA	1.00 RECESS 3-3.5 DIA. 1/8 DP G1 RECENTER		.04385		.050
0060 E	GOH-MH-01	1.00 TURN OBJECT OVER USING HOISTTURN AXLE 180 DEG BY HAND		.00445		.005
0070 E	RLA-HP-C3	1.00 CHUCK SYMET PART IN 4 JAW		.09095		.104
0080 N		1.00 S/U STEADY REST		.13300		.152
0090 E	RLA-HM-T2	1.00 INSTALL & ADJUST TOOL KDK BAR		.02972		.034
0100 E	RLA-RC-GA	1.00 RECESS 3-3.5 DIA. 1/8 DP G1 RECENTER		.04385		.050
0120 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0065 JA 01 15	.05	CHASE THREADS I.D. 2EA ENDS		1.197	.009	.069
0010 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574
0020 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2 OCC FOR 2 AXLE ENDS		.09095		.209
0030 N		1.00 S/U STEADY REST		.13300		.152
0040 E	RLA-HM-T2	1.00 INSTALL & ADJUST TOOL KDK BAR		.02972		.034
0050 E	GIG-RH-C3	1.00 CHASE THRDS W/TAP,HSNG LARGECHASE THREADS ON LATHE		.04263		.049
0060 E	GOH-MH-01	1.00 TURN OBJECT OVER USING HOISTTURN AXLE 180 DEG BY HAND		.00445		.005
0070 E	RLA-HP-C3	1.00 CHUCK SYMET PART IN 4 JAW		.09095		.104
0080 N		1.00 S/U STEADY REST		.13300		.152
0090 E	RLA-HM-T2	1.00 INSTALL & ADJUST TOOL KDK BAR		.02972		.034
0100 E	GIG-RH-C3	1.00 CHASE THRDS W/TAP,HSNG LARGECHASE THREADS ON LATHE		.04263		.049
0120 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0070 JA 01 15	.40	O/S CROSS BOLT LUGS		1.293	.078	.595
0010 E	RHL-SU-V1	1.00 S/U VERT MILL BORE SMAL FXTR		.75732		.870
0020 E	RHL-AL-CA	1.00 ALIGN HORIZ AXIS MAG BASE		.05917		.068
0030 E	RHL-AL-CB	1.00 ALIGN VERTICAL AXIS MAG BASE		.12351		.142
0040 E	RHL-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS		.07261		.083
0050 E	RHL-BD-AA	1.00 BORE HOLE 1 X 1/2 GROUP 4		.27100		.311
0070 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0349 JA 01 15	1.00	BUSH CROSS BOLT LUGS		.673	.101	.775
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962		.574
0004 E	RLA-HP-C3	1.00 CHUCK SYMET PART IN 4 JAW		.09095		.104
0008 E	KML-TB-CC	1.00 DIA .501-1.00 REM .033-.250		.07308		.084
0060 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0900		THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901		FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902		ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE				
0903		<				
JA 01 15	1.00	BUSH CROSS BOLT LUGS		.323	.049	.372
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18517		.212
0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023
0030 E	RBW-BU-C1	1.00 CHAMFER SET OF BUSHING BORES		.10435		.120
0040 E	RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D		.00333		.003
0060 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011

0900				THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT			
0901				FOR THIS OPERATION WERE DETERMINE:	DM		
0902				ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE			
0903				<			
9000	JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000 .000
0010				PRIOR HISTORY ON OO-ALC 494 FORM			
0020				24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPFWR1			
0030				ELEMENTS <OLD STD>	1.11		
0031				27DEC84 2 YR REVIEW W/OCC CHANGES > OLD STD < 1.12			
0032				30JULY95 CHANGED SUB OP TO MATCH 958 NO TIME CHANG			
0899				J.CALDWELL TECH MANEAA			
0900				HANEL CLINTON BENTLEY MRP II 7-3255			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
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SUB	TECH	TK	FR	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	DLY
STEP	D	L	K	C	DC	ELEMENT	FACT	HOURS	TIME	HOURS	PL
RA504	S	E	JA	EA	1	J 84154	.21 PERCENT ENGR 92.8	405	28.66		6.02
0001			JA	01	00		.00		.000	.000	.000
							8340783-10				
							8340783-30				
0030			JA	01	15		.05		.485	.004	.028
							REMOVE BUSHINGS				
							REPAIR OLEO TRUNNION				
							PART NUMBER/NSN				
							1620001947597				
							NSL				
							1.00 S/U FOR BENCH WORK GENERAL		.27525		.316
							1.00 BAKE LARGE PART		.11699		.134
							2.00 REM LRG BUSHING WITH PULLER 2EA BUSHINGS 4 OD X 4.5 LONG		.04169		.095
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0033			JA	01	15		.50		.143	.011	.082
							LOCALLY POL ID TRUN REM CORR				
							1.00		.13300		.152
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0035			JA	01	15		.50		.143	.011	.082
							LOCALLY POLISH TRUNNION END				
							1.00		.13300		.152
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0040			JA	01	15		1.00		.352	.053	.405
							NICK & BURR				
							1.00 S/U FOR BENCH WORK GENERAL		.27525		.316
							1.00 NICK & BURR MED STRUT PART		.06711		.077
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0045			JA	01	15		.50		1.664	.125	.957
							TRUNNION CENTER HOLE REWORK				
							1.00 S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921
							1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181
							1.00 ALIGN HORIZ AXIS ROD		.06265		.072
							1.00 ALIGN VERTICAL AXIS ROD		.12699		.146
							1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087
							1.00 BORE HOLE 4 X 6 GROUP 1		.42920		.493
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0050			JA	01	15		.50		1.664	.125	.957
							O/S END TRUN SOCKET <LEFT>				
							1.00 S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921
							1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181
							1.00 ALIGN HORIZ AXIS ROD		.06265		.072
							1.00 ALIGN VERTICAL AXIS ROD		.12699		.146
							1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087
							1.00 BORE HOLE 4 X 6 GROUP 1		.42920		.493
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0060			JA	01	15		.66		1.664	.165	1.263
							O/S END TRUN SOCKET <RIGHT>				
							1.00 S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921
							1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181
							1.00 ALIGN HORIZ AXIS ROD		.06265		.072
							1.00 ALIGN VERTICAL AXIS ROD		.12699		.146
							1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087
							1.00 BORE HOLE 4 X 6 GROUP 1		.42920		.493
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0070			JA	01	15		.33		.739	.037	.281
							O/S CROSS BOLT LUG <SMALL>				
							1.00 SET UP TO REBUSH BOSSES		.18517		.212
							6.00 REAM WITH LEMPCO REAMER 6 PASSES		.07337		.506
							1.00 CHAMFER SET OF BUSHING BORES		.10435		.120
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0075			JA	01	15		.33		.930	.046	.353
							ROLL BURNISH CROSS BOLT HOLE				
							2.00		.46000		1.058
							1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0080			JA	01	15		.17		.666	.017	.130
							O/S CROSS BOLT LUG <LARGE>				
							1.00 SET UP TO REBUSH BOSSES		.18517		.212

0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	6 PASSES	.07337		.421	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
JA 01	15	.17		ROLL BURNISH LG CRS BOLT HOL	.930	.024	.182	1
0010 N		2.00		ROLL BURNISH LRG CR BOLT HOL	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0090	JA 01	15	.05	O/S MOUNT FLANGE LUG <FWD>	.739	.006	.043	0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-R2	6.00	REAM WITH LEMPCO REAMER	6 PASSES	.07337		.506	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0095	JA 01	15	.05	ROLL BURNISH FWD MOUNTING	.930	.007	.053	0
0010 N		2.00		BURNISH MTN FLANGES BOLT HOL	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0100	JA 01	15	.05	O/S MOUNT FLANGE LUG <AFT>	.739	.006	.043	0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-R2	6.00	REAM WITH LEMPCO REAMER	6 PASSES	.07337		.506	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0105	JA 01	15	.05	ROLL BURNISH AFT MOUNTING FL	.930	.007	.053	0
0010 N		2.00		BURNISH AFT FLANGE BOLT HOLE	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0110	JA 01	15	.05	O/S AFT DOOR LEVER LUG<RIGHT	.666	.005	.038	0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
115	JA 01	15	.05	ROLL BURNISH AFT DOOR LEVER	.930	.007	.053	0
0010 N		2.00		BURNISH RS AFT DOOR LUG HOLE	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0120	JA 01	15	.05	O/S AFT DOOR LEVER LUG	.666	.005	.038	0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0125	JA 01	15	.05	ROLL BURNISH LS AFT DOOR LEV	.936	.007	.054	0
0010 N		2.00		BURNISH LS AFT DOOR LUG HOLE	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0135	JA 01	15	.05	ROLL BURNISH FWD DOOR LEVER	.13000		.007	
0130	JA 01	15	.05	O/S FWD DOOR LEVER LUG<RIGHT	.666	.005	.038	0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0135	JA 01	15	.05	ROLL BURNISH FWD DOOR LEVER	.930	.007	.053	0
0010 N		2.00		BURNISH FWD RT S DR LEV LUG	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0140	JA 01	15	.05	O/S FWD DOOR LEVER LUG<LEFT>	.666	.005	.038	0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212	
0020 E	RBW-BU-R2	5.00	REAM WITH LEMPCO REAMER	5 PASSES	.07337		.421	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
145	JA 01	15	.05	ROLL BURNISH FWD DOOR LEVER	.930	.007	.053	0
0010 N		2.00		BURNISH FWD DR LF S LEV LUG	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
145	JA 01	15	.05	O/S ACTUATOR LUGS	1.425	.011	.082	0
0010 E	RML-SU-V2	1.00		S/U LUCUS MILL	.80167		.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	



0050 E	RML-BA-AA	2.00	BORE HOLE 1 X 1/2 GROUP 1	2EA LUGS	.17936		.412	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00	ROLL BURNISH ACTUATOR LUG	.930	.140	1.070	4
J010 N			2.00	ROLL BURNISH ACTUATOR LUG HO	.46000		1.058	
0020 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0160	JA 01	15	.33	O/S ATTACH LUG FOR F/SPRAY	1.895	.094	.719	3
0010 E	RML-SU-V2	1.00		S/U LUCUS MILL	.80167		.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 HOLE	.55232		.952	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0170	JA 01	15	.17	O/S ATTACH LUG FOR BUSHINGS	1.895	.048	.371	1
0010 E	RML-SU-V2	1.00		S/U LUCUS MILL	.80167		.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 HOLE	.55232		.952	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0250	JA 01	15	.33	MACH CENTER ATT LUG F/SPRAY	1.895	.094	.719	3
0010 E	RML-SU-V2	1.00	S/U VERT MILL BORE LRG FIXTRS/U LUCUS MILL		.80167		.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 FLAME SPRAY	.55232		.952	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0273	JA 01	15	.17	MACH BUSH CENTER ATTACH LUG	.825	.021	.161	1
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0002 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0004 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250		.09193		.105	
0005 E	KML-TA-JD	5.00	DIA 6.0 REM .250 ADD INCH	OCC FOR 5 ADD. INCHES	.02665		.153	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0275	JA 01	15	.17	INSTALL BUSH CENTR ATTCH LUG	.217	.006	.342	0
0003 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0008 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0276	JA 01	15	.17	FINISH MACH CENTER BUSHING	1.895	.048	.371	1
0010 E	RML-SU-V2	1.00	S/U VERT MILL BORE LRG FIXTR		.80167		.921	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050 E	RML-BA-LM	1.50	BORE HOLE 6 X 6 GROUP 1	OCC FOR 6.5 X 9 BUSHING	.55232		.952	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0279	JA 01	15	1.00	MACH BUSH END TRUN SOCKET RT	1.092	.164	1.257	4
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0002 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW		.09095		.209	
0004 E	KML-TB-GC	1.00	DIA .501-1.00 REM .501-1.00		.13163		.151	
0005 E	KML-TB-GD	5.00	DIA 4.0 REM .250 ADD INCH	OCC FOR 5 ADD. INCHES	.05396		.310	
0120 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0280	JA 01	15	1.00	INSTALL BUSH END TRUN SOC RT	.217	.033	.250	1
0005 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0008 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0120 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0285	JA 01	15	1.00	FINISH BUSH ID END TRUN SOCK	.288	.043	.332	1
0010 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0120 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0289	JA 01	15	1.00	MACH BUSH END TRUN SOCKET LF	1.092	.164	1.257	4
0001 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0002 E	RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW		.09095		.209	

0004 E	KML-TB-GC	1.00 DIA .501-1.00 REM .501-1.00	.13163	.151	
0005 E	KML-TB-GD	5.00 DIA 4.0 REM .250 ADD INCH OCC FOR 5 ADD. INCHES	.05396	.310	
0120 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0290	JA 01 15	1.00 INSTAL BUSH END TRUN SOCK LF	.217	.033	.250 1
0005 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18669	.214	
0008 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0120 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0295	JA 01 15	1.00 FINISH BUSH ID E TRUN SOC LF	.376	.056	.433 2
0010 E	RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	.27525	.316	
0015 E	KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1	.04377	.100	
0020 E	RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D	.00333	.003	
0120 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0298	JA 01 15	1.00 MACH BUSH CROSS BOLT LUG 2SM	.825	.124	.949 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-BC	2.00 DIA .251-.500 REM .033-.250 2EA BUSHINGS	.06699	.154	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0300	JA 01 15	1.00 INSTAL BUSH CROSS BOLT LUG S	.948	.142	1.091 4
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18517	.212	
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	.22231	.255	
0030 E	RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES	.10435	.240	
0040 E	KTL-RM-B2	5.00 REAM BUSHING W ADJUST LEMPCO	.06442	.370	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0305	JA 01 15	1.00 MACH BUSH CROSS BOLT LUG LRG	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 L	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0310	JA 01 15	1.00 INSTAL BUSH CROSS BOLT LUG L	.755	.113	.868 3
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18517	.212	
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	.22231	.255	
0030 E	RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES	.10435	.240	
0040 E	KTL-RM-B2	2.00 REAM BUSHING W ADJUST LEMPCO	.06442	.148	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0315	JA 01 15	1.00 MACH BUSH MOUNT FLANGE FWLUG	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0320	JA 01 15	1.00 INSTAL BUSH MONT FLGE LUG FW	.290	.044	.335 1
0001 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18669	.214	
0002 E	KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1	.04377	.100	
0004 E	RBW-BU-P1	2.00 BUTTERFLY POLISH BUSHING I D	.00333	.007	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0325	JA 01 15	1.00 MACH BUSH MNT FLGE LUG AFT	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0330	JA 01 15	1.00 INSTAL BUSH MNT FLGE LUG AFT	.713	.107	.821 3
0010 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES	.18517	.212	
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	.22231	.255	
0030 E	RBW-BU-C1	2.00 CHAMFER SET OF BUSHING BORES	.10435	.240	
0040 E	KML-RE-MB	2.00 REAM HOLE 1/2-1 5/8 DIA 1	.04377	.100	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0335	JA 01 15	1.00 MACH BUSH AFT DOR LEVER LUG	.837	.126	.963 3
0002 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE	.49962	.574	
0004 E	RLA-HP-C3	2.00 CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095	.209	
0008 E	KML-TB-CC	2.00 DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308	.168	
0050 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	

0340	JA 01	15	1.00	INSTAL BUSH AFT DOR LEVR LUG	.720	.108	.828	3
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517		.212	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255	
0030 E		RBW-BU-C1	2.00	CHAMFER SET OF BUSHING BORES	.10435		.240	
0040 E		KML-RE-MB	2.00	REAM HOLE 1/2-1 5/8 DIA 1	.04377		.100	
0045 E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333		.007	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0345	JA 01	15	1.00	MACH AFT DOOR LEVER LUG BUSH	.837	.126	.963	3
0002 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574	
0004 E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095		.209	
0008 E		KML-TB-CC	2.00	DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308		.168	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0350	JA 01	15	1.00	INSTAL BUSH AFT DOR LEVR LUG	.720	.108	.828	3
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517		.212	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255	
0030 E		RBW-BU-C1	2.00	CHAMFER SET OF BUSHING BORES	.10435		.240	
0040 E		KML-RE-MB	2.00	REAM HOLE 1/2-1 5/8 DIA 1	.04377		.100	
0045 E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333		.007	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0355	JA 01	15	1.00	MACH FWD DOOR LEVER LUG BUSH	.837	.126	.963	3
0002 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574	
0004 E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095		.209	
0008 E		KML-TB-CC	2.00	DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308		.168	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0360	JA 01	15	1.00	INSTAL BUSH FWD DOR LEVR LUG	.761	.114	.876	3
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517		.212	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255	
0030 E		RBW-BU-C1	2.00	CHAMFER SET OF BUSHING BORES	.10435		.240	
0040 E		KTL-RH-R2	2.00	REAM BUSHING W ADJUST LEMPCD	.06442		.148	
0045 E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333		.007	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0365	JA 01	15	1.00	MACH BUSH FWD DOOR LEVER LUG	.837	.126	.963	3
0002 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574	
0004 E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095		.209	
0008 E		KML-TB-CC	2.00	DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308		.168	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0370	JA 01	15	1.00	INSTAL BUSH FWD DOR LEVR LUG	.632	.095	.728	3
0010 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18517		.212	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255	
0030 E		RBW-BU-C1	2.00	CHAMFER SET OF BUSHING BORES	.10435		.240	
0040 E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333		.007	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0375	JA 01	15	1.00	MACH BUSH ACTUATOR LUGS	.825	.124	.949	3
0001 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM	.49962		.574	
0002 E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 2EA BUSHINGS	.09095		.209	
0004 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.06699		.154	
0070 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0380	JA 01	15	1.00	INSTALL BUSH ACTUATOR LUGS	.254	.038	.293	1
0001 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669		.214	
0005 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	.05133		.059	
0010 E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333		.007	
0070 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0390	JA 01	15	1.00	REIDENTIFY	.665	.100	.766	3
0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
0020 E		KID-MS-01	1.00	METAL STAMP 1ST DIGIT	.00326		.003	
0025 E		AID-SM-01	12.00	METAL STAMP MOD PLATE	.03145		.424	
0030 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				PRIOR HISTORY ON 00-ALC 494 FORM				
0020				24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWR1				

0030  
0031  
032  
0899  
0900

ELEMENTS <OLD STD> 30.59  
27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 22.52  
30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PSD NROP NR  
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPRA

01/29/88  
452-59-3

A-E046B-MM1-DY-M45 PAGE 0001

74521A STRUT ASSY C-141 NLG

SUB	TECH	STEP	DL	TK	FR	KA	FA	SUPPORT	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT
RA510	S	E	JA	EA	1	J	84154	.29	PERCENT ENGR 99.9	REPAIR LOWER BEARING	405	2.03	.59	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
									3661226-101	1620001257860				
									115689A					
0030			JA	01	15			.13		MACH TO REMOVE FLAME SPRAY	1.489	.029	.223	11
0005	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0010	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0020	E					RLA-HM-T1		1.00	CHANGE TOOL QUICK CHANGE HLD		.00379		.004	
0030	E					RLA-HM-T2		1.00	INSTALL & ADJST TOOL KDK BAR		.02972		.034	
0040	E					RLA-HM-F1		1.00	CHANGE FEED		.00326		.003	
0050	E					RLA-BO-LA		1.00	BORE HOLE 5 - 5 1/2 DIA 1 DPBORE I.D.		.24214		.278	
0060	E					RLA-BO-LB		5.00	BORE HOLE 5-5.5 DIA. ADD IN OVER 5 INCHES LONG		.12191		.700	
0080	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15			.38		MACH TO CLEANUP I.D.	1.001	.057	.438	21
0010	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030	E					RLA-HM-T1		1.00	CHANGE TOOL QUICK CHANGE HLD		.00379		.004	
0040	E					RLA-HM-T2		1.00	INSTALL & ADJST TOOL KDK BAR		.02972		.034	
0050	E					RLA-HM-F1		1.00	CHANGE FEED		.00326		.003	
0060	E					RLA-BO-LA		1.00	BORE HOLE 5 - 5 1/2 DIA 1 DP		.24214		.278	
0070	E					RLA-BO-LB		1.00	BORE HOLE 5-5.5 DIA. ADD IN		.12191		.140	
0090	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
J			JA	01	15			1.00		MACH AFTER FLAME SPRAY	1.197	.180	1.378	68
0010	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030	E					RLA-HM-T1		1.00	CHANGE TOOL QUICK CHANGE HLD		.00379		.004	
0040	E					RLA-HM-T2		1.00	INSTALL & ADJST TOOL KDK BAR		.02972		.034	
0050	E					RLA-HM-F1		1.00	CHANGE FEED		.00326		.003	
0060	E					RLA-BO-LA		1.00	BORE HOLE 5 - 5 1/2 DIA 1 DP		.24214		.278	
0070	E					RLA-BO-LB		1.00	BORE HOLE 5-5.5 DIA. ADD IN		.12191		.140	
0080	E					RBW-LU-01		1.00	LUBRICATE BEARING LUG ASSY		.19646		.225	
0100	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0900									THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT FOR THIS OPERATION WERE DETERMINED EITHER FROM ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE					
0901														
0902														
0903														
9000			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									PRIOR HISTORY ON 00-ALC 494 FORM					
0020									24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL R.J.P.P.W.F.1 ELEMENTS <OLD STD> .40					
0030														
0031									27DEC84 2 YR REVIEW W/OCC CHANGE < OLD STD > .43					
0032									29JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG					
0899									J.CALDWELL TECH MANEAA					
0900									MANUEL CLINTON BENTLEY MRP II 7-3255					

PROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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or	TECH	S	S	W	F	PF	A/R	REV	SUB	T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	ACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C						
RA511	S	E	JA	EA	1	J	84154	.%	PERCENT ENGR 99.9	REPAIR STEERING COLLAR	405	2.26		2.17							
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0							
0010								3661092-111	1620009294672												
0045			JA	01	15		.05		EXTERNAL DEFECT REMOVAL	.331	.002	.019		1							
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316									
0020	E					RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART		.04595		.052									
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.011									
0050			JA	01	15		.05		O/S TORQUE ARM LUG	1.918	.014	.110		5							
0020	E					RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR		.75732		.870									
0030	E					RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP		.18155		.208									
0040	E					RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068									
0050	E					RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142									
0060	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083									
0070	E					RML-BO-BB	2.00	BORE HOLE 1.5 X 1 GROUP 4 2 HOLES		.35729		.821									
0090	E					RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.011									
0320			JA	01	15		1.00		MACHINE BUSHING	.691	.104	.795		35							
0002	E					RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574									
0004	E					RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS		.09095		.209									
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.011									
0900								THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT FOR THIS OPERATION WERE DETERMINED EITHER FROM ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE													
0901								<													
0902																					
0903																					
0325			JA	01	15		1.00		INSTALL & REAM BUSHING	1.165	.175	1.340		59							
0006	E					RSG-JP-T1	1.00	JOB PREP GENERAL FOR S & H		.22079		.253									
0008	E					KML-TB-DC	2.00	DIA 1.00-1.50 REM .033-.250 2EA BUSHINGS		.08429		.193									
0010	E					RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18517		.212									
0020	E					RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES OCC FOR 2EA MEN		.23835		.548									
0030	E					RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES		.10435		.120									
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.011									
0900								THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT FOR THIS OPERATION WERE DETERMINED EITHER FROM ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE													
0901								<													
0902																					
0903																					
9000			JA	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0							
0010								PRIOR HISTORY ON OO-MLC 494 FORM													
0020								24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1 ELEMENTS <OLD STD> 1.85													
0030								27DEC84 2 YR REVIEW W/OCC CHANGE < OLD STD > 2.12													
0031								29JULY85 CHANGED SUB OP TO MATCH 953 NO TIME CHANG													
0032								J.CALDWELL TECH MANEAM													
0899								MANEL CLINTON BENTLEY MRP II 7-3255													
0900																					

INTERROGATE LABOR STANDARDS, INPUT

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

4S2-59-3

STEP	TECH S S	W F PF A/R REV	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
0001	JA 01	00	PERCENT ENGR 91.9	2.78	.000	2.67	0
0010			REPAIR STEERING PLATE				
0040	JA 01	15	3661027-101 1620000110320	1.819	.014	.105	4
0010 E		RML-SU-V1	S/U VERT MILL BORE SMAL FXTRS/U JIG BORE SMALL FIXTURE	.75732		.870	
0020 E		RML-AL-CA	ALIGN HORIZ AXIS MAG BASE 2 HOLES	.05917		.136	
0030 E		RML-AL-CB	ALIGN VERTICAL AXIS MAG BASE2 HOLES	.12351		.284	
0040 E		RML-AL-CC	ALIGN HOLE TO SPINDLE MAG BS2 HOLES	.07261		.167	
0045 E		RML-RD-AA	BORE HOLE 1 X 1/2 GROUP 4 2 HOLES	.27100		.623	
0060 E		RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0050	JA 01	15	MACH KEYSLOTS	1.570	.184	1.409	51
0010 E		RML-SU-V1	S/U VERT MILL BORE SMAL FXTR	.75732		.870	
0020 E		RML-AL-CA	ALIGN HORIZ AXIS MAG BASE	.05917		.068	
0030 E		RML-AL-CB	ALIGN VERTICAL AXIS MAG BASE	.12351		.568	
0040 N			MACHINE SLOT	.25000		.287	
0060 E		RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0170	JA 01	15	MACHINE ATTACH HOLE BUSHINGS	1.058	.111	.852	31
0002 E		RLA-SU-S3	SET UP SMALL MEDIUM LATHE	.49962		.574	
0004 E		RLA-HP-C3	CHUCK SYMET PART IN 4 JAW 2EA BUSHINGS	.09095		.209	
0006 E		RSG-JP-T1	JOB PREP GENERAL FOR S & M	.22079		.253	
0008 E		KML-TB-CC	DIA .501-1.00 REM .033-.250 2EA BUSHINGS	.07308		.168	
0060 E		RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0900			THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT				
0901			FOR THIS OPERATION WERE DETERMINED EITHER FROM				
0902			ACTUAL COUNT OR FROM REFERENCE TO T.O, SHOWN ABOVE				
0903			>				
0175	JA 01	15	BUSH ATTACH LUG HOLES	.521	.055	.420	15
0010 E		RBW-BU-S1	SET UP TO REBUSH BOSSES	.18517		.212	
0020 E		RBW-BU-B2	REBUSH A SET OF 2 BOSSES	.22231		.255	
0030 E		RBW-BU-C1	CHAMFER SET OF BUSHING BORES	.10435		.120	
0060 E		RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000	JA 01	15	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			PRIOR HISTORY ON OO-ALC 494 FORM				
0020			24JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1				
0030			ELEMENTS <OLD STD> 2.48				
0031			27DEC84 2 YR REVIEW W/OCC CHANGE < OLD STD > 3.25				
0899			J.CALDWELL TECH MANEAA				
0900			MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

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74521A STRUT ASSY C-141 NLG

RCC MNPRA

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SUB	STEP	D	L	K	C	DC	ELEMENT	OCC	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A	
																			EA
0001	JA	01	15					1.00			PART NUMBER/NSN		.000	.000	.000				
0010									7530983-01		1620010397401LE								
0030	JA	01	15					1.00			MACH FILLER TUBE FOR STD SIZ		.573	.086	.659				84
0010	E						RLA-SU-S3	1.00			SET UP SMALL MEDIUM LATHE		.49962		.574				
0020	E						RLA-TD-DC	1.00			REMOVE .033 -.250 DIA OVER 1		.06341		.072				
0030	E						RJP-PW-R1	1.00			REM RPL PAPWRK SIGN OFF DOC		.01001		.011				
0040	JA	01	15					1.00			BRUSH CAD PLATE		.105	.016	.121				16
0020	E						RLG-RS-B1	1.00			BRUSH PLATE SPOT OR HOLE		.09546		.109				
0030	E						RJP-PW-R1	1.00			REM RPL PAPWRK SIGN OFF DOC		.01001		.011				
9000	JA	01	00					.01			LABOR STANDARD HISTORY		.000	.000	.000				0
0900											HANEL CLINTON BENTLEY MRP II 7-3255								

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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74521A		STRUT ASSY C-141 NLG				RCC MNRA		01/29/88		A-E046B-MM1-DY-M45		PAGE 0001		
JRCL	TECH	S	S	W	F	PF	A/R	REV						
SUB	T	K	#R	A	FA	SUPPORT	OCC	<-----	DESCRIPTION	----->	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS	DLY PCT C
RA524	S	E	JA	EA	1	J	87342	1.00	PERCENT ENGR 99.9	CHECK CONCENTRICITY	.33		.33	
0001			JA	01	00		.01		PART NUMBER/MSN		.000	.000	.000	0
								3G61091-103	162008676271					
0045			JA	01	15		1.00				.293	.044	.337	100
											.27525		.316	
											.00789		.009	
											.01001		.011	
9000			JA	01	00		1.00			LABOR STANDARD HISTORY	.000	.000	.000	0
0900										MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

01/29/88

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74521A STRUT ASSY C-141 MLG

RCC MNRB

452-59-3

TECH S S		W F PF A/R REV		SUB T K #R A FA SUPPORT		OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT C
R2501	S E	JA EA 3	J 84154	.75	PERCENT ENGR 99.9		405	15.77		11.83	
0001		JA 01	00	.00		OUTER CYL C141 MLG PART NUMBER/NSN		.000	.000	.000	0
					3G61090-119	1620004419763					
0110		JA 01	15	.39		1ST GR TRUN JR/CHROME		2.291	.134	1.028	7
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938		1.218	
0020	E		RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157	
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0040	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0050	E		RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON			.00685		.007	
0060	E		RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER			.08334		.095	
0070	E		RGR-GE-S2	54.00	GR STEEL OD (OCC FACT L X D)9 IN. LONG 6 IN. DIA.			.01093		.678	
0080	E		RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD)6 IN. DIA.			.01014		.069	
0090	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12			.09717		.111	
0110	E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0120		JA 01	15	.06		1ST GR TRUN JR/F-SPRAY		2.153	.019	.149	1
0010	E		RGR-SU-G1	.87	SET UP A GAP GRINDER	13 % OCC OCCURED IN 1ST GR		1.05938		1.059	
0011					FOR CHROME S/U						
0020	E		RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157	
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0040	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0050	E		RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON			.00685		.007	
0060	E		RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER			.08334		.095	
0070	E		RGR-GE-S2	54.00	GR STEEL OD (OCC FACT L X D)9 IN. LONG 6 IN. DIA.			.01093		.678	
0080	E		RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD)6 IN DIA			.01014		.069	
0090	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12			.09717		.111	
0110	E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0130		JA 01	15	.33		1ST GR COLLAR JR/CHROME		2.029	.100	.770	5
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938		1.218	
0020	E		RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157	
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0040	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0050	E		RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON			.00685		.007	
0060	E		RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER			.08334		.095	
0070	E		RGR-GE-S2	30.00	GR STEEL OD (OCC FACT L X D)5 IN LONG 6 IN DIA.			.01093		.377	
0080	E		RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD)6 IN DIA.			.01014		.069	
0090	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12			.09717		.111	
0110	E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0140		JA 01	15	.33		1ST GR COLLAR JR/SPRAY		2.029	.100	.770	5
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938		1.218	
0020	E		RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157	
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0040	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0050	E		RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON			.00685		.007	
0060	E		RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER			.08334		.095	
0070	E		RGR-GE-S2	30.00	GR STEEL OD (OCC FACT L X D)5 IN. LONG 6 IN DIA.			.01093		.377	
0080	E		RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD)6 IN DIA.			.01014		.069	
0090	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12			.09717		.111	
0110	E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
0150		JA 01	15	.44		1ST GRIND UPPER BORE		5.494	.363	2.780	18
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER		1.05938		1.218	
0020	E		RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT LOAD/UNLOAD PART MOIST			.36081		.414	
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0040	E		KMG-DW-ID	1.00	DRESS INTERNAL WHEEL			.02458		.028	

0050 E	KMG-ID-LE	6.00	GRIND OUT .010 5 ID X 3	OCC FOR AREA 18 INCHES LONG	.60998		4.208	
0060 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INTERNAL GRIND	.02632		.030	
0070 E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0080 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	INT GRINDER TURN OFF & ON	.00685		.007	
0090 E	RTL-MM-S1	1.00	SET UP INSIDE MICROMETER		.01920		.022	
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0160	JA 01	15	.33	1ST GRIND LOWER BORE	3.477	.172	1.320	8
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER	1.05938		1.218	
0020 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	LOAD/UNLOAD PART/HOIST	.36081		.414	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	KMG-ID-ID	1.00	DRESS INTERNAL WHEEL		.02458		.028	
0050 E	KMG-ID-NE	2.30	GRIND OUT .010 6.0 ID X 3.0	OCC FOR AREA 7 IN. LONG	.71847		1.900	
0060 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INT. GRINDER	.02632		.030	
0070 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0080 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF & ON INT. GRINDER	.00685		.007	
0090 E	RTL-MM-S1	1.00	SET UP INSIDE MICROMETER		.01920		.022	
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0470	JA 01	15	.06	2ND GR TRUN JR/F-SPRAY	2.291	.021	.158	1
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON		.00685		.007	
0060 E	RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070 E	RGR-GE-S2	54.00	GR STEEL OD (OCC FACT L X D) 9 X 6		.01093		.678	
0080 E	RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6 DIA		.01014		.069	
0090 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0470	JA 01	15	.33	2ND GR COLLAR JR/F-SPRAY	2.029	.100	.770	5
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON		.00685		.007	
0060 E	RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070 E	RGR-GE-S2	30.00	GR STEEL OD (OCC FACT L X D) 5 X 6	GRIND FLAME SPRAY	.01093		.377	
0080 E	RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6IN DIA	FLAME SPRAY	.01014		.069	
0090 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0490	JA 01	15	.39	2ND GR TRUN JR/CHROME	2.883	.169	1.293	8
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON		.00685		.007	
0060 E	RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070 E	RGR-GE-C2	54.00	GR CHROM OD (OCC FACT L X D) 9 X 6		.02189		1.359	
0080 E	RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6IN DIA		.01014		.069	
0090 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0500	JA 01	15	.39	2ND GR COLLAR JR/CHROME	2.358	.138	1.058	7
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON		.00685		.007	
0060 E	RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070 E	RGR-GE-C2	30.00	GR CHROM OD (OCC FACT L X D) 5 X 6		.02189		.755	
0080 E	RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD) 6IN DIA		.01014		.069	
0090 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	

0110 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0530	JA 01 15	.44		GRIND CHROME UPPER BORE	8.777	.579	4.441	28
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER	1.05938		1.218	
0020 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	LOAD/UNLOAD PART/HOIST	.36081		.414	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INT.GRINDER	.02632		.030	
0050 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF & ON INT.GRINDER	.00685		.007	
0060 E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL		.02458		.028	
0070 E	KMG-ID-LK	6.00	GRIND OUT .040 5 ID X 3	OCC FOR AREA 18 IN.LONG	1.15712		7.984	
0080 E	RTL-MM-S1	1.00	SET UP INSIDE MICROMETER		.01920		.022	
0090 E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0110 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0530	JA 01 15	.24		GRIND CHROME LOWER BORE	4.486	.162	1.238	8
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER	1.05938		1.218	
0020 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	LOAD/UNLOAD PART/HOIST	.36081		.414	
0030 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL		.02458		.028	
0060 E	KMG-ID-LK	2.30	GRIND OUT .040 5 ID X 3	OCC FOR AREA 7IN.LONG	1.15712		3.060	
0070 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0080 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	TURN OFF & ON INT GRINDER	.00685		.007	
0090 E	RTL-MM-S1	1.00	SET UP INSIDE MICROMETER		.01920		.022	
0110 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0900			THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT					
0901			FOR THIS OPERATION WERE DETERMINED EITHER FROM					
0902			ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE					
0903			<					
0000	JA 01 15	.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010			PRIOR HISTORY ON 00-ALC 494 FORM					
0020			27JUN83 NEW OCC. FACTOR STUDY & REMOVE ALL RJPWF1					
0030			ELEMENTS <OLD STD> 6.92					
0031			27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 8.69					
0032			30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG					
085			J.CALIWELL TECH MANEAA					
0900			MANEL CLINTON BENTLEY MRP II 7-3255					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
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74521A STRUT ASSY C-141 NLG

RCC MNFRB

4S2-59-3

TECH S S W F PF A/R REV

SUB	TK	RA	FA	SUPPORT	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY PCT		
STEP	D	L	K	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL				
RB502	S	N	JA	EA	3	J 84194	.50 PERCENT ENGR 79.1	GRIND INNER CYL C141 NLG 407	5.03		2.51	
0001			JA	01	00		.00	PART NUMBER/NSM	.000	.000	.000	0
0110			JA	01	15		.35	3G61089-111 1620004983226 1ST GRIND CYL. O.D.	3.076	.162	1.238	25
0010	E					RGR-SU-G1	1.00	SET UP A GAP GRINDER	1.05938		1.218	
0015	E					RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
0020	E					RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK	.22097		.254	
0030	E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0040	E					RGR-HM-H1	1.00	ADJUST HEADSTOCK GAP GRINDER	.08590		.098	
0050	E					RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	.00685		.007	
0060	E					RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER	.08334		.095	
0070	E					RGR-GE-S2	97.50	GR STEEL OD (OCC FACT L X D)19.5 X 5. IN DIA.	.01093		1.225	
0080	E					RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5. IN DIA.	.01014		.058	
0090	E					RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0110	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
0120			JA	01	15		.05	1ST GRIND UPPER END O.D.	2.041	.015	.117	2
0010	E					RGR-SU-G1	1.00	SET UP A GAP GRINDER	1.05938		1.218	
0015	E					RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
0020	E					RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK	.22097		.254	
0030	E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0040	E					RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	.00685		.007	
0050	E					RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER	.08334		.095	
0060	E					RGR-GE-S2	13.50	GR STEEL OD (OCC FACT L X D)3 X 4.5	.01093		.169	
0070	E					RGR-GE-D2	4.50	DWELL (GAP GRINDER STEEL OD)4.5 DIA	.01014		.052	
0080	E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0100	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
0125			JA	01	15		.17	HONE METERING PIN SEAL AREA	.566	.014	.111	2
0010	E					RBM-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
0020	E					RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
0030	E					ZPO-BP-C3	1.00	BUTTERFLY POLISH LRG CYL I.D	.21256		.244	
0040	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
0130			JA	01	15		.08	1ST GRIND SEAL AREA H/PIN ID	2.015	.024	.185	4
0010	E					RGR-SU-G1	1.00	SET UP A GAP GRINDER	1.05938		1.218	
0020	E					RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
0030	E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0040	E					KMG-DW-ID	2.00	DRESS INTERNAL WHEEL OCC FOR ROUGH & FINISH GRIND	.02458		.056	
0050	E					KMG-GM-LK	2.00	LOCATE WHEEL TO POSITION OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0060	E					KMG-ID-KC	1.00	GRIND OUT .010 ID X 1.5	.29382		.337	
0070	E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
0260			JA	01	15		.33	GRIND CHROME CYL O.D.	4.145	.205	1.573	31
0010	E					RGR-SU-G1	1.00	SET UP A GAP GRINDER	1.05938		1.218	
0015	E					RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	.36081		.414	
0020	E					RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK	.22097		.254	
0030	E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0040	E					RGR-HM-H1	1.00	ADJUST HEADSTOCK GAP GRINDER	.08590		.098	
0050	E					RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON	.00685		.007	
0060	E					RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER	.08334		.095	
0070	E					RGR-GE-C2	97.50	GR CHROM OD (OCC FACT L X D)19.5 X 5 INCH DIA	.02189		2.454	
0080	E					RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5. IN. DIA.	.01014		.058	
0090	E					RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0110	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
0270			JA	01	15		.05	GRIND CHROME UPPER END O.D	2.235	.017	.129	3

0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0015 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414	
0020 E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0030 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E	RGR-HM-S3	1.00	GAP GRINDER TURN OFF & ON		.00685		.007	
0050 E	RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0060 E	RGR-GE-C2	13.50	GR CHROM OD (OCC FACT L X D) 3 X 4.5		.02189		.339	
0070 E	RGR-GE-D3	4.50	DWELL (GAP GRINDER CHROM OD) 4.5 DIA		.02029		.105	
0080 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0100 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011	
0280	JA 01	15	.08	GRIND CHROME SEAL AREA M/PIN	2.320	.028	.214	4
				S/U INTERNAL GRINDER				
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E	RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT	LOAD EX LARGE PART INT GRIND	.36081		.414	
0030 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E	KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02458		.056	
0050 E	KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0060 E	KMG-ID-KH	1.00	GRIND OUT .040 4.5 ID X 1.5		.59881		.688	
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011	
0358	JA 01	15	.25	HONE AXLE ATT. LUG F/SPRAY	1.538	.058	.442	9
0010 E	RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HDS/U TO HONE		.42803		.492	
0020 N		1.00		HONE AXLE ATTACH LUG	1.10000		1.265	
0040 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011	
0430	JA 01	15	.58	HONE AXLE ATTACH LUG	1.538	.134	1.026	20
0010 E	RDR-SU-V1	1.00	S-U DR PRS W-VISE FIXT DV-HDS/U TO HONE		.42803		.492	
0020 N		1.00		HONE AXLE ATTACH LUG	1.10000		1.265	
0030 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011	
0900	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				PRIOR HISTORY ON 00-ALC 494 FORM				
0020				27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPWF1				
0030				ELEMENTS <OLD STD> 3.77				
0040				26JUL83 NEW SUB OP.0055-OCC. EST <OLD STD> 3.25				
0050				25JAN84 ADD SUB OP 0090-EST OCC- <OLD STD> 3.28				
0051				27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 3.47				
0052				30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG				
0899				J.CALDWELL TECH MANEAA				
0900				HANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

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74521A STRUT ASSY C-141 NLG

RCC XNPRB

4S2-59-3

TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL			C	
RR503	S E	JA EA	3	J	84154	.33 PERCENT ENGR 99.9	405	.03	1.33		
0001		JA 01	00			.00	PART NUMBER/NSN	.000	.000	.000	0
0010						3G61032-107	1620009272599				
0110		JA 01	15			.75	1ST GRIND CENTER JOURNAL	1.357	.153	1.171	29
0010 E				RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E				KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E				KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E				RGR-GE-S2	18.00	GR STEEL OD (OCC FACT L X D)1.5 X 4 X 3EA JOURNALS		.01093		.226	
0050 E				RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.046	
0060 E				RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0120		JA 01	15			.25	1ST GRIND LARGE JOURNALS	1.335	.050	.384	10
0010 E				RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E				KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E				KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E				RGR-GE-S2	16.00	GR STEEL OD (OCC FACT L X D)2 X 4 X 2EA JOURNALS		.01093		.201	
0050 E				RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.046	
0060 E				RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0140		JA 01	15			.13	1ST GRIND SMALL JOURNALS	1.292	.025	.193	5
0010 E				RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E				KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E				KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E				RGR-GE-S2	12.00	GR STEEL OD (OCC FACT L X D)1.5 X 4 X 2EA JOURNALS		.01093		.150	
0050 E				RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.046	
0060 E				RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0140		JA 01	15			.63	GR OD AREAS BETWEEN JOURNALS	.359	.034	.260	6
0010 E				RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E				GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILLS/U AIR GRINDER W/PAD/DISC		.00678		.007	
0030 E				RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077	
0050 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0260		JA 01	15			.75	CHROME GRIND CENTER JOURNALS	1.595	.180	1.376	34
0010 E				RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E				KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E				KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E				RGR-GE-C2	18.00	GR CHROM OD (OCC FACT L X D)1.5 X 4 X 3EA JOURNALS		.02189		.453	
0050 E				RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD		.02029		.093	
0060 E				RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0270		JA 01	15			.25	CHROME GRIND LARGE JOURNALS	1.511	.057	.434	11
0010 E				RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E				KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E				KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E				RGR-GE-C2	16.00	GR CHROM OD (OCC FACT L X D)2 X 4 X 2EA JOURNALS		.02189		.402	
0050 E				RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.046	
0060 E				RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	

0280	JA 01	15	.13	CHROME GRIND SMALL JOURNALS	1.464	.029	.219	5
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.945	
0015 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0020 E	XMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0030 E	XMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0040 E	RGR-GE-C2	12.00	GR CHROM OD (OCC FACT L X D)	1.5 X 4 X 2EA JOURNALS	.02189		.302	
0050 E	RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD)	DWELL CYL GRINDER OCC X OD	.02029		.093	
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0900			THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT					
0901			FOR THIS OPERATION WERE DETERMINED EITHER FROM					
0902			ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE					
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			PRIOR HISTORY ON 00-ALC 494 FORM					
0020			27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPPWF1					
0030			ELEMENTS <OLD STD> 1.17					
0031			27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.47					
0032			30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG					
0899			J.CALDWELL TECH MANEAA					
0900			HANEL CLINTON BENTLEY MRP II 7-3255					

TO INTERROGATE LABOR STANDARDS, INPUT

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TECH S S W F PF A/R REV		SUB T K #R A FA SUPPORT		OCC <----->		DESCRIPTION <----->		BASE	PFD	STD	A
STEP	D L	K C DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT C
RDS05	S E	JA EA 3	J 94154	.05	PERCENT ENGR 99.9	GRIND TRUNNION PIN 2EA 405	3.18		.15		
0001		JA 01	00	.00		PART NUMBER/NSN	.000	.000	.000		0
0010					3G61014-101	1620000271196					
0060		JA 01	15	.67		GRIND TRUNNION PIN LARGE O.D	.925	.093	.713		22
0010 E		RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472		
0020 E		RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030		
0030 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053		
0040 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155		
0050 E		RGR-GE-S2		16.00	GR STEEL OD (OCC FACT L X D)4 X 4		.01093		.201		
0060 E		RGR-GE-D2		4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.046		
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011		
0070		JA 01	15	.33		GRIND TRUNNION PIN SMALL O.D	.789	.039	.300		9
0010 E		RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472		
0020 E		RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030		
0030 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053		
0040 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155		
0050 E		RGR-GE-S2		5.00	GR STEEL OD (OCC FACT L X D)2 X 2.5		.01093		.062		
0060 E		RGR-GE-D2		2.50	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.029		
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5 PW 3G61014-101		.08102		.093		
0090 E		RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011		
5		JA 01	15	.33		GRIND TRUNNION PIN HOLES	1.369	.068	.520		16
0010 E		RGR-SU-J2		1.00	S-U JIG GRINDER LRG FIX-TBLE		.80167		.921		
0020 E		KMG-DW-ID		4.00	DRESS INTERNAL WHEEL	DRESS JIG GRINDER WHEEL OCCU	.02458		.113		
0021						ROUGH & FINISH GRIND 2EA HOLES					
0030 E		KMG-GW-LK		4.00	LOCATE WHEEL TO POSITION	OCC ROUGH & FINISH GRIND 2EA	.06761		.311		
0040 E		KMG-ID-AA		2.00	GRIND OUT .010-0.5 ID X 0.5 OCC FOR 2EA HOLES		.01367		.031		
0050 E		RGR-HM-C2		2.00	HANDLE & MEAS LENGTH 1 TO 5 OCC FOR 2EA HOLES		.08102		.186		
0070 E		RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011		
0160		JA 01	15	.75		CHROME GRIND PIN LARGE O.D.	1.141	.128	.984		31
0010 E		RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472		
0020 E		RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030		
0030 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053		
0040 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155		
0050 E		RGR-GE-C2		16.00	GR CHROM OD (OCC FACT L X D)4 X 4		.02189		.402		
0060 E		RGR-GE-D3		4.00	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD		.02029		.093		
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011		
0170		JA 01	15	.67		CHROME GRIND PIN SMALL O.D.	.869	.087	.670		21
0010 E		RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472		
0020 E		RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030		
0030 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053		
0040 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155		
0050 E		RGR-GE-C2		5.00	GR CHROM OD (OCC FACT L X D)2 X 2.5		.02189		.125		
0060 E		RGR-GE-D3		2.50	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD		.02029		.058		
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011		
7900					THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT						
0901					FOR THIS OPERATION WERE DETERMINED EITHER FROM						
0902					ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE						
9000		JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010					PRIOR HISTORY ON OO-ALC 494 FORM						
0020					27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPWF1						

