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**TECHNOLOGY INSERTION-ENGINEERING SERVICES
PROCESS CHARACTERIZATION
TASK ORDER NO. 1**

BOOK 3 OF 5

DATABASE DOCUMENTATION BOOK

OO-ALC

MANPWW

(MAIN LANDING GEAR EXCEPT C5 - WCD'S)

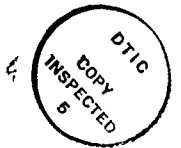
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