0030  
0031  
0032  
0899  
0900

ELEMENTS <OLD STD> .23  
27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.07  
30JULY85 CHANGED SUE OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROP NR  
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SUB	TECH S S	T K	#R A	W F PF A/R REV	FA SUPPORT	OCC	DESCRIPTION		BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C		
							STEP D L	K C DC ELEMENT					FACT	STORED
RB508	S	E	JA	EA	J	J	84154	.05 PERCENT ENGR 99.9	GRIND TRUNNION PIN 2EA	405	3.18	.15		
0001			JA	01	00			.00	PART NUMBER/NSN		.000	.000	.000	0
									3G61039-101	1620007575889				
0060			JA	01	15			.67	GRIND TRUNNION PIN LARGE O.D		.925	.093	.713	22
0010	E					RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472	
0020	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0030	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040	E					KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050	E					RGR-GE-S2		16.00	GR STEEL OD (OCC FACT L X D)4 X 4		.01093		.201	
0060	E					RGR-GE-D2		4.00	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.046	
0070	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15			.33	GRIND TRUNNION PIN SMALL O.D		.789	.039	.300	9
0010	E					RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472	
0020	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0030	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040	E					KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050	E					RGR-GE-S2		5.00	GR STEEL OD (OCC FACT L X D)2 X 2.5		.01093		.062	
0060	E					RGR-GE-D2		2.50	DWELL (GAP GRINDER STEEL OD)DWELL CYL GRINDER OCC X OD		.01014		.029	
0070	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5 PN 3G61039-101		.08102		.093	
0090	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
35			JA	01	15			.33	GRIND TRUNNION PIN HOLES		1.369	.068	.520	16
0010	E					RGR-SU-J2		1.00	S-U JIG GRINDER LRG FIX-TBLE		.80167		.921	
0020	E					KMG-DW-ID		4.00	DRESS INTERNAL WHEEL	DRESS JIG GRINDER WHEEL OCCU	.02458		.113	
0021									ROUGH & FINISH GRIND 2EA HOLES					
0030	E					KMG-GW-LK		4.00	LOCATE WHEEL TO POSITION	OCC ROUGH & FINISH GRIND 2EA	.06761		.311	
0040	E					KMG-ID-AA		2.00	GRIND OUT .010-0.5 ID X 0.5	OCC FOR 2EA HOLES	.01367		.031	
0050	E					RGR-HM-C2		2.00	HANDLE & MEAS LENGTH 1 TO 5	OCC FOR 2EA HOLES	.08102		.186	
0070	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0160			JA	01	15			.75	CHROME GRIND PIN LARGE O.D.		1.141	.128	.984	31
0010	E					RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472	
0020	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0030	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040	E					KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050	E					RGR-GE-C2		16.00	GR CHROM OD (OCC FACT L X D)4 X 4		.02189		.402	
0060	E					RGR-GE-D3		4.00	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD		.02029		.093	
0070	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0170			JA	01	15			.67	CHROME GRIND PIN SMALL O.D.		.869	.087	.670	21
0010	E					RGR-SU-P1		.50	SET UP PLANETARY GRINDER	S/U SM/MED CYL GRINDER	.82175		.472	
0020	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER CYL GRINDER	.02632		.030	
0030	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND	.02308		.053	
0040	E					KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND	.06761		.155	
0050	E					RGR-GE-C2		5.00	GR CHROM OD (OCC FACT L X D)2 X 2.5		.02189		.125	
0060	E					RGR-GE-D3		2.50	DWELL (GAP GRINDER CHROM OD)DWELL CYL GRINDER OCC X OD		.02029		.058	
0070	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0900									THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT					
0901									FOR THIS OPERATION WERE DETERMINED EITHER FROM					
0902									ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE					
9000			JA	01	15			.01	LABOR STANDARD HISTORY		.000	.000	.000	0
0010									PRIOR HISTORY ON 00-ALC 494 FORM					
0020									27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPWF1					

0030  
0031  
0032  
0899  
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ELEMENTS <OLD STD> .23  
27DEC84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.07  
30JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG  
J.CALDWELL TECH MANEAA  
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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TECH S S	W F PF A/R REV												
SUB	T K	#R A	FA SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A				
STEP D L	K C DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C		
RB511	S E	JA EA 3	J 84154	.14	PERCENT ENGR 99.9	GRIND STEERING COLLAR	405	9.48		1.32			
0001		JA 01	00	.00		PART NUMBER/NSN		.000	.000	.000	0		
0010					3G61092-111	1620009294672							
0070		JA 01	15	.25		1ST GRIND COLLAR I.D.		1.908	.072	.549	6		
0010 E		RGR-SU-G1		1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER		1.05938		1.218			
0020 E		RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INTERNAL GRIND		.02632		.030			
0030 E		RGR-HM-S3		1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON INTERNAL GRINDER		.00685		.007			
0040 E		KMG-DW-ID		2.00	DRESS INTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND		.02458		.056			
0050 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND		.06761		.155			
0060 E		KMG-ID-ND		1.09	GRIND OUT .010 6.0 I X 2.0	OCC FOR 6.5 I.D.		.49631		.622			
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093			
0090 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011			
0080		JA 01	15	1.80		1ST GRIND FACES OCC 2EA		2.177	.588	4.507	48		
0010					FACES								
0020 E		RGR-SU-G1		1.00	SET UP A GAP GRINDER	S/U SURFACE GRINDER		1.05938		1.218			
0030 E		RGR-HM-S3		1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON SURFACE GRINDER		.00685		.007			
0040 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND		.02308		.053			
0050 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND		.06761		.155			
0060 E		KMG-OD-CH		8.00	GRIND .040 1 OD X 2	1 X 8 4 EA OCC		.09467		.870			
0070 E		RGR-GE-D2		8.00	DWELL (GAP GRINDER STEEL OD)	DWELL SURFACE GRINDER 8IN OD		.01014		.093			
0080 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093			
0100 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011			
0160		JA 01	15	.25		CHROME GRIND I.D.		2.465	.092	.709	7		
0010 E		RGR-SU-G1		1.00	SET UP A GAP GRINDER	S/U INTERNAL GRINDER		1.05938		1.218			
0020 E		RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER	ADJUST TAPER INTERNAL GRIND		.02632		.030			
0030 E		RGR-HM-S3		1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON INTERNAL GRINDER		.00685		.007			
0040 E		KMG-DW-ID		2.00	DRESS INTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND		.02458		.056			
0050 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND		.06761		.155			
0060 E		KMG-ID-NJ		1.09	GRIND OUT .040 6.0 ID X 2.0	OCC FOR 6.5 I.D.		1.00729		1.262			
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093			
0090 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011			
0170		JA 01	15	.80		CHROME GRIND COLLAR FACE 1EA		1.798	.216	1.655	17		
0005					2EA FACES								
0010 E		RGR-SU-G1		1.00	SET UP A GAP GRINDER	S/U SURFACE GRINDER		1.05938		1.218			
0020 E		RGR-HM-S3		1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON SURFACE GRINDER		.00685		.007			
0030 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND		.02308		.053			
0040 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND		.06761		.155			
0050 E		KMG-OD-CH		4.00	GRIND .040 1 OD X 2	1 X 8 4EA OCC.		.09467		.435			
0060 E		RGR-GE-D2		8.00	DWELL (GAP GRINDER STEEL OD)	DWELL SURFACE GRINDER 8IN OD		.01014		.093			
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093			
0090 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011			
0240		JA 01	15	1.00		CHROME GRIND OPPOSITE FACE		1.798	.270	2.068	22		
0010 E		RGR-SU-G1		1.00	SET UP A GAP GRINDER	S/U SURFACE GRINDER		1.05938		1.218			
0020 E		RGR-HM-S3		1.00	GAP GRINDER TURN OFF & ON	TURN OFF/ON SURFACE GRINDER		.00685		.007			
0030 E		KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	OCC FOR ROUGH & FINISH GRIND		.02308		.053			
0040 E		KMG-GW-LK		2.00	LOCATE WHEEL TO POSITION	OCC FOR ROUGH & FINISH GRIND		.06761		.155			
0050 E		KMG-OD-CH		4.00	GRIND .040 1 OD X 2	1 X 8 4EA OCC.		.09467		.435			
0060 E		RGR-GE-D2		8.00	DWELL (GAP GRINDER STEEL OD)	DWELL SURFACE GRINDER 8IN OD		.01014		.093			
0070 E		RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093			
0090 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011			
0900					THE OCCURRENCE FACTORS AT STEP LEVEL DEVELOPMENT								
0901					FOR THIS OPERATION WERE DETERMINED EITHER FROM								
0902					ACTUAL COUNT OR FROM REFERENCE TO T.O. SHOWN ABOVE								

.9000	JA 01 15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			PRIOR HISTORY ON 00-ALC 494 FORM				
0020			27JUN83 NEW OCC FACTOR STUDY & REMOVE ALL RJPPWF1				
0030			ELEMENTS <OLD STD> 1.96				
0031			27DEC84 2 YR REVIEW W/ OCC CHANGE > OLD STD < .97				
0032			25FEB85 CHANGED ELINENT RLGGS2 TO KMGDCH 3 EA				
0033			PLACES TO COVER WHAT IS DONE MORE DIF. PART				
0034			30JULY85 CHANGED SUB OP TO MATCH 958 NU TIME CHANG				
0899			J.CALDWELL TECH MANEAA				
0900			MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNRB

06/22/88 A-E046B-MM1-DY-M45  
4S2-59-3

ER	TECH	S	S	W	F	PF	A/R	REV										
SUB	T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	FFD	STD							
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	HOURS	TIME	HOURS							
RBS12	S	E	JA	EA	3	J	88168	.25 PERCENT ENGR 99.9	.87		.21							
0001			JA	01	00			GRD STEERING PLATE	.000	.000	.000							
								PART NUMBER/NSN										
								3661027-101 1620000110320										
0039			JA	01	15			REMOVE RAISED FLAME SPRAY	.335	.013	.096							
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316							
0020	E					GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL	.00678		.007							
0030	E					RWB-NB-03	1.00	PROC TIME NCK / BUR MED PART	.03333		.038							
0040	E					RLG-EI-C3	1.00	CHK FACE TO FACE I/S OR O/S	.01427		.016							
0050	E					RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006							
0166			JA	01	15			MEASURE I.D.	.369	.014	.106							
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316							
0020	E					RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	.08248		.094							
0030	E					RLG-EI-C7	1.00	MKE I/D WARE CHK BY MEASRNG	.00534		.006							
0040	E					RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006							
0167			JA	01	15			JIG GRINDER LABOR	2.322	.087	.668							
0010	E					RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRORATE OVER 4 PARTS	1.03687		.298							
0020	E					RML-HP-CC	1.00	MOIST HANDLE NO WRAP 2 CLAMP	.15776		.181							
0030	E					RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP	.11975		.137							
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087							
0050	E					KMG-DW-ID	3.00	DRESS INTERNAL WHEEL 3 DRESSES REQUIRED	.02458		.064							
0060	E					KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION LOCATE AFTER EACH DRESS	.06761		.233							
0070	E					KMG-ID-NK	1.00	GRIND OUT .040 6.0 ID X 3.0	1.36294		1.567							
0080	E					RTL-MM-M1	1.00	MKE ID OR 2 FLAT SURFACES	.00481		.005							
0090	E					ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.	.05578		.064							
0100	E					RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011							
9000			JA	01	00			LABOR STANDARD HISTORY	.000	.000	.000							
0001								K. VINCENT, 16 JUN 88, MANEL, 73255										

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NR0P NR  
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPGR

02/01/88  
452-59-3

A-E046B-MM1-DY-M45 PAGE 00

74521A		STRUT ASSY C141 N.L.G.												
JOB	TECH	S	W	F	P	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	DLY	PCT
STEP	D	L	K	C	DC	ELEMENT	FACT	STO	SUPPLEMENTAL	HOURS	TIME	HOURS		
00010	E	N	HB	EA	5	J 87349	1.00	PERCENT ENGR 10.1	ASSY STRUT C141 N.L.G.	6.66		6.66		
0001			HB	01	00		1.00		PART NUMBER/NSN	.000	.000	.000		0
0010								3660005-141	1620001877445					
0490			HB	01	21		1.00		PRE TEST FILLER TUBE	.250	.053	.303	2.4	5
0010	E					ZPT-CL-M1	1.00	PRESSURE TEST MED SIZE CYL		.24000		.290		
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0501			HB	01	21		1.00		OK TO CLOSE/DR ASSEMBLE	.212	.045	.257		4
0010	N						1.00		OK TO CLOSE	.20200		.244		
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0503			HB	01	21		1.00		REASSEMBLE IN REV ORDER	1.010	.212	1.222		18
0010	N						1.00		SIGN OFF PARTS USED	1.00000		1.210		
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0505			HB	01	21		1.00		REASSEMBLE	3.010	.632	3.642		55
0010	N						1.00		REASSEMBLE	3.00000		3.630		
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0507			HB	01	21		1.00		TORQUE ALL NUTS & BOLTS	.760	.160	.920		14
0010	N						1.00		APPLY TORQUE TO ALL	.75000		.907		
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0510			HB	01	21		1.00		PRESSURE TEST	.266	.056	.323	2.4	5
0010	E					RLG-SF-L2	1.00	LEAK CHECK MEDIUM CAP STRUT		.25695		.310		
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
70			HB	01	21		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									PRIOR HISTORY ON OO-MLC 494 FORM					
0020									23JUN83 UPDATE OPERATION <OLD STD>			5.60		
0021									27DEC84 2 YR REVIEW W/ NO CHANGES					
0900									JENSEN HANEL			73255		

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC NHPGP

02/01/88  
4S2-59-3

A-E046B-NM1-DY-M45 PAGE 00

74521A		STRUT ASSY C141 NLG											
TECH S S		W F PF A/R REV											
SUB	T K	#R	A FA	SUPPORT	OCC	DESCRIPTION		BASE	PFD	STD			
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT		
PP502	S	E	3S	EA 5	J 87343	1.00	PERCENT ENGR 99.9			.54		.54	
0001			3S	01 00		.00			.000	.000	.000		
	0010						3G61089-111						
	0447		3S	01 25		1.00			.436	.109	.546	4.0 100	
	0010	E			ZPA-PP-C2	1.00	PREPAINT I.D. MED STRUT PART	INNER CYL	.42668		.533		
	0020	E			RJP-PW-R1	1.00	REN RPL PAPERK SIGN OFF DOC		.01001		.012		
	9000		3S	01 00		.00		LABOR STANDARD HISTORY	.000	.000	.000		
	0010						9DEC87 INITIAL INPUT BUILT TO MATCH 958						
	0900						JENSEN	MANEL			73255		

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/01/88

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74521A STRUT ASSY C141 NL6

RCC MRPG

452-59-3

SUB	TECH S S	T K	W F PF A/R REV	#R A FA SUPPORT	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY PC
STEP D L	K C DC ELEMENT	FACT	STOR	SUPPLEMENTAL						
PP503	3S EA 5	J 87345	1.00	PERCENT ENGR 99.9		PRE PAINT AXLE	.54		.54	
0001	3S 01 00		.00			PART NUMBER/MSN	.000	.000	.000	
0010				3661032-107		1620009272599				
0357	3S 01 25		1.00			PAINT NON CHROME SURFACES	.436	.109	.546	4.0 10
0010 E		ZPA-PP-C2	1.00	PREPAINT I.D. MED STRUT PART			.42668		.533	
0020 E		RJP-PW-R1	1.00	REN RPL PAPERWRK SIGN OFF DOC			.01001		.012	
9000	3S 01 00		.00			LABOR STANDARD HISTORY	.000	.000	.000	
0010				11DEC87 INITIAL INPUT		BUILT TO MATCH 958				
0900				JENSEN		HANEL				73255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MRPG NR

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SUB	TECH S S	W F F F A/R REV	#R A FA SUPPORT	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY P
STEP D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL					
PP504	S E JS EA 5	J 87344	1.00	PERCENT ENGR 99.9	PRE PAINT TRUNNION	1.09		1.09	
0001	JS 01 00		.00		PART NUMBER/NSN	.000	.000	.000	
	0010			8340783-10	1620001947597				
	0020			8340783-30	MSL				
0400	JS 01 25		1.00		PRE PAINT CENTER TRUNNION ID	.436	.109	.546	4.0 5
	0010 E	ZPA-PP-C2	1.00	PREPAINT I.D. MED STRUT PART	CENTER TRUNNION I.D.	.42668		.533	
	0020 E	RJP-PW-R1	1.00	REN RPL PAPERWRK SIGN OFF DOC		.01001		.012	
0410	JS 01 25		1.00		PAINT TRUNNION END I.D.	.436	.109	.546	4.0 5
	0010 E	ZPA-PP-C2	1.00	PREPAINT I.D. MED STRUT PART	TRUNNION END I.D.	.42668		.533	
	0020 E	RJP-PW-R1	1.00	REN RPL PAPERWRK SIGN OFF DOC		.01001		.012	
9000	JS 01 00		.00		LABOR STANDARD HISTORY	.000	.000	.000	
	0010			10DEC87 INITIAL INPUT	BUILT TO MATCH 958				
	0900			JENSEN	HANEL				73255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
 74521A STRUT ASSY C141 MLG  
 TECH S S W F PF A/R REV  
 SUB T K #R A FA SUPPORT OCC

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 4S2-59-3

A-E0468-MM1-DY-M45 PAGE

STEP	D L	K C	DC	ELEMENT	FACT	STO	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY P
PP505	S	E	3S	EA	5	J 87344	1.00 PERCENT ENGR 99.9	.37		.37	
0001			3S	00	00		PART NUMBER/NSN	.000	.000	.000	
	0010					3661014-101	1620000271196				
0227			3S	01	25		PRE PAINT PINS	.296	.074	.371	4.0 1
	0010	E			ZMP-PP-01	1.00	PREPAINT SMALL STRUT PART	.29676		.370	
9000			3S	00	00		LABOR STANDARD HISTORY	.000	.000	.000	
	0010					410DEC87	INITIAL INPUT BUILT TO MATCH 958				
	0900					JENSEN	MANEL			73255	

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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BLOS 505/507

1953 S.C.C.

BILL OF MATERIALS  
F-15 NOSE GEAR  
174028

12-May-87

STL-STEEL  
AL-MILUMIN  
MAGNESIUM  
TITANIUM  
505 ST.  
SYNTHETIC  
L-LEAD

\* \* \* (M)

ROUTED ITEM	BLDN LEVEL	QNTY NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNIT MEAS	PERCENT OF MATERIAL	REV	EFFECTIVE DATE	TECH NO	PENDING ACTION	PENDING ACTION	PENDING ACTION
10					NOSE STRUT ASSEMBLY	EA							
10					PISTON ASSEMBLY	EA							
10					PISTON SUBASSY	EA							
10					BUSHING (DM)	EA							
10					BUSHING (DM) (O.S.)	EA							
10					BUSHING (UP LOCK) (REPAIR)	EA							
10					PISTON	EA							
10					OUTER CYLINDER ASSEMBLY	EA							
10					FITTING (GREASE)	EA							
10					OUTER CYLINDER SUBASSY	EA							
10					BUSHING (BRACE PIN)	EA							
10					BUSHING (BRACE PIN) (O.S.)	EA							
10					BUSHING (TIE DOWN)	EA							
10					BUSHING (TIE DOWN) (O.S.)	EA							
10					BUSHING (RETRACT)	EA							
10					BUSHING (RETRACT) (O.S.)	EA							
10					BUSHING (STEERING COLLAR)	EA							
10					BUSHING (STEERING COLLAR) (O.S.)	EA							
10					BUSHING (STEERING COLLAR)	EA							
10					BUSHING (STEERING COLLAR) (O.S.)	EA							
10					BUSHING (JURY BRACE)	EA							
10					BUSHING (JURY BRACE) (O.S.)	EA							
10					BUSHING (URIFICE TUBE)	EA							
10					BUSHING (URIFICE TUBE) (O.S.)	EA							
10					BUSHING (TRAINING)	EA							
10					BUSHING (TRAINING) (O.S.)	EA							
10					BUSHING (TAG LOCK) (REPAIR)	EA							
10					BUSHING & PACKING ASSY. (PSEUDO)	EA							
10					BUSHING (URIFICE TUBE) (REPAIR)	EA							
10					PACKING (O-RING) (REPAIR)	EA							
10					OUTER LUBRIMER	EA							
10					KIT (O)	EA							
10					PACKING ASSEMBLY (T-SEAL)	EA							
10					PACKING ASSEMBLY (T-SEAL) (KIT)	EA							
10					PACKING ASSEMBLY (T-SEAL)	EA							
10					PACKING ASSEMBLY (T-SEAL) (KIT)	EA							
10					PACKING (O-RING) (KIT)	EA							
10					PACKING (O-RING) (SPARE) (KIT)	EA							
10					PACKING (O-RING) (KIT)	EA							
10					PACKING (O-RING) (KIT)	EA							
10					SCRAPPER (RING)	EA							
10					RETAINER (BRCK-UP RING) (KIT)	EA							
10					PACKING ASSEMBLY (T-SEAL) (KIT)	EA							
10					PATE (DINSTEAF) (DM)	EA							

201



12-May-89

BLP 5/30/7

Page 3

STL-STEEL  
 AL-ALUMINUM  
 MAG-MAGNESIUM  
 TIT-TITANIUM  
 SS-8 STL  
 SYN-11 SYNTHETIC  
 L-LEAD

F-15 N.L.P.

BILL OF MATERIALS

174024

\* = PMI

ROUTED ITEM	ILDM LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS PER ASSY	FIELD	SCRAP	PART NO.	IC	REV	EFFECTIVE DATE	TECH DMS NUMBER	PENDING ACTION	PENDING ACTION	PENDING ACTION	PENDING ACTION
	...	RING, TIE DOWN															
187L	1.1	IN.S.L.	15310003267531	176301	1..NUT (SUPPORT TUBE)	11	EA										
187L	1.1	IN.S.L.	15310003267531	176301	1..NUT (LOCK)	11	EA										
187L	1.1	IN.S.L.	11820003121818	176301	1..NUT (LOCK)	11	EA										
187L	1.1	IN.S.L.	11420003051748	176301	1..NUT (LOCK)	11	EA										
187L	1.1	IN.S.L.	197928	197928	1..SCREW (MACHINE)	12	EA										
187L	1.1	IN.S.L.	192215	192215	1..SCREW (MACHINE)	12	EA										
187L	1.1	IN.S.L.	185495	185495	1..SCREW (MACHINE)	12	EA										
187L	1.1	IN.S.L.	173197	173197	1..SCREW (MACHINE)	12	EA										
187L	1.1	IN.S.L.	186539	186539	1..SCREW (MACHINE)	12	EA										
187L	1.1	IN.S.L.	1990501079250	176301	1..PLATE (MOUNTING)	11	EA										
187L	1.1	IN.S.L.	15365003174656	176301	1..PLATE (THROUST)	11	EA										
187L	1.1	IN.S.L.	13110008201466	160380	1..BEARINGS (NEEDLE ROLLER)	11	EA										
187L	1.1	IN.S.L.	11620003072875	176301	1..RETAINER (BEARINGS)	11	EA										
187L	1.1	IN.S.L.	1620010453177	176301	1..WEAR PLATE ASSEMBLY	14	EA										
187L	1.1	IN.S.L.	15365010441513	176301	1..SWIR ASSEMBLY	14	EA										
187L	1.2	IN.S.L.	15365010238774	176301	1..SHAFT	14	EA										
187L	1.2	IN.S.L.	15365010238774	176301	1..SHAFT	18	EA										
187L	1.2	IN.S.L.	15365010238774	176301	1..SHAFT	110	EA										
187L	1.2	IN.S.L.	11420003109929	176301	1..SHOE	12	EA										
187L	1.2	IN.S.L.	173134	173134	1..HEAD (PISLON)	11	EA										
187L	1.2	IN.S.L.	109455	109455	1..HEAD (PISLON)	11	EA										
187L	1.2	IN.S.L.	11620003109831	176301	1..DAMPENER (RESOUND)	11	EA										
187L	1.2	IN.S.L.	11620003021679	176301	1..RETAINER RING ASSEMBLY (SET)	11	EA										
187L	1.2	IN.S.L.	116200033730192	176301	1..SPACER	11	EA										
187L	1.2	IN.S.L.	15315002341882	198906	1..PIN (COTTER)	12	EA										
187L	1.1	IN.S.L.	11620003021681	176301	1..PIN (LOWER CAM)	12	EA										
187L	1.1	IN.S.L.	11620003051932	176301	1..PIN (UPPER CAM)	14	EA										
187L	1.1	IN.S.L.	15365001394835	176301	1..SUPPORT (RING)	11	EA										
187L	1.1	IN.S.L.	11620003051936	176301	1..CAM ASSEMBLY (UPPER)	11	EA										
187L	1.2	IN.S.L.	15320001176938	176301	1..INSERT	12	EA										
187L	1.2	IN.S.L.	15320001176938	198906	1..RIVET	14	EA										
187L	1.2	IN.S.L.	11620002671045	176301	1..CAM (UPPER)	11	EA										
187L	1.2	IN.S.L.	15315003237776	176301	1..CAM ASSEMBLY (LOWER)	11	EA										
187L	1.2	IN.S.L.	15320001071444	198906	1..RIVET (CAM)	12	EA										
187L	1.2	IN.S.L.	15320001176931	198906	1..RIVET	12	EA										
187L	1.2	IN.S.L.	15330003267636	176301	1..CAM (LOWER)	11	EA										
187L	1.1	IN.S.L.	13120003053551	173134	1..RETAINER (PACKING)	11	EA										
187L	1.1	IN.S.L.	199455	199455	1..BEARINGS (LOWER)	11	EA										
187L	1.1	IN.S.L.	14730003068311	176301	1..NUT (BLAND)	11	EA										
187L	1.1	IN.S.L.	15311003176292	176301	1..CAM FOLLOWER ASST	11	EA										

203

STEEL  
ALUMINUM  
MAGNESIUM  
TITANIUM  
SILICON  
SODIUM  
LEAD

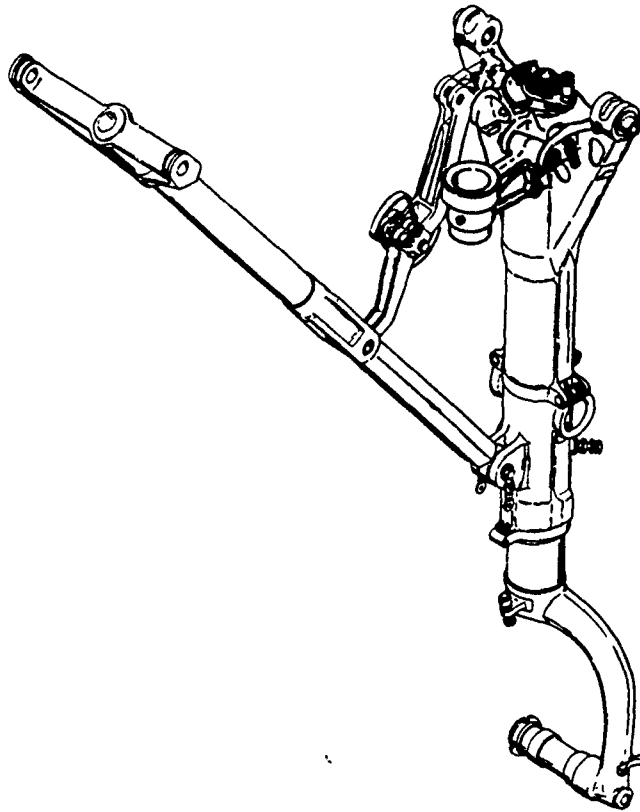
BILL OF MATERIALS

\* = PMI

ITEM	QTY	UOM	LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PERCENT	YIELD	ISOMP	PART	REV	EFFECTIVE	TECH	DRG	PENDING	PENDING	PENDING	
	1.2			INR816-1A	173000274780	180205	1...FITTING (GREASE)	1												
	1.2			M.P.L.	M.S.L.		1...CAM FOLLOWER	1												
	1.1			1E20465-300	531500231063	196906	1...PIN (COTTER)	1												
	1.1			1E10080-7	531000310990	172962	1...NUT (CASTEL)	1												
	1.1			1E10080-7	531000310990	192595	1...NUT (CASTEL)	1												
	1.1			17444007	531000310990	156878	1...NUT (CASTEL)	1												
	1.1			1M9600714L	5310002750616	188044	1...WASHER (FLAT)	1												
	1.1			1M9A50A83-1001	1162001014859	174301	1...NUT ASSEMBLY (RILE)	1												
	1.2			1M9A50A79-2001	5345010183863LE	176301	1...RING (LOCK)	1												
	1.2			M.P.L.	M.S.L.		1...NUT SUBASYS (RILE)	1												
	1.2			17829425-13	3120010731951	198747	1...NUT ASSEMBLY (RILE)	1												
	1.2			M.P.L.	M.S.L.		1...NUT (RILE)	1												
	1.1			1M9A50A-1005	176301	176301	1...NUT ASSEMBLY (RILE)	1												
	1.2			1M9A50A79-2001	5345010183863LE	176301	1...RING (LOCK)	1												
	1.2			M.P.L.	M.S.L.		1...NUT SUBASYS (RILE)	1												
	1.2			17829425-13	3120010731951	198747	1...NUT ASSEMBLY (RILE)	1												
	1.2			M.P.L.	M.S.L.		1...NUT (RILE)	1												
	1.1			1M9A50742-2001	1620010594894	176301	1...LOCK PLATE	1												
	1.1			1M9S1331C3M	5305003726315	180205	1...SCREW (MACHINE)	1												
	1.1			1M9A50743-1001	1620005342713	176301	1...VALVE ASSEMBLY (RESTRICTOR)	1												
	1.2			1M9A50A83-2001	53050063499VALE	176301	1...SCREW (STOP)	1												
	1.2			1M9A50729-2001	1620005239339	176301	1...STOP (SPRING)	1												
	1.2			1M9A50727-2001	53660004670457	176301	1...SPRING (COMPRESSION)	1												
	1.2			1M9S276-260	5305009124817	196906	1...SCREW (MACHINE)	1												
	1.2			1M9A50734-2001	53150053097249LE	176301	1...SLEEVE (VALVE)	1												
	1.2			1M9A50725-2001	1620003336193	176301	1...PIN (STOP)	1												
	1.2			1M9A50731-2001	53450063369994	176301	1...RING (RETAINING)	1												
	1.2			1E20465-300	5315002310663	196906	1...PIN (COTTER)	1												
	1.2			1M9A50732-2001	1620005342699	176301	1...RETAINER (VALVE)	1												
	1.2			1M9A50723-2001	1620006233941	176301	1...VALVE (CHECK)	1												
	1.2			1M9A50724-2001	1620003738194	176301	1...STOP (SLEEVE)	1												
	1.2			1M9A50722-1001	M.S.L.	176301	1...BODY ASSEMBLY	1												
	1.1			1M9A50739-2001	1620010074170	176301	1...RETAINER (RING)	1												
	1.1			1M9A50A80-2001	1620003109832	176301	1...RETAINER (RING)	1												
	1.1			1M9A50A35-2001	1620003072878	176301	1...RING (PISTON)	1												
	1.1			1M9A50A66-2001	5345003174906	176301	1...SPACER (RING)	1												
	1.1			1M9A50A59-2001	1620010596643	176301	1...PLATE (LOCK)	1												
	1.2			1E2120451-10	5340009662929	196906	1...INSERT (WELL-COIL)	1												
	1.2			M.P.L.	M.S.L.		1...EXTENSION	1												
	1.1			1M9A50A86-2001	1620005468498	176301	1...PISTON (FLOATING)	1												
	1.1			1M9A50A86-2001	1620005468498	176301	1...PISTON (FLOATING)	1												
	1.1			1M100-7	7690009375847	176301	1...PLATE (UNIFORMATION)	1												

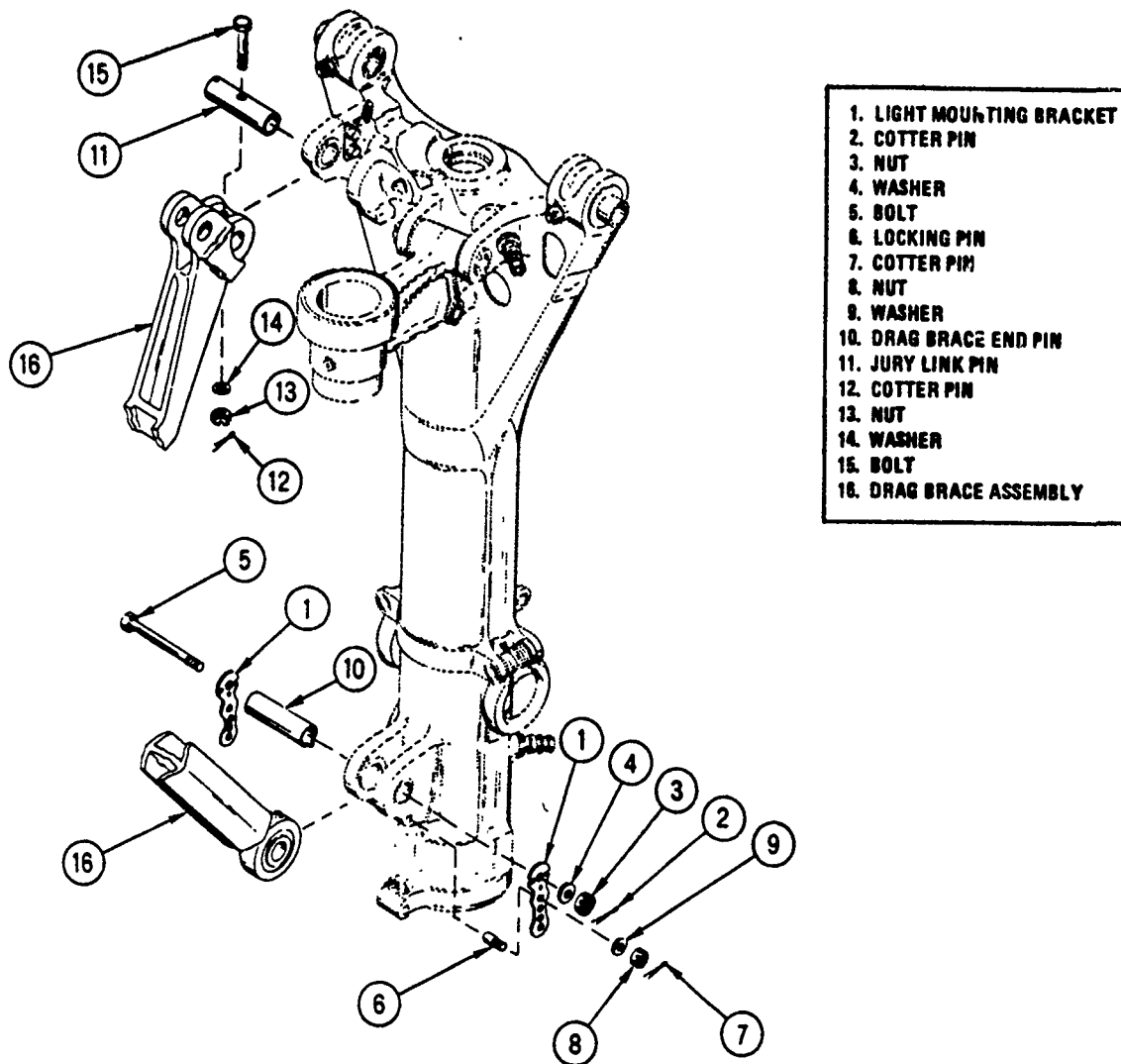


F-15 NLG



452-73-3-(11)

Nose Landing Gear Assembly



4S2-73-3-111

Figure 3-1. Removing Drag Brace from Shock Strut, Exploded View

**3-5. DISASSEMBLING DRAG BRACE.** See figure 3-2.

a. Remove cotter pin (2), nut (3), washer (4), and bolt (5) securing apex pin (1). Drive out apex pin, then separate lower jury link (40) and lower drag brace (9) from upper drag brace (51).

b. Do not remove flanged bushings (6), spherical bearing (7), or fittings (8) from lower drag brace (9) unless inspection indicates that replacement is necessary.

c. If linear actuating cylinder attaching parts were left on upper jury link (37), remove cotter pin (11), nut (12), washer (13), and bolt (10) from upper jury link.

d. Remove cotter pins (15), nuts (16), washers (17), and adjacent downlock spring (14). Remove spring sleeves (18), washers (19), washer (20), and spacer (21) from left side of jury links. From opposite side

of jury links, remove bolts (22), washers (23), spring sleeve (24), washers (25), washer (26), and spacer (27).

e. Remove cotter pin (28), nut (29), washer (30), and apex pin (31); separate upper jury link (37) assembly from lower jury link (40). Do not remove flanged bushings (32, 33, 34, and 35) or fittings (36) from upper jury link unless inspection indicates that replacement is necessary.

f. Do not remove flanged bushings (38 and 39) from lower jury link (40) unless inspection indicates that replacement is necessary.

g. Remove cotter pins (41), nuts (42), washers (43), bolts (44), and trunnion pins (45 and 46). Do not remove flanged bushings (47, 48, and 49) or fittings (50) from upper drag brace (51) unless inspection indicates that replacement is necessary.

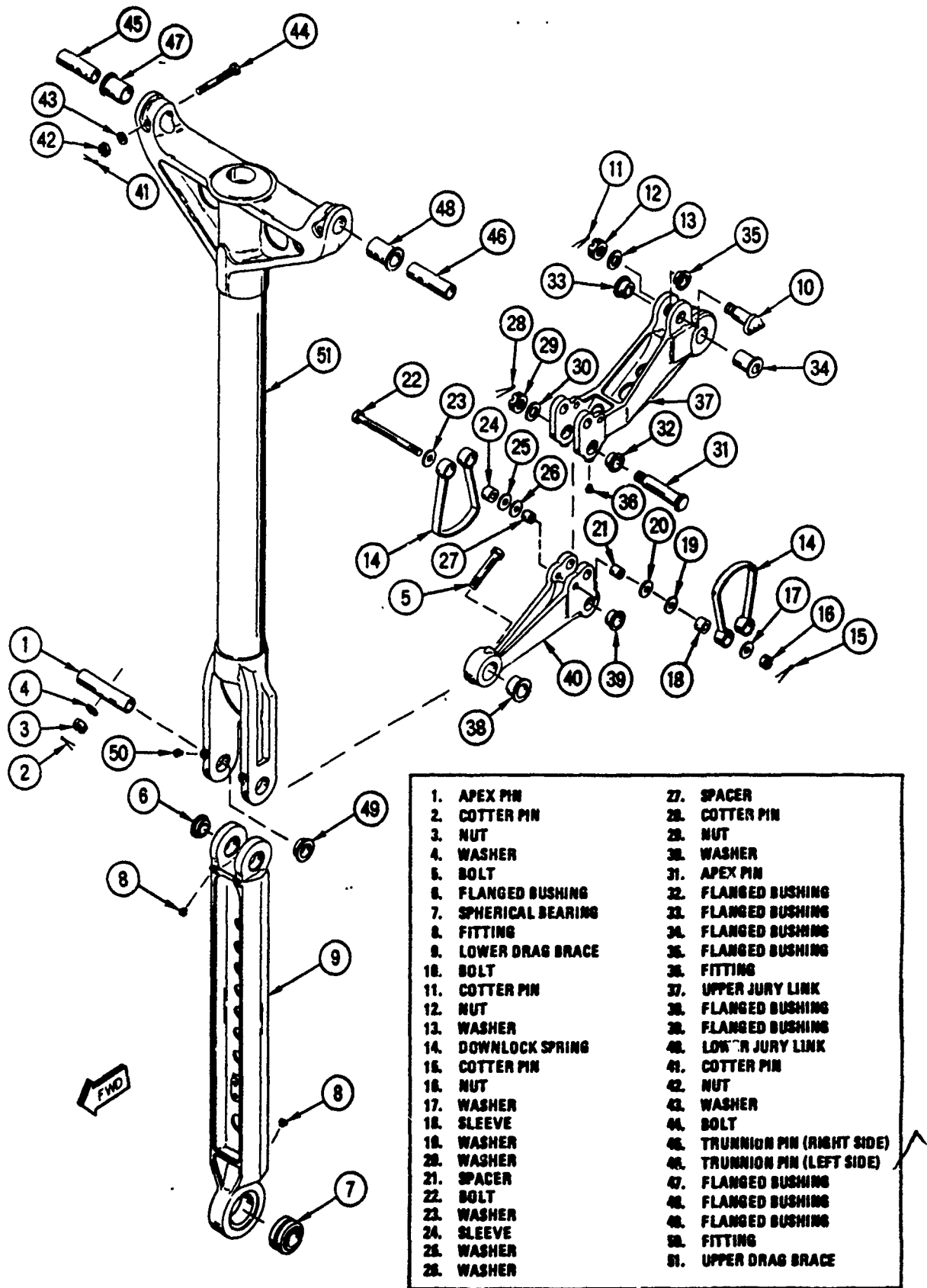


Figure 3-2. Drag Brace, Exploded View

4S2-73-3-12

5. REMOVING PISTON AND ORIFICE SUPPORT TUBE FROM CYLINDER. See figure 3-3.

**CAUTION**

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

- a. Discharge high then low pressure chambers.

**NOTE**

Nose landing gear is to be drained of all oil.

- b. Remove oil valve (47, figure 3-7) drain oil, and install oil valve.

- c. Rotate piston assembly (15, figure 3-3) as necessary to gain access to lock tab (1) and bolts (4). Remove nuts (2), washers (3), bolts (4), washers (5), and lock tab. Remove steering crank nut (7) and steering crank (6) from end of orifice support tube (14).

- d. Remove nut (22) and washer (23) from steering crank (6).

- e. Place strut in horizontal position and remove cotter pins (9), nuts (10), washers (11), and bolts (12). Remove instruction plate (13) if installed. Remove lock tab (8) securing gland nut (17). Unscrew gland nut to disengage from cylinder threads.

- f. Provide a drain pan under cylinder to catch oil. Pull piston assembly (15) and orifice support tube (14) out of cylinder assembly (16).

3-7. REMOVING ORIFICE SUPPORT TUBE FROM PISTON. See figure 3-4.

**CAUTION**

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

**NOTE**

Plate (1, figure 3-4) and bearing (2) may remain in cylinder when piston and orifice support tube are removed.

- a. If necessary, remove plate (1) and bearing (2) from cylinder bore. Remove retainer (3) from shoulder of orifice support tube (7). Keep parts together.

- b. Push orifice support tube (7) into piston (8) sufficiently to disengage tube from wear plates (4).

- c. Remove wear plates (4), shims (5), and shoes (6) from inside barrel of piston (8).

- d. Withdraw orifice support tube (7) from piston (8).

- |                          |
|--------------------------|
| 1. LOCK TAB              |
| 2. NUT                   |
| 3. WASHER                |
| 4. BOLT                  |
| 5. WASHER                |
| 6. STEERING CRANK        |
| 7. STEERING CRANK NUT    |
| 8. LOCK TAB              |
| 9. COTTER PIN            |
| 10. NUT                  |
| 11. WASHER               |
| 12. BOLT                 |
| 13. INSTRUCTION PLATE    |
| 14. ORIFICE SUPPORT TUBE |
| 15. PISTON ASSEMBLY      |
| 16. CYLINDER ASSEMBLY    |
| 17. GLAND NUT            |
| 18. LOWER SEARING        |
| 19. LOWER CAM            |
| 20. UPPER CAM            |
| 21. SCRAPER              |
| 22. NUT                  |
| 23. WASHER               |

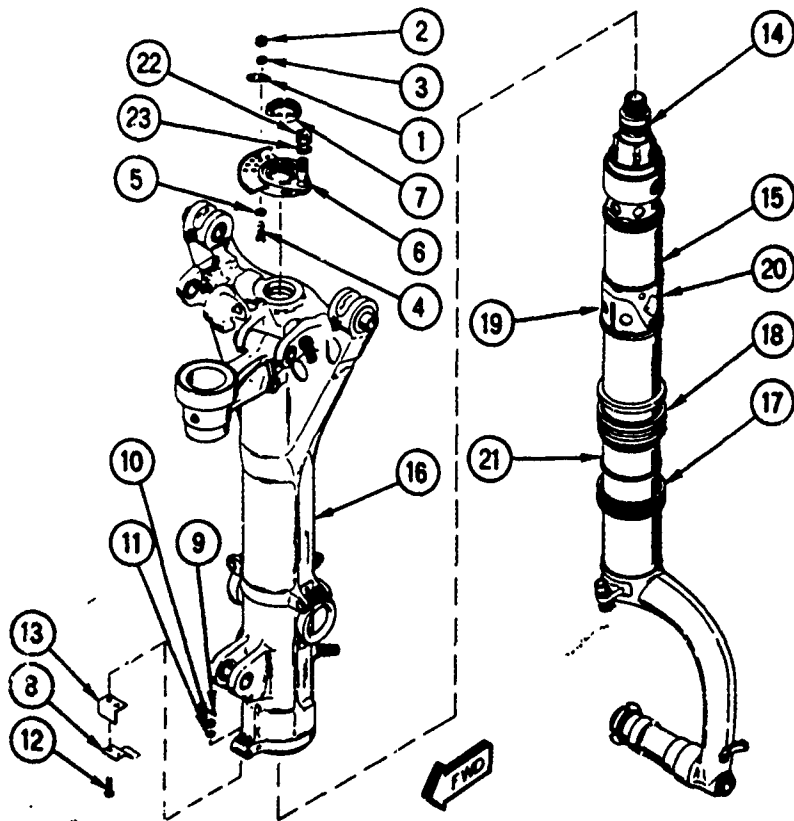
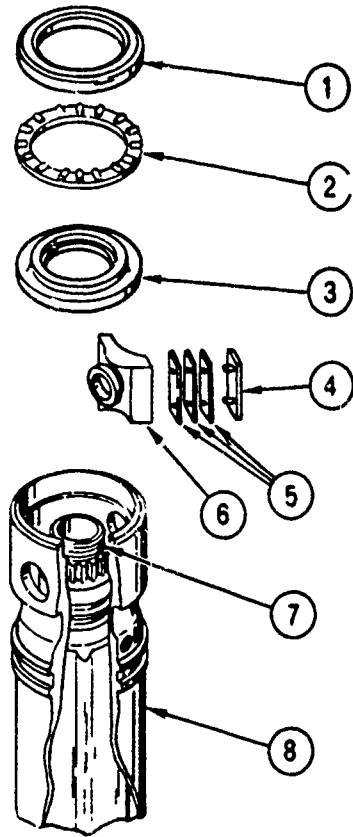


Figure 3-3. Removing Piston and Orifice Support Tube from Cylinder, Exploded View

4S2-73-3-ENC



- |    |                      |
|----|----------------------|
| 1. | PLATE                |
| 2. | BEARING              |
| 3. | RETAINER             |
| 4. | WEAR PLATE           |
| 5. | SHIMS                |
| 6. | SHOE                 |
| 7. | ORIFICE SUPPORT TUBE |
| 8. | PISTON               |

Figure 3-4. Removing Orifice Support Tube from Piston, Exploded View

3-8. DISASSEMBLING ORIFICE SUPPORT TUBE ASSEMBLY. See figure 3-5.

**CAUTION**

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

a. Remove retainer rings (1) and packings (2) below splines from orifice support tube (32).

**NOTE**

Assembly consisting of index Nos. 3 through 28, figure 3-5, are not to be disassembled except for replacement of obviously damaged and/or unserviceable parts. Disassembly is to be limited to that level required to replace those components identified as unserviceable.

b. Cut lockwire, then remove screw (4) and lock plate (3).

c. Remove body assembly (5 through 20) from orifice support tube extension (28). Remove retainers (21 and 22), ring (23), and spacer (24).

d. To disassemble body assembly (5 through 20) remove three screws (5) securing spring stop (6). Remove spring stop and spring (7) from bore of body (20). Remove two screws (9), then separate band (8) securing pins (10). Remove pins, then slide sleeve (11) out of body bore. Slide retainer (14) away from retainer ring (12); remove cotter pin (13), retainer ring (12), and retainer (14). Remove check valve (15) from end of body. Remove stop (16) from bore of body. Do not remove inserts (17, 18, and 19) from body unless inspection indicates that replacement is necessary.

e. Cut lockwire, then remove screws (26) and lock plate (25). Remove extension (28) from end of orifice support tube (32). Do not remove inserts (27) from extension unless inspection indicates that replacement is necessary.

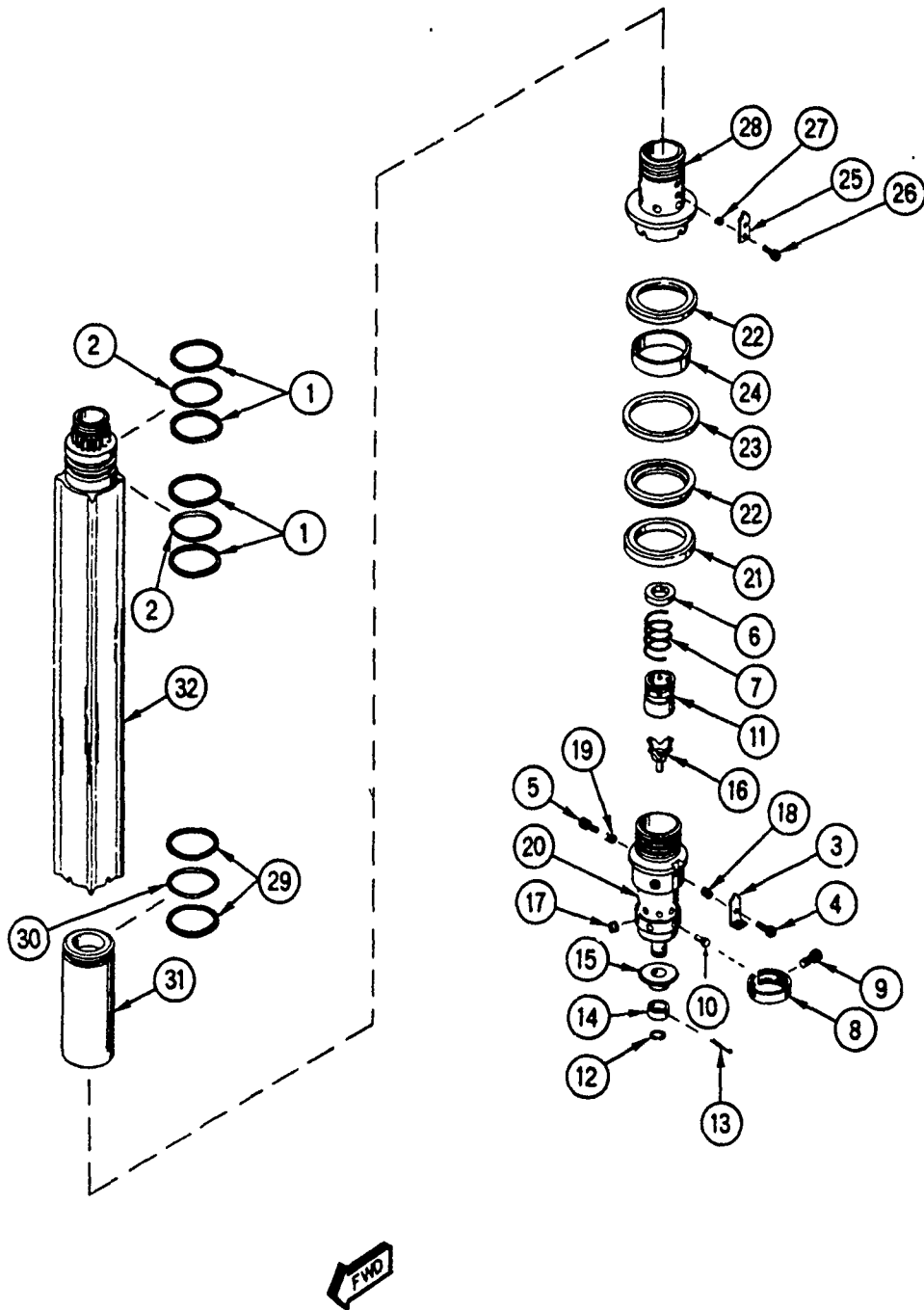
f. Bump orifice support tube (32) on bench or use air pressure administered through hole in top of orifice support tube to remove piston (31). Remove retainer rings (29) and packing (30) from piston.

3-9. DISASSEMBLING PISTON. See figure 3-6.

**CAUTION**

To prevent damage to unpainted or bare metal parts handle with extreme care as they may be easily damaged.

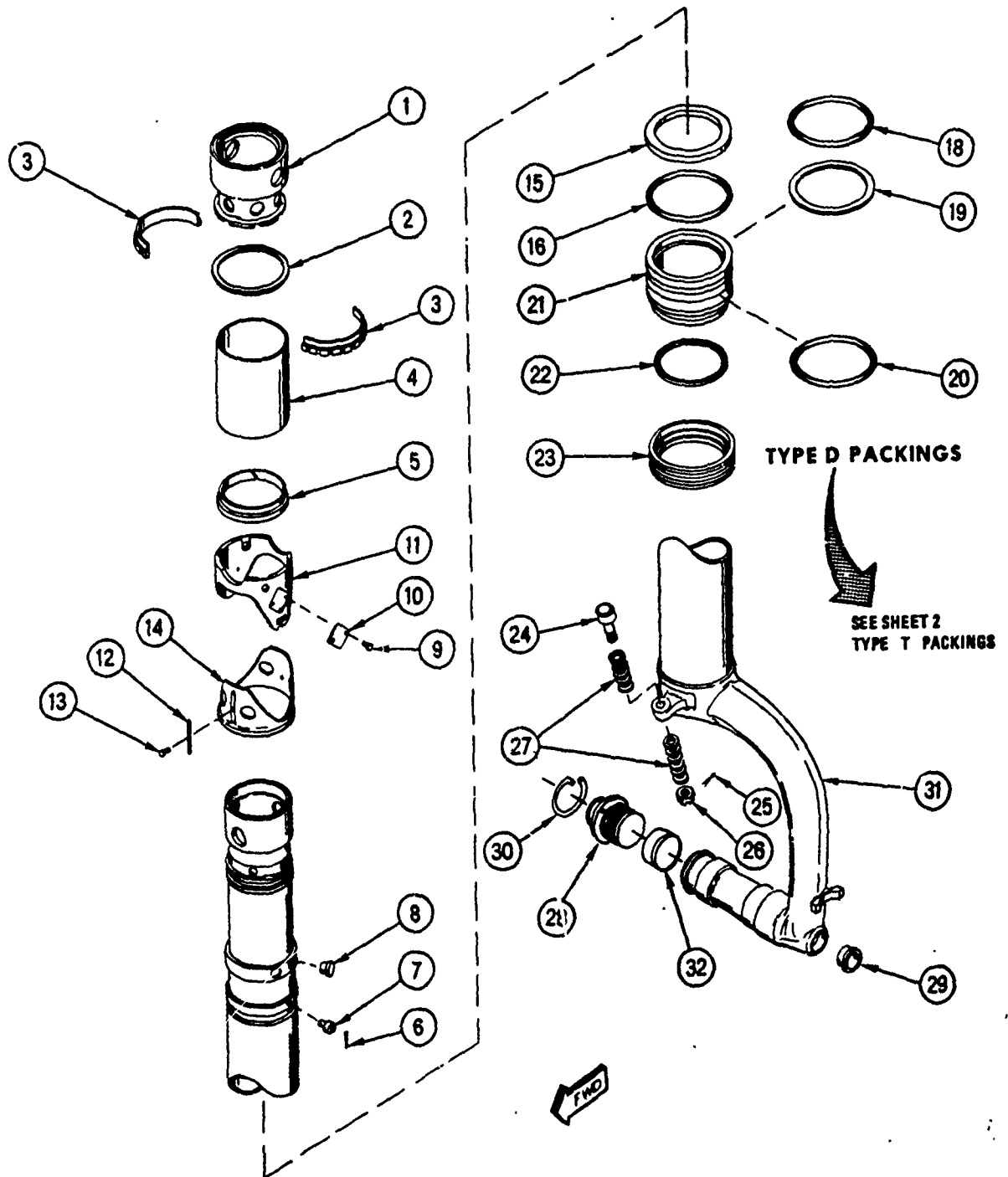
a. Slide head (1) off barrel of piston (31); remove snubber valve (2) and split retainers (3). Remove spacer (4) and support (5) from piston.



1. RETAINER RING	9. SCREW	17. INSERT	25. LOCK PLATE
2. PACKING	10. PIN	18. INSERT	26. SCREW
3. LOCK PLATE	11. SLEEVE	19. INSERT	27. INSERT
4. SCREW	12. RETAINER RING	20. BODY	28. EXTENSION
5. SCREW	13. COTTER PIN	21. RETAINER	29. RETAINER RING
6. SPRING STOP	14. RETAINER	22. RETAINER	30. PACKING
7. SPRING	15. CHECK VALVE	23. RING	31. PISTON
8. BAND	16. STOP	24. SPACER	32. ORIFICE SUPPORT TUBE

4S2-73-3-(6)

Figure 3-5. Orifice Support Tube Assembly, Exploded View



- |                   |                    |                     |
|-------------------|--------------------|---------------------|
| 1. HEAD           | 11. UPPER CAM      | 22. SCRAPER         |
| 2. SNUBBER VALVE  | 12. KEY            | 23. GLAND NUT       |
| 3. SPLIT RETAINER | 13. RIVET          | 24. CAM FOLLOWER    |
| 4. SPACER         | 14. LOWER CAM      | 25. COTTER PIN      |
| 5. SUPPORT        | 15. RETAINER       | 26. NUT             |
| 6. COTTER PIN     | 16. PACKING        | 27. WASHER          |
| 7. APEX PIN       | 17. RETAINER RINGS | 28. AXLE NUT        |
| 8. PIN            | 18. PACKING        | 29. FLANGED BUSHING |
| 9. RIVET          | 19. RETAINER RINGS | 30. AXLE NUT SPRING |
| 10. INSERT        | 20. SPARE PACKING  | 31. PISTON          |
|                   | 21. LOWER BEARING  | 32. NYLON PLUG      |

492-73-3-16-118

Figure 3-6. Piston, Exploded View (Sheet 1 of 2)

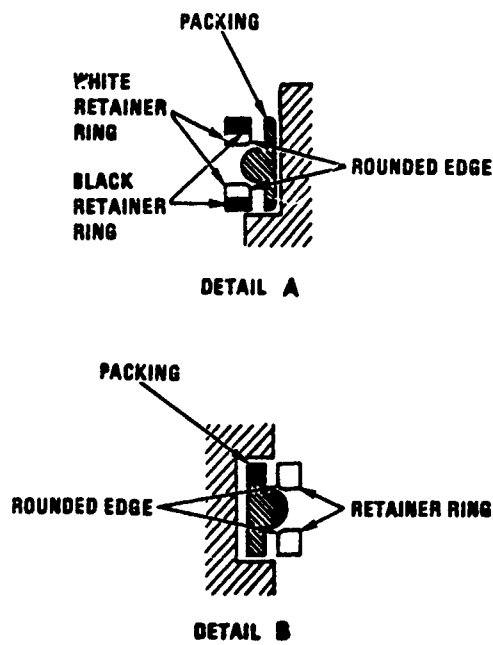
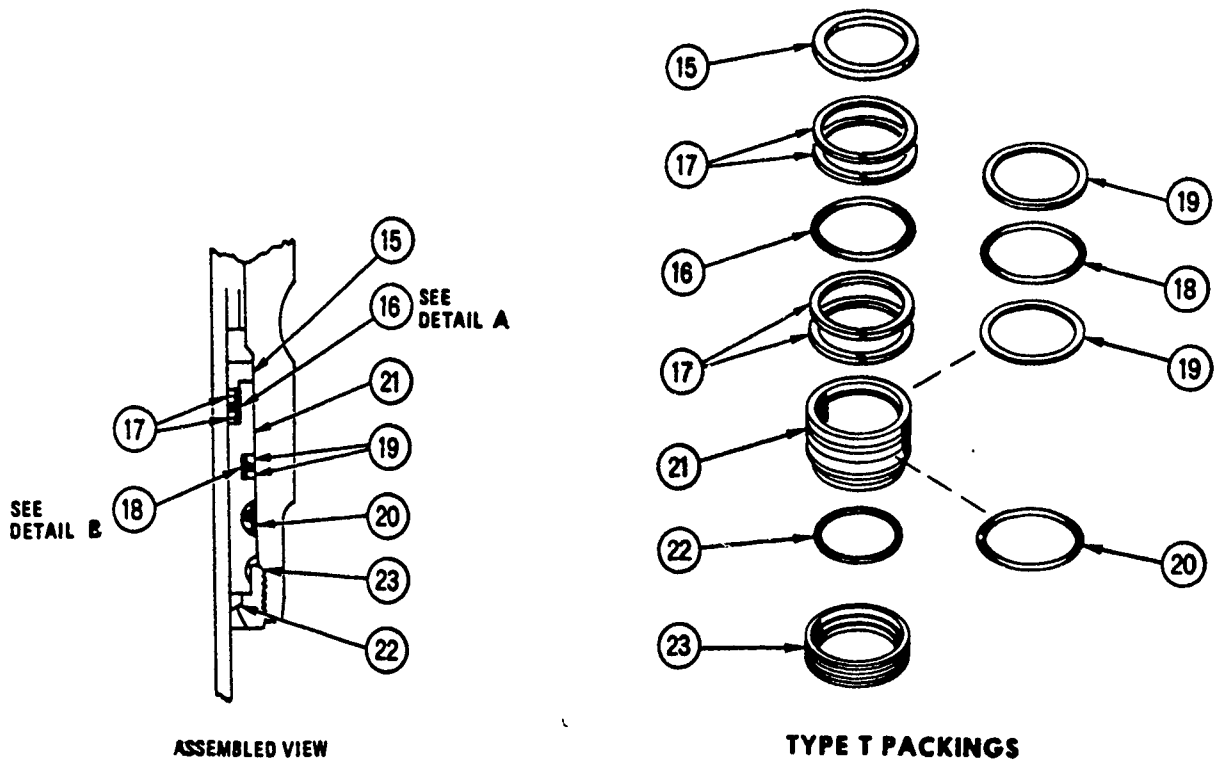
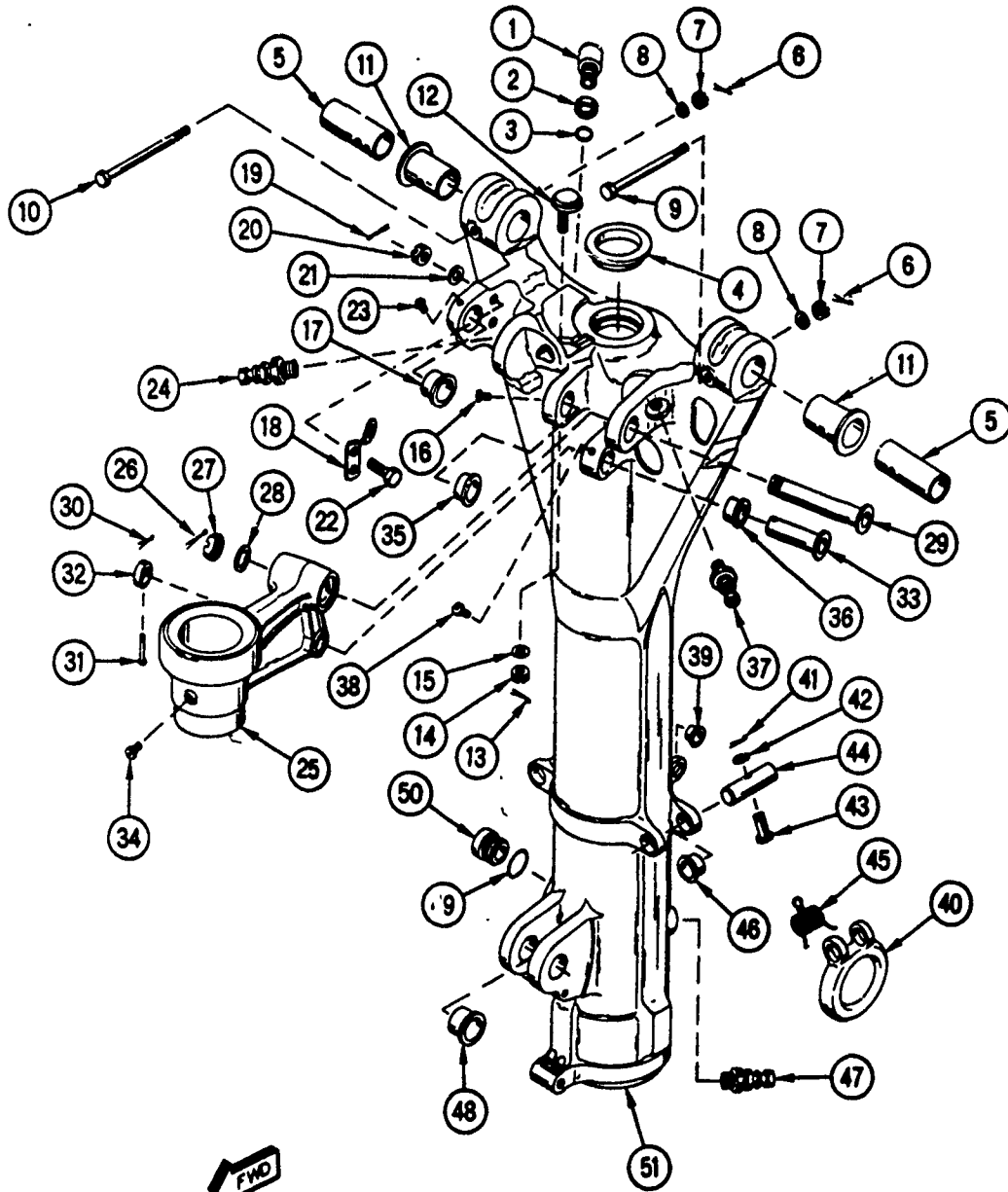


Figure 3-6. Piston, Exploded View (Sheet 2)

4S2-73-3-16-28





1. PRESSURE GAGE	14. NUT	27. NUT	48. TIE DOWN RING
2. NUT	15. WASHER	28. WASHER	41. COTTER PIN
3. PACKING	16. FITTING	29. UPPER BOLT	42. WASHER
4. FLANGED BUSHING	17. FLANGED BUSHING	30. COTTER PIN	43. STRAIGHT PIN
5. TRUNNION PIN	18. SWITCH MOUNT BRACKET	31. STRAIGHT PIN	44. TIE DOWN RING PIN
6. COTTER PIN	19. COTTER PIN	32. COLLAR	45. SPRING
7. NUT	20. NUT	33. LOWER PIN	46. FLANGED BUSHING
8. WASHER	21. WASHER	34. FITTING	47. OIL VALVE
9. BOLT	22. BOLT	35. FLANGED BUSHING	48. FLANGED BUSHING
10. BOLT	23. FITTING	36. FLANGED BUSHING	49. PACKING
11. FLANGED BUSHING	24. AIR VALVE	37. AIR VALVE	50. PLUG
12. INSERT	25. SUPPORT ARM	38. FITTING	51. CYLINDER
13. COTTER PIN	26. COTTER PIN	39. FLANGED BUSHING	

**NOTE**

Ⓛ PLUG AN614-180L AND PACKING MS28778-18 ARE FOR SHIPPING PURPOSES ONLY.

Figure 3-7. Cylinder, Exploded View

FAMILY 4  
CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TEC ORDER
COOP	COOP	16283A		C-141 MLG	DRAG BRACE SHAFT	1620-00-785-6873	3611500-101	451-73-3
MONR	COOP	16296A	-6	H-3 MLG	STRUT ASSY	1620-00-482-1247	S6127-50102-4	451-72-3
MONR	COOP	16297A	-6	CH-3 MLG	STRUT ASSY	1620-01-037-4639	S6127-50501-4	452-50-3
JENS	RIGB	16298A		F-15 C & D	BRAKE HOUSING	1630-01-065-9469	2606006	481-2-1173
MONR	ANDE	16301A	-6	F-4 MLG	STRUT ASSY R/H DRY	1620-00-919-6846	53-41400-302	451-71-3
MONR	ANDE	16302A	-6	F-4 MLG	STRUT ASSY L/H DRY	1620-00-919-6847	53-41400-301	451-71-3
COOP	COOP	16315A		F-16 MLG	AXLE L/H	1620-01-071-0535	2006035-103	451-109-3
MART	SHEL	16328A		F-15	DRUM ASSY	1005-01-042-9746	205F481	11W1-7-15-4
MART	SHEL	16331A			ENTRANCE UNIT ASSY	1005-00-397-7834	189F322	11W1-29-9-2&3
COOP	COOP	16334A		F-16 MLG	AXLE R/H	1620-01-071-0537	2006035-104	451-109-3
DELE		16352A		C-7 MLG	HOUSING	1620-01-020-8650	17 OCT 88	451-81-3
JENS	PRIC	16404A	-J	C-130 MLG	WHEEL (NAVY)	1630-01-014-0656	48	NAVAIR 04-10-1
DELE		16409A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-052-8403	9550402	481-2-133
DELE		16411A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-875-4866LC	9541667	481-2-133
COOP	COOP	16582A		F-16 MLG	TORQUE ARM-LOWER	1620-01-071-5592	2006629-105	452-00-3
MART	SHEL	16613A		F-16	AIM ADAPTER ASSY	1440-01-050-9264AB	16S301-817	11LAB-9-2
MART	SHEL	16614A		F-15	UNLOAD DRIVE ASSY	1005-00-100-6969	176F727	11W1-1-15-4
MART	SHEL	16615A		F-106	DRUM ASSY	1005-00-397-7835	189F336	11W1-29-9-2&3
COOP	COOP	16623A		C-141 MLG	TORQUE ARM	1620-01-114-6869	3610007-117	451-73-3
MART	SHEL	16705A		F-15	LAU 114 LAUNCHER	1440-01-114-9506AB	68A732501-1009	11W1-2-14-25-
COOP	COOP	16727A	J	F-16 MLG	TORQUE ARM-UPPER	1620-01-024-9157	2006629-111	452-00-3
COOP	RIGB	16734A	-J	F-111 MLG	TORQUE PLATE	1630-00-460-1727	4-52	481-2-483
COOP	POLL	16743A		C-141 MLG	DOWN LOCK BELLCRANK	1620-00-204-1208	3661100-101	452-59-3
COOP	COOP	16744A		F-111 MLG	PIN AXLE	1620-00-004-6044	12L594-7	444-1-113
JENS	RIGB	16776A	-J	A-37 MLG	BRAKE ASSY	1630-00-847-3731	9550404	481-2-1023
JENS	COOP	16777A		C-7A MLG	DRAG BRACE	1620-00-066-2768	5750-15	451-82-3
MONR	ANDE	16836A	-6	F-4 MLG	STRUT ASSY R/H WET	1620-00-109-4286	53-41500-1	451-71-3
MONR	ANDE	16837A	-6-J	F-4 MLG	STRUT ASSY L/H WET	1620-00-109-9287	53-41500-2	451-71-3
JENS	COOP	16915A	✓	KC-135 MLG	TRUCK ASSY	1620-00-940-5066	1583-166A	444-12-23
COOP	COOP	17142A	✓-6-J	B-52 MLG	STRUT ASSY H/W	4620-00-139-8473	7027648-190-150	451-57-3
COOP	COOP	17143A	✓-6-J	B-52 MLG	STRUT ASSY H/W	1620-00-139-8474	7027648-210-170	451-57-3
JENS	COOP	17224A	-J	E-7 MLG	HOUSING	1620-00-403-8443	69F27216-02	451-81-3
JENS	COOP	17239A	✓-6-J	KC-135 MLG	TRUNNION	1620-00-679-3440	50-9717-22	444-12-23
BENT	COOP	17245A	✓-6-J	KC-135 MLG	DRAG BRACE	1620-00-652-5472	50-9733-1	444-12-23
BENT	COOP	17313A	✓-6-J	KC-135 MLG	TRUNNION	1620-00-651-8222	50-9717-4	444-12-23
BENT	COOP	17314A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-306-9942	5-84011-1	444-12-23
BENT	COOP	17315A	-6-J	KC-135 MLG	UPPER SIDE BRACE	1620-00-306-9943	5-84011-3	444-12-23
COOP	TOLM	17324A	-6	F-111 MLG	STRUT ASSY-SHOCK	1620-00-300-2261	7327000-50	451-78-3
BENT	COOP	17327A	✓-6-J	KC-135 MLG	TRUNNION	1620-00-911-8301	50-9717-25	444-12-23
COOP	TOLM	17346A	-6	F-111 MLG	AXLE	1620-00-439-3651	12L10021-804	444-17-3
BENT	COOP	17347A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-709-9371	5-84011-1	444-12-23
BENT	COOP	17348A	✓-6-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-711-7771	5-84011-28	444-12-23
COOP	COOP	17353A	-6	F-111 MLG	STRUT ASSY	1620-00-545-9395	7430562-10	444-18-3
COOP	TOLM	17354A	✓-6	F-111 MLG	STRUT ASSY	1620-00-545-9439	7430564-10	444-14-3
BENT	COOP	17357A	✓-6-J	KC-135 MLG	BRACE ASSY	M 1620-00-741-9178	65-4829-3	45A6-5-3
COOP	COOP	17402A	✓-6-J	F-15 MLG	STRUT ASSY	M 1620-01-062-7002	68A450401-1013	452-73-3
BENT	COOP	17407A	-6-J	KC-135 MLG	BOLT-TRUNNION	1620-00-972-1498	09-10052-2	444-12-24
COOP	TOLM	17418A	-6	F-111 MLG	STRUT ASSY-SHOCK	1620-01-013-5910	7327074-90	451-78-3
BENT	COOP	17451A	✓-6-J	KC-135 MLG	TRUNNION	M 1620-00-651-8221	50-9717-3	444-12-23
COOP	TOLM	17461A	-6-J	F-106 MLG	STRUT ASSY	1620-00-592-9638	578100-505	451-32-23

FACTORED

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAND HOURS
17402A	MNPGP	J0010	N	H3	5	4.36	1.00	4.36
		PP502	N	SS	5	.97	1.00	.97
F-15 NLG		PP512	N	SS	5	1.30	1.00	1.30
FAMILY 4 *								6.53
	MNPGW	PM512	E	DJ	5	1.35	1.00	1.35
		W0001	E	KI	5	1.71	1.00	1.71
		W0001	E	H3	5	2.62	1.00	2.62
		WE501	E	DI	5	1.66	1.00	1.66
		WE502	N	DI	5	.18	1.00	.18
		WE503	N	DI	5	1.12	1.00	1.12
		WE504	N	DI	5	.16	1.00	.16
		WE506	N	DI	5	.16	1.00	.16
		WE513	N	DI	5	.16	1.00	.16
		XNPGW	X	H3	5	5.61	1.00	5.61
*								14.79
	MNPNA	NA501	E	DB	2	.43	.96	.43
		NA502	E	DB	2	.05	1.00	.05
		NA503	N	DB	2	1.91	1.00	1.91
		NA504	E	DB	2	.33	1.00	.33
		NA506	E	DB	2	.12	.67	.12
		NA513	E	DB	2	.40	1.00	.40
		XNPNA	X	DB	2	3.58	1.00	3.58
*								6.76
	MNPRA	RA501	E	JA	1	6.77	1.00	6.77
		RA502	E	JA	1	7.22	1.00	7.22
		RA503	E	JA	1	1.56	1.00	1.56
		RA506	E	JA	1	.54	.05	.54
		RA513	E	JA	1	.54	1.00	.54
*								16.11
	MNPRB	R3501	E	JA	3	9.09	.92	8.36
		R3503	N	JA	3	9.67	.26	2.51
		R3504	E	JA	3	6.94	.95	6.59
		R3506	E	JA	3	.52	.05	.52
		R3513	E	JA	3	1.30	1.00	1.30
*								18.78
	MNPRC	RC501	E	UP	3	2.43	.96	2.33
		RC502	E	UP	3	.34	1.00	.34
		RC503	E	UP	3	2.97	1.00	2.97
		RC504	N	UP	3	4.43	1.00	4.43
		RC506	E	UP	3	.93	.96	.89
		RC513	N	UP	3	2.27	.87	2.27
		XNPRC	X	UP	3	2.77	1.00	2.77

(G402A-TIP001)

LABOR STD REVIEW 10, APR, 69

4:37 PM

PROD NBR	RCC	OPER NBR	TYP STD	SY	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
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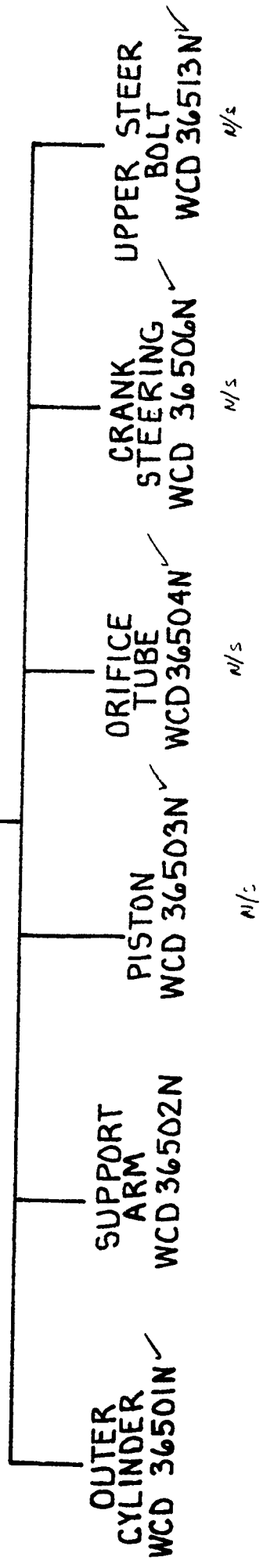
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16.00

17402A	MNPWW	WFS02	N	WF	9	3.15	.75	2.36
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2.36

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81.43

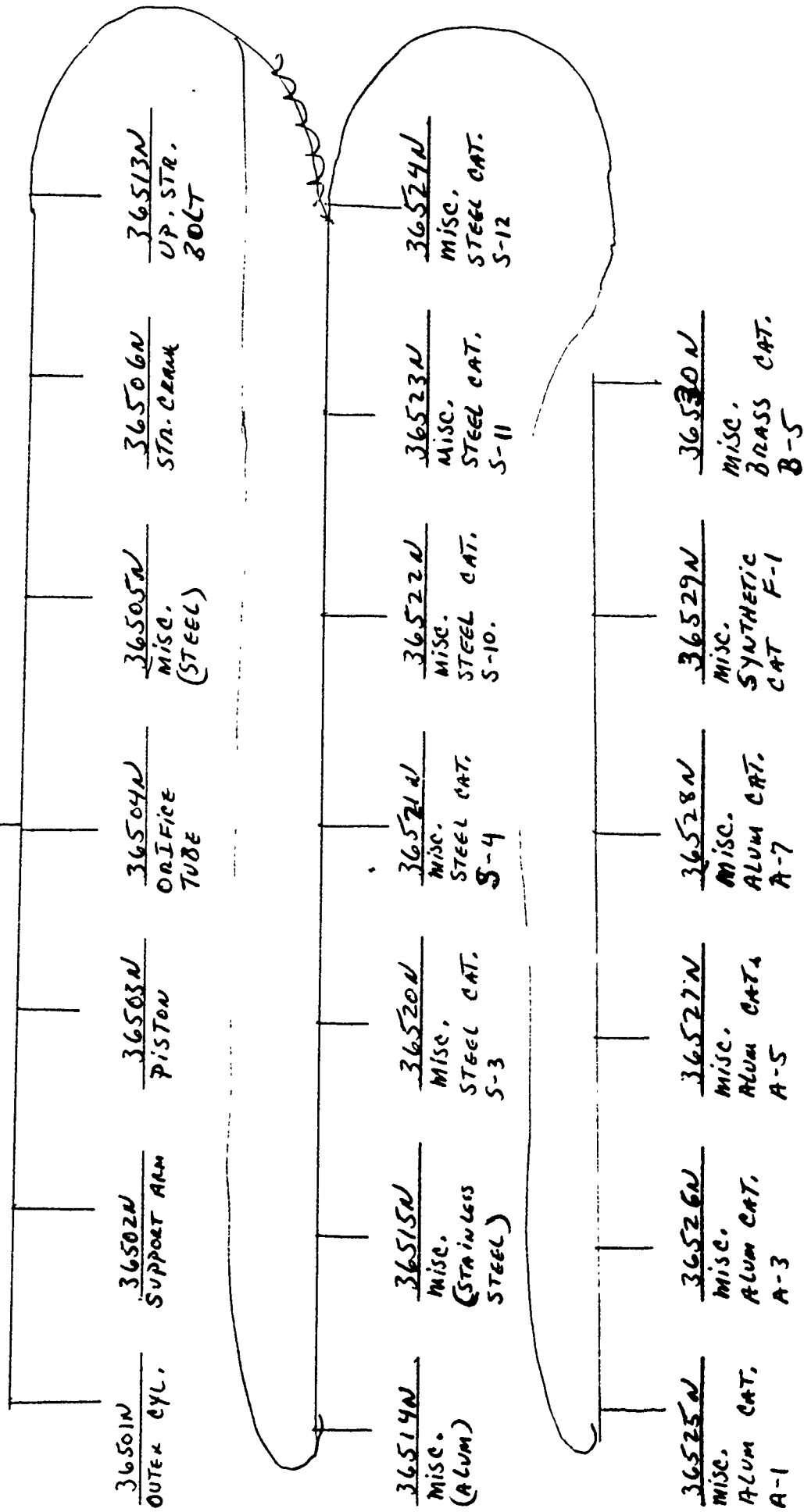
F-15  
NOSE LANDING GEAR ASSY  
PCN 17402A  
WCD 36512N ✓



# F-15 NLG

Assy	Complete	79 operations
DISASSY	''	106 OPER
PLATING		190 OPER
NOI		<del>58</del> 58 OPER
Machine/Grind		155
WELD		6 OPER

STRUT A.  
36512N  
C/N 17402A



# F-15 NLG OLA

<u>C/N</u>	<u>WLD NAME</u>	<u>NOUW</u>
17402A } 60343A }	36501N	OUTER CYL.
17402A } 68884A }	36502N	SUPPORT ARM (BRONZE) I.D
17402A } 63269A }	36503N	PISTON
17402A } 17494A }	36504N	ORIFICE TUBE
17402A	36505N	MISC. (STEEL)
17402A	36506N	CRANK STEERING
17484A	36587N	UPPER TERY LINK.
69455A	<del>365</del> 36509N	UPPER BRACE ASSY
69707A	36510N	LOWER BRACE ASSY
26244A	36511N	TURY LINK LOWER
17402A	36512N *	STRUT ASSY
17402A	36513N	UPPER STEERING BOLT
17402A	36514N	MISC. (ALUM.)
174021A	36515N	MISC. (STAINLESS STEEL)
17402A	36520N	MISC. STEEL CAT. S-3
17402A	36521N	MISC. STEEL CAT. S-4
17402A	36522N	MISC. STEEL CAT. S-10
17402A	36523N	MISC. STEEL CAT. S-11
17402A	36524N	MISC. STEEL CAT. S-12
17402A	36525N	MISC. ALUM. CAT. A-1
17402A	36526N	MISC. ALUM. CAT. A-3
17402A	36527N	MISC. ALUM. CAT. A-5
17402A	36528N	" " CAT. A-7
17402A	365229N	" SYNTHETIC CAT. F-1



<u>C/N</u>	<u>WCD NAME</u>	<u>NOUN</u>
17402A	36530N	Misc. DRABS CAT. B-5
17402A	36531N	" SS CAT. SS-2
17402A	36532N	" CAT. SS-3
17402A	36533N	" SS CAT. SS-4

ON 80/20 LIST

17402A

NET ON 80/20 LIST

26244A

69707A

69455A

17484A

63269A

68884A

60343A

36512N WORK CONTROL DOCUMENT (MEDS)

DATE 89039

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2 JOB ORDER NO 17402A	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER 68A450600-1013	8 TECH DATA 4S-1-182 4S2-73-3	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES F-15 NLO	11 STOCK NUMBER 1620010627002	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN STRUT ASSY	17402A
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15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
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		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
--	--	--	--	--	--

		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND			
--	--	---	--	--	--

		T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH			
--	--	---	--	--	--

		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
--	--	---	--	--	--

		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF			
--	--	---	--	--	--

		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
--	--	--	--	--	--

		PRECLUDE INJURIES. *REDD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
--	--	---	--	--	--

	001	68A450600-1013			
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34A		MATCH-UP **ROUTED COMPONENTS** *REQUI* NEW REWORKED NO SERVICABLE 958 REWORK		001 MNP GP 002 06 003 MU01	
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		OUTER CYL / / 36501N (CONTINUED)			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36512N	
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCT/SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN STPUT ASSY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18 MECHANIC	19	20
		SUPPORT ARM / 36502N							
		PISTON / 36503N							
		ORIFICE TUBE / 36504N							
		MISC. (STEEL) / 36505N							
		STR. CRANK / 36506N							
		UP STR BOLT / 36510N							
		MISC. (ALUM) / 36514N							
		MISC. (STAINLESS STEEL) / 36515N							
		MISC STEEL CAT S-3 / 36520N							
		MISC STEEL CAT S-4 / 36521N							
		MISC STEEL CAT S-10 / 36522N							
		MISC STEEL CAT S-11 / 36523N							
		MISC STEEL CAT S-12 / 36524N							
		MISC ALUM CAT A-1 / 36525N							
		MISC ALUM CAT A-3 / 36526N							
		MISC ALUM CAT A-5 / 36527N							
		MISC ALUM CAT A-7 / 36528N							
		MISC SYNTHETIC CAT F-1 / 36529N							
		MISC BRASS CAT B-5 / 36530N							
*C/P MOVE									

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8. TECH DATA		9. ITEM SERIAL NO.	
10 MODEL DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL		
13 SERIAL NUMBER	14 NOUN STRUT ASSY			

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20. "Q"
33A	[REDACTED] *REQD*	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FOREIGN MATERIAL PRIOR TO REASSEMBLE *C/P MOVE	5	001 MNPDP 002 06 003 SA03	
34A	[REDACTED] *REQD*	OK TO CLOSE AND/OR ASSEMBLE *C/P MOVE	2.4	001 MNPDP 002 06 003 SA03	
33A	[REDACTED] *REQD*	CAM ALIGNMENT *C/P MOVE		001 MNPDP 002 06 003 SA03	
34A	[REDACTED] *REQD*	CHECK STROKE JAW T.O. *C/P MOVE		001 MNPDP 002 06 003 SA03	
34A	[REDACTED] *REQD*	SAFETY WIRE AS REQUIRED. JAW T.O. 452-73-3 *C/P MOVE	20	001 MNPDP 002 06 003 SA03	
34A	[REDACTED] *REQD*	TIGHTEN, TORQUE NUTS & BOLTS JAW T.O. 452-73-3 PG 8-5 *C/P MOVE	20	001 MNPDP 002 06 003 SA03	
34T	[REDACTED] *REQD*	PRESSURE TEST *C/P MOVE		001 MNPDP 002 06 003 TL07	
32P	[REDACTED] *REQD*	MASK, PRIME AND PAINT *C/P MOVE **NOTE** CHECK OPERATION NUMBERS 450 AND 460 ON PISTON WCD 958 FOR COLOR OF BANDS		001 MNPDP 002 09 003 WB03	
34P	[REDACTED] *REQD*	DECALS *C/P MOVE		001 MNPDP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9. ITEM SERIAL NO.
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER	12 OPTIONAL	
13 SERIAL NUMBER		14 NOUN STRUT ASSY		

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34P	[REDACTED] *REQD*	PROTECTIVE MASK ALL EXPOSED THREADED SURFACES *C/P MOVE		001 MNRGP 002 09 003 WR03	
34P	[REDACTED] *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNRGP 002 09 003 WR03	
34P	[REDACTED] *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNRGP 002 09 003 WR03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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36501N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPRA	5 DATE SCHED	6 DATE COMPLETE
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7 PART NUMBER	8 TECH DATA 4S-1-182 4S2-73-3 & -4	9 ITEM SERIAL N
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10 MODEL-DESIGN-SERIES F 15 NLG	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	17402A
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19	20
P-N		NSN C7R			
68A45002-1001		1620003109830 17402A			
68A45002-1001		1620003109830 60343A			

\*\*\*\*\* UNIT COST: 42704.13 \*\*\*\*\*

GOVERNING DIRECTIVES: AFLOR 60-51

MANC: 60-3

FPI IAW MIL-STD-6866

STRIP IAW MIL-STD-871

SHOT PLEN IAW MIL-S-13165

ANODIZE IAW MIL-A-8625

BRUSH ANODIZE IAW MIL-STD-865

BLAST IAW MIL-STD-1504

\*\*\*\*\* ALUMINUM \*\*\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O. S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

WARNING

MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO INEXPERIENCED PERSONNEL. ADEQUATE SAFEGUARDS & PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450302 1001							
	005	DISASSEMBLE. +C/P MOVE						001 MNP GW 002 02 003 LG02 005 X8745194	
33C	007	CHEM CLEAN +C/P MOVE						001 MNP GW 002 03 003 AC02	
33D	009	BLAST CLEAN ONLY +C/P MOVE						001 MNP GW 002 03 003 BL01	
		[REDACTED] +C/P MOVE				M		001 MNP PA 002 05 003 ZY05	
34E	040	E & I INSPECTION						001 MNP GW 002 04 003 EI01	
		*REQD* DRAG BRACE BUSHINGS I.D. .8750/.8760/.8780							
		FACE TO FACE .880/.887/REP AT .905 FLANGE THICKNESS MIN .050							
		UPPER JURY BRACE BUSHING I.D. .8440/.8450/.8470							
		FACE TO FACE 2.295/2.302/REP AT 2.316 FLANGE .039/.040 MIN .032							
		LOWER SUPPORT ARM BUSHINGS I.D. .7500/.7510/.7530 (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20. "Q"
		FACE TO FACE .880/.887/.905 REPLACE AT .942 FLANGE .039/.040 MIN .032			
		UPPER SUPPORT ARM BUSHINGS I.D. .9995/1.0005/1.0070 FACE TO FACE 2.170/2.176/REP 2.190 FLANGE .039/.040 MIN .032			
		ORIFICE HOLE BUSHINGS I.D. 1.9920/1.9930/1.9950 WEAR 1.997			
		TRUNNION SOCKET BUSHINGS I.D. 1.1250/1.1260/1.1280			
		FACE TO FACE 15.366/15.372/REP AT 15.356 FLANGE .059/.060 MIN .052			
		ROCK LINK BUSHINGS I.D. .2500/.2510/.2530 TIE DOWN LUGS .477/.438			
		FACE TO FACE 2.093/2.138/REP 2.168 FLANGE .060/.062 LOWER BORE ID 4.244/4.246/4.253 MAX UPPER BORE I.D. 4.0000/4.0020/4.0070 MAX.			
		*****N O T E***** 100% INSPECTION IS REQUIRED OF NLG OUTER CYLINDER, P/N 68A450602-1001. INSPECT TRUNNION SOCKET WALL THICK- NESS TO INSURE THAT THEY MEET THE DIMENSIONAL REQUIREMENTS OF DRAWING NO. 68A450602. WALL THICKNESS WITH BUSH. .748+- .020, WITHOUT BUSH. .675+- .020. UNITS WITH SOCKET WALL (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36501N
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8. TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 "Q"	
		TOO THICK WILL REQUIRE ENGINEERING ASSISTANCE. ***** NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FPJ MUST BE PERFORMED. *C/P MOVE							
69 ✓	045	BUSHING REMOVAL *C/P MOVE						001 MNRA 002 03 003 BE01	
69 ✓	048	O/S DRIFICE TUBE SUPPORT BUSHING SOCKET MAX REWORK DIA 2.251						001 MNRA 002 03 003 MH04	
69 ✓	050	DRIFICE TUBE HOLE REPAIR OVERSIZE 2.052/2.112 MACHINE AS REQUIRED MIN 2.052 MAX 2.112 *C/P MOVE						001 MNRA 002 03 003 MH04	
69 ✓	051	LOWER DRAG BRACE BUSHING REPAIR O/S MACHINE LUG O/S 1.064 MAX *C/P MOVE						001 MNRA 002 03 003 BE01	
69 ✓	052	TIE DOWN LUGS 2 PLACES BUSHING REPAIR O/S MACHINE LUGS O/S .626 MAX *C/P MOVE						001 MNRA 002 03 003 BE01	
69 ✓	053	DOOR LINK LUG O/S REPAIR MACHINE LUG O/S .4385 MAX *C/P MOVE						001 MNRA 002 03 003 BE01	
69 ✓	054	SUPPORT ARM LOWER LUG O/S REPAIR MACHINE LUG O/S .939 MAX *C/P MOVE						001 MNRA 002 03 003 BE01	
69 ✓	055	SUPPORT ARM UPPER LUG O/S REPAIR MACHINE LUG O/S 1.189 MAX *C/P MOVE						001 MNRA 002 03 003 BE01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36501N			
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN OUTER CYLINDER
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 'P'	20 'Q'
69 ✓	056	UPPER JURY BRACE LUG O/S REPAIR MACHINE LUG O/S .970 MAX *C/P MOVE		001 MNPRA 002 03 003 MH04	
69 ✓	057	TRUNNION SOCKET O/S REPAIR MACHINE LUGS O/S 1.314 MAX *C/P MOVE		001 MNPRA 002 03 003 BE01	
69 ✓	058	MACH MOUNTING HOLE O/S .263 MAX 1.0 *C/P MOVE  ***** NOTE ***** DO NOT STRIP DRIFICE TUNE HOLE		001 MNPRA 002 03 003 MH04	
26 ✓	059	STRIP TYPE 11 ANODIZE U.D. *C/P MOVE		001 MNPRA 002 03 003 AN04	
26 ✓	070	STRIP ANODIZE UPPER BORE *C/P MOVE		001 MNPRA 002 03 003 AN04	
26 ✓	080	STRIP ANODIZE LOWER BORE *C/P MOVE		001 MNPRA 002 03 003 AN04	
		 *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****	M	001 MNPRA 002 06 003 ZA02	
8	099	POLISH UPPER BORE 4.010 MAX		001 MNPRA 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN OUTER CYLINDER
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15 DISPATCH STATION	16 PER/RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20 "Q"
8 ✓	100	HONE UPPER BORE 4.010 MAX *C/P MOVE		001 MNPRB 002 01 003 HV02 005 XB745245	
8 ✓	101	POLISH LOWER BORE 4.247/4.255 O/S FOR HARD ANODIZE TYPE III		001 MNPRB 002 01 003 BE01	
8 ✓	102	HONE LOWER BORE 4.247/4.255 O/S FOR HARD ANODIZE TYPE III *C/P MOVE		001 MNPRB 002 01 003 HV02 005 XB745245	
26 ✓	104	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 0001	
26 ✓	105	GLASS BEAD THREADS ONLY .004/.008A *C/P MOVE		001 MNPRC 002 01 003 BL03	
26 ✓	110	SHOT PEEN ALL REWORKED AREAS ON 200% 4A TO 10A DO NOT SHOT PEEN AREAS AS PORTS, SEAT GROOVES ETC. *C/P MOVE		001 MNPRC 002 01 003 SP01	
26 ✓	120	SHOT PEEN UPPER BORE I.D. 200% 4A TO 10A DO NOT SHOT PEEN AREAS AS PORTS, SEAT GROOVES, ETC. *C/P MOVE		001 MNPRC 002 01 003 SP01	
26 ✓	125	SHOT PEEN LOWER BORE 200% 4A TO 10A *C/P MOVE		001 MNPRC 002 01 003 SP01	
26 ✓	130	SHOT PEEN OVERSIZED DRIFICE TUBE HOLE 200% 4A TO 10A DO NOT SHOT PEEN AREAS AS PORTS, SEAT GROOVES ETC *C/P MOVE		001 MNPRC 002 01 003 SP01	
26 ✓	135	ANODIZE OD TYPE II CLASS I *C/P MOVE		001 MNPRC 002 03 003 AS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOLN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18 MECHANIC	19. "P"	20. "Q"
26	138	ANODIZE ORIFICE TUBE HOLE IF ITS BEEN REWORKED TYPE II CLASS I *C/P MOVE						001 MNPRC 002 03 003 A503	
8	140	POLISH UPPER BORE AFTER SHOT SHOT PEEN 32RMS NOT TO EXCEED 4.010 PRODUCTION COUNT A0020 *C/P MOVE						001 MNPRB 002 01 003 BE01	
8	145	POLISH LOWER BORE AFTER SHOT PEEN. 32 R.M.S., NOT TO EXCEED 4.255 *C/P MOVE						001 MNPRB 002 01 003 BE01	
26	160	ANODIZE UPPER BORE TYPE III 4.000/4.004 *C/P MOVE						001 MNPRC 002 03 003 AH01 008 AJ010	
26	175	2ND REPAIR HARD ANODIZE TYPE III LOWER BORE 4.244/4.246 NOT TO EXCEED 4.253 *C/P MOVE						001 MNPRC 002 03 07 YH01 06 AI020	
8	177	FINAL POLISH UPPER BORE 4.000/4.002 32 RMS *C/P MOVE						001 MNPRB 002 01 003 BE01	
8	179	FINAL POLISH LOWER BORE 4.244/4.245/4.253 32 RMS *C/P MOVE						001 MNPRB 002 01 003 BE01	
26BP	180	BRUSH ANODIZE ORIFICE TUBE HOLE AS PER T.O. *C/P MOVE						001 MNPRC 002 02 003 BP01	
26	182	ADDITIONE REWORK AREAS IAW MIL-C-5541						001 MNPRC 002 03 003 TA01	
69	184	MACHINE MOUNTING BUSH O/S *C/P MOVE P/N 7829423-15						001 MNPRB 002 03 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERFORM NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P"	20. "O"	
69 ✓	185	MOUNTING BUSH O/S INSTALLATION FINISH I.D. .190/.200 P/N 7829423-15 PRESS FIT .0005-.0010 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	189	MACHINE DRAG BRACE BUSHING *C/P MOVE P/N ST4M130-14004					001 MNFRA 002 03 003 LE02		
69 ✓	190	DRAG BRACE BUSHINGS INSTALLATION P/N ST4M130-14004 LINE REAM .87501/.8760 FACE TO FACE .880/.887 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	194	MACHINE DRAG BRACE O/S BUSHING *C/P MOVE P/N 7829424-35					001 MNFRA 002 03 003 LE02		
69 ✓	195	DRAG BRACE O/S BUSHING INSTALLATION LINE REAM TO .875/.876 6ARMS FACE TO FACE .880/.887 PRESS FIT .0010-.0025 P/N 7829424-35 *C/P MOVE					001 MNFRA 002 03 003 BE01		
69 ✓	199	MACHINE UPPER JURY BRACE BUSHING *C/P MOVE P/N ST4M130-14003					001 MNFRA 002 03 003 LE02		
69 ✓	200	UPPER JURY BRACE BUSH INSTALLATION P/N ST4M130-14003 LINE REAM .84401/.8450 FACE TO FACE 2.295/2.302 *C/P MOVE					001 MNFRA 002 03 003 BE01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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36501N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
69 ✓	204	MACHINE UPPER JURY BRACE O/S/ BUSH *C/P MOVE P/N 7829424-23					001 MNFRA	002 03	003 LE02
69 ✓	205	UPPER JURY BRACE O/S BUSHING INSTALLATION LINE REAM .844/.845 64 RMS FACE TO FACE 2.295/2.302 PRESS FIT .0005-.0015 P/N 7829424-23 *C/P MOVE					001 MNFRA	002 03	003 BE01
69 ✓	219	MACHINE UPPER SUPPORT ARM BUSH *C/P MOVE P/N 5T4M130-16000					001 MNFRA	002 03	003 LE02
69 ✓	220	UPPER SUPPORT ARM BUSH INSTALLATION P/N 5T4M130-16002 FINISH I.D. .9995/1.0005 FACE TO FACE 2.170/2.176 *C/P MOVE					001 MNFRA	002 03	003 BE01
69 ✓	224	MACHINE SUPPORT ARM UPPER LUG O/S BUSHING *C/P MOVE P/N 7829424-25					001 MNFRA	002 03	003 LE02
69 ✓	225	SUPPORT ARM UPPER LUG O/S BUSHING INSTALLATION LINE REAM .9995/1.0005 64 RMS FACE TO FACE 2.170/2.176 PRESS FIT .0010-.0025 P/N 7829424-25 *C/P MOVE					001 MNFRA	002 03	003 BE01
69 ✓	229	MACHINE LOWER SUPPORT ARM BUSHING *C/P MOVE P/N 5T4M130-12007					001 MNFRA	002 03	003 LE02
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
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7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69 ✓	230	LOWER SUPPORT ARM BUSH INSTALLATION P/N ST4M130-12007 FINISH I.D. .7500/.7510 FACE TO FACE .956/.962 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69 ✓	234	MACHINE SUPPORT ARM LOWER LUG O/S BUSHING *C/P MOVE P/N 7829424-27					001 MNPRA 002 03 003 LE02		
69 ✓	235	SUPPORT ARM LOWER LUG O/S BUSHING INSTALLATION LINE REAM .750/.751 64 RMS FACE TO FACE .956/.962 PRESS FIT .0005-.0010 P/N 7829424-27 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69 ✓	239	MACHINE DOOR LINK BUSHING *C/P MOVE P/N ST4M130-04001					001 MNPRA 002 03 003 LE02		
69 ✓	240	DOOR LINK BUSHING INSTALLATION P/N ST4M130-04001 FINISH ID .2500/.2510 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69 ✓	244	MACHINE DOOR LINK LUG O/S BUSHING *C/P MOVE P/N 7829424-33					001 MNPRA 002 03 003 LE02		
69 ✓	245	DOOR LINK LUG O/S BUSH INSTALLATION LINE REAM TO .250/.251 64 RMS P/N 7829424-33 PRESS FIT .0005-.0010 *C/P MOVE					001 MNPRA 002 03 003 BE01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN OUTER CYLINDER
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18. DISPATCH STATION	16. PERFORM. RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69 ✓	249	MACHINE TRUNNION SOCKET BUSHING *C/P MOVE P/N 68A450631-2001		001 MNPRA 002 03 003 LE02	
69 ✓	250	TRUNNION SOCKET BUSH INSTALLATION P/N 68A450631-2001 FINISH I.D. 1.1250/1.1260 FACE TO FACE 15.366/15.372 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69 ✓	254	MACHINE TRUNNION SOCKET O/S BUSH *C/P MOVE P/N 7829420-1		001 MNPRA 002 03 003 LE02	
69 ✓	255	TRUNNION SOCKET O/S BUSHING INSTALLATION LINE REAM 1.125/1.126 FACE TO FACE 15.366/15.372 PRESS FIT .0010-.0025 P/N 7829420-1 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69 ✓	259	MACHINE TIE DOWN LUGS BUSHING *C/P MOVE P/N ST4M139P7-44		001 MNPRA 002 03 003 LE02	
69 ✓	260	TIE DOWN LUGS BUSHING INSTALLATION P/N ST4M139P7-44 FINISH ID .437/.438 FACE TO FACE 2.093/2.133 PRODUCTION COUNT B0020 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69 ✓	264	MACHINE TIE DOWN LUG O/S BUSHING *C/P MOVE P/N 7829424-31		001 MNPRA 002 03 003 LE02	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OCTER CYLINDER						
15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69 ✓	265	TIE DOWN LUG O/S BUSH INSTALLATION 2 PLACES LINE REAM TO .562/.563 64 RMS FACE TO FACE 2.093/2.138 PRESS FIT .0005-.0010 P/N 7829424-31 *C/P MOVE					001 MNRRA 002 03 003 BE01		
69 ✓	279	MACHINE ORIFICE TUBE HOLE BUSH *C/P MOVE P/N 8412725-01 P/N 2-033N674					001 MNRRA 002 03 003 LE02		
69 ✓	280	ORIFICE TUBE HOLE BUSHING P/N 8412725-01 & P/N 2-033N674 INSTALLATION, LOWER FINISH I.D. 1.9920/1.9930 SHRINK FIT .0005-.0015 *C/P MOVE					001 MNRRA 002 03 003 BE01		
69 ✓	289	MACHINE ORIFICE TUBE HOLE BUSHING *C/P MOVE P/N ST4M130-24002					001 MNRRA 002 03 003 LE02		
69 ✓	290	ORIFICE TUBE HOLE BUSHING INSTAL. P/N ST4M 130-24002 FINISH ID 1.9920/1.9930 SHRINK FIT .0005-.0015 *C/P MOVE					001 MNRRA 002 03 003 BE01		
69 ✓	294	MACHINE ORIFICE TUBE HOLE O/S BUSHING *C/P MOVE P/N 7829424-91					001 MNRRA 002 03 003 LE02		
69	295	ORIFICE TUBE HOLE BUSHING INSTALL O/S FINISH I.D. 1.9920/1.9930 *C/P MOVE P/N 7829424-91					001 MNRRA 002 03 003 BE01		

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19. "P"	20 "Q"
[REDACTED]	297	PAINT RC/P MOVE						001 MNR GP 002 09 003 WBO3	
[REDACTED]	298	DECAL RC/P MOVE						001 MNR GP 002 09 003 WBO3	
[REDACTED]	300	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958						001 MNR GP 002 06 003 SA03	
[REDACTED]	310	FINAL PRODUCT VISUAL INSPECTION RC/P MOVE						001 MNR GP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
7. PART NUMBER		8 TECH DATA 4S-1-182 4S2-73-3 & -4		9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES F-15 NLG	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN SUPPORT ARM (BRONZE) I.D.	17402A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P7N 68A450	53-1001	NSN C/N 1620003051726 17402A 68884A			
		***** UNIT COST: 1547.02 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANUT 66-3 FPI JAW MIL-STD-6866 STRIP 1AW MIL-STD-871 ANODIZE 1AW MIL-A-8625 ALDGINE 1AW MIL-C-5541 BLAST 1AW MIL-SID-1504 FLAME SPRAY 1AW MIL-STD-869 *****ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO INEXPERIENCED PERSONNEL. ADEQUATE SAFEGUARDS & PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15. DISPATCH STATION	16. PERFORM NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQU* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450653-1001							
	005	DISASSEMBLE						001 MNR GW	
	*REQU*							002 02	
								003 L802	
								005 X8745199	
	007	CHEM CLEAN						001 MNR GW	
	*REQU*							002 03	
								003 AC02	
	009	BLAST CLEAN ONLY						001 MNR GW	
	*REQU*							002 03	
								003 BL07	
		[REDACTED]						001 MNR NA	
	*REQU*					M		002 05	
								003 ZY05	
	020	E & I INSPECTION						001 MNR GW	
	*REQU*	UPPER BEARING I.D. 2.4995/2.5010/2.5040/0.5400						002 04	
		LOWER BEARING I.D. 1.8745/1.8760/1.8790						003 E101	
		SUPPORT ARM UPPER BOLT HOLE I.D. 1.0000/1.0010/1.0030							
		SUPPORT ARM LOWER BOLT HOLE I.D. .75007.75107.7530							
		OVERALL 4.107/4.113 (CONTINUED)							

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15 DISPATCH STATION	16 PERFORM NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		NOTE: IF SUPPORT ARM HAS BLACK FABROID COATING, ROUTE TO MACHINE SHOP FOR FLAME SPRAY: REIDENTIFY USING P/N 68A450653-1001 *C/P MOVE							
26 ✓	021	STRIP ANODIZE *C/P MOVE*						001 MNRRC 002 03 003 AN04	
69 ✓	022	O/S LOWER BOLT HOLE .814 MAX AS REQUIRED ONLY TO REMOVE CORROSION *C/P MOVE						001 MNRRA 002 02 003 MH06	
69 ✓	023	MACHINE LOG FACES TO REMOVE CORROSION IAW AF DWG. 856003 1.0255/1.0305 FACE TO FACE * C/P MOVE						001 MNRRA 002 02 003 MV00	
69 ✓	024	O/S UPPER BOLT HOLE 1.120 MAX. AS REQ'D ONLY TO REMOVE CORROSION * C/P MOVE						001 MNRRA 002 02 003 MH06	
26 ✓	025	VAPOR DECREASE *C/P MOVE						001 MNRRC 002 03 003 IG01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****						001 MNRRA 002 06 003 ZA02	
26 ✓	028	ANODIZE TYPE II CLASS I NOTE: MASK OFF UPPER AND LOWER BEARING I.D.'S AND LIPS (CONTINUED)						001 MNRRC 002 03 003 AS03	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SUPPORT ARM (BRONZE) I.D.						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
69 ✓	029	MACHINE O/S BUSHING *C/P MOVE P/N 7829423-21 P/N 7829424-95					001 MNFRA 002 02 003 LE02		
69 ✓	030	INSTALL FLANGED BUSHING IF OPERATION 023 COMPLETED P/N 7829424-95 I.D. .750/.751 32 PMS FACE TO FACE .9655/.9680/.9705 PRESS FIT .0005-.0020 *C/P MOVE					001 MNFRA 002 02 003 BE01		
69 ✓	032	INSTALL O/S BUSHING 7829423-21 ID .750/.751 FIT AT .0005/.0015 *C/P MOVE					001 MNFRA 002 02 003 BE01		
69 ✓	034	MACHINE O/S BUSHING *C/P MOVE P/N 7829423-35					001 MNFRA 002 02 003 LE02		
69 ✓	036	INSTALL O/S BUSHING 7829423-35 I.D. 1.000/1.001 FIT AT .0005/.0020 *C/P MOVE					001 MNFRA 002 02 003 RE01		
69 ✓	037	MACHINE UPPER LIP FOR FLAME SPRAY IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNFRA 002 02 003 LE02 005 X8633612		
69 ✓	038	MACHINE 45 DEGREE CHAMFER ON UPPER LIP FOR FLAME SPRAY IAW PRINT 68A450653					001 MNFRA 002 02 003 LE02 005 X8633612		
69 ✓	040	MACHINE LOWER LIP FOR FLAME SPRAY IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNFRA 002 03 003 MV00 005 X8633613		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN	
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15 DISPATCH STATION	16 PERF RCC'OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 'P'	20 'Q'	
69 ✓	050	OVERSIZE UPPER BEARING ID FOR FLAME SPRAY MAX 2.528/2.518 MIN *C/P MOVE					001 MNPRA 002 02 003 LE02 005 X8633612		
69 ✓	060	OVERSIZE LOWER BEARING ID FOR FLAME SPRAY MAX 1.903/1.893 *C/P MOVE					001 MNPRA 002 02 003 LE02 005 X8633612		
		[REDACTED] TO FLAME SPRAY *C/P MOVE					001 MNPWW 002 08 003 DG02		
		[REDACTED] AREAS PRIOR TO FLAME SPRAY *C/P MOVE					001 MNPWW 002 08 003 BL01		
		[REDACTED] BEARING SUFFICIENT TO MACHINE TO 2.4995/2.5015 IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPWW 002 08 003 FS12 005 X8929483		
		[REDACTED] BEARING SUFFICIENT TO MACHINE TO 1.8745/1.8765 IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPWW 002 08 003 FS12 005 X8929483		
		[REDACTED] R LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPWW 002 08 003 FS12 005 X8929483		
		[REDACTED] R LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE					001 MNPWW 002 08 003 FS12		
69 ✓	140	MACHINE UPPER BEARING I.D. 2.4995/2.5015 *C/P MOVE NOTE: REF FIG 9-4 FOR ALLOW LIMITS ON FLAME SPRAY					001 MNPRA 002 02 003 LE02 005 X8633618		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SUPPORT ARM (BRONZE) I.D.						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 "P"	20 "Q"
69 J	150	MACHINE LOWER BEARING I.D. 1.8745/1.8765 *C/P MOVE						001 MNPRN 002 O2 003 LE02 005 XB633612	
69 J	160	MACHINE UPPER LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPRA 002 O2 003 LE02 005 XB633612	
69 J	165	MACHINE 45 DEGREE CHAMFER ON UPPER LIP IAW PRINT 68A450653						001 MNPRA 002 O2 003 LE02 005 XB633612	
69 J	170	MACHINE LOWER LIP IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPRA 002 O2 003 HV00 005 XB633612	
69 J	180	DRILL HOLE FOR NASS16-1 FITTING IAW MCDONNELL PRINT 68A450653 *C/P MOVE						001 MNPRA 002 O2 003 BE01	
69 J	181	REIDENTIFY TO 68A450653-1001 *C/P MOVE						001 MNPRA 002 O3 003 BE01	
26 ✓	183	SPOT ALUMINE ONLY *C/P MOVE						001 MNPRC 002 O3 003 TA01	
34P		MASK, PRIME AND PAINT *C/P MOVE						001 MNPRGP 002 O9 003 WB03	
34P		DECAL *C/P MOVE						001 MNPRGP 002 O9 003 WB03	
34P		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958						001 MNPRGP 002 O9 003 WB03	

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8. TECH DATA	9 ITEM SERIAL NO
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10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN
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SUPPORT ARM (BRONZE) I. O.

15 DISPATCH STATION	16. PERFORM RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
JFF	[REDACTED]	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 RND CP 002 09 003 WR03	

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21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4S2-73-3 & -4 4S-1-182	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES F 15 NLG	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN PISTON	17402A
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
P/N 68A450	704-1003	NSN 1620010232138	C/N 17402A 63269A		

UNIT COST: \$15625.10 GOVERNING DIRECTIVES: AFPCR 66-51 MAN01 66-3 IVD ALUM PLATE IAW MIL-C-83488A FPJ IAW MIL-STD-6866 FMPI IAW MIL-STD-1949 P/O NO1561 STRIP IAW MIL-STD-871 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-150 BAKE IAW 4S-1-182 MA01 74-12 BLAST IAW MIL-STD-1504 ALODINE IAW MIL-C-5541 PRESS T F E L 280,000/300 000 PSI**					
ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS (CONTINUED)					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* IN COLUMN 18 IS EQUIVALENT TO DELTA STAMP.							
	001	88A4507, 4-1008							
	005	DISASSEMBLE		*C/P MOVE			001 MNP0W	002 02	
		*REQD*					003 1 002	005 XF 243 99	
	007	OILM CLOS		*C/P MOVE			001 MNP0W	002 03	
		*REQD*					003 SF 01		
	009	BLAST ID OF FORK AND BELL AREA WITH PLASTIC BEAD OR WALNUT SHELL TO REMOVE PAINT AND CORROSION (REFER TO FIGURE 8-6)					001 MNP0W	002 03	
		*REQD*					003 BL02		
		*C/P MOVE							
	011	BAKE 4 HRS AT 350-400F					001 MNP0W	002 03	
		*REQD*		DATE IN _____ TIME IN _____			003 BK03		
				DATE OUT _____ TIME OUT _____					
		*C/P MOVE							
		[REDACTED]					001 MNP0W	002 05	
		*REQD*					003 ML04		

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
E	000 *READY*	E 3. ] INSPECTION REF FIG 8-5 & 8-6 FOR INTERIOR, EXTERIOR REPAIR PISTON O.D. 3.495/3.497/3.492					001 MPLOW 002 04 003 EI01		
		INNER WHEEL JOURNAL 2.2447/2.2466/2.2420 OUTER WHEEL JOURNAL 2.2147/2.2166/2.2120							
		OUTER AXLE I.D. 1.690/1.700 CENTER AXLE I.D. 1.940/1.960 INNER AXLE I.D. 1.550/1.570 PISTON UNLOCK ID .428/.409							
		PISTON TOE SOCKET .755/.765 I.D. PISTON I.D. 3.140/3.145							
		*****							
		* --- NOTE --- * CHECK RADIUS AS PER TECH ORDER * 1 0 0 % REQUIREMENT * RECORD SERIAL NUMBER FOR * ENGINEERING							
		* IF MACHINING OF RADIUS IS * REQUIRED, TEMPER ETCH MUST BE * ACCOMPLISHED							
		* CHECK FURK + AXLE AREA FOR PAINT * AND CORROSION REMOVAL *****							
		*****							
		* --- "SPECIAL NOTE" --- *ULTRA SONIC INSPECTION OPERATIONS * #035 AND #040 ARE NOT REQUIRED * FOR -2009 PISTONS *****							
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE							

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		[REDACTED] LAW FIG. 6-6 MIN WALL THICKNESS .190 IN RECORD MEASUREMENT *C/P MOVE				M	001 MNP/NA 002 05 003 EC04		
		[REDACTED] AS PER T.O. CHECK WALL THICKNESS .220/.310 AS PER T.O. RECORD MEASUREMENT *C/P MOVE				M	001 MNP/NA 002 05 003 EC04		
		[REDACTED] , IF .160 OR ABOVE , STA. 34P WILL PAINT A "1" INCH GREEN BAND BETWEEN JACK-PAD LUG AND PISTON AREA				M	001 MNP/NA 002 05 003 EC04		
		CHECK WALL THICKNESS BELOW .160 AND ESTIMATE NUMBER OF LANDINGS LEFT IN PISTON							
		RECORD "T1" DIMENSION-----							
		RECORD "T2" DIMENSION-----							
		RECORD "T MEN" DIMENSION-----							
		RECORD "T" DIMENSION-----							
		RECORD NUMBER OF LANDINGS----- STA. 34P WILL PAINT "1" INCH YELLOW BAND BETWEEN JACK-PAD AND PISTON AREA							
		***** NOTES ***** 1- IF LESS THAN 200 LANDINGS REMAIN AFLD FORM 103 THE PISTON							
		2- IF MORE THAN 200 LANDINGS REMAIN LANDINGS ARE TO BE ANNOTATED ON THE AFTO 95 FORM							
26	044	VAPOR DECREASE						001 MNP/RC 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36503N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
20 ✓	046	STRIP OAD *C/P MOVE					001 MNP RC	002 02 003 CS01	
26 ✓	048	STRIP RUST *C/P MOVE					001 MNP RC	002 02 003 CS02	
69 ✓	050	MACHINE RADIUS ON I.D. OF FORK IAW FIG 8-6 & DRAWING 68A450604 REMOVE X OR M FROM SER. #. *C/P MOVE					001 MNP RA	002 03 003 MH02	
69 ✓	060	POLISH RADIUS ON I.D. OF FORK IAW FIG 8-6. *C/P MOVE					001 MNP RA	002 03 003 BE01	
8 ✓	065	POLISH OUTER AXLE I.D. 1.680/1.700 *C/P MOVE+ 63RMS					001 MNP RR	002 01 003 BE01	
8 ✓	070	POLISH INNER AXLE I.D. 1.940/1.960 *C/P MOVE+ 63RMS					001 MNP RR	002 01 003 BE01	
8 ✓	075	POLISH INNER AXLE I.D. 1.550/1.570 *C/P MOVE 63RMS					001 MNP RR	002 01 003 BE01	
		[REDACTED] IAW FIG. 8-6 MIN WALL THICKNESS .190 IN *REQD* RECORD MEASUREMENT ..... *C/P MOVE				M	001 MNP RA	002 05 003 EC04	
69 ✓	090	UNLOCK BUSHING REPAIR OVERSIZE LUG MIN. .498 TO MAX AS REQUIRED TO .564 64 RMS *C/P MOVE					001 MNP RA	002 03 003 BE01	
69 ✓	100	TOW SOCKET BUSHING REPAIR OVERSIZE LUG MIN. .9360 TO MAX. 1.00 64 RMS (CONTINUED)					001 MNP RA	002 03 003 MH04	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		36503N				
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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO & ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
26 ✓	110	STRIP CHROME PISTON O.D. *C/P MOVE*					001 MNRRC 002 02 003 SC02		
26 ✓	112	STRIP CHROME INNER AXLE JOURNAL O.D. *C/P MOVE*					001 MNRRC 002 02 003 SC02		
26 ✓	115	STRIP CHROME OUTER AXLE JOURNAL O.D. *C/P MOVE*					001 MNRRC 002 02 003 SC02		
26 ✓	117	STRIP CHROME PISTON I.D. *C/P MOVE					001 MNRRC 002 02 003 SC02		
86 ✓	120	FIRST GRIND PISTON O.D. 3.4750 MIN *C/P MOVE					001 MNRRC 002 03 003 GG01 005 X8745186		
86 ✓	130	FIRST GRIND INNER AXLE JOURNAL U.D MIN DIA 2.2250 *C/P MOVE					001 MNRRC 002 03 003 GG01 005 X7831922		
86 ✓	140	FIRST GRIND OUTER AXLE JOURNAL O.D MIN DIA 2.195 *C/P MOVE					001 MNRRC 002 03 003 GG01 005 7831922		
8	145	FIRST HONE PISTON I.D. MAX. DIA 3.150 <i>Grind</i> *C/P MOVE					001 MNRRC 002 01 003 HV03 005 X8745246		
		[REDACTED] DATE OUT _____ *C/P MOVE				M	001 MNRNA 002 06 003 TE03		

(CONTINUED)

81. FINAL DESTINATION		82. COORDINATION/INITIATING RCC SIGNATURE/DATE		83. DOCUMENT/BN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 "P"	20 "Q"
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****							
26A	160	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE							001 MNPRC 002 02 003 BK01
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****					M		001 MNPRC 002 06 003 ML04
26	175	VAPOR DECREASE *C/P MOVE							001 MNPRC 002 03 003 DG01
26	180	SHOT PEEN REWORK AREA PISTON, 200% COVERAGE 3A TO 6A *C/P MOVE							001 MNPRC 002 01 003 SP02
26	190	SHOT PEEN FORK AND AXLE I.D. 200% COVERAGE 3 TO 6A INTENSITY *REQD* *C/P MOVE							001 MNPRC 002 01 003 SP02
26	200	GLASS BEAD PEEN THREADS INTENSITY 4A TO 8A *C/P MOVE							001 MNPRC 002 01 003 BL03
26	210	SHOT PEEN INNER AXLE JOURNALS 200% COVERAGE 3A TO 6A *C/P MOVE							001 MNPRC 002 01 003 SP02

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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		B	D		

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERFORM NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26 ✓	220	SHOT PEEN OUTER AXLE JOURNALS 200% COVERAGE 3A TO 6A *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	225	SHOTPEEN PISTON I.D. 200% COVERAGE 3A TO 6A *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	227	PREPARE AXLE JOURNALS FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	228	PREPARE AXLE JOURNALS FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	230	CHROME PLATE INNER AXLE JOURNAL CLASS III TYPE II SUFFICIENT TO GRIND TO 2.2447/2.2466					001 MNPRC 002 02 003 CP01 008 CD010		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26 ✓	240	CHROME PLATE OUTER AXLE JOURNAL CLASS III TYPE II SUFFICIENT TO GRIND TO 2.2147/2.2166					001 MNPRC 002 02 003 CP01 008 CD020		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26B ✓	250	BAKE 4 HRS WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
DISPATCH		FUNCTIONAL CODE	A		C		36503N		
			B		D				

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20 "Q"
26 ✓	253	PREPARE O.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC 002 02 003 BE01	
26 ✓	257	PREPARE PISTON O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	250	CHROME PLATE O.D. CLASS III TYPE II SUFFICIENT TO GRIND TO 3.495/ 3.497 DATE OUT TIME OUT MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC 002 02 003 CP01 005 X8343080 008 C0020	
26B ✓	270	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME. DATE & TIME IN DATE & TIME OUT *C/P MOVE						001 MNPRC 002 02 003 BK01	
26 ✓	271	PREPARE PISTON I.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC. MACHANIC SIGN OFF REQ'D *C/P MOVE						001 MNPRC 002 02 003 BE01	
26 ✓	272	PREPARE PISTON I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	273	CHROME PLATE PISTON I.D. CLASS III TYPE II SUFF. TO GRIND TO 3.140/3.145 (CONTINUED)						001 MNPRC 002 02 003 CP01 008 CI010	
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE	A	C	D	E	F	G	H	
								36503N	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQ'D _____							
26B ✓	275	BAKE 23 HRS AT 350-400 F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____						001 MNPFB 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *REQD AFTER FINAL CHROME PLATE OPERATION* *C/P MOVE							
8G ✓	280	FINISH GRIND INNER AXLE JOURNAL O.D. 2.2447/2.2466 *C/P MOVE						001 MNPFB 002 03 003 GG01 005 X7831922	
8G ✓	290	FINISH GRIND OUTER AXLE JOURNAL O.D. 2.2147/2.2166 *C/P MOVE						001 MNPFB 002 03 003 GG01 005 X7831922	
8G ✓	300	FINISH GRIND O.D. 3.495/3.497 16RMS *C/P MOVE						001 MNPFB 002 03 003 GG01 005 X8745186	
8 ✓	305	FINISH GRIND PISTON I.D. 3.140/3.145 32 RMS *C/P MOVE						001 MNPFB 002 02 003 GJ05	
26B ✓	310	BAKE 4 HRS DATE IN _____ TIME IN _____						001 MNPFB 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE				M		001 MNPFA 002 06 003 ML04	
				***** NOTE ***** (CONTINUED)					
81. FINAL DESTINATION			82. COORDINATION/INITIATING RCC SIGNATURE/DATE				83. DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE		A	C		36503N			
			B	D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIEE			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****							
26 ✓	325	VAPOR DECREASE *C/P MOVE						001 MNPRC 002 03 003 D001	
		*L/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				m		001 MNPRC 002 06 003 Z501	
26 ✓	331	GRIT BLAST PISTON I.D. JAW MIL-STD-1504 *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	332	GRIT BLAST AXLE I.D. JAW MIL-STD-1504 *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	333	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAS ALL AREAS TO BE CAD/VAC CAD/IVD PLATED *C/P MOVE						001 MNPRC 002 01 003 BL02	
26 ✓	335	VACUUM CAD PLATE TYPE II CLASS 2 OPTIONAL WHEN BUSHINGS HAVE NOT BEEN REMOVED *C/P MOVE						001 MNPRC 002 02 003 VC01	
26 ✓	340	CAD PLATE TYPE II CLASS 2 1.05 SQ FT AT 52.5 - 70.4 AMPS TIME OUT _____ DATE OUT _____ NOTE. AXLE AND FORK I.D. RECEIVES 100% SURFACE COVERAGE IAW FIG 8-6 *C/P MOVE						001 MNPRC 002 03 003 CA01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		36503N				
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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
---------------	-------------	-------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN PISTON	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
20B E ✓	380	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____		001 MNRRC 002 02 003 BK01	

		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

20 ✓	390	IRIDITE *C/P MOVE		001 MNRRC 002 02 003 IR01	
---------	-----	----------------------	--	---------------------------------	--

	-65	*C/P MOVE *****NOTE***** IF LAST MII OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****	M	001 MNRNA 002 06 003 MLO4	
--	-----	--	---	---------------------------------	--

20 ✓	402	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 275 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNRRC 002 03 003 IVO1	
---------	-----	---	--	---------------------------------	--

20 ✓	403	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNRRC 002 03 003 TA01	
---------	-----	--	--	---------------------------------	--

		AS PER FIG. 8-6 MIN WALL THICKNESS .190 IN *REQD* RECORD MEASUREMENT _____ *C/P MOVE	M	001 MNRNA 002 05 003 EC04	
--	--	---	---	---------------------------------	--

		AS PER T.O. CHECK WALL THICKNESS .280/.310 AS *REQD* PER T.O. RECORD MEASUREMENT _____ (CONTINUED)	M	001 MNRNA 002 05 003 EC04	
--	--	---	---	---------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36503N	
		B	D	20B	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN PISTON						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 "Q"	
		*C/P MOVE							
69 ✓	418	MACHINE TOWING BUSHING		63 RMS			001 MNPRA		
		P/N ST4M139P12-62		*C/P MOVE			002 03		
							003 LE02		
69 ✓	420	TOWING BUSHING INSTALLATION					001 MNPRA		
		*C/P MOVE*		.755/.765			002 03		
							003 ME01		
69 ✓	429	MACHINE UNLOCK BUSHING		64 RMS			001 MNPRA		
		P/N 7829423-11		*C/P MOVE			002 03		
							003 LE02		
69 ✓	430	UNLOCK BUSHING INSTALLATION							
		P/N 7829423-11 PRESS FIT .0005/.001							
		FINISH I.D. .438							
69 ✓	439	MACHINE TOW SOCKET BUSHING		64 RMS			001 MNPRA		
		P/N 7829424-21		*C/P MOVE			002 03		
							003 LE02		
69 ✓	440	TOW SOCKET BUSHING INSTALLATION							
		P/N 7829424-21 PRESS FIT .0005/.001							
		FINISH I.D. .755/.765							
	442	PRE- PAINT PISTON					001 MNP GP		
		*C/P MOVE*					002 09		
							003 PP01		
	445	ASSEMBLE NLG PISTON					001 MNP GP		
		*C/P MOVE*					002 06		
							003 SA03		
	450	PAINT FORK AND AXLE IAW I.D.					001 MNP GP		
		452-73-3 PARA. 4-12 TO 4-16					002 09		
		*C/P MOVE					003 WB03		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36503N	
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN PISTON	

15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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34P		PAINT GREEN BAND-----		001 MNFGP	
		PAINT YELLOW BAND-----		002 09	
				003 WB03	

(C/P MOVE)

34P		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFGP	
				002 09	
				003 WB03	

34P		FINAL PRODUCT VISUAL INSPECTION		001 MNFGP	
		(C/P MOVE)		002 09	
				003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPQP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4S2-73-3 & -4 4S-1-182	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES F 15 NLG	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN ORIFICE TUBE	17402A
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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P/N 68A4507	26-2001	NSN 1620003084145	C/N 17402A 17494A		
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		GOVERNING DIRECTIVES: AFMOR 68-51 MANDI 68-3			
		IVD ALUM PLATE IAW MIL-C-83488A			
		FPI IAW MIL-STD-6866			

		FMP1 IAW MIL-STD-1949 P/O N01561			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			

		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		CHROME IAW MIL-STD-1501 P/O N61891			

		AND/OR P/O N41321			
		ALCOINE IAW MIL-C-5541			
		VAC CHD IAW MIL-C 8637			
		CAD IAW MIL-STD-870			

		BAKE IAW 4S-1-182 MANDI 74-12			
		NICKLE PLATE IAW MIL-STD-865			
		BLAST IAW MIL-STD-1504			

		UNIT COST \$2298.00 STEEL 280,000/300,000			
--	--	--	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
--	--	---	--	--	--

		*COMPONENTS WILL BE THOROUGHLY (CONTINUED)			
--	--	--	--	--	--

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9. ITEM SERIAL NO.			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "O"	
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO INEXPERIENCED PERSONNEL. ADEQUATE SAFEGUARDS & PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A450726 2001							
<del>34C</del>	005 +REQD*	DISASSEMBLE		+C/P MOVE				001 MNP GW 002 02 003 LG02 005 XB745199	
<del>34C</del>	007 +PEQD+	CHEM CLEAN		+C/P MOVE				001 MNP GW 002 03 003 SL01	
<del>34C</del>	009 +REQD*	BLAST CLEAN ONLY		+C/P MOVE				001 MNP GW 002 03 003 BL01	
<del>34C</del>	011 +REQD*	BAKE 4 HRS AT 350-400F		DATE IN _____ TIME IN _____				001 MNP GW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____		+C/P MOVE					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20. "Q"	
	*REQD*	*C/P MOVE				M	001 MNPRA 002 05 003 MS03		
846	020	E & I INSPECTION SEAL LANDS O.D. 1.990/1.991 WEAR 1.987 I.D. 1.995/1.997 WEAR 1.999					001 MNPRA 002 04 003 E101		
		SPLINES AREA OVER 2 PINS 1.8847/1.8867 WEAR 1.8827 TUBE SEAL GROOVES 1.748/1.750/1.743							
8	035	POLISH ID TO CLEAN UP ONLY MAX ID 1.999 *C/P MOVE*					001 MNPRA 002 01 003 RE01		
8	036	HONE I.D. TO CLEAN UP ONLY. MAX I.D. 1.999					001 MNPRA 002 01 003 HVO 005 X8745245		
8	038	CHECK RACEWAYS TO CENTERLINE .623/.627 *REQD*					001 MNPRA 002 02 003 GS01 005 X8745174		
26	040	VAPOR DEGREASE *C/P MOVE					001 MNPRA 002 03 003 IG01		
26	042	STRIP CHROME, SEAL LANDS OD *C/P MOVE					001 MNPRA 002 02 003 SC02		
8	044	FIRST GRIND SEAL LANDS OD MIN DIA 1.970 *C/P MOVE*					001 MNPRA 002 02 003 GE00 005 X8745763		
8	045	FIRST GRIND TUBE SEAL GROOVES O.D. NOT TO EXCEED 1.730 *C/P MOVE					001 MNPRA 002 02 003 GE02		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		[REDACTED]				M		001 MNPNA 002 06 003 TE03	
		TIME OUT _____ DATE OUT _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *							
26B	048	BAKE 4 HRS WITHIN 8 HRS OF ETCH						001 MNP RC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]				M		001 MNPNA 002 06 003 ML04	
		*C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *							
26	051	VAPOR DECREASE						001 MNP RC 002 03 003 DG01	
		*C/P MOVE							
26	052	SHOT PEEN REWORKED AREA 200% COVERAGE INTENSITY OF .006/.010 A						001 MNP RC 002 01 003 SP02	
26	053	PREPARE SEAL LANDS OD FOR CHROME PLATE CLASS 3 TYPE II MASK/FIXTURE/ ETC. MECHANIC SIGN OFF REQUIRED						001 MNP RC 002 02 003 BE01	
26	054	CHROME PLATE SEAL LANDS O.D. CLASS 3 TYPE II SUFFICIENT TO GRIND BACK TO 1.9910/1.9900 (CONTINUED)						001 MNP RC 002 02 003 CP01 008 CD010	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36504N	
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 "P"	20 "Q"
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26B ✓	35	BAKE 4 HRS. WITHIN 4 HRS. OF PLATING  DATE IN- - - - - TIME IN- - - - -						001 MNPRC 002 02 003 BK01	
		DATE OUT- - - - - TIME OUT- - - - - *C/P MOVE*							
8 ✓	056	FINISH GRIND SEAL LANDS OD 1.990/1.991 16RMS *C/P MOVE						001 MNPRC 002 02 003 GE00 004 X8745763	
26B ✓	058	BAKE 4 HRS. 350/400F  DATE IN- - - - - TIME IN- - - - -						001 MNPRC 002 02 003 BK01	
		DATE OUT- - - - - TIME OUT- - - - - *C/P MOVE*							
26 ✓	059	PREPARE TUBE SEAL GROOVES O.D. FOR NICKLE PLATE MASK/FIXTURE/ETC. *C/P MOVE						001 MNPRC 002 02 003 BE01	
26 ✓	060	PREPARE FOR NICKLE PLATE GRIT BLAST *C/P MOVE						001 MNPRC 002 02 003 SC02	
26 ✓	061	PREPARE FOR NICKLE PLATE, DEGREASE/ HAND CLEAN *C/P MOVE						001 MNPRC 002 03 003 DG01	
26 ✓	062	NICKLE PLATE TUBE SEAL GROOVES O.D. SUFFICIENT TO GRIND TO 1.748/1.750						001 MNPRC 002 03 003 NP02	

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36504N
		B	D	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OP IF ICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
26 ✓	063	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF NICKLE PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRB 002 02 003 GS01 005 X8745174	
8 ✓	064	FINISH GRIND TUBE SEAL GROOVES O.D. 1.748/1.750 32RMS						001 MNPRB 002 02 003 GE02	
26 ✓	065	BAKE 4 HRS 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRB 002 02 003 BK01	
26 ✓	067	STRIP CHROME RACEWAYS *C/P MOVE						001 MNPRB 002 02 003 SC02	
8 ✓	069	CHECK CENTERLINE TO RACEWAY *C/P MOVE						001 MNPRB 002 02 003 GS01 005 X8745174	
8 ✓	070	1ST GRIND 4 DEG ANGLE ON ENDS OF RACEWAYS *C/P MOVE						001 MNPRB 002 02 003 GJ02	
8 ✓	080	FIRST GRIND RACEWAYS MIN .6000, FROM CENTER LINE *C/P MOVE						001 MNPRB 002 02 003 GS01 005 X8745174	
<p>NOTE: IF RACEWAY ARE GROUND INITIATE OP. 090, 100, 110, 120, 140, 151, 153, 154, (CONTINUED)</p>									
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
DISPATCH	FUNCTIONAL CODE		A	C		36504N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		200, 205 & 210							
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M		001 MNPNA 002 06 003 TEO3	
		***** NOTE ***** IF LAST NDJ OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
16B	100	BARE 4 HRS WITHIN 8 HRS OF ETCH						001 MNPRC 002 02 003 BK01	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]							
		*C/P MOVE*				M		001 MNPNA 002 06 003 ML04	
		***** NOTE ***** IF LAST NDJ OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
26	115	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26	120	***** NOTE ***** DO NOT SHOTPEEN RACEWAYS IF THEY * ARE TO BE FLASH CHROMED. *						001 MNPRC 002 01 003 SP02	
		SHOT PEEN REWORKED AREAS ONLY 200% COVERAGE AT .006/.010A INTENSITY (CONTINUED)							
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN			
DISPATCH		FUNCTIONAL CODE	A	C		36504N			
			B	D					

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7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
26 ✓	125	CLASS BEAD THREADS .004/.008A INTENSITY *C/P MOVE					001 MNPRC 002 01 003 BLOC		
26 ✓	130	PREPARE RACEWAYS FOR FLASH CHROME CLASS 3 TYPE I .0003 MIN. MASK/ FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	135	FLASH CHROME RACEWAYS CLASS 3 TYPE I .0003 MIN DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 008 C0020		
26 ✓	133	PREPARE RACEWAYS FOR CHROME PLATE CLASS 3 TYPE II. MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	140	CHROME PLATE RACEWAYS CLASS 3 TYPE II DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 006 C0020		
268 ✓	145	BAKE 4 HRS. WITHIN 4 HRS. OF PLATING DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36504N			
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
B ✓	150	FINISH GRIND 4 DEG ANGLE ON ENDS OF RACEWAYS  *C/P MOVE					001 MNPRC 002 02 003 GJ02		
B ✓	153	FINISH GRIND RACEWAYS SUFFICIENT TO CLEAN-UP 16RMS. 90% IAW T.O. PAGE 5-2 PARA 5-3 2-E  *C/P MOVE					001 MNPRC 002 02 003 GS01 005 X8745174		
26B ✓	154	BAKE 4 HRS. 350/400F  DATE IN----- TIME IN-----  DATE OUT----- TIME OUT----- *C/P MOVE*					001 MNPRC 002 02 003 BK01		
26 ✓	155	PREPARE RACEWAYS FOR CHROME LAMINATING, MASK/FIXTURE/ETC.					001 MNPRC 002 02 003 BE01		
26 ✓	156	LAMINATE RACEWAYS SUFFICIENT TO GRIND TO .623/.627 TIME OUT----- DATE OUT----- *C/P MOVE*					001 MNPRC 002 02 003 CP01 008 C0030		
26B ✓	160	BAKE 4 HRS. WITHIN 4 HRS. OF CHROME PLATE (IF VAC CAD PLATED)  DATE IN----- TIME IN-----  DATE OUT----- TIME OUT----- *C/P MOVE					001 MNPRC 002 02 003 BK01		
B ✓	162	FINISH GRIND RACEWAYS .623/.627 FROM CENTER LINE MUST MEET 16 RMS FINISH 90% IAW T.O. PAGE 5-2 PARA. 5-3 2-E  *C/P MOVE					001 MNPRC 002 02 003 GS01 005 X8745174		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		36504N				
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26B ✓	104	BAKE 4 HRS AT 350/400T DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ +C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	180	PREPARE SPLINES FOR FLASH CHROME PLATE CLASS 3 TYPE II. MASK/FIXTURE/ ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01		
26 ✓	192	FLASH CHROME PLATE SPLINES CLASS 3 TYPE II  DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED +C/P MOVE					001 MNPRC 002 02 003 CP01 008 CD040		
26B ✓	193	BAKE 4 HRS. WITHIN 4 HRS. OF PLATING  DATE IN- ----- TIME IN- -----  DATE OUT----- TIME OUT----- +C/P MOVE*					001 MNPRC 002 02 003 BK01		
		[REDACTED]  +C/P MOVE* ***** NOTE *****				M	001 MNPRC 002 06 003 ML04		
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODCUTION COUNT. *							
26 ✓	205	VAPOR DECREASE  +C/P MOVE					001 MNPRC 002 03 003 DG01		
		[REDACTED]  +C/P MOVE ***** NOTE *****				M	001 MNPRC 002 06 003 ZS01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		36504N				
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETD	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ORIFICE TURE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		REQUIRES 23 HRS. BAKE IF PART IS TO BE VACUUM CAD- PLATED AND HAS NOT RECEIVED A 23 HR. BAKE AFTER THE LAST CHROME PLATE OPERATION.							
		***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. + *****							
26B	213	BAKE 23 HRS AT 350-400 F IF PART IS TO BE VAC CAD OR VAC IVD PLATED. DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	217	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAS ALL AREAS TO BE CAD/VAC CAD/IVD PLATED. *C/P MOVE					001 MNPRC 002 01 003 RL04		
26	220	VACUUM CAD PLATE TYPE II CLASS 2 *C/P MOVE					001 MNPRC 002 02 003 VC01		
26	230	CAD PLATE TYPE II CLASS 2 .40 SQ FT AT 60 AMPS PER SQ FT TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B	240	BAKE 23 HRS WITH 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	243	IRIDIUM *C/P MOVE					001 MNPRC 002 02 003 IR01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36504N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OP OFFICE TUBE						
18 DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		[REDACTED]							
	265	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. † † † † † † † † † † † † † † † † †					M	001 MNFPA 002 06 003 ML04	
26	247	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 213 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE						001 MNPRC 002 03 003 1V01	
26	248	ALDINE IVD ALUM PLATE CLASS 1A *C/P MOVE						001 MNPRC 002 03 003 TA01	
8	249	CHECK I.D. FOR CORROSION, HONE I.D. IF CORRODED. MAX I.D. 1.999 *REQD* CLEAN & PROTECT I.D. WITH MIL-C-16173D, GRADE 1 CORROSION PREVENTIVE COMPOUND † C/P MOVE						001 MNPRC 002 01 003 HV02 005 X8745244	
	250	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958						001 MNPRC 002 06 003 SA03	
	260	FINAL PRODUCT VISUAL INSPECTION *REQD* †C/P MOVE						001 MNPRC 002 06 003 SA03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C	36504N		
		B				D			

U.S. GOVERNMENT PRINTING OFFICE: 1986-548-183

36506N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO 17402A	3 QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER 68A450610-2003	8. TECH DATA 4S-1-182 4S2-73-3			9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES 1-15 NOSE	11 STOCK NUMBER 1620003109834	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN CRANK STEERING	17402A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANO1 66-3 BLAST IAW MIL-STD-1504 FPI IAW MIL-STD-6866			
		BAKE IAW 45-1-182 CHROME PLATE IAW MAO1 74-12 MIL-STD-1501 P/O N41891			
		CAD PLATE IAW MIL-STD-870 FMP1 IAW MIL-STD-1949 P/O N01561 VAC 1VD ALUM PLATE IAW MIL-C-80468A			
		ALDINE IAW MIL-C-5541 TEMPER ETC IAW MIL-STD-867 ***UNIT COST \$781.10*** ***STEEL 300M 280-300 KSI***			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FROM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36506N
		B	D	

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1 DATE 89039

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIAL			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELIA STAMP.							
	001	68A450610-2000							
	005	DISASSEMBLE			*C/P MOVE			001 MNP GW	
	*REQD*							002 02	
								003 L002	
								005 X8745199	
	007	CHEM CLEAN			*C/P MOVE			001 MNP GW	
	*REQD*							002 03	
								003 SL01	
34B	009	BLAST CLEAN ONLY			*C/P MOVE			001 MNP GW	
	*REQD*							002 03	
								003 BL07	
34B	011	BAKE 4 HRS AT 350-400F						001 MNP GW	
	*REQD*	DATE IN _____ TIME IN _____						002 03	
		DATE OUT _____ TIME OUT _____						003 BK03	
					*C/P MOVE				
	*REQD*						M	001 MNP NA	
								002 05	
								003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36506N	
		B	D		

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
34E	025	E. R. I (INSPECT *REQD* MEASURE ID OF SPLINES USING .120 PINS 1.5033/1.5068					001 MNP GW 002 04 003 EI01		
		ACTUATOR BOSS OD .748/.749/.746 *C/P MOVE							
26	027	VAPOR DEGREASE *C/P MOVE					001 MNP RC 002 03 003 DG01		
26	028	STRIP LAD *L/P MOVE					001 MNP RC 002 02 003 CS01		
26	029	STRIP RUST *C/P MOVE					001 MNP RL 002 02 003 CS02		
26	031	STRIP CHROME ACTUATOR BOSS U.D. ONLY C/P MOVE					001 MNP RL 002 02 003 SC02		
26	032	STRIP FLASH CHROME FROM SPLINE I.D. C/P MOVE					001 MNP RL 002 02 003 SC02		
36	035	RECENTER CRANK *C/P MOVE					001 MNP RA 002 03 003 LE02		
8	040	1ST GRIND BOSS OD MIN .734 32RMS *C/P MOVE					001 MNP RB 002 02 003 GJ02		
[REDACTED]						M	001 MNP RA 002 06 003 TE03		
DATE OUT _____ TIME OUT _____ (CONTINUED)									

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36506N
		B	D	

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
---------------	-------------	-------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN CRANK STEERING
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15 DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
---------------------	-------------------	-----------------------------	--------------	---------	---------

		*C/P MOVE ***** NOTE ***** IF LAST ND1 OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
--	--	--	--	--	--

		*****			
--	--	-------	--	--	--

25R	060	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____		001 MNPRL 002 02 003 BK01	
-----	-----	---	--	---------------------------------	--

		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

		 *C/P MOVE ***** NOTE ***** IF LAST ND1 OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	
--	--	--	---	---------------------------------	--

26	075	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
----	-----	--------------------------	--	---------------------------------	--

26	080	SHOT PEEN REWORK AREA 200% COVERAGE INTENSITY OF .003/.006A C/P MOVE		001 MNPRC 002 01 003 SP02	
----	-----	---	--	---------------------------------	--

26	082	GLASS BEAD BLAST THREADS INTENSITY OF .004/.008A		001 MNPRC 002 01 003 BL03	
----	-----	---	--	---------------------------------	--

26	083	PREPARE SPLINES ID FOR CHROME PLATE GRIT BLAST. *C/P MOVE		001 MNPRC 002 01 003 BL04	
----	-----	--	--	---------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36506N
		B	D	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 "P"	20 "Q"
26 C	084	PREPARE SPLINES ID FOR CHROME PLATE MASK/FIXTURE/ETC.						001 MNPRC 002 02 003 BE01	
26 E	085	FLASH CHROME PLATE SPLINES J.D. C/P MOVE						001 MNPRC 002 02 003 CP01 008 CI010	
26 E	086	BAKE 4 HRS AT 350-400 F WITHIN 4 HRS OF CHROME. DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26 E	088	PREPARE BOSS OD FOR CHROME PLATE TYPE JJ CLASS 3. MASK/FIXTURE/ETC.  MECHANIC SIGN OFF REQUIRED						001 MNPRC 002 02 003 BE01	
26 E	089	PREPARE BOSS OD FOR CHROME PLATE, GRIT BLAST. *C/P MOVE						001 MNPRC 002 01 003 BL04	
26 E	090	CHROME PLATE BOSS O.D. TYPE JJ CLASS III SUFFICIENT TO GRIND TO .748/.749						001 MNPRC 002 02 003 CP01 008 CD010	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26B E	100	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C			36506N			
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1988-548-103

36506N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5. DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
B	110	FINISH GRIND BOSS OD .7487.749 *C/P MOVE					001 MNP RB	002 02 003 GJ02	
Job	120	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNP RC	002 02 003 BK01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M	001 MNP NA	002 06 003 ML04	
26	130	VAPOR DEGREASE *C/P MOVE					001 MNP RC	002 03 003 DG01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *				M	001 MNP NA	002 06 003 ZS01	
26	145	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE					001 MNP RC	002 01 003 BL02	
26	150	CAD PLATE TYPE II CLASS II .01 SQ FT AT 5 - 7 AMPS TIME OUT _____ DATE OUT _____ (CONTINUED)					001 MNP RC	002 03 003 CA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36506N
		B	D	

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1 DATE 89039

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN CRANK STEERING						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
26B	155	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MNP RC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	160	CHROMATE CONVERSION FOR TYPE [1] CAD *C/P MOVE					001 MNP RC 002 02 003 IR01		
		<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> *C/P MOVE * * * * * N O T E * * * * * IF LAST NOJ OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * *				M	001 MNP NA 002 06 003 RL04		
26	184	IVD PLATE (INITIATED BY PLATING) *NOTE* OPERATION 155 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION. C/P MOVE					001 MNP RC 002 03 003 IV01		
26	188	ALODINE IVD AREAS (INITIATED BY PLATING) C/P MOVE					001 MNP RC 002 03 003 TA01		
34A		<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQUI*					001 MNP GP 002 06 003 SA03		
34A		<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQUI*					001 MNP GP 002 06 003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		36506N				
		B	D						

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36513N WORK CONTROL DOCUMENT (MEDS)

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2 JOB ORDER NO 17402A	3 QUANTITY	4 PRODUCTION SEC/RCC HNP GP	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER 68A450625-2001	8. TECH DATA 4S-1-182 4S2-73-3		9. ITEM SERIAL NO.	

10 MODEL-DESIGN-SERIES F-15 NOSE	11 STOCK NUMBER 5306003291614	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN UPPER STEERING BOLT	17402A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*****UNIT COST: \$29.89***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949			
		FPI IAW MIL-STD-6866 CHROME STRIP IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 VAC CAD IAW MIL-C-8837 CAD IAW MIL-STD-870			
		BAKE IAW 4S-1-182 MAOI 74-12 VAC IVD ALUM PLATE IAW MIL-C-83488A /LODINE IAW MIL-C-5541			
		BLAST IAW MIL-STD-1504  STEEL 180,000/200,000			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *****WARNING***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36513N
		B	D	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 P	20 "O"
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	68A450625-2001							
	005 *REQD*	DISASSEMBLE *C/P MOVE						001 MNR/GW 002 02 003 LC02 005 X8745199	
	007 *REQD*	CHEM CLEAN *C/P MOVE						001 MNR/GW 002 03 003 SL01	
	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE						001 MNR/GW 002 03 003 RL07	
	011 *REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNR/GW 002 03 003 BK03	
		[REDACTED] *C/P MOVE *REQD*					M	001 MNR/NA 002 05 003 MS03	
	040 *REQD*	E & I BOLT O.D. .99817-.999 WEAR LIMIT .996 *C/P MOVE						001 MNR/GW 002 04 003 EI01	

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36513N
		B	D	

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20. "Q"	
26 C	044	VAPOR DECREASE *C/P MOVE						001 MNPRC	
								002 03	
								003 DG01	
26	046	STRIP CAD *C/P MOVE						001 MNPRC	
								002 02	
								003 CS01	
26	048	STRIP RUST *C/P MOVE						001 MNPRC	
								002 02	
								003 CS02	
26	050	STRIP CHROME BOLT O.D. *C/P MOVE						001 MNPRC	
								002 02	
								003 SC02	
69	060	RECENTER *C/P MOVE						001 MNPRC	
								002 03	
								003 LE02	
8	070	FIRST GRIND BOLT O.D. TO CLEAN UP NOT TO EXCEED .978 MIN *C/P MOVE						001 MNPRC	
								002 01	
								003 GE00	
		DATE OUT _____ TIME OUT _____				M		001 MNPRC	
								002 06	
								003 TE03	
		*C/P MOVE							
		***** NOTE *****							
		IF LAST NDI OPERATION IS COMPLETED*							
		HERE, TAKE PRODUCTION COUNT. *							
		*****							
26B	090	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH						001 MNPRC	
								002 02	
								003 BK01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36513N
		B	D	

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN UPPER STEERING BOLT
------------------	--------------------------------

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE			
		[REDACTED] *C/P MOVE *****NDTE***** IF LAST NDJ OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNPNA 002 06 003 ML04	
26	105	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	110	SHOT BEEN REWORKED AREA INTENSITY OF .006/.010A *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	115	PREPARE FOR CHROME PLATE BOLT O.D. TYPE II CLASS III MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	120	CHROME PLATE BOLT O.D. TYPE II CLASS III SUFF. TO GRIND BACK TO .9981/.999 TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF *REDD* *C/P MOVE		001 MNPRC 002 02 003 CP01 008 CD010	
26R	130	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36513N
		B	D	

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36513N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89039

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER				8 TECH DATA				9. ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
B ✓	140	FINISH GRIND BOLT O.D. .9981/.999 63 RMS *C/P MOVE						001 MNP RB	
								002 01	
								003 CE00	
OSR	150	BAKE 4HRS AT 350-400F						001 MNP RC	
		DATE IN _____ TIME IN _____						002 02	
		DATE OUT _____ TIME OUT _____						003 BK01	
		*C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNP NA	
								002 06	
								003 PL04	
26 S	157	VAPOR DEGREASE *C/P MOVE						001 MNP RC	
								002 03	
								003 DC01	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNP NA	
								002 06	
								003 ZS01	
26 S	165	PRIOR TO VAC CAD/CAD/IVD, GRIT BLAST ALL AREAS TO BE VAC CAD/CAD/ IVD PLATED. *C/P MOVE						001 MNP RC	
								002 01	
								003 BL04	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36513N			
		B		D					

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36513N WORK CONTROL DOCUMENT (MEDS)

DATE 89039

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETE	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN UPPER STEERING BOLT						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
26	170	VAC CAD PLATE TYPE II CLASS II *C/P MOVE						001 MNPRC 002 02 003 VC01	
26	180	CAD PLATE TYPE II CLASS II  TIME OUT _____ DATE OUT _____ *C/P MOVE						001 MNPRC 002 03 003 CA01	
26B	190	BAKE 23 HRS WITHIN 4HRS OF CAD PLATE  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC 002 02 003 BK01	
26	200	IRIDITE *C/P MOVE						001 MNPRC 002 02 003 IR01	
	165	<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****					M	001 MNPRC 002 06 003 ML04	
26	214	IVD PLATE (INITIATED BY PLATING) *NOTE* OPERATION 190 MUS: BE ACCOMPLISHED PRIOR TO USING IVD OPTION C/P MOVE						001 MNPRC 002 03 003 IV01	
26	218	ALODINE IVD AREAS (INITIATED BY PLATING) C/P MOVE						001 MNPRC 002 03 003 TA01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C			36513N			
		B	D						

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36513N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89039

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO.			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN UPPER STEERING BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
	220	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNR GP		
	*REQD*						002 06		
							003 SA03		
	230	FINAL PRODUCT VISUAL INSPECTION					001 MNR GP		
	*REQD*	10/P MOVE					002 06		
							003 SA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		36513N				
		B	D						

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F-15 NL6

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/21/58 A-20462-AM1-DY-M45 PAGE 000  
 RCC MNPRA 482-73-3

SUP	STEP	DL	TK	NR	FA	SUPPORT	CCC	DESCRIPTION	BASE HOURS	PRD TIME	STD HOURS	DLY PCT	
							FACT	STORED	SUPPLEMENTAL				
RA501	S	E	JA	EA	1	K	82162	1.00 PERCENT ENGR 94.4	F-15 OUTER CYL	6.76	6.76		
0001			JA	01		00		.00	PART NUMBER/NSN	.000	.000	.000	0
									65A450602-1001			1520003109830	
0045			JA	01		15		.23	REMOVE BUSHING/1" DIA	.203	.007	.054	1
0010	E						RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020	E						RLG-RS-KA	16.00 K/O SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER	.00780		.143	
0030	E						RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0048			JA	01		15		.02	O/S HOLE ON MILL/MED PART	.776	.009	.071	1
0010	E						RNL-SU-V2	.25 S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020	E						RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030	E						RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E						RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E						RML-SA-CC	1.00 BORE HOLE 2 X 1 1/2 GROUP 1	USE PROPER ELEMENT/TABLE	.20567		.236	
0060	E						RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0050			JA	01		15		.03	O/S HOLE ON MILL/MED PART	.776	.009	.071	1
0010	E						RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020	E						RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030	E						RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E						RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E						RML-SA-CC	1.00 BORE HOLE 2 X 1 1/2 GROUP 1	USE PROPER ELEMENT/TABLE	.20567		.236	
0060	E						RJP-FW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
			JA	01		15		.05	OVERSIZE HOLE WITH REAMER	.275	.002	.016	0
0010	E						RBW-SU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E						RLG-HP-V7	1.00 OBJ IN/OUT STP VISE-HST HAND		.06831		.078	
0030	E						RBW-BU-R2	2.00 REAM WITH LEMPCO REAMER	3 PASSES	.07337		.168	
0040	E						RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E						RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0052			JA	01		15		.05	OVERSIZE HOLE WITH REAMER	.275	.002	.016	0
0010	E						RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E						RLG-HP-V7	1.00 OBJ IN/OUT STP VISE-HST HAND		.06831		.078	
0030	E						RBW-BU-R2	2.00 REAM WITH LEMPCO REAMER	3 PASSES	.07337		.168	
0040	E						RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E						RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0053			JA	01		15		.05	OVERSIZE HOLE WITH REAMER	.349	.003	.020	0
0010	E						RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E						RLG-HP-V7	1.00 OBJ IN/OUT STP VISE-HST HAND		.06831		.078	
0030	E						RBW-BU-R2	3.00 REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253	
0040	E						RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E						RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0054			JA	01		15		1.00	HAND HOME BUSHING	.198	.030	.228	3
0010	E						RBW-SU-S1	.25 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0020	N							1.00	HONE PART NAME	.10000		.115	
0030	E						RSG-JF-05	1.00 PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0040	E						RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D		.00333		.003	
0050	E						RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0055			JA	01		15		1.00	HAND HOME BUSHING	.198	.030	.228	3
0010	E						RBW-SU-S1	.25 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0020	N							1.00	HONE PART NAME	.10000		.115	
0030	E						RSG-JF-05	1.00 PREP HAND DRILL CHANGE 1 BIT		.01603		.018	

0040 E		RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D	.00333		.003	
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
	JA 01	15	.08 O/S HOLE ON MILL/MED PART	.756	.009	.070	1
0110 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BA-AB	1.00 BORE HOLE 1 X 1 GROUP 1	.18482		.212	
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0057	JA 01	15	.05 HAND HONE BUSHING	.278	.002	.026	0
0010 E		RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525		.077	
0020 N			2.00 HONE PART NAME	.10000		.230	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0053	JA 01	15	.05 O/S HOLE ON MILL/MED PART	.733	.006	.045	1
0010 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BA-AG	1.00 BORE HOLE 1 X 3 1/2 GROUP 1 USE PROPER ELEMENT/TABLE	.21012		.243	
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0124	JA 01	15	.05 TURN BUSHING GROUP 1/BRONZE	.211	.002	.012	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030 E		KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250	.06699		.077	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0135	JA 01	15	.05 INST STRAIGHT BUSH NO POLISH	.077	.001	.004	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 INSTALL ONE STRAIGHT BUSHING	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
	JA 01	15	.88 TURN BUSHING GROUP 1/BRONZE	.289	.038	.292	4
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0190	JA 01	15	.88 INST/REAM SET FLANGED BUSH	.295	.039	.299	4
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0194	JA 01	15	.05 TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0195	JA 01	15	.05 INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0199	JA 01	15	.83 TURN BUSHING GROUP 1/BRONZE	.289	.036	.276	4
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0200	JA 01	15	.83 INST/REAM SET FLANGED BUSH	.295	.037	.282	4
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	

0204	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0205	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0219	JA 01	15	.88	TURN BUSHING GROUP 1/BRONZE	.289	.038	.292	4
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0220	JA 01	15	.88	INST/REAM SET FLANGED BUSH	.295	.039	.299	4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0224	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0225	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.295	.044	.339	5
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0226	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0230	JA 01	15	.88	INST/REAM SET FLANGED BUSH	.295	.039	.299	4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0234	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023	
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0235	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0239	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.366	.055	.421	6
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	3.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.034	
0030 E		KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250	.06699		.231	
0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0240	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.295	.044	.339	5
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0241	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.366	.003	.021	0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	

0020 E	SLA-HP-C1	3.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.024		
0030 E	KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250	.06699		.231		
40 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	0	
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053		
0020 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274		
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0249	JA 01	15	1.00	TURN BUSHING GROUP 4/STEEL	.411	.062	.473	7
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143		
0020 E	SLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023		
0030 E	KML-TD-CC	2.00	DIA .501-1.00 REM .033-.250	.10898		.250		
0040 E	KML-TD-CD	1.00	DIA 1.00 REM .250 ADD INCH	.03865		.044		
0050 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0250	JA 01	15	1.00	INST STRAIGHT BUSH NO POLISH	.763	.114	.678	13
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053		
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023		
0030 E	RBW-SU-G1	2.00	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525		.633		
0040 N		1.00	HONE PART NAME	.10000		.115		
0060 E	RSG-JP-05	2.00	PREP HAND DRILL CHANGE 1 BIT	.01603		.036		
0070 E	RBW-BU-F1	1.00	BUTTERFLY POLISH BUSHING I D	.00333		.003		
0080 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0254	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	.411	.063	.024	0
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143		
0020 E	SLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023		
0030 E	KML-TD-CC	2.00	DIA .501-1.00 REM .033-.250	.10898		.250		
0040 E	KML-TD-CD	1.00	DIA 1.00 REM .250 ADD INCH	.03865		.044		
0050 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
FF	JA 01	15	.05	INST STRAIGHT BUSH NO POLISH	.763	.006	.044	1
010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053		
020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023		
0030 E	RBW-SU-G1	2.00	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525		.633		
0040 N		1.00	HONE PART NAME	.10000		.115		
0060 E	RSG-JP-05	2.00	PREP HAND DRILL CHANGE 1 BIT	.01603		.036		
0070 E	RBW-BU-F1	1.00	BUTTERFLY POLISH BUSHING I D	.00333		.003		
0080 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0259	JA 01	15	.96	TURN BUSHING GROUP 1/BRONZE	.289	.042	.319	5
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143		
0020 E	SLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023		
0030 E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0260	JA 01	15	.96	INST/REAM SET FLANGED BUSH	.295	.042	.326	5
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053		
0020 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274		
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0264	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.278	.002	.016	0
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143		
0020 E	SLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011		
0030 E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0265	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053		
0020 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274		
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011		
0270	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.211	.002	.012	0
010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143		
0280 E	SLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011		

0030 E		KML-TA-EC	1.00 DIA 1.50-2.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DCC		.01001		.011	
	JA 01	15	.05	INST STRAIGHT BUSH NO POLISH	.265	.002	.015	0
010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 N			1.00	HONE PART NAME	.10000		.115	
0060 E		RSG-JP-05	1.00 PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0070 E		RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D		.00333		.003	
0050 E		RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DCC		.01001		.011	
0285	JA 01	15	.92	TURN BUSHING GROUP 1/BRONZE	.239	.040	.306	5
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DCC		.01001		.011	
0290	JA 01	15	.92	INST STRAIGHT BUSH NO POLISH	.107	.015	.114	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	2.00 INSTALL ONE STRAIGHT BUSHING		.02062		.047	
0030 E		RJP-PW-R1	2.00 REM RPL PAPERWK SIGN OFF DCC		.01001		.023	
0294	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.239	.002	.017	0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.023	
0030 E		KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DCC		.01001		.011	
0295	JA 01	15	.05	INST STRAIGHT BUSH NO POLISH	.763	.006	.044	1
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RBW-SU-G1	2.00 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.633	
040 N			1.00	HONE PART NAME	.10000		.115	
060 E		RSG-JP-05	2.00 PREP HAND DRILL CHANGE 1 BIT		.01603		.024	
0070 E		RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D		.00333		.003	
0060 E		RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DCC		.01001		.011	
0000	JA 01	00	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				KIM VINCENT, MANEL, 10 JUN 68				

TO INTERROGATE LA608 STANDARDS, INPUT

RCC PRD NROP NR

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1034567890123456 ELSE PUT IN END

SUB	STEP	D L	T K	NR	A	FA	SUPPORT	QCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C	
								FACT	STORED	SUPPLEMENTAL				
4822	S	E	JA	EA	1		K	88161	1.00	PERCENT ENGR 99.9		7.22	7.22	
0001			JA	01			00		.00	PART NUMBER/NSN	.000	.000	.000	0
									68A450643-1001	1620003051726				
0010			JA	01			15		1.00	O/S BOLT HOLES	.604	.091	.695	10
0010	E								.25	S/U VERT MILL BORE SMAL FXTXPRGRATE OVER 4 PARTS	.50518		.145	
0020	E								1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.093	
0030	E								1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040	E								1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.057	
0050	E								1.00	BORE HOLE 1 X 1/2 GROUP 1 USE PROPER ELEMENT/TABLE	.17936		.206	
0060	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0023			JA	01			15		1.00	MACH FACES	.631	.095	.726	10
0010	E								.25	S/U VERT MILL BORE SMAL FXTXPRGRATE OVER 4 PARTS	.50518		.145	
0020	E								1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.093	
0030	E								1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040	E								1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.057	
0050	E								1.00	BORE HOLE 1 X 3 GROUP 1 USE PROPER ELEMENT/TABLE	.20666		.237	
0060	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0024			JA	01			15		1.00	O/S UPPER BOLT HOLE	.604	.091	.695	10
0010	E								.25	S/U VERT MILL BORE SMAL FXTXPRGRATE OVER 4 PARTS	.50518		.145	
0020	E								1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.093	
0030	E								1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040	E								1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.057	
0050	E								1.00	BORE HOLE 1 X 1/2 GROUP 1 USE PROPER ELEMENT/TABLE	.17936		.206	
0060	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0029			JA	01			15		1.00	MACH BUSHING	.307	.046	.354	5
0010	E								.25	SET UP SMALL MEDIUM LATHE PRGRATE OVER 4 PARTS	.49962		.143	
0020	E								2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023	
0030	E								2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040	E								2.00	DIA 1.0 REMOVE .250 ADD INCH	.00947		.021	
0050	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0030			JA	01			15		1.00	INSTALL	.295	.044	.339	5
0010	E								.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020	E								1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0032			JA	01			15		1.00	INSTL O/S BUSHING	.295	.044	.339	5
0010	E								.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020	E								1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0034			JA	01			15		1.00	MACH O/S BUSHING	.307	.046	.354	5
0010	E								.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020	E								2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023	
0030	E								2.00	DIA .501-1.00 REM .033-.250	.06699		.154	
0040	E								2.00	DIA 1.0 REMOVE .250 ADD INCH	.00947		.021	
0050	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0036			JA	01			15		1.00	INSTL O/S BUSHING	.295	.044	.339	5
0010	E								.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020	E								1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030	E								1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0038			JA	01			15		1.00	MACH UPPER LIP	.240	.036	.276	4



0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-GC	1.00	DIA 3.00-4.00 REM .033-.250		.07800		.089	
0040	E	KML-TA-GD	1.00	DIA 4.0 REM .250 ADD INCH		.01707		.019	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0038	JA 01	15	1.00		MACH CHAMPHER	.240	.036	.276	4
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-GC	1.00	DIA 3.00-4.00 REM .033-.250		.07800		.089	
0040	E	KML-TA-GD	1.00	DIA 4.0 REM .250 ADD INCH		.01707		.019	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0040	JA 01	15	1.00		MACH LOWER LIP	.614	.092	.706	10
0010	E	KYM-SU-V1	.25	S/U VERT MILL BORE SMAL	FXTRPRORATE OVER 4 PARTS	.50518		.145	
0020	E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E	RML-BA-EA	1.00	BORE HOLE 3 X 1/2 GROUP 1	USE PROPER ELEMENT/TABLE	.18962		.218	
0060	E	RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0050	JA 01	15	1.00		MACH UPPER BEARING	.240	.036	.276	4
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-GC	1.00	DIA 3.00-4.00 REM .033-.250		.07800		.089	
0040	E	KML-TA-GD	1.00	DIA 4.0 REM .250 ADD INCH		.01707		.019	
0050	E	RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0060	JA 01	15	1.00		O/S LOWER BEARING	.216	.032	.248	3
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-GC	1.00	DIA 3.00-4.00 REM .033-.250		.07104		.081	
0040	E	RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00		MACH UPPER BEARING	.297	.045	.342	5
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023	
0030	E	KML-TA-GC	2.00	DIA 2.00-3.00 REM .033-.250		.07104		.163	
0040	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0150	JA 01	15	1.00		MACH LOWER BEARING	.211	.032	.244	3
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-EC	1.00	DIA 1.50-2.00 REM .033-.250		.06699		.077	
0040	E	RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0160	JA 01	15	1.00		MACH UPPER LIP	.229	.034	.264	4
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-HC	1.00	DIA 4.00-5.00 REM .033-.250		.08497		.097	
0040	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0165	JA 01	15	1.00		MACH CHAMPHER	.240	.036	.276	4
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-GC	1.00	DIA 3.00-4.00 REM .033-.250		.07800		.089	
0040	E	KML-TA-GD	1.00	DIA 4.0 REM .250 ADD INCH		.01707		.019	
0050	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
0170	JA 01	15	1.00		MACH LOWER LIP	.240	.036	.276	4
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	KML-TA-GC	1.00	DIA 3.00-4.00 REM .033-.250		.07800		.089	
0040	E	KML-TA-GD	1.00	DIA 4.0 REM .250 ADD INCH		.01707		.019	
0050	E	RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	

0150	JA 01	15	1.00	DRILL HOLE	.072	.011	.034	1
0010 E		KML-CB-P1	1.00 CENTER DRILL		.01519		.017	
0020 E		RSG-JP-03	1.00 PREP HAND DRILL FOR USE		.00861		.009	
0030 E		RLA-DR-CA	1.00 DRILL HOLE 1/8-1/4 DIA ( 1/2		.03903		.044	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0181	JA 01	15	1.00	REIDENTIFY	.099	.015	.114	2
0010 E		RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020 E		GID-SA-A1	1.00 STAMP WITH METAL STAMP		.00342		.003	
0030 E		GID-SA-A2	9.00 STAMP W/METAL STAMP ADDL	NINE ADDITIONAL NUMBERS	.00187		.019	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	00	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0001				INITIAL INPUT, 9 JUNE 88				

TO INTERROGATE LABOR STANDARDS, INPUT

500 PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNFRA

06/24/88  
4S2-73-3

A-E046B-MM1-DY-M45 PAGE 00

17402A STRUT F-15 NOSE  
OPFR... TECH S S W F PF A/R REV  
T K #R A FA SUPPORT OCC  
EP D L K C DC ELEMENT FACT

				DESCRIPTION		BASE	PFD	STD		
				STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT
RA503	S E JA EA 1	J 88161	1.00	PERCENT ENGR 99.9	F-15 NLG PISTON	1.56		1.56		
0001	JA 01	00	.00		PART NUMBER/NSN	.000	.000	.000		0
	0010			68A450704-1003	1620010232138					
0050	JA 01	15	.65		O/S HOLE ON MILL/SMALL PART	.675	.068	.520		33
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SHAL	EXTRPRORATE OVER 4 PARTS	.50518		.145		
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2	CLAMPS	.06531		.098		
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	USE PROPER ELEMENT/TABLE	.27100		.311		
0060 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0060	JA 01	15	.65		POLISH I.D.	.029	.003	.022		1
0010 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1	BIT	.01603		.018		
0020 E		R3W-BU-P1	1.00	BUTTERFLY POLISH BUSHING	I D	.00333		.003		
0030 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0090	JA 01	15	.05		OVERSIZE HOLE WITH REAMER	.349	.003	.020		1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST	HAND	.06831		.078		
0030 E		RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
0040 E		RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH	SIDES	.00423		.004		
0050 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0100	JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.695	.005	.040		3
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SHAL	EXTRPRORATE OVER 4 PARTS	.50518		.145		
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2	CLAMPS	.06531		.098		
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.097		
0050 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	USE PROPER ELEMENT/TABLE	.27100		.311		
0060 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0410	JA 01	15	.87		TURN BUSHING GROUP 1/BRONZE	.289	.038	.289		19
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL	CHUCK	.01006		.023		
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250		.06699		.154		
0040 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0420	JA 01	15	.87		INST/REAM SET FLANGED BUSH	.295	.039	.295		19
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0429	JA 01	15	.17		TURN BUSHING GROUP 1/BRONZE	.289	.007	.057		4
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL	CHUCK	.01006		.023		
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250		.06699		.154		
0040 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0430	JA 01	15	.17		INST/REAM SET FLANGED BUSH	.295	.008	.058		4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-FW-R1	1.00	REM RPL PAPERWK SIGN OFF	DOC	.01001		.011		
0439	JA 01	15	.39		TURN BUSHING GROUP 1/BRONZE	.289	.017	.130		8
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL	CHUCK	.01006		.023		
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250		.06699		.154		

0040 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011
0440	JA 01	15	.39		INST/REAM SET FLANGED BUSH	.295	.017	.132
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23335		.274
0030 E		RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011
	JA 01	00	.01		LABOR STANDARD HISTORY	.000	.000	.000
0001				KIM VINCENT, MANEL, 73255				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
 <---X---X--->  
 1234567890123456 ELSE PUT IN END

17402A F-15 DAMPER; PISTON RCC NNRB 9H2-3-83-3 85231

JOB NO	TECH	S	S	W	F	PF	A/R	REV	SUPPORT OCC		DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY	PCT	C		
									#R	FA								STO	FACT
B501	S	E	JA	EA	3	J	88098	.92	PERCENT	ENGR	99.9	GRD.REPR.OTR.CYL.F-15NLG	9.08		8.36				
0001			JA	01	00			.00				PART NUMBER/NSN	.000	.000	.000		0		
0010										68M450602-1001	1620003109830								
0099			JA	01	15			1.00				POLISH UPPER BORE	.495	.074	.570		6		
0010	E							1.00	S/U	FOR	BENCH	WORK	GENERAL	.27525		.316			
0020	E							1.00	BUTTERFLY	POLISH	CYL	I.D.	.15445		.177				
0030	E							1.00	VISUAL	INSP	MEDIUM	CYL	I.D.	.05578		.064			
0040	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0100			JA	01	15			.95				HONE	UPPER	BORE	3.271	.466	3.574	39	
0010	E							.50	LOAD	UNLOAD	HONE	WITH	HOIST	.17802		.102			
0020	E							.50	SET	UP	LARGE	VERTICAL	HONE	.55195		.317			
0030	E							6.00	GRIND	OUT	.010-4	IN	ID	X	3	HONE	I.D.	.48265	3.330
0040	E							1.00	INSP	-	TEST	BORE	IND	GAGE	.00020		.000		
0050	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0101			JA	01	15			1.00				POLISH	LOWER	BORE	.495	.074	.570	6	
0010	E							1.00	S/U	FOR	BENCH	WORK	GENERAL	.27525		.316			
0020	E							1.00	BUTTERFLY	POLISH	CYL	I.D.	.15445		.177				
0030	E							1.00	VISUAL	INSP	MEDIUM	CYL	I.D.	.05578		.064			
0040	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0102			JA	01	15			1.00				HONE	LOWER	BORE	1.823	.273	2.097	23	
0010	E							.50	LOAD	UNLOAD	HONE	WITH	HOIST	.17802		.102			
0020	E							.50	SET	UP	LARGE	VERTICAL	HONE	.55195		.317			
0030	E							3.00	GRIND	OUT	.010-4	IN	ID	X	3	HONE	I.D.	.48265	1.665
0040	E							1.00	INSP	-	TEST	BORE	IND	GAGE	.00020		.000		
0050	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0140			JA	01	15			1.00				POLISH	UPPER	BORE	.495	.074	.570	6	
0010	E							1.00	S/U	FOR	BENCH	WORK	GENERAL	.27525		.316			
0020	E							1.00	BUTTERFLY	POLISH	CYL	I.D.	.15445		.177				
0030	E							1.00	VISUAL	INSP	MEDIUM	CYL	I.D.	.05578		.064			
0040	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0145			JA	01	15			1.00				POLISH	LOWER	BORE	.495	.074	.570	6	
0010	E							1.00	S/U	FOR	BENCH	WORK	GENERAL	.27525		.316			
0020	E							1.00	BUTTERFLY	POLISH	CYL	I.D.	.15445		.177				
0030	E							1.00	VISUAL	INSP	MEDIUM	CYL	I.D.	.05578		.064			
0040	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0177			JA	01	15			1.00				POLISH	UPPER	BORE	.495	.074	.570	6	
0010	E							1.00	S/U	FOR	BENCH	WORK	GENERAL	.27525		.316			
0020	E							1.00	BUTTERFLY	POLISH	CYL	I.D.	.15445		.177				
0030	E							1.00	VISUAL	INSP	MEDIUM	CYL	I.D.	.05578		.064			
0040	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
0179			JA	01	15			1.00				POLISH	LOWER	BORE	.495	.074	.570	6	
0010	E							1.00	S/U	FOR	BENCH	WORK	GENERAL	.27525		.316			
0020	E							1.00	BUTTERFLY	POLISH	CYL	I.D.	.15445		.177				
0030	E							1.00	VISUAL	INSP	MEDIUM	CYL	I.D.	.05578		.064			
0040	E							1.00	REN	RPL	PAPWRK	SIGN	OFF	.01001		.011			
9000			JA	00	00			.00				LABOR STANDARD HISTORY	.000	.000	.000		0		
0010												7 APRIL 88 INITIAL INPUT/NEW WORKLOAD							
0900												KERRY COOP MANEL TECHN 73357							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR  
 <---X---X--->

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  
RCC MNPRB

12/02/88  
9H2-3-83-3

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17402A F-15 DAMPER; PISTON

CH S S W F PF A/R REV

T K #R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

-----<----- DESCRIPTION ----->  
STORED SUPPLEMENTAL

BASE PFD STD A  
HOURS TIME HOURS DLY PCT C

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RB503	S	N	JA	EA	3	K 88161	.26	PERCENT ENGR 65.1	GRD REPAIR PISTON	9.66		2.51	
0001			JA	01	00		.00		PART NUMBER/MSN	.000	.000	.000	0
								68A450704-1003	1620010232138				
0065			JA	01	00		.00			.406	.000	.000	0
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.275	
0020	E					ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.065	
0030	E					ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.055	
0040	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010	
0070			JA	01	00		.00			.406	.000	.000	0
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.275	
0020	E					ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.065	
0030	E					ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.055	
0040	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010	
0075			JA	01	00		1.00			.406	.000	.407	4
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.275	
0020	E					ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.065	
0030	E					ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.055	
0040	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010	
0120			JA	01	15		.33		1ST GRIND PISTON OD-050- PRORATE 2 PARTS	1.929	.096	.732	8
0010	E					RGR-SU-G1	.50	SET UP A GAP GRINDER		1.05938		.609	
0020	E					RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354	
0030	E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0040	E					RGR-GE-S2	70.00	GR STEEL OD (OCC FACT L X D) 3.5 X 20 IN		.01093		.879	
0050	E					RGR-GE-D2	3.50	DWELL (GAP GRINDER STEEL OD) 3.5 DIA		.01014		.040	
0060	E					RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070	E					RGR-HH-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0080	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0130			JA	01	15		.50		1ST GRD INNER JRNL -060-	.876	.066	.504	5
0010	E					RGR-SU-G1	.50	SET UP A GAP GRINDER	2 JRNLS	1.05938		.609	
0020	E					RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR	2 JRNLS	.30830		.177	
0030	E					RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW	2 JRNLS	.09095		.052	
0040	E					RGR-GE-S2	2.23	GR STEEL OD (OCC FACT L X D) 2.23 X 1 IN		.01093		.028	
0050	E					RGR-GE-D2	2.23	DWELL (GAP GRINDER STEEL OD) 2.23 DIA		.01014		.026	
0060	E					RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER	2 JRNLS	.08334		.047	
0070	E					RGR-HH-C4	.50	HANDLE & MEAS LENGTH 12 - 24	2 JRNLS	.10674		.061	
0080	E					RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC	2 PLACES	.01001		.005	
0140			JA	01	15		.50		1ST GRD OUTER JRNL -070-	.875	.066	.504	5
0010	E					RGR-SU-G1	.50	SET UP A GAP GRINDER	2 JRNLS	1.05938		.609	
0020	E					RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR	2 JRNLS	.30830		.177	
0030	E					RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW	2 JRNLS	.09095		.052	
0040	E					RGR-GE-S2	2.20	GR STEEL OD (OCC FACT L X D) 2.20 X 1 IN		.01093		.027	
0050	E					RGR-GE-D2	2.20	DWELL (GAP GRINDER STEEL OD) 2.20 DIA		.01014		.025	
0060	E					RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER	2 JRNLS	.08334		.047	
0070	E					RGR-HH-C4	.50	HANDLE & MEAS LENGTH 12 - 24	2 JRNLS	.10674		.061	
0080	E					RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC	2 PLACES	.01001		.005	
0145			JA	01	00		1.00			1.103	.000	1.104	11
0010	E					RHO-HP-L1	1.00	LOAD UNLOAD HOME WITH HOIST		.17802		.178	
0020	E					RHO-SU-V1	1.00	SET UP LARGE VERTICAL HOME		.55195		.551	
0030	E					KMG-ID-GE	1.00	GRIND OUT .010 3 ID X 3		.36332		.363	

0040 E		BIT-BI-01	1.00	INSP - TEST BORE IND GAGE		.00020		.000	
0050 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010	
0280	JA 01	15	.50	FINISH GRD INN JRNL-190-		.923	.069	.531	5
010 E		RGR-SU-G1	.50	SET UP A GAP GRINDER 2 JRNL		1.05938		.609	
.020 E		RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR 2 JRNL		.30830		.177	
0030 E		RLA-HP-C3	.50	CHUCK SYNET PART IN 4 JAW 2 JRNL		.09095		.052	
0040 E		RGR-GE-C2	2.23	GR CHROM OD (OCC FACT L X D) 2.23 X 1 IN		.02189		.056	
0050 E		RGR-GE-D3	2.23	DWELL (GAP GRINDER CHROM OD) 2.23 DIA		.02029		.052	
0060 E		RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER 2 JRNL		.08334		.047	
0070 E		RGR-HM-C4	.50	HANDLE & MEAS LENGTH 12 - 24 2 JRNL		.10674		.061	
0080 E		RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC 2 PLACES		.01001		.005	
0290	JA 01	15	.50	FINISH GRD OUT JRNL-200-		.922	.069	.530	5
0010 E		RGR-SU-G1	.50	SET UP A GAP GRINDER 2 JRNL		1.05938		.609	
0020 E		RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR2 JRNL		.30830		.177	
0030 E		RLA-HP-C3	.50	CHUCK SYNET PART IN 4 JAW 2 JRNL		.09095		.052	
0040 E		RGR-GE-C2	2.20	GR CHROM OD (OCC FACT L X D) 2.20 X 1 IN		.02189		.055	
0050 E		RGR-GE-D3	2.20	DWELL (GAP GRINDER CHROM OD) 2.20 DIA		.02029		.051	
0060 E		RGR-WD-G2	.50	WHEEL DRESS GAP GRINDER 2 JRNL		.08334		.047	
0070 E		RGR-HM-C4	.50	HANDLE & MEAS LENGTH 12 - 24 2 JRNL		.10674		.061	
0080 E		RJP-PW-R1	.50	REM RPL PAPWRK SIGN OFF DOC 2 PLACES		.01001		.005	
0300	JA 01	15	.33	FINISH GRD PISTN O.D.		2.732	.135	1.037	11
0010 E		RGR-SU-G1	.50	SET UP A GAP GRINDER PRORATE 2 PARTS		1.05938		.609	
0020 E		RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354	
0030 E		RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW		.09095		.104	
0040 E		RGR-GE-C2	70.00	GR CHROM OD (OCC FACT L X D) 3.5 X 20 IN		.02189		1.762	
0050 E		RGR-GE-D3	3.50	DWELL (GAP GRINDER CHROM OD) 3.5 DIA		.02029		.081	
0060 E		RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070 E		RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0080 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00	GRIND CHROME I.D.		3.757	.564	4.321	45
0010 E		RGR-SU-I1	.25	S/U SMALL INTERNAL GRINDER PRORATE OVER 4 PARTS		.49838		.143	
0020 E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E		KMG-DW-ID	4.00	DRESS INTERNAL WHEEL		.02458		.113	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 H			1.00	GRD CHROM I.D. .040-3.2 X 36		3.00000		3.450	
0070 E		RGR-GE-D3	3.50	DWELL (GAP GRINDER CHROM OD)		.02029		.081	
0080 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090 E		ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064	
0100 E		RBW-BU-P1	.50	BUTTERFLY POLISH BUSHING I D		.00333		.001	
0110 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTCRY		.000	.000	.000	0
0010				04MAR83 HATCH UP SUB OPS TO FORM 470					
0020				04MAR83 UPDATE OPER LINE & OCC FACTORS 00570					
0030				17AUG83 REVIEW AND CHG OCC. FACTORS					
0040				PREVIOUS STD HRS 0.56					
0045				11SEPT84 OCC ADJSTD <OLD STD>1.27					
0046				10OCT84 ADDED PR&D OLD TIME 71					
0047				6 NOV84 2 YR REVIEW W/OCC CHANGE .79					
0048				23JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG					
0049				28AUG85 OCC FACTOR CHANGE OLD STD .96					
0900				J.CALDWELL TECH MANEAA					

ERROGATE LABOR STANDARDS, INPUT

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

06/24/83  
942-3-93-3

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85231

17402A F-15 DAMPER; PISTON

RCC MNFRB

OPER	TECH	S	S	W	F	PF	A/R	REV	T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	FFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C					
83506	S	E	JA	EA	3	J 88160	.05	PERCENT ENGR 99.9	GRIND CRANK STEERING	.52		.02								
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0						
			0010					66A450610-2003	1620003109834											
0040			JA	01	15		1.00		1ST GRIND BOSS O.D.-040-	.225	.034	.09		50						
0010	E					RGR-SU-J2	.20	S-U JIG GRINDER LRG FIX-TBLE PRORATE 5 PARTS		.90167		.184								
0020	E					KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026								
0030	E					KMG-OB-CA	1.00	GRIND .010 1 OD X 1		.03200		.036								
0040	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011								
0110			JA	01	15		1.00		FINSH GRD BOSS O.D.-110-	.229	.034	.264		50						
0010	E					RGR-SU-J2	.20	S-U JIG GRINDER LRG FIX-TBLE PRORATE 5 PARTS		.90167		.184								
0020	E					KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026								
0030	E					KMG-OB-AF	1.00	GRIND .040 FROM 1/2B X 1		.03433		.041								
0040	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011								
9000			JA	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0						
0010								24FEB83 UPGRADE TO E STD CHG OCC FACTORS	14000											
0020								17AUG83 REVIEW AND CHG OCC. FACTORS												
0030								PREVIOUS STD HRS 0.19												
0035								12SEPT84 OCC ADJSTD <OLD STD>.02												
0036								10OCT84 ADDED PR&D TIME OLD STD	02											
0037								6 NOV84 2 YR REVIEW W/OCC CHANGE < OLD STD >	.02											
0038								23JULY85 CHANGED SUB OP TO MATCH 958 NO TIME CHANG												
0900								J.CALDWELL TECH MANEAA												

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

06/24/88

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17-02A F-15 DAMPER; PISTON

RCC MNPRB

9H2-3-83-3

85231

OPER TECH S S W F FF A/R REV

T K #R A FA SUPPORT

REP D L K C DC ELEMENT

OCC <-----DESCRIPTION----->

BASE PFD ETD A  
HOURS TIME HOURS DLY PCT C

REP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	ETD HOURS	A DLY PCT C
88513	S	E	JA	EA	3	J 88160	1.00	PERCENT ENGR 99.9	GRIND UP STEERING BOLT F-15		1.29		1.29	
0001			JA	01	00		.00		PART NUMBER/NSN		.000	.000	.000	0
								68A450625-2001	5306003291614					
0070			JA	01	15		1.00		1ST GRIND O.D.		.642	.096	.739	57
0010	E					RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER			.29197		.335	
0020	E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E					KMG-DW-0D	1.00	DRESS EXTERNAL WHEEL			.02308		.026	
0050	E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E					KMG-0D-CE	1.00	GRIND .010 1 OD X 3			.08533		.098	
0070	E					RGR-GE-02	1.00	DWELL (GAP GRINDER STEEL OD) OCCURRANCED FOR DIA			.01014		.011	
0080	E					RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH			.00616		.042	
0090	E					RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC			.01001		.011	
0140			JA	01	15		1.00		GRIND CHROME O.D.		.485	.073	.558	43
0010	E					RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER PRORATE OVER 4 PARTS			.29197		.083	
0020	E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E					RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E					KMG-DW-0D	1.00	DRESS EXTERNAL WHEEL			.02308		.026	
0050	E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E					KMG-0D-CK	1.00	GRIND .040 1 OD X 3			.13734		.157	
0070	E					RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD) OCCURRANCED FOR DIA			.02029		.023	
0080	E					RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH			.00616		.042	
0090	E					RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC			.01001		.011	
			JA	00	00		.00		LABOR STANDARD HISTORY		.000	.000	.000	0
010								6 APRIL 88 TIME COORDINATED WITH FRMN K. STEPHENS						
0900								KERRY COOP MANEL TECHN 73357						

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17402A F-15 NLG ORIFICE TUBE

RCC MNRBB

PER SUB STEP	TECH D L	S S T K	W F PF A/R REV #R A FA SUPPORT K C DC ELEMENT	FACT	OCC FACT	DESCRIPTION STORED SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
850-	S E	JA EA 3	K 88159	.75	PERCENT ENGR 99.3	GRIND ORIFICE TUBE	6.94		6.59	
0001		JA 01 00		.00		PART NUMBER/NSM	.000	.000	.000	0
					68A450726-2001	1620003084145				
0035		JA 01 15		.05		POLISH I.D.	.131	.001	.008	0
0010 E			R8W-SU-G1	.00	S/U FOR BENCH WORK GENERAL	0	.27525		.000	
0020 E			ZFO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.		.06549		.075	
0030 E			ZIT-VI-R2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05378		.064	
0040 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOCRJPWR1		.01001		.011	
0036		JA 01 15		.79		HONE I.D.	-040-	2.026	.240	1.841 27
0010 E			RHO-MM-H1	1.00	CHANGE STONES LRG VERT HONE		.06126		.070	
0020 E			RHO-MM-S1	1.00	ADJUST STOPS LARGE VERT HONE		.01422		.016	
0030 E			RHO-HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST		.17802		.204	
0040 E			KMG-ID-HD	6.00	GRIND OUT .010 3.5 ID X 2	12IN I.D. HONE	.29382		2.027	
0050 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0039		JA 01 15		.68		CHECK RACE WAY CENTER LINE	.143	.015	.112	2
0005 E			R8W-SU-G1	.25	S/U FOR BENCH WORK GENERAL	<	.27525		.079	
0010 E			RLG-EI-AC	1.00	CHECK ALIGNMENT	<	.06483		.074	
0020 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0044		JA 01 15		.90		1ST GRIND O.D.	.466	.063	.483	7
0010 E			RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER		.29197		.083	
0020 E			RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E			KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E			KMG-OD-EC	1.00	GRIND .010 2 OD X 2		.11834		.136	
0070 E			RGR-GE-D2	2.00	BWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.023	
0080 E			RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0045		JA 01 15		.0E		1ST GRIND O.D.	.391	.003	.023	0
0010 E			RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083	
0020 E			RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E			KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E			KMG-OD-EH	1.00	GRIND .040 2 OD X 2		.17084		.219	
0070 E			RGR-GE-D3	2.00	BWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.046	
0080 E			RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0056		JA 01 15		.90		GRIND CHROME	.559	.076	.579	8
0010 E			RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083	
0020 E			RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E			KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E			KMG-OD-EH	1.00	GRIND .040 2 OD X 2		.17084		.219	
0070 E			RGR-GE-D3	2.00	BWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.046	
0080 E			RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042	
0090 E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0063		JA 01 15		.05		CHECK CNTRLINE TO RACEWAY	.350	.003	.020	0

0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		RLG-EI-AC	1.00	CHECK ALIGNMENT		.06483		.074	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0064	JA 01	15	.05	GRIND CHROME O.D.		.437	.003	.025	0
0010 E		RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER PRORATED OVER 4 PARTS		.29197		.083	
0020 E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E		KMG-OD-DF	1.00	GRIND .040 1 1/2 OD X 1		.07883		.090	
0070 E		RGR-GE-D3	1.50	DWELL (GAP GRINDER CHROM OD) OCCURRED FOR DIA		.02029		.035	
0080 E		RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0069	JA 01	15	.05	CHECK CENTRELNE TO RACEWAY		.350	.003	.020	0
0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		RLG-EI-AC	1.00	CHECK ALIGNMENT		.06483		.074	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070	JA 01	00	.90	FIRST GRIND		.672	.000	.605	9
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATED OVER 4 PARTS		.75732		.189	
0020 E		PYL-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.119	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0040 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.067	
0060 E		RLA-PT-GC	4.00	MACH TIME 25 SFPM .007 FEED		.02506		.100	
0070 E		RGR-GE-C2	6.00	GR CHROM OD (OCC FACT L X D)		.02189		.131	
0080 E		RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.004	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
0080	JA 01	00	.25	FIRST GRIND		1.722	.000	.431	6
0010 E		RGR-SU-S1	.25	SET UP SURFACE GRINDER PRORATED OVER 4 PARTS		.04390		.010	
0020 E		RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST		.45621		.456	
0030 E		RLA-HP-C6	1.00	LOAD/UNLOAD SML PART-CENTERS		.02466		.024	
0040 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0050 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0060 E		RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.020	
0070 E		KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION		.06761		.270	
0080 E		RGR-GE-C2	40.00	GR CHROM OD (OCC FACT L X D)		.02189		.375	
0090 E		RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.004	
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
0150	JA 01	00	.90	FIRST GRIND		.686	.000	.618	9
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATED OVER 4 PARTS		.75732		.189	
0020 E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.119	
0030 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0040 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.067	
0060 E		RLA-PT-GC	4.00	MACH TIME 25 SFPM .007 FEED		.02506		.100	
0070 E		RGR-GE-C2	6.00	GR CHROM OD (OCC FACT L X D)		.02189		.131	
0080 E		RTL-MM-M1	4.00	MIKE ID OR 2 FLAT SURFACES		.00481		.019	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
0153	JA 01	00	.90	FIRST GRIND		1.722	.000	1.550	22
0010 E		RGR-SU-S1	.25	SET UP SURFACE GRINDER PRORATED OVER 4 PARTS		.04390		.010	
0020 E		RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST		.45621		.456	
0030 E		RLA-HP-C6	1.00	LOAD/UNLOAD SML PART-CENTERS		.02466		.024	
0040 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.026	
0050 E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.023	
0060 E		RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.020	
0070 E		KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION		.06761		.270	

0080 E	RGR-GE-C2	40.00	GR CHROM OD (OCC FACT L X D)	.02189	.875	
0090 E	RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES	.00481	.004	
0100 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.010	
0162	JA 01 00	.25	FIRST GRIND PRORATED OVER 4 PARTS	1.722	.000	.431 6
0010 E	RGR-SU-S1	.25	SET UP SURFACE GRINDER	.04390	.010	
0020 E	RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST	.45621	.456	
0030 E	RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS	.02466	.024	
0040 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632	.026	
0050 E	KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL	.02308	.023	
0060 E	RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)	.02029	.020	
0070 E	KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION	.06761	.270	
0080 E	RGR-GE-C2	40.00	GR CHROM OD (OCC FACT L X D)	.02189	.875	
0090 E	RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES	.00481	.004	
0100 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.010	
0249	JA 01 15	1.00	VERTICAL OR HORIZONTAL HONE	.172	.026	.198 3
0010 E	RHO-SU-V1	.10	SET UP LARGE VERTICAL HONE	.55195	.063	
0020 E	RML-SU-F3	.10	LRG FIXTUR TO/FRM MACH HOIST	.45621	.052	
0030 N		.10	LOAD & UNLOAD PART	.12200	.014	
0040 N		.10	HONE	.30000	.034	
0050 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.018	
0060 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D	.00333	.003	
0070 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
9000	JA 01 15	.01	LABOR STANDARD HISTORY	.000	.000	.000 0
0010			17AUG83 REVIEW AND CHG OCC. FACTORS			
0020			PREVIOUS STD HRS 0.73			
0030			08MAR84 REVIEW SUB OPR 030/1.045/050/.931 OLD STD			
0040			04APR84OPR 1/30 ADDED FOR REROUTE OF ITEM 16 % IS			
0041			28AUG85 OCC FACTOR CHANGE & ADDED 0154 O/STD 2.46			
0050			EST ONLY NO HISTORY			
0055			12SEPT84 OCC ADJUSTD <OLD STD>3.70			
0056			10OCT84 ADDED PF&D TIME < OLD STD> 1058			
0057			6 NOV84 2 YR REVIEW W/OCC CHANGE < OLD STD > 9.55			
0058			10JULY85 ADDED TIME SUB OP 0007 OLD STD 2.45			
0059			22JULY CHANGED STD TO MATCH 958 NO TIME CHANGE			
0900			J.CALDWELL TECH MANEAA			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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KC-135 NLG

Garrett Cannon

James L. Ellison

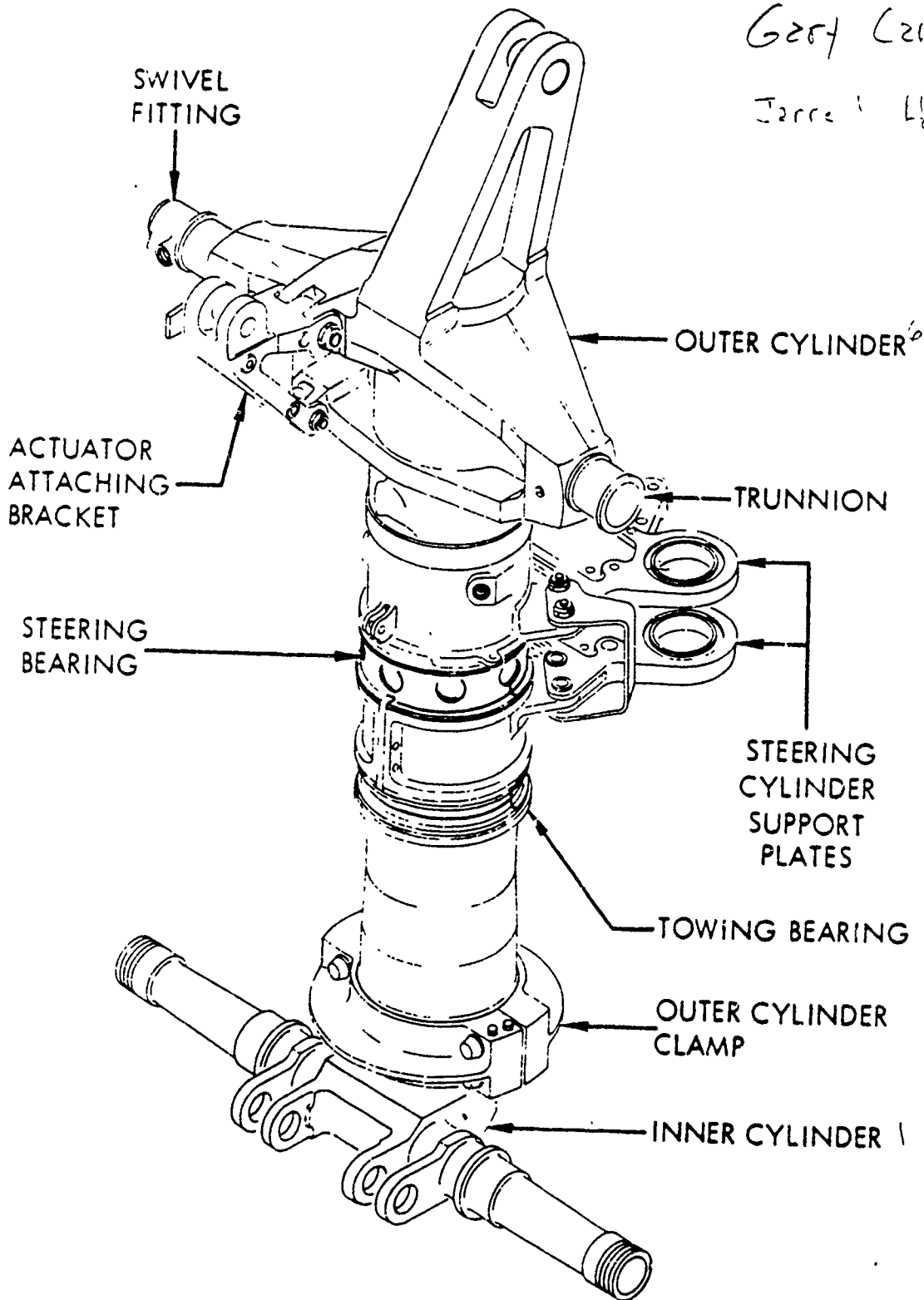


Figure 1-2. Nose Gear Oleo and Collar Assembly

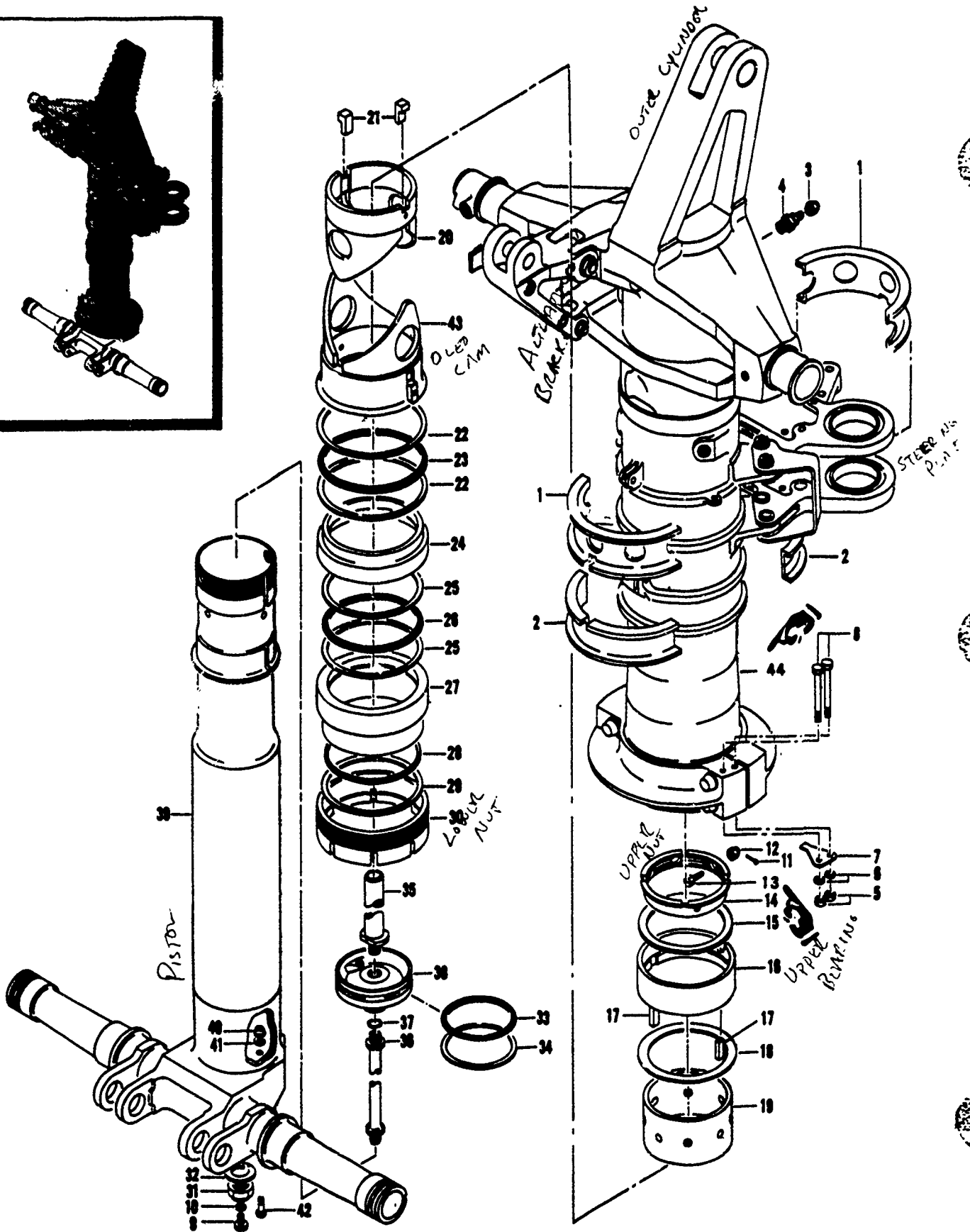
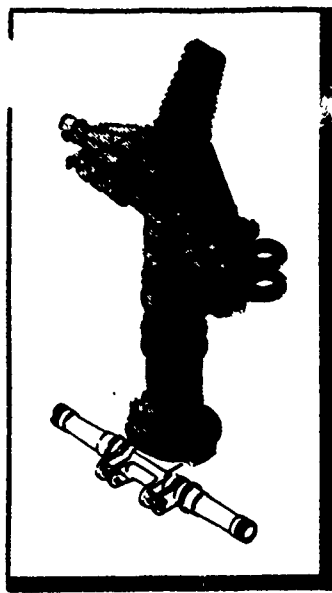


Figure 2-2. Nose Gear Oleo and Collar Assembly (Sheet 1 of 2)

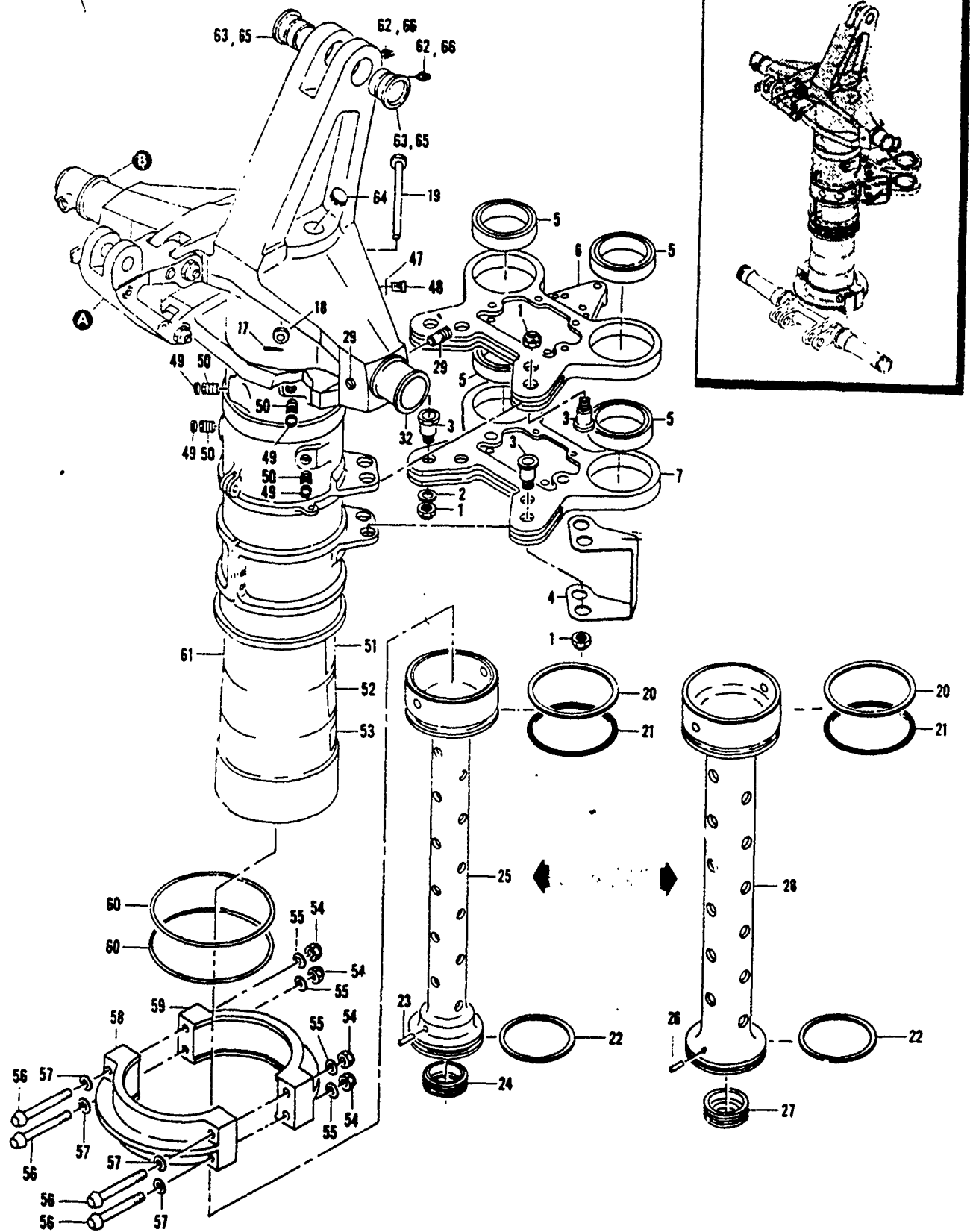


Figure 2-3. Nose Gear Outer Cylinder Assembly (Sheet 1 of 2)

KEY TO FIGURE 2-3

1 NUT	14 BOLT	27 PLATE	40 FITTING	53 METAL-CAL
2 WASHER	15 WASHER	28 TUBE	41 PLUG	54 NUT
3 PIN	16 BRACKET	29 SCREW	42 FITTING	55 WASHER
4 BRACKET	17 PIN	30 NUT	43 TRUNNION PIN	56 BOLT
5 BEARING	18 NUT	31 SCREW	44 BOLT	57 WASHER
6 PLATE	19 BOLT	32 TRUNNION	45 BRACKET	58 CLAMP HALF
7 PLATE	20 RING	33 PIN	46 SLEEVE	59 CLAMP HALF
8 NUT	21 PACKING	34 WASHER	47 PACKING	60 PACKING
9 NUT	22 RING	35 FITTING	48 FITTING	61 OUTER CYLINDER
10 WASHER	23 PIN	36 RING	49 RING	62 FITTING
11 WASHER	24 PLATE	37 PACKING	50 SLEEVE	63 BUSHING
12 BOLT	25 TUBE	38 PIN	51 METAL-CAL	64 PLUG
13 WASHER	26 PIN	39 PLUG	52 METAL-CAL	65 BUSHING
				66 FITTING

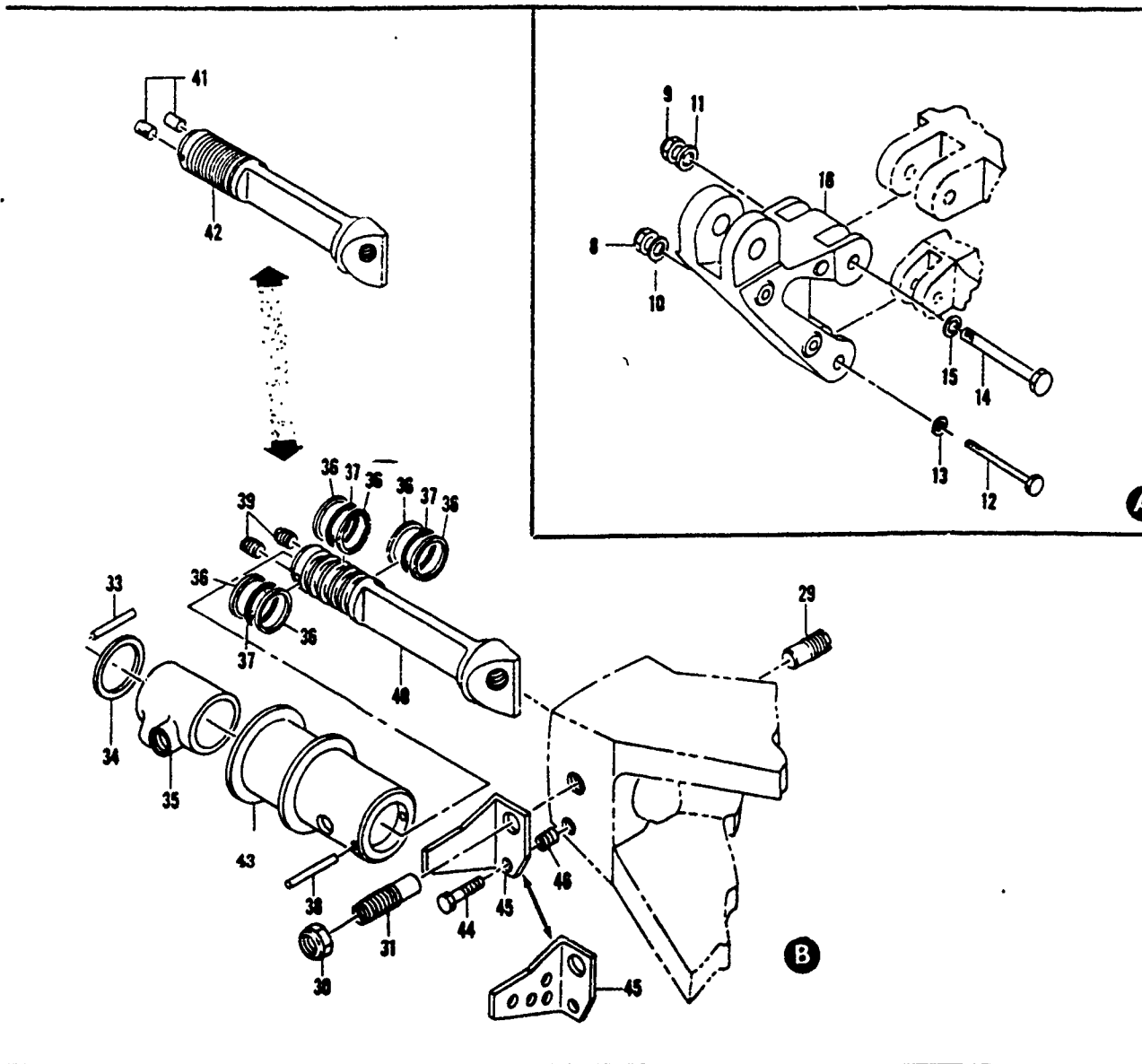


Figure 2-3. Nose Gear Outer Cylinder Assembly (Sheet 2 of 2)



**SECTION X**  
**MAINTENANCE PARTS LIST**

**NOTE**

This parts list reflects the user with most replacement parts usable at major overhaul and at minor repair. Standard parts, and parts having multiapplication, are stocked in their appropriate class.

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
10-1-	5-83069-8	81205	OLEO ASSEMBLY, NOSE GEAR (Parts ..... kits available)	REF		
	7327025-30	98747	OLEO ASSEMBLY, NOSE GEAR .....	REF		
	7327025-50	98747	OLEO ASSEMBLY, NOSE GEAR .....			PAODD
	7327025-110	98747	OLEO ASSEMBLY, NOSE GEAR .....			PAODD
-1	9-55604-2	81205	BEARING ASSEMBLY, Steering knuckle..... for bearing land width 3.252/3.255 (standard)	1		PAODD
	9-55604-4	81205	BEARING ASSEMBLY, Steering knuckle..... for bearing land width 3.352/3.335 (oversize)	1		PAODD
-2	9-55608-2	81205	BEARING ASSEMBLY, Towing collar for ..... bearing land width 1.877/1.880 (stan- dard)	1		PAODD
	90-6715-6	81205	BEARING ASSEMBLY, Towing collar for ..... bearing land width 2.228/2.230 (over- size)	1		PAODD
	5-83069-4	81205	OLEO ASSEMBLY, Nose gear (use..... with 90-6715-6 and 9-55604-4)	1		PAODD
	5-83069-6	81205	OLEO ASSEMBLY, Nose gear (use..... with 69-11369 and 69-11370)	REF		
	5-83069-7	81205	OLEO ASSEMBLY, Nose gear (use..... with 90-6715-6 and 9-55604-4)	1		PAODD
-2a	52-032-156-1000	72962	PIN, Spring steel (BAC P18 ..... L10P1000)	4		PAOZZ
-2b	3-95606	81205	KEY, Nose gear steering bearing .....	2		PAOZZ
-3	AN813-1B	80205	CAP, Protective, dust and ..... moisture seal	1		PAOZZ
-4	MS28889-1	80205	VALVE, Stop check (preferred).....	1		PAOZZ
	AN6287-1	80205	VALVE, Stop check.....	1		PAOZZ
-5	AN3-33A	80205	BOLT.....	2		PAOZZ
-6	NAS679-A3W	80205	NUT.....	2		PAOZZ
-7	AN960C10L	80205	WASHER.....	2		PAOZZ
-8	63-10418-1	81205	LOCKING KEY .....	1		PAOZZ
	5-83069-1	81205	INNER CYLINDER ASSEMBLY, ..... Nose gear	1		PAODD
	5-83069-3	81205	INNER CYLINDER ASSEMBLY, ..... Nose gear	1		PAODD
-9	AN814-6L	88044	PLUG, Machine thread.....	1		PAOZZ
-10	MS28778-6	88044	PACKING (Optional..... AN6227B10)	1		PAOZZ
	AN6227B10	88044	PACKING.....	1		PAOZZ
-11	AN380-2-2	88044	PIN, Cotter .....	1		PAOZZ
-12	AN320-4	88044	NUT.....	1		PAOZZ
-13	60-6656	81205	PIN, Nut retainer .....	1		PAOZZ
-14	60-6681	81205	NUT, Nose gear upper oleo ..... bearing (optional 60-6681-1)	1		PAOZZ
	60-6681-1	81205	NUT, Nose gear upper oleo ..... bearing	1		PAOZZ
	60-6681-2	81205	NUT, Nose gear upper oleo ..... bearing (preferred)	1		PAOZZ
-15	60-6619-1	81205	WASHER, Nose gear oleo..... upper, 0.040	AR		

T.O. 4S2-30-3

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
10-1-15	60-6619-2	81205	.	.	.	WASHER, Nose gear oleo..... upper, 0.050				AR		
	60-6619-3	81205	.	.	.	WASHER, Nose gear oleo..... upper, 0.063				AR		
	60-6619-4	81205	.	.	.	WASHER, Nose gear oleo..... upper, 0.080				AR		
	60-6619-5	81205	.	.	.	WASHER, Nose gear oleo..... upper, 0.090				AR		
-16	6-55002-1	81205	.	.	.	BEARING, Nose gear upper..... oleo				1		PAOZZ
	8020062-1	98747	.	.	.	BEARING, Nose gear upper..... oleo (preferred item)				1		PAOZZ
-17	3-71002-1	81205	.	.	.	KEY, Nose gear upper bearing.....				2		PAOZZ
-18	6-55018-1	81205	.	.	.	WASHER.....				1		PAOZZ
-19	6-55001-1	81205	.	.	.	SPACER, Nose gear upper cam.....				1		PAOZZ
-20	6-68004	81205	.	.	.	CAM, ASSEMBLY, Nose gear..... upper (for replacement, order 5 83012-1 and 66-18273)				REF		
	158660	81205	.	.	.	CAM, Nose gear upper (replace..... with 5-83012-1)				REF		
-20A	5-83012-1	81205	.	.	.	CAM, Nose gear upper (use..... with 66-18273)				1		PAOZZ
-20B	66-16273	81205	.	.	.	KEY, Upper cam, nose gear..... (use with 5-83012-1)				2		PAOZZ
-21	43A3MT-160A-N	72902	.	.	.	PACKING ASSEMBLY.....				1		PAOZZ
	43A3MT-2N	72902	.	.	.	BACK-UP RING (optional..... MS28782-59 use only with AN6227B59)				2		XA
	43A2MT-160A	72902	.	.	.	PACKING (optional..... AN6227B59 use only with MS28782-59)				1		XA
-22	Deleted											
-23	66-10461	72902	.	.	.	ADAPTER PACKING.....				1		PAOZZ
-24	42A9FT-160A-N	72902	.	.	.	PACKING ASSEMBLY.....				1		PAOZZ
	42A9FT-2N	72902	.	.	.	BACK-UP RING (optional..... MS28782-56 use only with AN6227B56)				2		XA
	42A9FT-160A	72902	.	.	.	PACKING (optional..... AN6227B56 use only with MS28782-56)				1		XA
-25	Deleted											
-26	69-11344	81205	.	.	.	BEARING LOWER (standard).....				1		PAOZZ
	69-11344-1	81205	.	.	.	BEARING LOWER (oversize).....				1		PAOZZ
-27	MS28932-1	90696	.	.	.	FELT STRIP.....				1		PAOZZ
-28	MS28776M2-45	90696	.	.	.	RING WIPER.....				1		PAOZZ
-29	158665	81205	.	.	.	NUT, Nose gear lower oleo..... (optional 9-55612)				1		PAOZZ
-30	NAS509-16	88044	.	.	.	NUT, Drilled jam.....				1		PAOZZ
-31	3-95613	81205	.	.	.	WASHER, Nose gear drain tube.....				1		PAOZZ
-32	345MS-16A-N	72902	.	.	.	PACKING ASSEMBLY (optional..... use AN6227B48 with MS28782-48)				1		PAOZZ
-33	345MS-2N	72902	.	.	.	RING, Back-up (optional..... MS28782-48 use with AN6227B48)				2		PAOZZ
-34	9-60375	81205	.	.	.	ROD, Orifice, nose gear.....				1		PAODD
-35	6-55020	81205	.	.	.	TUBE, Drain, nose gear.....				1		PAOZZ
-36	AN6227B12	72902	.	.	.	PACKING.....				1		PAOZZ
-37	9-55621	81205	.	.	.	BULKHEAD, Orifice rod, nose..... gear				1		PAODD

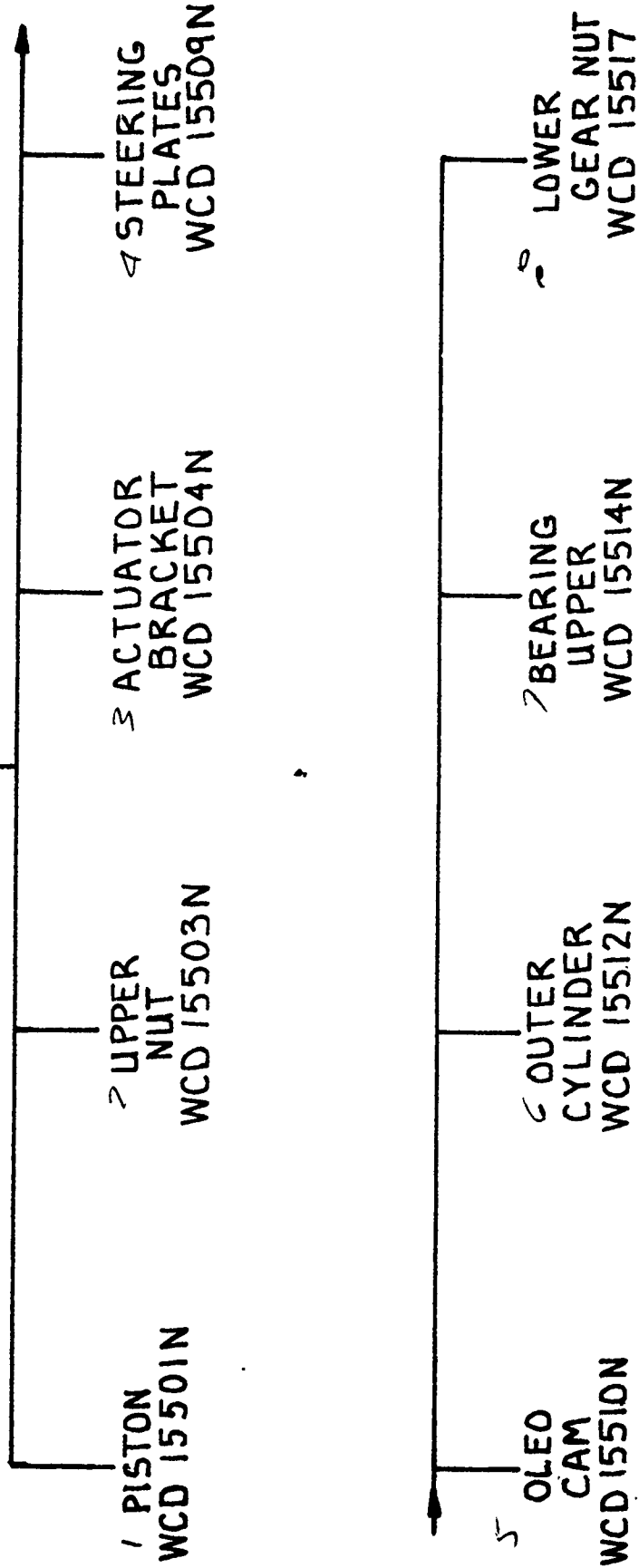
FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE	
			1	2	3	4	5	6	7				
10-1-38	7531263-10	98747	.	.	.						1		PAODD
	5-73144	81205	.	.	.						1		XC
	5-73144-1	81205	.	.	.	.					1		XC
-39	NAS679-A3W	88044	.	.	.	.	.	.	.	.	1		PAOZZ
-40	AN960-10	88044	.	.	.	.	.	.	.	.	1		PAOZZ
-41	AN3H5A	88044	.	.	.	.	.	.	.	.	1		PAOZZ
	65A30315-10	98747	.	.	.	.	.	.	.	.	AR		PAOZZ
	65A30315-68	98747	.	.	.	.	.	.	.	.	AR		PAOZZ
-42	90-9128	81205	.	.							1		PAOZZ
	90-9128-2	81205	.	.							1		PAOZZ
	90-9128-3	81205	.	.							1		PAOZZ
	158662	81205	.	.							1		PAOZZ
	5-83011-2	81205	.	.							1		PAOZZ
	30-3065-1	81205	.	.							2		PAOZZ
-43	5-83025-3	81205	.	.							1		PAODD

# FAMILY 5

## CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JDP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	6019 FLOW DAYS
COOP	TOLM	68878A		F-111 MLG	STRUT ASSY	1620-01-100-9806	7327080-110	4S1-78-3	44
COOP	COOP	68884A	-6	F-15 MLG	STEERING ARM	1620-00-305-1726	68A450653-1001	4A4-22-3	3
COOP	RIGB	68891A	-J	FB-111 MLG	BRAKE BACKING PLATE	1630-00-856-2195	9535519	4B1-2-493	19
MART	SHEL	68973A		F-15	ADU-407	1440-01-064-3475AB	68A731301-1007	11LAB-7-3	7
MART	SHEL	68981A		MULTI	LAUNCHER LAU-101 R/H	1440-01-104-0367AB	7839472-50	11L1-2-11-504	16
DELE		69032A		AE-37A	BATTERY PACK	6135-00-074-2973TA	12 SEPTEMBER 85	802-3-1	
DELE		69072A		LGM-30	BATTERY-POWER	1430-00-135-5627AH	23 DECEMBER 86	8011-3-29-2	
COOP	TOLM	69081A		F-111 MLG	PIN TRUN HINGE	1620-00-118-7445	12L9545-801	4A4-1-113	35
MART	SHEL	69087A		B-52	AMMO BOX	1005-00-970-6111	571541-409	11FB-3-7-3	15
MART	SHEL	69088A		F-16	EXIT UNIT	1005-01-050-2735	16V002002-2	11W1-7-16-2	13
MART	SHEL	69089A		F-15	UNIT ENTRANCE	1005-01-050-2736	16VS002003-2	11W1-7-16-2	9
MART	SHEL	69093A		F-15	UNIT ENTRANCE	1005-00-268-7019	189F490	11W1-7-15-2	7
DELE		69095A			CIRCUIT BOARD MAU-58	1005-00-050-1978	28 OCT 86	11W1-7-10-3	
MART	SHEL	69096A			FEED SYSTEM MAU-58	1005-00-249-9828	7832656	11W1-7-10-3	20
JENS	POLL	69098A	-6-J	C-130	BALLSCREW	1620-00-365-4001	8353-M1	1663-2-01-3	20
COOP	TOLM	69101A		F-111 MLG	BRACE LOWER	1620-00-924-0926	12L9105-1	4A4-15-3	25
DELE		69112A		E-3A MLG	LOWER SIDE STRUT	1620-01-009-0094	30 NOV 87	4S1-106-3	
DELE		69117A		MS-212	AIRFOIL	1325-00-427-9097	23 DEC 86	11A6-12-3	
DELE		69118A		MS-212	AIRFOIL	1325-00-427-9099	23 DEC 86	11A6-12-3	
COOP	POLL	69136A		C-141 MLG	LINK	1620-00-927-2600	3611014-107	4S1-73-3	21
DELE		69216A		F-4	HYD GUN DRIVE	1005-01-041-0667	10 APR 85	11W1-28-5-3	
DELE		69228A		C-130	STAND GUN	1005-00-110-7197	28 OCT 86	11W1-1-34-3-1	
DELE		69247A		F-106 MLG	CENTER LINK BRACE	1620-00-604-7386	19 NOV 86	4S2-40-13	
DELE		69248A		F-111 MLG	PIN STAB ROD	1620-00-422-1832	4 FEB 86	4A4-19-3	
DELE		69271A		F-111 MLG	PIN TRUN HINGE	1620-00-121-9443	4 FEB 86	4A4-1-113	
DELE		69273A		F-111 MLG	PIN STAB ROD	1620-00-221-2453	4 FEB 86	4A4-1-113	
DELE		69276A	-J	F-16 MLG	BRAKE ASSY	1630-01-087-0431	8-12-87	4B1-2-1162	
MART	SHEL	69282A		A-70	HOUSING	1005-00-547-7184	201F315	11W1-7-1-103	20
POLL	POLL	69288A		C-141	BRACE	1620-00-943-0753	3F31004-117	4SA6-19-3	0
DELE		69322A		XM10	FEEDER UNIT SUU-11	1005-00-903-0753	28 OCT 86	11W1-31-3-2	
DELE		69323A		F-15	DRUM ASSY	1005-01-007-7186	28 OCT 86	11W1-7-15-2	
MART	SHEL	69324A	-6	MULTIPLE	MAU-12DA	1005-01-100-3892	69J13060-7	11B29-3-25-2	19
MART	SHEL	69332A		F-4	PYLON O.B. L/H	1560-01-034-5064BF	53673301-25	16N6-1-102	28
BENT	COOP	69354A	-6	KC-135 MLG	STRUT ASSY	1620-01-059-7042	7327075-110	4S2-30-3	37
DELE		69389A		LGM-25	SHOCK STRUT	1450-00-690-6303AE	10 FEB 87	36Y56-2-3	30
DELE		69455A		F-15 MLG	UPPER BRACE	1620-00-305-1772	4 FEB 86	4S2-73-4	
BENT	POLL	69545A		C-130 MLG	STRUT ASSY	1620-00-085-2624	388071-3	4S2-23-3	65
BENT	COOP	69549A		KC-135 MLG	LOWER SIDE SEGMENT	1620-00-138-6373	74-30366-01	4A4-12-23	30
BENT	COOP	69551A		KC-135 MLG	SUPPORT LINK	1620-00-312-9664	5-83050	4A4-12-23	30
BENT	COOP	69554A		KC-135 MLG	UNIVERSAL LOW SIDE STRUT	1620-00-525-1156	9-60346-7	4A4-12-23	25
BENT	COOP	69555A		KC-135 MLG	UPPER UNIVERSAL L/H	1620-00-614-2351	9-60346-7	4A4-12-23	30
BENT	COOP	69556A		KC-135 MLG	ACTUATOR BEAM	1620-00-591-0508	4-30364-10	4A4-12-23	35
BENT	COOP	69557A		KC-135 MLG	BRACE EQUAL ROD	1620-00-650-7900	65-1266-2	4A4-12-23	29
BENT	COOP	69558A	-6	KC-135 MLG	UPPER UNIVERSAL R/H	1620-00-614-2352	9-60346-8	4A4-12-23	30
BENT	POLL	69559A	-6	C-130 MLG	MAIN PISTON	1620-00-862-4057	388059-1	4S1-37-3	63
DELE		69561A		C-130 MLG	AFT TORQUE STRUT	1620-00-862-4059	25 NOV 86	4S1-69-13	
DELE		69562A		C-130 MLG	CYLINDER	1620-00-862-8285	25 NOV 86	4S1-37-3	
BENT	POLL	69563A		C-130 MLG	LOWER TORQUE ARM	1620-00-686-8889	388060-1	4S2-23-3 25	
BENT	POLL	69564A		C-130 MLG	UPPER TORQUE ARM	1620-00-886-8890	388069-1	4S2-23-3	25
BENT	POLL	69567A		C-130 MLG	BRACE ASSY	1620-00-976-3392	371689-7	4SA6-7-3	35

KC-135 NOSE  
 LANDING GEAR ASSEMBLY  
 PCN 69354A  
 WCD 15511N



(G402A-TIP001)

LABOR STD REVIEW 10 APR 89

4:38 PM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED
								STAND HOURS
69354A	MKPRW	XKPRW	X	4N	6	.54	1.00	54
								-----
FAMILY 5 *								54
KC-135	MNPCD	C0514	N	VR	4	.51	1.00	51
NLG								-----
*								51
	MNPGP	00010	N	HB	5	5.93	1.00	5.93
		PP501	E	3S	5	.34	1.00	34
		PP512	E	3S	5	.34	1.00	34
		PS511	N	3S	5	.96	1.00	96
								-----
								7.57
	MNPGW	PM010	E	DJ	5	1.22	1.00	1.22
		PM511	E	DJ	5	1.32	1.00	1.32
		WC001	E	KI	5	1.62	1.00	1.62
		W0001	E	H3	5	2.50	1.00	2.50
		WE501	E	DI	5	1.15	1.00	1.15
		WE503	N	DI	5	.16	1.00	16
		WE504	N	DI	5	.26	1.00	26
		WE509	N	DI	5	.26	1.00	26
		WE510	N	DI	5	.40	1.00	40
		WE512	E	DI	5	1.16	1.00	1.16
		WE514	N	DI	5	.28	1.00	28
		WE517	N	DI	5	1.13	1.00	1.13
		WE528	N	DI	5	.16	1.00	16
		XNPGW	X	H3	5	5.69	1.00	5.69
								-----
*								17.31
	MNPNA	NA501	E	DB	2	.94	1.00	94
		NA503	F	DB	2	.10	.47	4
		NA504	E	DB	2	.33	1.00	33
		NA509	E	DB	2	.29	.61	17
		NA510	E	DB	2	.10	.10	1
		NA512	E	DB	2	.50	.96	48
		NA517	E	DB	2	.10	1.00	10
		NA528	E	DB	2	.10	1.00	10
		XNPNA	X	DB	2	4.71	1.00	4.71
								-----
*								6.88
	MNPRA	RA501	N	JA	1	1.42	.29	49
		RA503	E	JA	1	.23	1.00	28
		RA504	E	JA	1	.79	1.00	79
		RA509	E	JA	1	1.39	.79	1.09
		RA510	E	JA	1	.34	.05	4
		RA511	E	JA	1	.7	1.00	0.75

3K

PROJ NBR	FCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
								11.47
09354A	MNPR3	R5501	E	JA	1	5.65	.21	1.18
		R5512	N	JA	3	3.03	.50	1.51
								2.69
	MNPRC	RC501	N	UP	5	4.27	.53	2.47
		RC503	E	UP	8	.61	.38	23
		RC504	E	UP	8	.69	.46	31
		RC509	E	UP	8	2.09	1.08	2.25
		RC510	E	UP	8	.54	.63	40
		RC512	E	UP	8	1.94	.71	1.37
		RC517	E	UP	8	1.54	.05	8
		RC528	E	UP	8	1.69	2.00	3.38
		XNPRC	X	UP	8	2.55	1.00	2.55
								13.04
	MNPWW	WF512	N	WF	9	6.19	.22	1.36
								1.36
								61.37

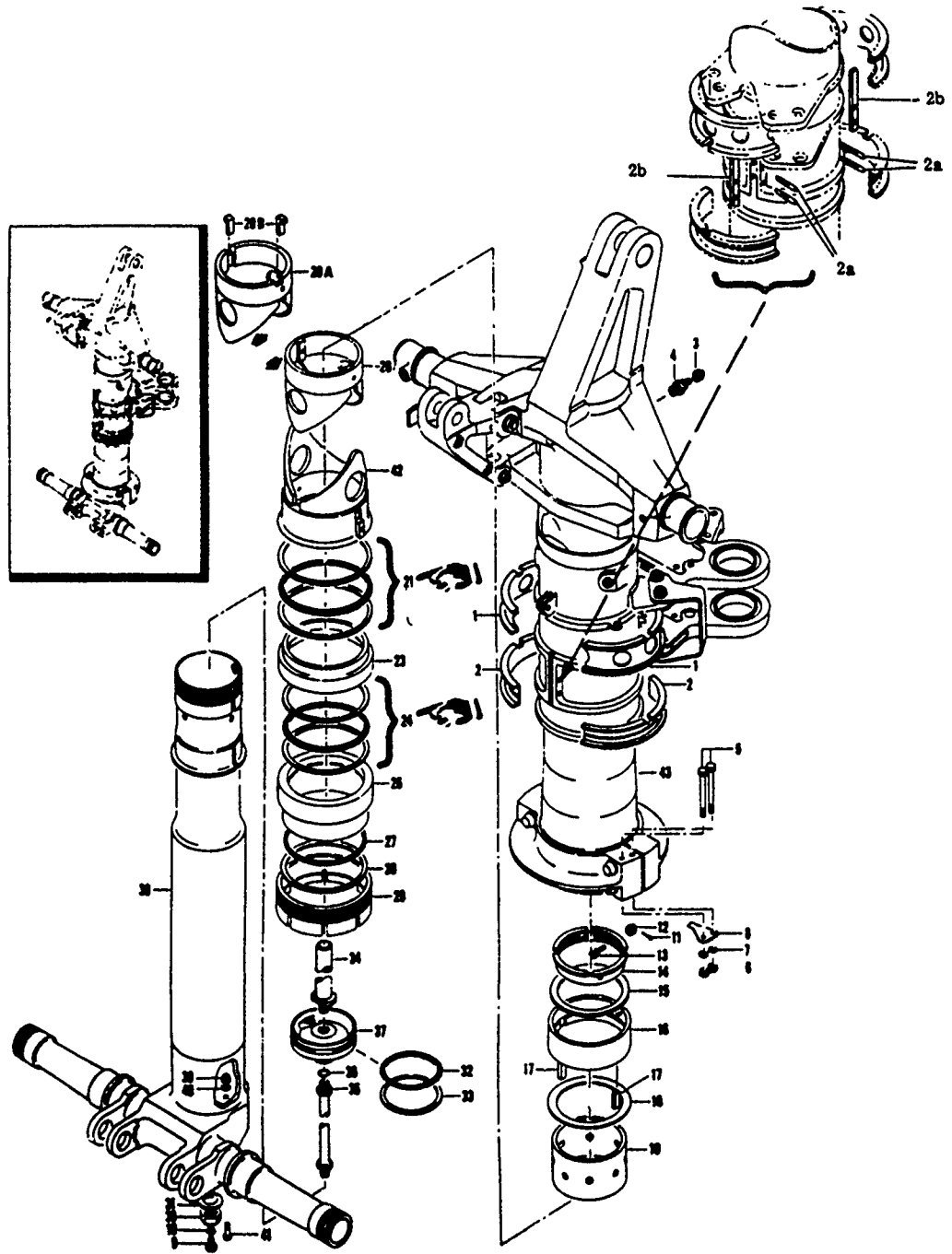


Figure 10-1. Nose Gear Oleo Assemblies

■ 10-4 Change 9

Pages 10-4A and 10-4B are deleted in their entirety.



FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
10-2-	5-83025-3	81205	CYLINDER ASSEMBLY, NOSE GEAR..... OUTER	REF		PAODD
	5-83025-4	81205	CYLINDER ASSEMBLY, NOSE GEAR..... OUTER	REF		PAODD
	5-83025-5	81205	CYLINDER ASSEMBLY, NOSE GEAR..... OUTER	REF		PAODD
	5-83025-6	81205	CYLINDER ASSEMBLY, NOSE GEAR..... OUTER	REF		PAODD
	7327022-30	98747	CYLINDER ASSEMBLY, NOSE GEAR..... OUTER			PAODD
-1	NAS1022-A9	88044	. NUT.....	8		PAOZZ
	MS21245-L9	88044	. NUT.....	8		PAOZZ
-2	AN960D916	88044	. WASHER.....	4		PAOZZ
-3	3-95685	81205	. PIN, Steering plate, nose gear.....	8		PAOZZ
-4	60-6144	81205	. BRACKET, Wire support, nose gear.....	1		PAOZZ
-5	KP498	80205	. BEARING, Ball, ar frame.....	4		PAOZZ
-6	5-73193	81205	. PLATE, Support, steering cylinder..... nose gear	1		PAODD
	NAS537B12P-21	88044	. BUSHING (Repair only).....	AR		PAOZZ
-7	5-73193-1	81205	. PLATE, Support, steering cylinder..... nose gear	1		PAODD
	NAS537B12P-21	88044	. BUSHING (Repair only).....	AR		PAOZZ
-8	NAS1022-A9	88044	. NUT.....	1		PAOZZ
-9	NAS1022-A10	88044	. NUT.....	1		PAOZZ
-10	AN960D916	88044	. WASHER.....	1		PAOZZ
-11	AN960D1016	88044	. WASHER.....	1		PAOZZ
-12	NAS1109-44W	88044	. BOLT, Shear, close tolerance.....	1		PAOZZ
-13	MS20002C9	88044	. WASHER, Countersunk.....	1		PAOZZ
-14	NAS1110-58W	88044	. BOLT, Shear, close tolerance.....	1		PAOZZ
-15	MS20002C10	88044	. WASHER, Countersunk.....	1		PAOZZ
-16	5-72349	81205	. BRACKET, Actuator attaching, nose..... gear (optional 5-72439-200)	1		PAOZZ
-17	AN380-3-3	88044	. PIN, Cotter.....	1		PAOZZ
-18	AN310-6	88044	. NUT.....	1		PAOZZ
-19	NAS1306-118DH	88044	. BOLT, Shear.....	1		PAOZZ
-20	AN6246-56	88044	. GASKET.....	1		PAOZZ
	MS28774-429	88044	. RETAINER, Packing, back-up..... (optional MS28782-56)	1		PAOZZ
-21	AN6227-56	88044	. PACKING.....	1		PAOZZ
-22	6-55019	81205	. RING PISTON.....	1		PAODD
	5-83018	81205	. TUBE ASSEMBLY, Piston nose gear.....	1		PAODD
-23	52-040-187-0562	72962	. PIN, Spring (BAC-P18L-12P..... 0562)	1		PAODD
-24	6-68072	81205	. PLATE, Orifice, nose gear piston..... tube	1		PAODD
-25	5-83018-1	81205	. TUBE, Piston, nose gear.....	1		PAODD
	6-14297		. TUBE ASSEMBLY, Piston, nose gear.....	1		PAODD
-26	NAS561PF6-12		. PIN, Spring.....	1		PAODD
-27	6-68072		. PLATE, Orifice.....	1		PAODD
-28	65-14297-1		. TUBE, Piston, nose gear.....	1		PAODD
-29	6-68015		. LOCKSCREW, Nose gear trunnion.....	3		PAOZZ
	8121566-05	98747	. LOCKSCREW, Nose Gear trunnion..... (oversize) (can be used in place of 6- 68015)	3		PAOZZ
	8121566-21	98747	. LOCKSCREW, Nose gear trunnion..... (oversize)	3		PAOZZ
	68J29645-61-S32P		. BUSHING, (repair only) cylinder..... trunnion retaining pin hole	AR		PAODD
-30	NAS1022C10		. NUT.....	1		PAOZZ
-31	6-68015-1		. LOCKSCREW, Nose gear trunnion.....	1		PAOZZ
	8121566-01	98747	. LOCKSCREW, Nose gear trunnion..... (can be used in place of 6-68015-1)	1		PAOZZ
	8121566-07	98747	. LOCKSCREW, Nose gear trunnion..... (oversize)	1		PAOZZ
	8121566-15	98747	. LOCKSCREW, Nose gear trunnion..... (oversize)	1		PAOZZ
	65832580-05		. BUSHING (repair only).....	AR		FAODD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR CODE
10-2-32	6-68002 7729421-03		. TRUNNION, Nose gear .....	1		PAOZZ
			. TRUNNION, Nose Gear (replaces .....	2		PAODD
			part Nos. 6-68002, 6-68001, and .....			
			7729421-01)			
-33	MS24665-370		. KEY, Cotter .....	1		
	MS24665-377		. KEY, Cotter .....	1		
-34	3-71050		. WASHER, Nose gear swivel fitting .....	1		PAOZZ
-35	6-55067		. FITTING, Swivel, nose gear .....	1		PAOZZ
-36	AN6246-23		. GASKET .....	6		PAOZZ
	MS28774-218		. RETAINER, Packing back-up (optional ....	6		PAOZZ
			MS28782-23)			
-37	AN6227B23		. PACKING .....	3		PAOZZ
	MS28775-218		. PACKING (Alternate to part No. ....	3		PAOZZ
			AN6227B23)			
-38	52-028-125-2000		. PIN, Spring .....	1		PAOZZ
	9-55602		. SWIVEL ASSEMBLY, Steering, nose .....	1		PAOZZ
			gear (for replacement use .....			
			7729422-30)			
-39	AN913-15		. PLUG, Pipe .....	2		
-40	9-55602-1		. SWIVEL FITTING, Steering, nose .....	1		PAOZZ
			gear			
	9-55602-2		. SWIVEL ASSEMBLY, Steering nose .....	1		PAOZZ
			gear (for replacement use .....			
			7729422-30)			
-40a	3A		. PLUG, Pin .....	2		PAOZZ
-40b	9-55602-3		. SWIVEL FITTING, Steering, nose .....	1		PAOZZ
			gear			
	65832580-05		. BUSHING (repair only) .....	AR		PAODD
	7729422-30		. SWIVEL ASSEMBLY, Steering nose .....	2		XA
			gear (when 9-55602 and .....			
			9-55602-2 are beyond repair, this .....			
			assembly will be used) (use with .....			
			trunnion pin 7729421-03)			
	7729421-03		. SWIVEL FITTING .....	1		PAOZZ
	281101	92555	. PLUG .....	2		XA
-41	6-68001		. TRUNNION, Nose gear .....	REF		
	7729421-03		. TRUNNION (preferred item) .....	1		PAOZZ
-42	AN3H4A		. BOLT .....	1		PAOZZ
-43	6-68014		. BRACKET, Steering shutoff valve .....	1		PAOZZ
			actuator			
	6-68014-1		. BRACKET, Steering shutoff valve .....	1		PAOZZ
			actuator			
-44	1191-3CX.380		. SLEEVE, Steel wire .....	1		PAOZZ
	BAC-S13P-3C-4		. SLEEVE, Steel wire .....	1		PAOZZ
	MS124735		. SLEEVE, Steel wire (alternate to .....	1		PAOZZ
			1191-3CX.380 and BAC-S13P-3C-			
			4)			
-45	AN6227-11		. PACKING .....	1		PAOZZ
-46	3-71015		. FITTING, Nose gear air valve .....	1		PAOZZ
-47	RZA-10330-7		. RING, Lock .....	4		PAOZZ
-48	R206S88		. SLEEVE, Threaded .....	4		PAOZZ
-49	BAC-M10L-33-1BED		. METAL-CAL .....	1		PAOZZ
-50	BAC-M10L-31-1AUR		. METAL-CAL .....	1		PAOZZ
-51	BAC-M10L-32-1BEG		. METAL-CAL .....	1		PAOZZ
	65-13211-3		. CLAMP ASSEMBLY, Nose gear outer .....	1		PAODD
			cylinder			
-52	NAS1021A8		. NUT .....	4		PAOZZ
-53	AN960PD816		. WASHER .....	4		PAOZZ
-54	MS20008-46		. BOLT .....	4		PAOZZ
-55	MS20002-C8		. WASHER, Countersunk .....	4		PAOZZ
-56	65-13211-4		. CLAMP HALF .....	1		PAODD
-57	65-13211-5		. CLAMP HALF .....	1		PAODD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
10-2-58	MS29513-260		.							2		PAOZZ
	65-4854-5		.							1		PAODD
	65-4854-3001		.							1		PAODD
	7327022-30		.							1		PAODD
	5-83005-8		.							1		PAODD
	5-83005-9		.							1		PAODD
	.59	65-4854-4		.						1		PAODD
		65-4854-2002		.						1		PAODD
		7327021-03		.						1		XA
	.60	MS15001-1		.						2		PAOZZ
	.61	63-2030-1		.						2		PAOZZ
	.62	SS-48165		.						2		PAOZZ
	.63	63-2030-2		.						2		PAOZZ
	.64	MS15001-1		.						2		PAOZZ

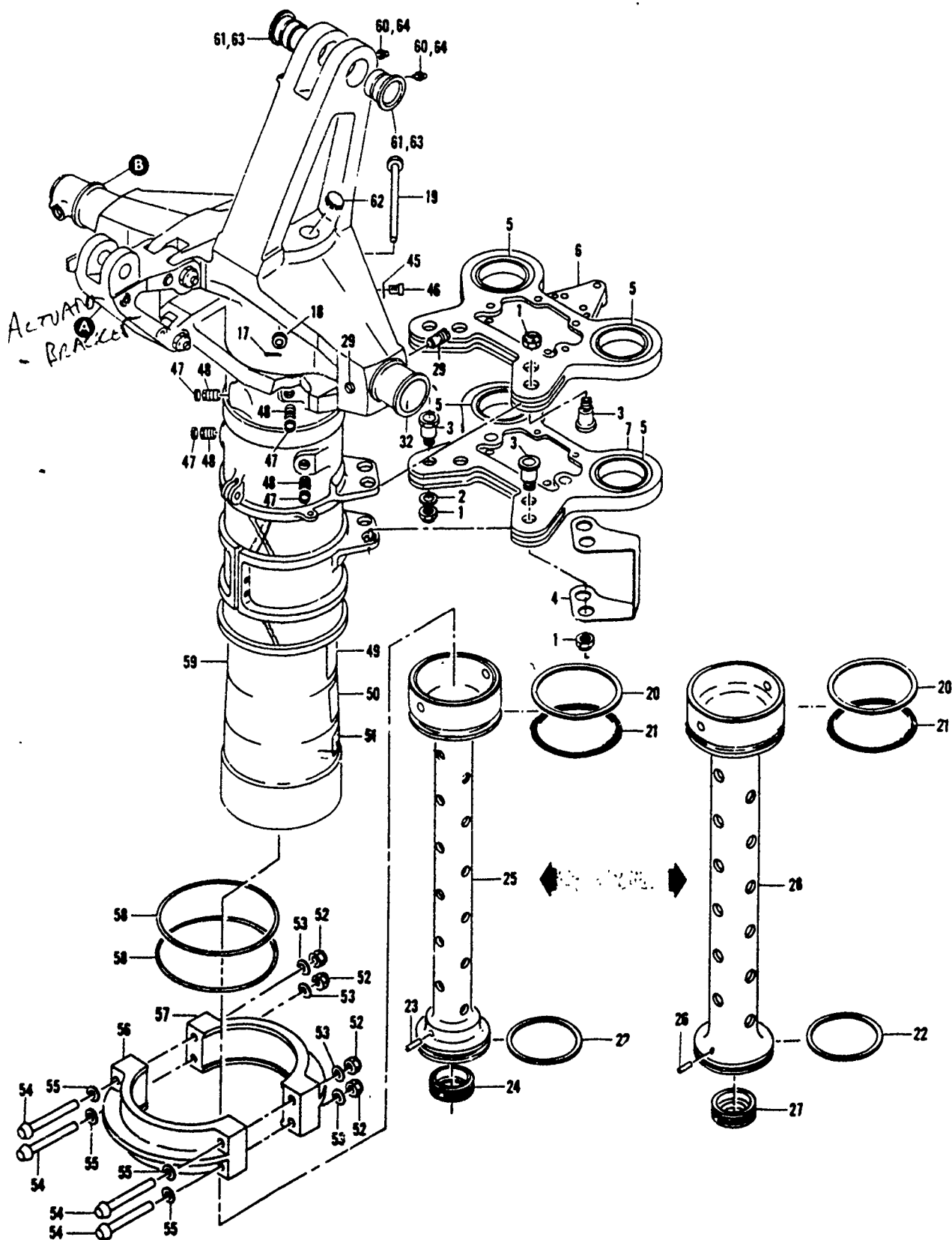


Figure 10-2. Nose Gear Outer Cylinder Assemblies (Sheet 1 of 2)

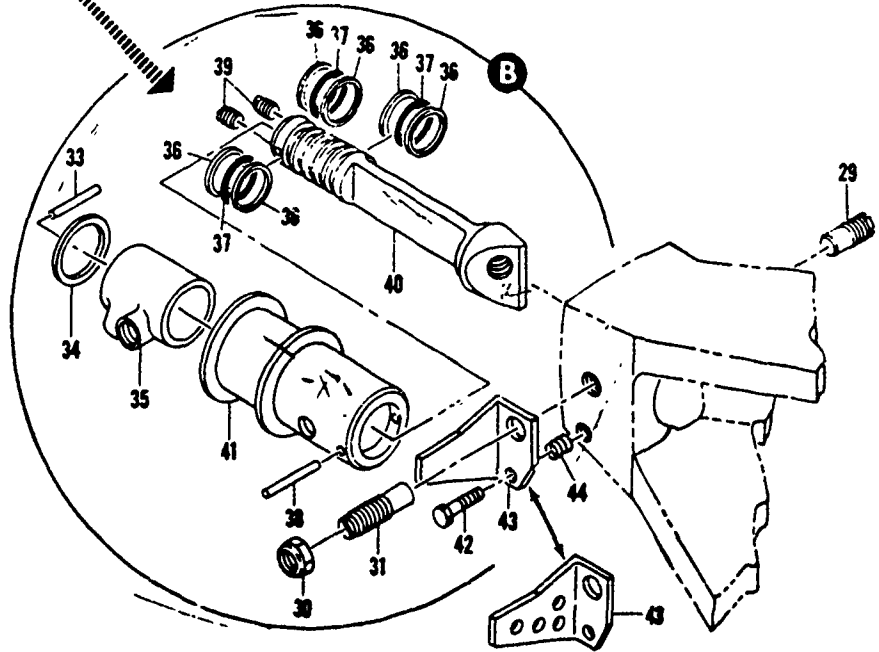
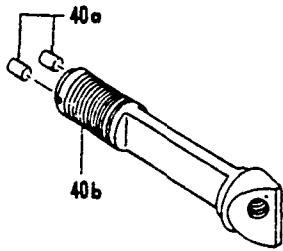
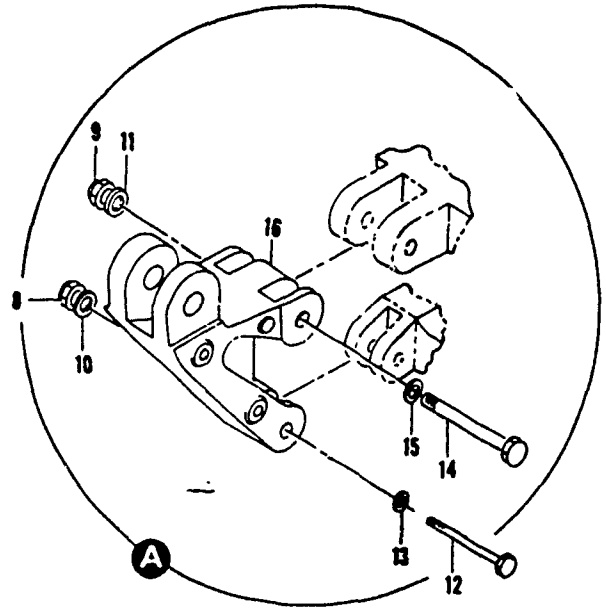
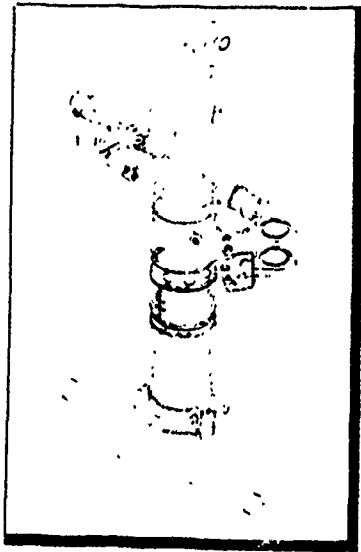


Figure 10-2. Nose Gear Outer Cylinder Assemblies (Sheet 2 of 2)



12-May-89

KC-135 NOSE STRUT ASSEMBLY

BILL OF MATERIALS

6933AA

\* = INT

ROUTED ITEM	ITEM CODE	ITEM LEVEL	PART NUMBER	STOCK NUMBER	VENOR CODE	NOMENCLATURE	UNITS PER ASSY	PERCENT OF RATE	IR,D,C,I	REV	EFFECTIVITY	TECH ORD	PENDING	PENDING	PENDING	
													103	232	AFTD 22	
													ACTION	ACTION	ACTION	
STL		1.1	IN628F3C-18-8	IN.S.L.	18044	..FELT, STRIP	11									
		1.1	IN628F3C-1	1533000034341	19496	..FELT, STRIP	11	IEA								
		1.1	IN628F3C-45	1143000014223	19496	..NUTS, RING	11	IEA								
		1.1	IN628F3C-45	153300074507451	181205	..NUT, BLIND	11	IEA								
		1.1	IN628F3C-16	1531000028548	180205	..NUT, DRILLED JAW	11	IEA								
		1.1	13-95A12	15310000964381	180205	..WASHER, DRAIN TUBE	11	IEA								
		1.1	13429B-1A0A-H	153300100561101E	172902	..SEAL ASSEMBLY	11	IEA								
		1.2	13429B-1A0A	IN.S.L.	172902	..PACKING, SEAL	11									
		1.2	13429B-2H	IN.S.L.	172902	..PACKUP RING	12									
		1.1	IN.P.L.	IN.S.L.		..SEAL ASSEMBLY (PRELUB)	11									
		1.2	IN628F3C-16	15330001943738	18044	..PACKING, SEAL	11	IEA								
		1.2	IN628F3C-48	15330001715042	19496	..PACKUP RING	12	IEA								
IAL		1.1	19-40375	116200003049962	181205	..ROD, ORIFICE METERING	11	IEA								
IAL		1.1	14-55020	116200003042002	181205	..TUBE, DRAIN	11	IEA								
		1.1	IN628F3C-12	15330000633338	18044	..PACKING, O-RING	11	IEA								
		1.1	IN628F3C-114	153300004180001	100389	..PACKING, PREFORM	11	IEA								
		1.1	19-55A21	116200003049937	181205	..BALLHEAD, ORIFICE ROD	11	IEA								
		1.2	190-912B-2	11620010151460	181205	..CAM ASSY (LOWER)	11	IEA								
		1.2	130-30A5-1	IN.S.L.		..KEY	12									
		1.1	1130A42	11620000781753	150284	..CAM ASSY (LOWER)	11	IEA								
		1.2	190-912B-1	11620010151460	181205	..CAM	11	IEA								
		1.2	130-30A5-1	IN.S.L.		..KEY	12									
		1.2	IN628F3C-43M	153100004848972	18044	..NUT	11	IEA								
		1.2	IN628F3C-10	15310001670818	18044	..WASHER	11	IEA								
		1.2	IN628F3C-16	15304001822058	18044	..BOLT	11	IEA								
		1.2	IN.P.L.	IN.S.L.		..INNER CYL SUBMESH	11									
		1.3	165A30215-10	13120000943324	190747	..BURRING, TORQUE APP BUSH (O.S.) (PPR)	14	ARIEA								
		1.3	165A30215-48	131200010446906	190747	..BURRING, TORQUE APP BUSH (O.S.) (PPR)	14	ARIEA								
		1.3	173312A3	IN.S.L.		..INNER CYL (MACHINED)	11									
		1.1	IN628F3C-49	15310000285078	180205	..NUT	19	IEA								
		1.1	IN628F3C-19	15310000497230	19496	..NUT	19	IEA								
		1.1	IN628F3C-16	15310001670743	18044	..WASHER	15	IEA								
		1.1	13-95A85	116200003041999	181205	..PIN, STEERING PLATE ATTACH	18	IEA								
		1.1	140-4144	11620007213972	181205	..BRACKET, WIRE SUPPORT	11	IEA								
		1.1	104988	13110000420998	121760	..BEARING, STEER PLATE	14	IEA								
		1.1	15-73193	1162000722657	181205	..PLATE ASSY, STEER SUPPORT UPPER	11	IEA								
		1.2	IN628F3C-21	13120011846371	180205	..BURRING, ATTACH HOLES (O.S.) (PPR)	18	ARIEA								
		1.2	IN.P.L.	IN.S.L.		..PLATE, STEER SUPPORT UPPER	11									
		1.2	IN628F3C-21	13120011846371	180205	..BURRING, ATTACH HOLES (O.S.) (PPR)	18	ARIEA								
		1.2	IN.P.L.	IN.S.L.		..PLATE, STEER SUPPORT LOWER	11									
		1.1	IN628F3C-1016	15310001670744	18044	..WASHER	11	IEA								
		1.1	IN628F3C-110	15310000497230	199999	..NUT	11	IEA								
		1.1	IN628F3C-14M	1530400220875	180205	..BOLT, SHEAR	11	IEA								
		1.1	IN628F3C-27	15310000961712	19496	..WASHER, COUNTERSUNK	11	IEA								

KC-135 NOSE STRUT ASSEMBLY

BILL OF MATERIALS

6933AA

\* - MRI

12-May-69

STEEL  
ALUMINUM  
TITANIUM  
SYNTHETIC  
LUB-LEAD

ROUTED ITEM	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSEMBLY	TECH LEVEL	REV	EFFECTIVE DATE	CONTROL NUMBER	PENDING 103 ACTION	PENDING 202 ACTION	PENDING AFTO 22 ACTION
	1.1	1481110-10M	530400274473	80205	BOLT, SHEAR	11	EA						
	1.1	1481200-2E10	531000972711	94906	WASHER, COUNTERSUNK	11	EA						
	1.2	1481300-15-7A	512000924297	98747	BUSH, ACTUATOR ATTACH HOLE (O.S.) (RFR) 12	AR1EA							
	1.2	1481303-15-7B	5120009433261	98747	BUSH, ACTUATOR ATTACH HOLE (O.S.) (RFR) 12	AR1EA							
	1.3	1481378 (P-42)	51200020030832	80205	BUSH, ATTACH HOLE UPPER (O.S.) (RFR) 14	AR1EA							
	1.2	1481378 (P-104)	IN.S.L.										
	1.2	1481378 (P-75)	5120000802994	80205	BUSH, ATTACH HOLE LOWER (O.S.) (RFR) 14	AR1EA							
	1.2	1481378 (P-33)	IN.S.L.										
	1.2	1481380-3-3	5315007545377	88044	BRACKET, ACTUATOR ATTACHING	11	EA						
	1.1	1481380-4	5310000260508	81332	COTTER, PIN	11	EA						
	1.1	1481380-1180H	530401017274LE	80205	NUT	11	EA						
	1.1	1481380-54	5300001861331	88044	BOLT, SHEAR	11	EA						
	1.1	1481377-4-29	53300018724226	94906	BACKUP RING	11	EA						
	1.1	1481377-54	5330000821561	81108	PACKING, O-RING	11	EA						
	1.1	14-88019	53300011604329	94906	PACKING, O-RING	11	EA						
	1.1	14-14297	1420000140097	99999	RING, SCAMPER	11	EA						
	1.2	14-88072	1420001033076	81205	ORIFICE TUBE ASSY	11	EA						
	1.2	14-88072	5315007541871	72962	PIN, SPRING	11	EA						
	1.2	14-88072	14200009070347	81205	PLATE, ORIFICE	11	EA						
	1.1	14-88015	5305002074370	81205	LOCKSCREEN, STANDARD	13	EA						
	1.1	1812564-03	IN.S.L.										
	1.1	1812564-21	IN.S.L.										
	1.1	1481022E10	5310009796566	80205	NUT	11	EA						
	1.1	14-88015-1	5305002074371	81205	LOCKSCREEN, STANDARD	13	EA						
	1.1	18121564-01	53050011442203	98747	LOCKSCREEN, OVERSIZE	13	AR1EA						
	1.1	18121564-07	53050011442200	98747	LOCKSCREEN, OVERSIZE	13	AR1EA						
	1.1	18121564-15	53050011442197	98747	LOCKSCREEN, OVERSIZE	13	AR1EA						
	1.1	17729421-03	14200010644789	98747	TRANSITION PIN	12	EA						
	1.1	14824645-370	5315002568359	94906	COTTER, KEY	11	EA						
	1.1	14824645-377	5315002857161	94906	COTTER, KEY	11	EA						
	1.1	13-71050	53050006373153	81205	WASHER, SPACER RING	11	EA						
	1.1	14-25047	1420003042003	81205	FITTING, SHIVEL	11	EA						
	1.1	148227823	5330000468204	88044	PACKING, O-RING	13	EA						
	1.1	1482775-218	53300008940263	94906	PACKING, O-RING	13	EA						
	1.1	1482746-23	5310001841312	88044	BACKUP RING	16	EA						
	1.1	14828774-218	5330000822150	94906	BACKUP RING	16	EA						
	1.1	14828782-23	5330001715076	94906	BACKUP RING	16	EA						
	1.1	14828782-23	5315011454675	72962	PIN, SPRING	11	EA						
	1.1	14828782-23	14200010544788	98747	SHIVEL ASSY (OS)	11	EA						
	1.2	IN.P.L.	IN.S.L.		SHIVEL, FITTING	11	EA						
	1.2	281101	53040012125961	93385	PLUG	12	EA						
	1.1	1481380-4A	5304001822057	88044	BOLT	11	EA						
	1.1	14-88014-1	14200004000375	81205	BRACKET	11	EA						
	1.1	1191-310380	5340002904480	26344	SLEEVE, STEEL WIRE	11	EA						
	1.1	1481380-3P304	5340002904487	81205	SLEEVE, STEEL WIRE	11	EA						

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KC-135 NOSE STRUT ASSEMBLY

BILL OF MATERIALS

693544

STL-STEEL  
AL-ALUMINUM  
INB-INCONEL  
TIT-TITANIUM  
SS-8 STL  
SYN-100  
LW-LEAD

\* = INT

ROUTED ITEM	ILUM LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	LIMITS (UNIT)	PERCENT OF INMATE (FAC)	YIELD (ISCRAP)	PART (MIC)	REV (EFFECTIVITY)	TECH (DRD)	PENDING		PENDING		PENDING	
												103	ACTION	232	ACTION	470	72
									IR, D, C	CONTROL DATE	NUMBER						
					1. GLEEVE STEEL WIRE	11	IEA										
					1. PACKING, O-RING	11	IEA										
					1. FITTING, AIR VALVE	11	IEA										
					1. RING, LOCK	14	IEA										
					1. INSERT	14	IEA										
					1. CLAMP ASBY	11	IEA										
					1. NUT, SELF LOCK	14	IEA										
					1. WASHER	14	IEA										
					1. BOLT	14	IEA										
					1. WASHER, COUNTERSUNK	14	IEA										
					1. CLAMP	11	IEA										
					1. PACKING	12	IEA										
					1. FITTING, LIB	12	IEA										
					1. PLUS, BUTTON	12	IEA										
					1. OUTER CYL. SUBASSY	11	IEA										
					1. BUSHING, DRAG BRACE HOLE	12	IEA										
					1. BUSHING, DRAG BRACE HOLE (O.S.)	12	ARIEA										
					1. BUSHING, TRUNNION HOLE (O.S.) (RPR)	12	ARIEA										
					1. BUSHING, TRUNNION HOLE (O.S.) (RPR)	12	ARIEA										
					1. BUSHING, TRUN RETAINING HOLE (O.S.) (RPR)	14	ARIEA										
					1. BUSHING, TRUN RETAINING HOLE (O.S.) (RPR)	14	ARIEA										
					1. BUSHING, STEERING LUGS (O.S.) (RPR)	18	ARIEA										
					1. BUSHING, ACTUATOR HOLE (O.S.) (RPR)	12	ARIEA										
					1. BUSHING, ACTUATOR HOLE (O.S.) (RPR)	12	ARIEA										
					1. BUSHING, DR ATT LUG (4130 STL) (1ST RPR)	12	ARIEA										
					1. BUSHING, DR ATT LUG (4130 STL) (2ND RPR)	12	ARIEA										
					1. OUTER CYL. (MACHINED)	11	IEA										
					1. DECAL	11	IEA										
					1. DECAL	11	IEA										
					1. DECAL	11	IEA										
					1. PLUS, PROTECTIVE	14	IEA										

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15511N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89038

1

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPGR	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S2-30-3	9. ITEM SERIAL NO.
----------------	--------------------------------------	--------------------

10. MODEL DESIGN SERIES KC135 NOSE	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN STRUT ASSY (NOSE)	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
73270	25-50	1620010381912 17567A			
73270	25-110	1620010597842 69354A			
		GOVERNING DIRECTIVES: AFLCP 66-51 MANOI 66-3 *****7049 ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			

\* U.S. GOVERNMENT PRINTING OFFICE: 1988-648-185

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	15511N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE 89038

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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY (NOSE)						
5. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
	001	7327025-50 7327025-110							
34A	010	MATCH UP ****ROUTED COMPONENTS**** NEW/ REWORKED NO SERVICABLE 958 REWORK						M	MNDGP 06 MU01
		PISTON 15501N NUT UPPER OLEO 15503N ACTUATOR BRACKET 15504N STEERING PLATES 15509N OLEO CAM UPPER & LOWER 15510N OUTER CYL 15512N BEARING UPPER 15514N LOWER GEAR NUT 15517							
34A	020	OK TO CLOSE AND/OR ASSEMBLE *C/P MOVE						M	MNDGP 06 SA03
	*REQD*								
34A	030	ASSEMBLE INTERNAL PARTS *C/P MOVE NEW OUTER S/N _____ NEW INNER S/N _____						M	MNDGP 06 SA03
	*REQD*								
34A	040	INSTALL SWIVEL ASSY P/N 9-55602-1 / 2 INSTALL SWIVEL FITTING P/N 6-55067 CAUTION: SWIVEL MUST NOT BE (CONTINUED)						M	MNDGP 06 SA03
	*REQD*								

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STRUT ASSY (NOSE)
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18. DISPATCH STATION	19. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		<del>INSTALLED UPSIDE DOWN *C/P MOVE</del>			
<del>34A</del>	<del>050</del>	<del>CAM ALIGNMENT *C/P MOVE *REQD</del>		<del>M</del>	<del>MNDGP 06 SA03</del>
<del>34A</del>	<del>055</del>	<del>TORQUE ALL NUTS &amp; BOLTS IAW T O *C/P MOVE *REQD</del>		<del>M</del>	<del>MNDGP 06 SA03</del>
<del>34T</del>	<del>060</del>	<del>PRESSURE TEST *C/P MOVE *REQD</del>		<del>M</del>	<del>MNDGP 06 TL07</del>
<del>34P</del>	<del>080</del>	<del>MASK, PRIME, AND PAINT *C/P MOVE *REQD</del>		<del>M</del>	<del>MNDGP 09 WB03</del>
<del>34P</del>	<del>090</del>	<del>DECALS *C/P MOVE *REQD</del>		<del>M</del>	<del>MNRGP 09 WB03</del>
<del>34P</del>	<del>105</del>	<del>FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS &amp; ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD</del>		<del>M</del>	<del>MNDGP 09 WB03</del>
<del>34P</del>	<del>120</del>	<del>FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD</del>		<del>M</del>	<del>MNDGP 09 WB03</del>

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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		B	D	

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		MNP GP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	49-1-182	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
KC185 NOSE		17567A
13. SERIAL NUMBER	14. NOUN	
	PISTON	69354A

15. DISPATCH STATION	16. PERFORMANCE NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
7531269-10		1620010284057 17567A 69354A			
		GOVERNMENT DIRECTIVE: AFM 71-151 MANUAL 2-13			
		ALODINE IAW MIL-STD-8841			
		IVE ALUM PLATE IAW MIL-STD-8841			
		BLAST IAW MIL-STD-1500			
		FPI IAW MIL-STD-8841			
		FAPL IAW MIL-STD-1500			
		BRIME IAW MIL-STD-8841			
		TEMP & ELEM IAW MIL-STD-8841			
		SHOT PRES IAW MIL-STD-1500			
		CHROME IAW MIL-STD-8841			
		COAT PLATE IAW MIL-STD-8841			
		STRIP IAW MIL-STD-8841			
		BAKE IAW 49-1-182			
		PERMATEL STEEL (220/300 FPI)***			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (O/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PISTON
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE TRAINING AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.

\*REQD\* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.

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	001	7531263-10			
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	005	DISASSEMBLE *C/P MOVE *REQD* REMOVE & SERIALIZE SHOULDER BLOCKS WITH PISTON SERIAL # 7531263-10		001 MRF GW 002 02 003 1002 004 03 0200 006 03 05115	
--	-----	--	--	---	--

	007	CHEM CLEAN *C/P MOVE *REQD*		001 MRF GW 002 03 003 SLO1	
--	-----	--------------------------------	--	----------------------------------	--

	009	BLAST CLEAN ONLY *C/P MOVE *REQD*		001 MRF GW 002 03 003 BL01	
--	-----	--------------------------------------	--	----------------------------------	--

	011	BAKE 4 HRS AT 350-400F *REQD* DATE IN _____ TIME IN _____		001 MRF GW 002 03 003 BK03	
--	-----	--	--	----------------------------------	--

		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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21. FINAL DESTINATION DISPATCH	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	23. DOCUMENT/SN 15501N
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PISTON
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15. DISPATCH STATION	16. PERP. REC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE	M	001 MNRNA 002 05 003 04	
	*REQD*				
	020	E & I INSPECTION		001 MNRSD 002 01 003 01	
	*REQD*	INNER CYL OD 4.999/5.001			
		AXLE JOURNAL INBOARD OD 2.9988/2.9998			
		AXLE JOURNAL OUTBOARD OD 2.4993/2.4998			
		TORQUE ARM BOSS HOLES ID 1.501/1.502 1.375/1.380 FACE TO FACE			
		UPPER BEARING LAND OD 4.750/4.752			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
26	035	VAPOR DEGREASE	*C/P MOVE	001 MNRRC 002 03 003 001	
26	040	STRIP CAD	*C/P MOVE	001 MNRRC 002 02 003 001	
26	045	STRIP RUST	*C/P MOVE	001 MNRRC 002 02 003 002	
		2 IN. RADIUS		001 MNRRA 002 04 003 001	
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/N
DISPATCH	FUNCTIONAL	A	B	15501N

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PISTON
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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25	080	TORQUE ARM JOBB OVERSIZE REPAIR OVERSIZE BY REAMING OR HONING ONLY OVERSIZE TO CLEANUP WITHIN ID		001 MNFRA 002 04 003 BE01	
----	-----	--	--	---------------------------------	--

1.5827.1.780  
NOTE: DO NOT EXCEED MIN WALL OF .320  
\*C/P MOVE

26	070	STRIP CHROME FROM PISTON *C/P MOVE		001 MNFRC 002 02 003 SC02	
----	-----	---------------------------------------	--	---------------------------------	--

26	080	STRIP CHROME FROM AXLE JOURNAL #1 (OUTBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02	
----	-----	--	--	---------------------------------	--

26	090	STRIP CHROME FROM AXLE JOURNAL #2 (INBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02	
----	-----	---	--	---------------------------------	--

26	100	STRIP CHROME FROM AXLE JOURNAL #3 (INBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02	
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26	110	STRIP CHROME FROM AXLE JOURNAL #4 (OUTBOARD) VIEWED UPRIGHT FACING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRC 002 02 003 SC02	
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26	120	STRIP CHROME FROM UPPER BEARING AREA *C/P MOVE		001 MNFRC 002 02 003 SC02	
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26	130	GRIND INNER CYL MIN OD 4.981. *C/P MOVE		001 MNFRC 002 03 003 GG01	
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26		TORQUE ARM LUGS #LEFT TO RIGHT 1-4		001 MNFRC 002 03 003 GG01 005 YP 15302	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RES SIGNATURE/DATE	23. DOCUMENT/BN
		15501N

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1. DATE

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN/SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NAME PISTON	

15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
86 J	150	GRIND AXLE JOURNAL #2 MIN OD 2.9838 (INBOARD) VIEWED UPRIGHT FACEING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRB 002 03 003 GB01	
86 J	160	GRIND AXLE JOURNAL #3 MIN OD 2.9838 (INBOARD) VIEWED UPRIGHT FACEING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRB 002 03 003 GB01	
86 J	170	GRIND AXLE JOURNAL #4 MIN OD 2.4843 (OUTBOARD) VIEWED UPRIGHT FACEING TORQUE ARM LUGS #LEFT TO RIGHT 1-4 *C/P MOVE		001 MNFRB 002 03 003 GB01	
86 J	180	GRIND UPPER BEARING LAND MIN DIA 4.740 *C/P MOVE		001 MNFRB 002 03 003 GB01	
		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNFRB 002 06 003 TE03	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26B	200	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ MOVE		001 MNFRB 002 02 003 BK01	
		TIME IN _____ TIME OUT _____ *C/P MOVE	M	001 MNFRB 002 06 003 ML04	
		***** NOTE *****			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RGS SIGNATURE/DATE	23. DOCUMENT/ON
		15501N

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1. DATE

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NO. USER	14. NOUN PISTON
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
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26	225	VAPOR DEGREASE *C/P MOVE		001 MNRFC 002 03 003 1001	
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26	230	SHOT PEEN O.D. SHOT SIZE .019/.028 INTENSITY OF .008/.012 A2 10% COVERAGE *C/P MOVE		001 MNRFC 002 01 003 SP02	
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26	240	SHOT PEEN AXLE I.D. INTENSITY OF .010/.014A 200% COVERAGE *C/P MOVE		001 MNRFC 002 01 003 SP02	
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26	250	SHOT PEEN REWORKED AXLE JOURNALS SHOT SIZE .019/.028 INTENSITY .008/ 012 A2 100% COVERAGE *C/P MOVE		001 MNRFC 002 01 003 SP02	
----	-----	--	--	---------------------------------	--

26	260	SHOT PEEN UPPER BEARING AREA INTENSITY OF .008/.010A 100% COVERAGE *C/P MOVE		001 MNRFC 002 01 003 SP02	
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26	265	PREPARE INNER CYLINDER O.D. FOR CHROME PLATE, MASK/FIXTURE, ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNRFC 002 02 003 BE01	
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26	267	PREPARE UPPER BEARING AREA O.D. FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNRFC 002 02 003 BE01	
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26	270	CHROME PLATE INNER CYLINDER O.D. SUFFICIENT TO ALLOW GRINDING BACK TO 4.999/5.001 TYPE II CLASS II *C/P MOVE		001 MNRFC 002 02 003 CP01 004 50010	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
		15501N

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PISTON
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18. DISPATCH STATION	19. PERP. RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED-----> *C/P MOVE			
26	275	CHROME PLATE UPPER BEARING AREA O.D. TYPE II CLASS II TO ALLOW GRINDING BACK TO 4.750/4.752. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED-----> *C/P MOVE		001 MNRC 002 02 003 5001 008 0000	
26B	280	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNRC 002 02 003 BK01	
26	285	PREPARE JOURNALS FOR CHROME PLATE. FIXTURE/MASK/ETC. MECHANIC SIGN OFF REQUIRED----->		001 MNRC 002 02 003 BE01	
26	290	CHROME PLATE AXLE JOURNAL #1 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.4993/2.4998. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED----->		001 MNRC 002 02 003 CP01 008 0000	
26	300	CHROME PLATE AXLE JOURNAL #2 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.9988/2.9998. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED----->		001 MNRC 002 02 003 CP01 008 0000	

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PISTON
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18. DISPATCH STATION	19. PERFORM NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		*C/P MOVE			
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26	320	CHROME PLATE AXLE JOURNAL #3 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.9988/2.9998. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED		001 MNFRB 002 02 003 CP01 005 BR00	
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26	342	CHROME PLATE AXLE JOURNAL #4 VIEWED UPRIGHT FACING TORQUE ARM LUGS # LEFT TO RIGHT 1-4 TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 2.4993/2.4998. TIME OUT _____ DATE OUT _____ MECHANIC SIGNOFF REQUIRED		001 MNFRB 002 02 003 CP01 005 BR00	
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26	345	BAKE 4 HRS AT 350-400 F WITHIN 4 HRS OF CHROME PLATE. TIME IN _____ DATE IN _____ TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNFRB 002 02 003 BK01	
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80	370	FINISH GRIND UPPER BEARING AREA O.D. 4.750/4.752 *C/P MOVE		001 MNFRB 002 03 003 GG01	
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80	380	FINISH GRIND INNER CYLINDER O.D. 4.9994/5.001 *C/P MOVE		001 MNFRB 002 03 003 GG01	
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		FINISH GRIND TORQUE ARM O.D. VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4 005 BR00		001 MNFRB 002 03 003 GG01	
--	--	--	--	---------------------------------	--

21. FINAL DESTINATION  
22. COORDINATION/INITIATING RCC SIGNATURE/DATE  
23. DOCUMENT/BN

24. DISPATCH	25. FUNCTIONAL			15501N
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NAME PISTON
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
8G	400	FINISH GRIND AXLE JOURNAL #2 O.D. 2.9988/2.9998 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4		001 MNRK8 002 03 003 8501	
8G	410	*C/P MOVE FINISH GRIND AXLE JOURNAL #3 O.D. 2.9999/2.9998 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4		001 MNRK9 002 03 003 8501	
8G	420	*C/P MOVE FINISH GRIND AXLE JOURNAL #4 O.D. 2.4999/2.4998 VIEWED UPRIGHT FACING TORQUE ARM LUGS LEFT TO RIGHT 1-4		001 MNRK6 002 03 003 8501	
26B	430	*C/P MOVE BAKE 4 HRS AT 350-400F  DATE IN _____ TIME IN _____		001 MNRK6 002 02 003 8K01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		[REDACTED] *C/P MOVE	M	001 MNRK4 002 06 003 MLC4	
26	440	VAPOR DEGREASE *C/P MOVE		001 MNRK6 002 03 003 8501	
		[REDACTED] *C/P MOVE	M	001 MNRK4 002 06 003 ZS01	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****			

21. FINAL DESTINATION DISPATCH	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	23. DOCUMENT/SN 15501N
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER		14. ROOM
PISTON		

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	454	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNR RC 002 01 003 BL02	
26	455	AXLE ID & LOWER END PISTON ID REPAIR GARNET BLAST TO CLEAN-UP CORROSION. *C/P MOVE		001 MNR RC 002 01 003 BL02	
26	460	CAD PLATE TYPE II CLASS 2 1.9 SQ FT AT 95-133 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNR RC 002 03 003 CA03	
26B	470	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNR RC 002 02 003 BK01	
26	480	IRIDIUM *C/P MOVE		001 MNR RC 002 02 003 IR01	
		<div style="background-color: black; width: 150px; height: 15px; margin-bottom: 5px;"></div> *C/P MOVE .65 * * * * * N O T E * * * * * IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * * *	M	001 MNR NA 002 06 003 ML04	
26	486	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 470 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNR RC 002 03 003 IVD1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	B	15501N
				339

15501N WORK CONTROL DOCUMENT (MEDS)

DATE 89038

PAGE 1 OF 1 PAGES

1. JOB ORDER NO.	2. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLET/D
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN PISTON	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	487	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNRRC 002 02 003 1A01	
69	488	MACHINE TORQUE ARM BOSS FLANGE BUSHING.		001 MNRRC 002 02 003 LE02	
69	490	TORQUE ARM BOSS "FLANGE" BUSHING REPAIR 1.375/1.380 FACE TO FACE *C/P MOVE		001 MNRRA 002 04 003 1E01	
69	498	MACHINE TORQUE ARM BUSHING P/N 65A30315-10		001 MNRVA 002 04 003 LE02	
69	500	TORQUE ARM BOSS BUSHING INSTALLATION P/N 65A30315-10 PRESS FIT .0005/.0015 FINISH LINE REAM BUSHING ID 1.301/1.302 USE A 65A30315 OR BUSHING WHEN -10 DEPLETES *C/P MOVE		001 MNRRA 002 04 003 LE01	
69	510	REPLACE SHOULDER BLOCKS *C/P MOVE		001 MNRRA 002 04 003 BE01	
	520	PAINT ID OF AXLE WITH POLYURETHANE PER T.O. *REQD* *C/P MOVE		001 MNRGP 002 09 003 PP01	
	530	FINAL ACC PTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNRUP 002 06 003 SA03	
	540	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNRGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	15501N

340

15503N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89088

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		4NPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
KC135 NOSE		00-20-5 17567A 452-30-3 69354A 45-1-182 17567A
13. SERIAL NUMBER	14. NGUN	
	NUT UPPER OLED	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
60-668		NSL 17567A			
60-668		NSL			
60-668	-1	5310010153748 69354A			
60-668	-1	5310010206440 17567A			
60-668	-2	5310010206440 69354A			
60-668	-2	5310010206440 69354A			

GOVERNING DIRECTIVES: AFM 66-51  
MANUE 66-3  
FMP I IAW MIL-STD-194  
SHO1 PEEN IAW MIL-S-10165

\*\*\*\*\*UNIT COST \$ 350.99\*\*\*\*\*  
\*\*\*\*\*PART L #150 #125/145 KSI\*\*\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN PARR. 8 OF THIS AFM FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

WARNING

MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	G	15503N



15503N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCT ID - SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN NUT UPPER OLEO						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PERSONNEL, ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 17 IS EQUIVALENT TO DELTA STAMP.							
	001	60-6681 60-6681-1 60-6681-2							
	005	DISASSEMBLE *REQD* *C/P MOVE						001 MNP GW 002 02 003 LG02 005 Y8745200 006 Y8745138	
	006	DECREASE ONLY *REQD*						001 MNP GW 002 02 003 8902	
		*C/P MOVE *REQD*				M		001 MNP RA 002 05 003 M503	
04E	025	E & I **NOTE: ROUTE FOR REPAIR IF CRACKED *REQD* *C/P MOVE						001 MNP GW 002 04 003 EI01	
05	030	REMOVE CRACKS FOUND IN SLOTS IAW PAGE 6-33 PARA "K" MAX. WIDTH OF SLOT AFTER REWORK NOT TO EXCEED .440 MAX .845 FROM BOTTOM OF NUT .845 ALL EDGES RADIUS .03/.06 32 RMS *C/P MOVE						001 MNP RA 002 04 003 MV00	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15503N			

15503N

WORK CONTROL DOCUMENT (MEDS)

1 DATE

87038

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN NUT UPPER OLEO	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PC/P MOVE ***** NOTE ***** IF LAST NET OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNR NA 002 05 003 M506	
25	045	WATER TIGHTNESS PC/P MOVE		001 MNR RC 002 01 003 3401	
26	050	SHOT PEEN NUT TO AN INTENSITY OF .007/.0106 THREADS AND HOLES SHOULD NOT BE SHOT PEENED		001 MNR RC 002 01 003 3402	
	080	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNR OP 002 06 003 3403	
	090	FINAL PRODUCT VISUAL INSPECTION PC/P MOVE		001 MNR OP 002 06 003 3402	

31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	E	15503N

15504N

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPSP	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 45-1-182	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES KC135 NOSE	11. STOCK NUMBER 452 50	12. OPTIONAL <b>17567A</b> <b>69354A</b>
13. SERIAL NUMBER	14. NOUN ACTUATOR BRACKET	

15. DISPATCH STATION	16. PERM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 5-7234		NSN 1620009080935	C/N 17567A 69354A		
		***** UNIT COST \$121.72 ***** GOVERNING DIRECTIVES: APLCR 66-51 MANOI 66-3			
		PTI 1AW MIL-STD-883C STRIP 1AW MIL-STD-871 ANGLIZE 1AW MIL-A-8625 BLAST 1AW MIL-STD-1504			
		*****ALUMINUM 7075-T6*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA			

21. FINAL DESTINATION DISPATCH		22. COORDINATION/INITIATING RCC SIGNATURE/DATE (CONTINUED)		23. DOCUMENT/BN 15504N
FUNCTIONAL CODE	A	B	C	

15504N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89023

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN ACTUATOR BRACKET						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		STAMP							
	001	5-22249							
34B	005	DISASSEMBLE					001 MNP GW		
	*REQD*	*C/P MOVE					002 02		
							003 L902		
							006 3145106		
	007	CHEM CLEAN					001 MNP GW		
	*REQD*	*C/P MOVE					002 02		
							003 AD02		
34B	009	BLAST CLEAN ONLY					001 MNP GW		
	*REQD*	*C/P MOVE					002 03		
							003 BL07		
							001 MNP GW		
	*REQD*	*C/P MOVE				M	002 05		
							003 ZY05		
34C	030	E AND I INSPECTION					001 MNP GW		
	*REQD*	TRUNNION HOLES UPPER I.D.					002 04		
		.5257/.526					003 EI01		
		TRUNNION HOLES LOWER I.D.							
		.563/.564							
		ACTUATOR ATTACH HOLE SINGLE							
		.875/.876							
		*C/P MOVE							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL	A	B	15504N	

345

1. JOB ORDER NO.	2. QUANTITY	3. PRODUCTION SEC/RCU	4. DATE SCHED.	5. DATE COMPLETED
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6. PART NUMBER	7. TECH DATA	8. ITEM SERIAL NO.
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9. MODEL DESIGN SERIES	10. STOCK NUMBER	11. OPTIONAL
------------------------	------------------	--------------

12. SERIAL NUMBER	13. NSUN
ACTUATOR BRACKET	

14. DISPATCH TATION	15. PERP REC/OP NO.	16. WORK TO BE ACCOMPLISHED	17. MECHANIC	18. "P"	19. "Q"
✓	040	DRILL AND LINE REAM NEW ACTUATOR BRACKET TRUNNION HOLES UPPER ID .625/.625 TRUNNION HOLES LOWER ID .625/.625 63 RMS *C/P MOVE		001 MNFRA 002 04 003 BE01	
✓	045	SPOT ALODINE MINOR REWORK *C/P MOVE		001 MNFRA 002 04 003 BE01	
✓	050	ACTUATOR ATTACH HOLE SINGLE OVERSIZE TO CLEAN UP ID 1.00 MAX 63 RMS *C/P MOVE		001 MNFRA 002 04 003 BE01	
✓	060	TRUNNION ATTACH HOLES UPPER OVERSIZE TO CLEAN UP ID .8129 MAX O/S 63RMS *C/P MOVE		001 MNFRA 002 04 003 BE01	
✓	070	TRUNNION ATTACH HOLES LOWER OVERSIZE TO CLEAN UP ID .6879 MAX O/S 63RMS *C/P MOVE		001 MNFRA 002 04 003 BE01	
✓	080	STRIP ANODIZE *C/P MOVE		001 MNFRC 002 03 003 AN03	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNFRA 002 06 003 ZA02	
6	090	ANODIZE TYPE II *C/P MOVE		001 MNFRC 002 03 003 AS03	

20. DISPATCH DESTINATION		21. COORDINATION/INITIATING RCC SIGNATURE/DATE		22. DOCUMENT/BN
DISPATCH	FUNCTIONAL	A	E	15504N
				346

15504N WORK CONTROL DOCUMENT (MEDS)

1 DATE

59038

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/ACC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NSUN	

ACTUATOR BRACKET

15. DISPATCH STATION	16. PERP ACC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
59	109	MACHINE ACTUATOR ATTACH HOLE BUSHING P/N 65A20315-7A OR P/N 65A20315-7B		001 MNA 002 04 003 LE	
59	100	ACTUATOR ATTACH HOLE SINGLE BUSHING INSTALLATION P/N 65A20315-7A OR -7B PRESS FIT .0008/.002 FINISH LINE REAM ID .873/.878 53 RMS *C/P MOVE		001 MNA 002 04 003 LE	
59	108	MACHINE TRUNNION ATTACH HOLE UPPER BUSHING P/N NAS537810P-42 OR P/N NAS537810P-104		001 MNA 002 04 003 LE	
59	110	TRUNNION ATTACH HOLE UPPER BUSHING INSTALLATION P/N NAS537810P-42 OR P-104 PRESS FIT .0005/.0017 FINISH LINE LINE REAM ID .820/.825 53 RMS *C/P MOVE		001 MNA 002 04 003 LE	
59	118	MACHINE TRUNNION ATTACH HOLE LOWER BUSHING P/N NAS53789P-25 OR P/N NAS53789P-33		001 MNA 002 04 003 LE	
59	120	TRUNNION ATTACH HOLE LOWER BUSHING INSTALLATION P/N NAS53789P-75 & -33 PRESS FIT .0005/.0017 FINISH LINE REAM ID .563/.564 54 RMS *C/P MOVE		001 MNA 002 04 003 BE	
	170	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*		001 MNA 002 06 003 SA	

21. FINAL DESTINATION DISPATCH	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
		15504N

15504N

**WORK CONTROL DOCUMENT (MEDS)**

1. DATE

89001

PAGE 5 OF 5 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER			8. TECH DATA		9. ITEM SERIAL NO.	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NAME ACTUATOR BRACKET	

15. DISPATCH STATION	16. PERFORMANCE NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[REDACTED]	180	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 06 003 SA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL	A	B	15504N

15509N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/ACC	5. DATE SCHED.	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	45-1-182	

10. MODEL DESIGN SERIES (T)	11. STOCK NUMBER	12. ITEM SERIAL NO.
KC135 NOSE		

13. SERIAL NUMBER	14. NSN	15. WORK TO BE ACCOMPLISHED	16. MECHANIC	17. "P"	18. "Q"
	STEERING PLATES				

17567A  
69354A

19. DISPATCH STATION	20. PERP ACC/OP NO.	21. P/N	22. NSN	23. C/N
		5-73193	1620007729657	17567A
		5-73193-1	1620007729658	69354A

24. GOVERNING DIRECTIVES:	AFMOR 66-51
	MANCI 66-3
BLAST	IAW MIL-STD-1504
FPI	IAW MIL-STD-883C
STRIP	IAW MIL-STD-871
ANDDIZE	IAW MIL-A-8625
CHEM FILM	IAW MIL-C-5541
SPOTTEEN	IAW MIL-S-28165

\*\*\*\*\*MAT'L 7075S-T6 ALUMINUM\*\*\*\*\*  
\*\*\*\*\*UNIT COST \$ 236.90\*\*\*\*\*  
\*\* ALUMINUM \*\*

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\*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

WARNING  
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25. FINAL DESTINATION		26. COORDINATION/INITIATING ACC SIGNATURE/DATE		27. DOCUMENT/ON
OPERATOR	FUNCTIONAL			15509N



15509N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89038

PAGE 2 OF 4 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NGUN
STEERING PLATES	

15. DISPATCH STATION	16. PER ACC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		PERCAUTIONS MUST BE EMPLOYED TO PERCLUDE INJURIES.			
--	--	--	--	--	--

		*REQD* (MINIMUM REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
--	--	---	--	--	--

	001	5-73193 5-73193-1			
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34D	005	DISASSEMBLE	*C/P MOVE		001 MNPBW 002 02 003 LG02 005 7015100 006 X8745108
	*REQD*				

34C	007	CHEM CLEAN	*C/P MOVE		001 MNPBW 002 03 003 AC02
	*REQD*				

34B	009	BLAST CLEAN ONLY	*C/P MOVE		001 MNPBW 002 03 003 BL01
	*REQD*				

			*C/P MOVE	M	001 MNPBW 002 05 003 ZY05
	*REQD*				

34A	020	E & I INSPECTION			001 MNPBW 002 04 003 E101
	*REQD*	LARGE HOLES ID 4.000/4.001			

		SMALL ATTACH HOLES ID .750/.751			
		BASE METAL - SMALL ATTACH HOLES			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CASE	A	C	15509N

15509N WORK CONTROL DOCUMENT (MEDS)

DATE 89068 PAGE 1 OF 1 PAGES

1. JOB ORDER NO.	2. QUANTITY	3. PRODUCTION SEC/RCC	4. DATE SCHED.	5. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN STEERING PLATES	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		REWORK TO MIN .812 MAX .928 SMALL ATTACH POLES BUSHING I.D. .750/.751 *C/P MOVE			
69	030	MODIFICATION OF SUPPORT PLATE COUNTER BORE BEARING HOLES TO I.D. 4.000/4.001 LEAVING A .180/.170 LIP AT BOTTOM ENLARGE ATTACH POLES TO I.D. .750/.751 *C/P MOVE		001 MNFR 002 04 003 MV02 005 08 11507	
69	032	MACHINE .219 RADIUS IF CRACKS APPEAR IN SLOT AREAS IAW PRINT 5-73193 *C/P MOVE*		001 MNFR 002 04 003 BE01	
69	035	MACHINE RADIUS I.A.W. PRINT 5-73193 REF. B 4 PLACES FOR EACH PLATE *C/P MOVE		001 MNFR 002 04 003 BE01	
69	040	BORE/REAM SMALL ATTACH HOLES TO MIN .812 MAX .928 COUNTER SINK HOLES PER T.D. *C/P MOVE		001 MNFR 002 04 003 MV02 005 X8090606	
26	050	STRIP ANODIZE *C/P MOVE		001 MNFR 002 03 003 AN04	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNFR 002 06 003 ZA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	E	15509N

15509N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89068 PAGE 4 OF 4 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STEERING PLATES
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	058	SHOT-PEEN LOCAL REWORK ON LUG EARS 100% .004/.010A INTENSITY LAW PAGE 6-7 FIG 6-2 NOTE "F" C/P MOVE*		001 MNRRC 002 01 003 SP01	
26	060	HARD ANODIZE OVERSIZED LARGE BEARING HOLES TYPE III MIL-A-8625 4.000/4.002 *C/P MOVE		001 MNRRC 002 03 003 AN01 004 A110	
26	065	ANODIZE STEERING PLATE TYPE II *C/P MOVE		001 MNRRC 002 03 003 AS03	
69	068	MACHINE BUSHING .0005/.0015 PRESS FIT BRUSH CADMIUM PLATE O.D. PER MIL-STD-865 P/N NAG537B12P-21		001 MNRRA 002 04 003 LE02	
69	069	INSTALL BUSHING WITH MIL-S-81733 SEALER		001 MNRRA 002 04 003 BE01	
69	070	LINE BORE BUSHING ID TO .750/.751 COUNTERSINK 110 DEGREES X .01 INCH *C/P MOVE NOTE: SOME NOSE BEAR STEERING SUPPORT PLATES CONTAIN UNDERSIZE HOLES. THESE HOLES MUST BE MACHINED TO SIZE & LOCATED TO MATCH HOLES IN OLD PLATE TO PREVENT BINDING OF STEERING ACTUATOR. A. MACHINE MOUNTING HOLES TO .750/.751 COUNTERSINK HOLES 110 DEGREES X .01 INCH COUNTERSINK HOLES ON THE SIDE BOLT IS INSTALLED FROM. COUNTERSINK UPPER PLATE 5-73193 ON BOTTOM. COUNTERSINK LOWER PLATE 5-73193-1 ON TOP. B. COUNTERBORE BEARING HOLE 4.000/4.001 (CONTINUED)		001 MNRRA 002 04 003 MV02 005 XE-29106	

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10. MODEL DESIGN SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN					
15. DISPATCH STATION	16. PERM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
		C. LEAVE .18 / 12 IN THICK SHOULDER TO ACCOMMODATE BEARING.					
		D. CHAMFER EDGE OF COUNTERBORE 45 DEG. 1/8 X 1/8 IN.					
		E. RADIUS INTERNAL 100 00702 IN.					
		F. MACHINE UPPER PLATE WITH UP UP					
		G. MACHINE LOWER PLATE WITH DOWN *C/P MOVE					
		[REDACTED]					
26	084	SHOTPEEN BEARING HOLES .009 TO .010A2 INTENSITY 100 PERCENT COVERAGE *C/P MOVE				001 MNR RC 002 06 003 ZA 2	
26	090	ALODINE REWORKED *C/P MOVE				001 MNR RC 002 03 003 TA01	
	100	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*				001 MNR RC 002 06 003 SA03	
	110	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*				001 MNR RC 002 06 003 SA03	
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10. MODEL-DESIGN-SERIES K2135 NU-E	11. STOCK NUMBER	12. OPTIONAL 01-20-8 48-1-1-82 482-60-8
13. SERIAL NUMBER	14. NOUN BLEED CAM JIFL & FLOWER	
<p><b>17567A</b> <b>69354A</b></p>		

15. DISPATCH STATION	16. PERFORMANCE NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/R 16866L 5-93012	1-1	NSN 1620005934049 DYN 69354A			
		GOVERNING DIRECTIVES BLAST EQUIP STUFFING			
		REFLECTOR 66-5 MAMU 66-3 TAW MIL-STD-150 970-10-134 MIL-STD-134 MIL-STD-134 MIL-STD-134			
		ALL PERSONNEL INVOLVED IN THE WORK PROCEEDINGS SHOWN ON THIS DOCUMENT MUST BE TRAINED IN ALL REPAIR AND PROCEDURES WITH ALL NECESSARY SAFETY PRECAUTIONS AND HAZARDOUS MATERIALS THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN B OF THIS AFM FORM 953. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOW) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			

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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OLEU DAY UPPER & LOWER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		VISUAL INSPECTION *C/P MOVE			
	020	CLEANLY & VISIBLY ALL AREAS REMOVE RIVETS & NUTS AS SHOWN *C/P MOVE		001 04 002 04 003 04	
69	058	MODIFY CAM I.A.W. 452-30-3 PAGE 6-9 P/N 5-83010-1 *C/P MOVE		001 04 002 04 003 04	
69	060	MODIFY CAM IAW 452-30-3 PAGE 6-9 PARA. 6-6 REIDENTIFY P/N 5-83012-1 *C/P MOVE		001 04 002 04 003 04	
		[REDACTED] *C/P MOVE ***** IF LAMP POSITION IS NOT IS IDENTIFIED HERE, THE FOLLOWING COUNT *****		001 04 002 04 003 04	
26	073	VAPOR CLEANING *C/P MOVE		001 04 002 04 003 04	
26	077	PRIOR TO PHOSPHATE, SPIT BLAST ALL AREAS TO BE PHOSPHATE COATED. *C/P MOVE		001 04 002 04 003 04	
26	080	PHOSPHATE LUSTING TYPE M CLASS 23 ALL SURFACES ON UPPER, ALL SURFACES BUT RAMPS ON THE LOWER IAW FIG 6-1 PAGE 6-2 *C/P MOVE		001 04 002 04 003 04	

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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	BLEED LAM UPPER & LIP EX

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERFORM ALL MAINTENANCE BY EMPLOYEES WITH PERMISSION OF THE SUPERVISOR TO ALL PROTECTIVE SYSTEMS			
		PERFORM MAINTENANCE ON ALL SYSTEMS EXCEPT 16 15 100 1000 1000 1000 STANDARD			
		LEAKAGE DRAINAGE			
		REPAIR/REPLACE		001 MM 02 01 002 02 003 02	
				001 MM 002 02 003 02	
		INCREASE ONLY REPAIR ONLY		001 MM 002 02 003 02	
		BLAST CLEAN ONLY		001 MM 002 02 003 BL	
		STRESS RELIEF BY 4000 AT 350-400F DATE IN _____ TIME IN _____ *REQD* DATE OUT _____ TIME OUT _____ REPAIR ONLY		001 MM 002 02 003 02	
		REPAIR ONLY	M	001 MM 002 02 003 MS	
		E & I INSPECTION *REQD* CAM RAMP 60% MIN CONTACT		001 MM 002 04 003 EI	

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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OLEC CAN UPPER & LOWER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
248	320	BAKE 8 HRS AT 210-220F  DATE IN _____ TIME IN _____		001 001	001 002
		DATE OUT _____ TIME OUT _____ NO/P MOVE			
[REDACTED]		FINAL ATTEMPT OF WORK IN THE INDICATED OR UNDEVELOPED OF ALL 2 LINE SCHEDULES		001 001	001 001
24	22	FINAL PRODUCT INSPECTION #1 1000		001 001	001 001

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			FUNCTIONAL CODE

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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
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13. SERIAL NUMBER	14 NOUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES			
		MAINTAIN A 32 RMS FINISH ON ALL REWORKED SURFACES			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	7327022-30			
34D	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745188	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNP GW 002 03 003 AC02	
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNP GW 002 03 003 BL01	
		[REDACTED] *C/P MOVE	M	001 MNP NA 002 05 003 ZY05	
34E	050 *REQD*	E & I AND ROUTE DRAG BRACE LUG BASE HOLE 1.750/1.752 (CONTINUED)		001 MNP GW 002 04 003 EI01	

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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DRAG BRACE BUSHING I.D. 1.500/1.501 OVERALL 3.497/3.499 TRUNNION BORES 2.250/2.251			
		TRUNNION RETAINING PIN HOLES .438/.440			
		ACTUATOR BRACKET LUGS J .625/.626 K .563/.564			
		STEERING PLATE LUG HOLES .750/.751			
		STEERING COLLAR AREA WIDTH 3.352/3.355 O.D. 7.118/7.120 TOWING COLLAR AREA WIDTH 2.228/2.230			
		O.D. 7.118/7.120 UPPER SEAL AREA BORE APP 206 WIDTH STD SIZE I.D. 5.502/5.504 UPPER BEARING BORE-STD 5.625/5.630			
		1ST OVERSIZE 5.680/5.685 LOWER BEARING BORE STD 5.875/5.877 1ST OVERSIZE 5.915/5.920			
		DOOR ATTACH LUGS .312/.315			
		INTERNAL DEFECTS LESS THAN .006 IN DEPTH ARE SATISFACTORY WITHOUT REMOVAL PROVIDED THEY ARE NOT IN THE UPPER OR LOWER SEAL AREA OR CLOSER THAN 1 IN. APART.			
		NOTE: DO NOT STRIP HARD ANODIZE UNLESS DEFECTS EXCEED .006 OR DAMAGE IS IN THE SEAL AREA REFER TO 6-15 (CONTINUED)			

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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		FOR ADDITIONAL LIMITS *C/P MOVE NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL REWORK MUST BE ACCOMPLISHED. *C/P MOVE			
69	052	NICK & BURR OUTER *C/P MOVE*		001 MNPRA 002 04 003 BE01	
69	055	REMOVE BUSHINGS IF NECESSARY *C/P MOVE		001 MNPRA 002 04 003 BE01	
26	060	STRIP ANODIZE O.D. TYPE 2 ONLY *C/P MOVE		001 MNPRC 002 03 003 AN04	
26	064	STRIP HARD ANODIZE I.D. TYPE 3 ONLY DN 7327022 CYLINDER FOR O/S REPAIR OR WHEN INTERNAL DEFECTS EXCEED .006 IN DEPTH *C/P MOVE		001 MNPRC 002 03 003 AN04	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNPNA 002 06 003 ZA02	
69	070	DRAG BRACE HOLE REPAIR O/S AS REQUIRED TO CLEAN UP MIN 1.753 TO MAX 1.850 *C/P MOVE		001 MNPRA 002 04 003 MH02 005 XB33611	
69	080	TRUNNION BORE 1ST REPAIR PITS OVER .006 MAYBE REMORKED IF LESS THAN 20% OF SOCKET IS EFFECTED. MAX REWORK (CONTINUED)		001 MNPRA 002 04 003 MH02 005 XB33611	

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10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		.015 REQUIRES SHOT PEEN & ALODINE *C/P MOVE			
69	082	TRUNNION BORE 2ND REPAIR O/S AS REQUIRED TO CLEAN UP MIN 2.330 TO MAX 2.500 *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8533611	
69	090	TRUNNION RETAINING PIN HOLE REPAIR OVERSIZE TO CLEANUP .500/.501 *C/P MOVE		001 MNPRA 002 04 003 MH02 005 X8533611	
69	095	ROLL BURNISH TO .502/.503 AND ALODINE *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	100	ACTUATOR BRACKET HOLE REPAIR (J) O/S TO CLEANUP AS REQUIRED MAX O/S .8129 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	105	DOOR LUG HOLE REPAIR OVERSIZE TO .370/.372 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	110	ACTUATOR BRACKET HOLE REPAIR (K) O/S TO CLEANUP AS REQUIRED MAX O/S .6879 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	120	STEERING PLATE LUG HOLE REPAIR O/S TO CLEANUP AS REQUIRED MAX O/S .9379 *C/P MOVE		001 MNPRA 002 04 003 BE01 005 X8120881	
69	130	STEERING COLLAR REPAIR 1ST REPAIR PITS DEEPER THAN .006 MAY BE LOCALLY POLISHED TO DEPTH OF .050 INCH OVER 50% OF ANY ONE SQ INCH AREA BLEND REWORKED AREA WITH RUN OUT 3 TIMES THE DEPTH OF REWORK *C/P MOVE		001 MNPRA 002 04 003 BE01	

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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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15. DISPATCH STATION	16. PERFORM NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	140	TOWING COLLAR REPAIR PITS DEEPER THAN .006 MAY BE LOCALLY POLISHED TO DEPTH OF .050 INCH OVER 50% OF ANY ONE'S SQ INCH AREA. BLEND REWORKED AREA WITH RUN OUT 5 TIMES THE DEPTH OF REWORK *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	145	STEERING COLLAR AREA 2ND REPAIR FOR FLAME SPRAY MACHINE TO REMOVE CORROSION OR DAMAGE NOT TO EXCEED 6.940 OD 3.515 WIDTH *C/P MOVE		001 MNPRA 002 04 003 LE07	
69	146	TOWING COLLAR AREA 2ND REPAIR FOR FLAME SPRAY MACHINE TO REMOVE CORROSION OR DAMAGE NOT TO EXCEED 6.940 OD 2.430 WIDTH *C/P MOVE		001 MNPRA 002 04 003 LE07	
8	150	I.D. REWORK ON BASE METAL DRESS OUT LONGTUDINAL DEFECTS MAX. LENGTH 4 IN. MIN. RADIUS 1 TO 2 IN. SEE FIG. 6-7 FOUR EACH ALLOWED ONE ELEVATION 60 DEG. APART *C/P MOVE		001 MNPRA 002 01 003 BE01	
8	151	I.D. REWORK ON BASE METAL DRESS OUT CIRCUMFERENTIAL DEFECTS MAX. LENGTH 2 IN. RADIUS 1 TO 2 IN. AT ANY ONE ELEVATION ONLY CIRCUMFERENTIAL (LATERAL) IRREGULARITY SHALL BE DRESSED OUT SEE FIG. 6-8 FOR ADDITIONAL DRESS OUTS *C/P MOVE		001 MNPRA 002 01 003 BE01	
8	152	HONE UPPER SEAL AREA BORE, LOCATED BETWEEN 36.10 INCHES AND 37.35 INCHES ABOVE LWR END OF CYL MAY BE REWORKED, NOT TO EXCEED 5.522 I.D. *C/P MOVE		001 MNPRA 002 01 003 HV03 005 X8745246	

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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	153	IRREGULARITIES MAY BE DRESSED OUT TO .006 INCHES MAX ON A SIDE, PROVIDED THE MAX 5.522 ID IS NOT EXCEEDED. 2 INCH MIN RADIUS SHALL BE MAINTAINED AT EDGE OF DRESS OUT. 63 RMS OR BETTER. RECORD BASE METAL DIMENSION. *C/P MOVE		001 MNPRB 002 01 003 BE01	
8	154	HONE STD REPAIR UPPER BEARING BORE 5.625/5.630 HONE IAW PAGE 6-16 PARG "I" T.O. 492-30-3 125RMS. RECORD DIMENSIONS. C/P MOVE		001 MNPRB 002 01 003 HV03 005 X8745246	
8	155	HONE 1ST REPAIR UPPER BEARING BORE 5.680/5.685 REIDENTFY IAW T.O. 492-30-3 PAGE 6-19 PARG "N" 125RMS. RECORD DIMENSIONS. *C/P MOVE*		001 MNPRB 002 01 003 HV03 005 X8745246	
8	156	HONE STD SIZE LOWER BEARING BORE 5.875/5.877 ID TO CLEAN-UP NOT TO EXCEED WEAR 5.893 125 RMS. RECORD BASE METAL DIMENSION. *C/P MOVE*		001 MNPRB 002 01 003 HV03 005 X8745246	
8	158	HONE 1ST REPAIR LOWER BEARING BORE NOT TO EXCEED 5.920 MAX. REIDENTFY IAW 492-30-3 PAGE 6-19 PARG "N" 125RMS. RECORD DIMENSIONS. *C/P MOVE*		001 MNPRB 002 01 003 HV03 005 X8745246	

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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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15. DISPATCH STATION	16. PERFORM. RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	170	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DGO1	
		*C/P MOVE ***** NOTE ***** IF LAST MNT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****	M	001 MNPAA 002 06 003 ZAO2	
26	180	SHOT PEEN OUTER CYLINDER REWORK AREAS .010/.014 *C/P MOVE		001 MNPRC 002 01 003 SPO1	
26	183	SHOT-PEEN I.D. FOR ANODIZE .010/.014 INTENSITY *C/P MOVE		001 MNPRC 002 01 003 SPO1	
26	185	SHOT-PEEN TRUNNION SOCKET HOLES I.D. 100% 2.250 HOLES *C/P MOVE*		001 MNPRC 002 01 003 SPO1	
26	190	CLEAN SHOT PEENED AREAS OF OUTER & SOCKET *C/P MOVE		001 MNPRC 002 01 003 BE01	
26	200	POLISH STEERING COLLAR AREAS TO REMOVE 70-80% OF SHOT *C/P MOVE		001 MNPRC 002 03 003 BE01	
26	210	POLISH TOW LUG AREA TO REMOVE 70-80% OF SHOT *C/P MOVE		001 MNPRC 002 03 003 BE01	
25B	212			001 MNPJW 002 08 003 DGO1	

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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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18. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
25B	213	[REDACTED] *C/P MOVE		001 MNPWW 002 08 003 BE01	
25B	214	[REDACTED] *C/P MOVE		001 MNPWW 002 08 003 BL01	
25B	215	[REDACTED]		001 MNPWW 002 08 003 FSO4 005 YB929447	
25B	220	[REDACTED]		001 MNPWW 002 08 003 FSO4 005 YB929447	
25B	222	[REDACTED]		001 MNPWW 002 08 003 FSO4	
25B	224	[REDACTED]		001 MNPWW 002 08 003 FSO4	
69	225	MACHINE STEERING COLLAR AREA 7.118/7.120 OD 3.352/3.355 WIDTH 63 RMS FINISH *C/P MOVE		001 MNPRA 002 04 003 LE07	
69	228	MACHINE TOWING COLLAR AREA 7.118/7.120 OD 2.228/2.230 WIDTH 63 RMS FINISH *C/P MOVE		001 MNPRA 002 04 003 LE07	
26	230	ANODIZE OUTER CYLINDER TYPE II O.D. ONLY *C/P MOVE		001 MNPRC 002 03 003 ASD3	
26	232	ANODIZE OUTER CYL TYPE II COMPLETE ID & OD. *C/P MOVE		001 MNPRC 002 03 003 ASD3	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER
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18. DISPATCH STATION	19. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	234	HONE UPPER SEAL BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.522 MAX		001 MNPRB 002 01 003 HV03 005 X8745244	
8	236	POLISH UPPER SEAL BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.522 MAX		001 MNPRB 002 01 003 BE01	
8	238	HONE UPPER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.685 MAX		001 MNPRB 002 01 003 HV03 005 X8745244	
8	240	POLISH UPPER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.685 MAX		001 MNPRB 002 01 003 BE01	
8	242	HONE LOWER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.920 MAX		001 MNPRB 002 01 003 HV03 005 X8745244	
8	244	POLISH LOWER BORE TO REMOVE TYPE II ANODIZE 32 RMS 5.920 MAX		001 MNPRB 002 01 003 BE01	
26	245	HARD ANODIZE TYPE III I.D. ONLY MIN. .002 TO MAX .004 PER DIA. *C/P MOVE ***** NOTE ***** ALL HOLES TO BE PLUGGED BEFORE HARD ANODIZE		001 MNPRC 002 03 003 AH01 008 AT010	
8	250	FINAL POLISH UPPER SEAL BORE STD 5.502/5.504 63 RMS 5.522 MAX *C/P MOVE		001 MNPRB 002 01 003 BE01	
8	255	FINAL POLISH UPPER BORE STD SIZE 5.625/5.630 1ST O/S 5.680/5.685 63 RMS *C/P MOVE		001 MNPRB 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NGUN OUTER CYLINDER
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
B	258	FINAL POLISH LOWER BORE STD SIZE 5.875/5.877 63 RMS 5.893 MAX		001 MNPRB 002 01 003 BE01	
B	260	REIDENTIFY OUTER CYLINDERS WITH O/S BORES IAW PAGE 6-19, PAR. "N" C/P MOVE		001 MNPRB 002 01 003 BE01	
26	265	ALODINE MINOR REWORK AREAS C/P MOVE		001 MNPRC 002 03 003 TA01	
69	268	MACHINE DRAG BRACE HOLE BUSHING P/N 63-2030-1 P/N 63-2030-2		001 MNPRA 002 04 003 LE02	
69	270	DRAG BRACE HOLE BUSHING INSTALLATION P/N 63-2030-1/63-2030-2 PRESS FIT .0005/.0015 LINE REAM 1.500/1.501 OVERALL 3.497/3.499		001 MNPRA 002 04 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	278	MACHINE TRUNNION HOLE BUSHING P/N 65B32580-01 P/N 65B32580-03		001 MNPRA 002 04 003 LE02	
69	280	TRUNNION HOLE BUSHING INSTALLATION INSTALL BUSH 65B32580-01 OR -03 I.D. DIM. 2.250/2.251 .110/.120 BELOW BORE FACE *C/P MOVE* PRESS FIT .0005/.0008		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	281	CENTER DRILL TRUNNION RETAINING PIN HOLE .406/.423 INSTALL TRUNNION AND LINE REAM RETAINING PIN HOLES TO .436/.440 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	290	MACH TRUNNION RETAINING PIN BUSHING P/N 68J29645-61S32P FLUSH TO .005 BELDW CYLINDER SURFACE INSIDE FINISH TO .438/.440 PRESS FIT TO .001/.0015		001 MNPRA 002 04 003 LE02	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE P/N 68J29645-61S32P			
69	291	MACHINE STEERING PLATE LUG BUSHING P/N NAS537B12P-43		001 MNPRA 002 04 003 LE02	
69	292	STEERING PLATE LUG BUSHING INSTALLATION P/N NAS537B12P-43 LINE REAM .750/.751 PRESS FIT .0006/.002		001 MNPRA 002 04 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	293	MACHINE ACTUATOR BRACKER HOLE (J) BUSHING P/N NAS537B10P-86		001 MNPRA 002 04 003 LE02	
69	295	ACTUATOR BRACKET HOLE (J) BUSHING INSTALLATION P/N NAS537B10P-86 PRESS FIT .0005/.0015 FINISH LINE REAM		001 MNPRA 002 04 003 BE01	

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7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ID .625/.626 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
<del>69</del>	296	MACHINE ACTUATOR BRACKET HOLES (K) BUSHING. P/N NAS537B9P-61		001 MNPRA 002 04 003 LE02	
<del>69</del>	297	ACTUATOR BRACKET HOLES (K) BUSHING INSTALLATION P/N NAS537B9P-61 PRESS FIT .0005/.0015 FINISH LINE REAM ID .563/.564 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 04 003 BE01	
<del>69</del>	299	MACHINE DOOR ATTACH LUG BUSHINGS		001 MNPRA 002 04 003 LE02	
69	300	DOOR ATTACH LUG BUSHING .312/.316 FLUSH TO .0005 BELOW LUG FACE PRESS FIT .0003/.0012 *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	310	INSTALL TRUNNION PINS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	320	REAM TRUNNION PIN LOCK SCREW HOLES .436/.440 *C/P MOVE		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	330	MARK AND REMOVE TRUNNION PIN P/N 6-68001 FIG 2-3 INDEX 43 4S2-30-3 *C/P MOVE		001 MNPRA 002 04 003 BE01	
		P/N 6-68001			
69	340	INSTALL HELICOILS *C/P MOVE		001 MNPRA 002 04 003 BE01	
34PP	343 *REQD*	PRE-PAINT STEERING COLLAR JOURNALS *C/P MOVE*		001 MNP GP 002 09 003 PP01	
34A	345 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 06 003 SA03	
34A	350 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 45-1-182 452-30-3	9. ITEM SERIAL NO.
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10. MODEL/DESIGN/SERIES KC-135 NOSE	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN BEARING UPPER
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15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 6-55002-1		NSN C/N 1620005168897 17567A 69354A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		*****"W A R N I N G"*****			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
		***** M I C A R T A ***** ***** UNIT COST \$50.49 *****			

21. FINAL DESTINATION DISPATCH	21. FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	22. COORDINATION/INITIATING RCC SIGNATURE/DATE C	23. DOCUMENT/BN 15514N
		B	D	

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NSUN BEARING UPPER	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	6-55002-1			
34D	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPBW 002 02 003 LG02 005 X8745233 006 X8745188	
34D	006 *REQD*	DEGREASE ONLY *C/P MOVE		001 MNPBW 002 02 003 DG02	
34E	020	E & I I.D 4.753/4.755 O.D 5.620/5.625 OVERSIZE O.D 5.670/5.675 C/P MOVE		001 MNPBW 002 04 003 EI01	
29	030	EPOXY O.D. RESOLIN RLF COTTON FIBER EPOXY RESIN SUFFICIENT TO MACHINE TO 5.660/5.690 *C/P MOVE		001 MNPWD 002 10 003 PLO3	
69	038	MACHINE O.D. 5.670/5.675 63 RMS		001 MNPRA 002 04 003 LE02	
69	040	NICK & BURR *C/P MOVE		001 MNPRA 002 04 003 BE01	
34A	050 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPBP 002 06 003 SA03	
34A	060 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPBP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPQP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 482-30-3/45-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES KC-135 N.L.G.	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NSUN LOWER GEAR NUT
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 158665		NSN C/N 5365007660478LE 17567A 69354A			
		*****UNIT COST \$58.42***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BLAST IAW MIL-STD-1504 BAKE IAW 48-1-182 MAOI 74-12 FMPI IAW MIL-STD-1949 P/O NO1561			
		STRIP CAD I A W MIL-STD-871 CAD PLATE I A W MIL-STD-870 VAC CAD I A W MIL-C-8837 TUD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541			
		*****S T E E L*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		*****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN LOWER GEAR NUT	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN			
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	158665			
34D	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPBW 002 02 003 LC02 005 XB745233 006 XB745188	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPBW 002 03 003 SL01	
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPBW 002 03 003 BL07	
34B	011 *REQD*	BAKE 4 HRS AT 350/400F DATE IN _____ TIME IN _____		001 MNPBW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		[REDACTED] *C/P MOVE	M	001 MNPNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN LOWER GEAR NUT
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15. DISPATCH STATION	16. PERM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	020 *REQD*	E & I VISUAL DAMAGE CHECK *C/P MOVE		001 MNPGW 002 04 003 EI01	
34E	030 *REQD*	NICK & BURR THREADS AND LOCAL DAMAGE *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	032	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	034	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	036	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	038	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	040	VAC-CAD-PLATE TYPE II CLASS II *C/P MOVE		001 MNPRC 002 02 003 VC01	
26	050	CAD-PLATE TYPE II CLASS II *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	060	BAKE 23 HRS AT 350/400F WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
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10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN LOWER GEAR NUT	

15. DISPATCH STATION	16. PERM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	070	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
		[REDACTED] *C/P MOVE		001 MNPNA 002 06 003 ML04	
	.65	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M		
26	083	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 060 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
26	087	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
34A	090	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 06 003 SA03	
34A	100	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE		001 MNP GP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15517N
		B	D	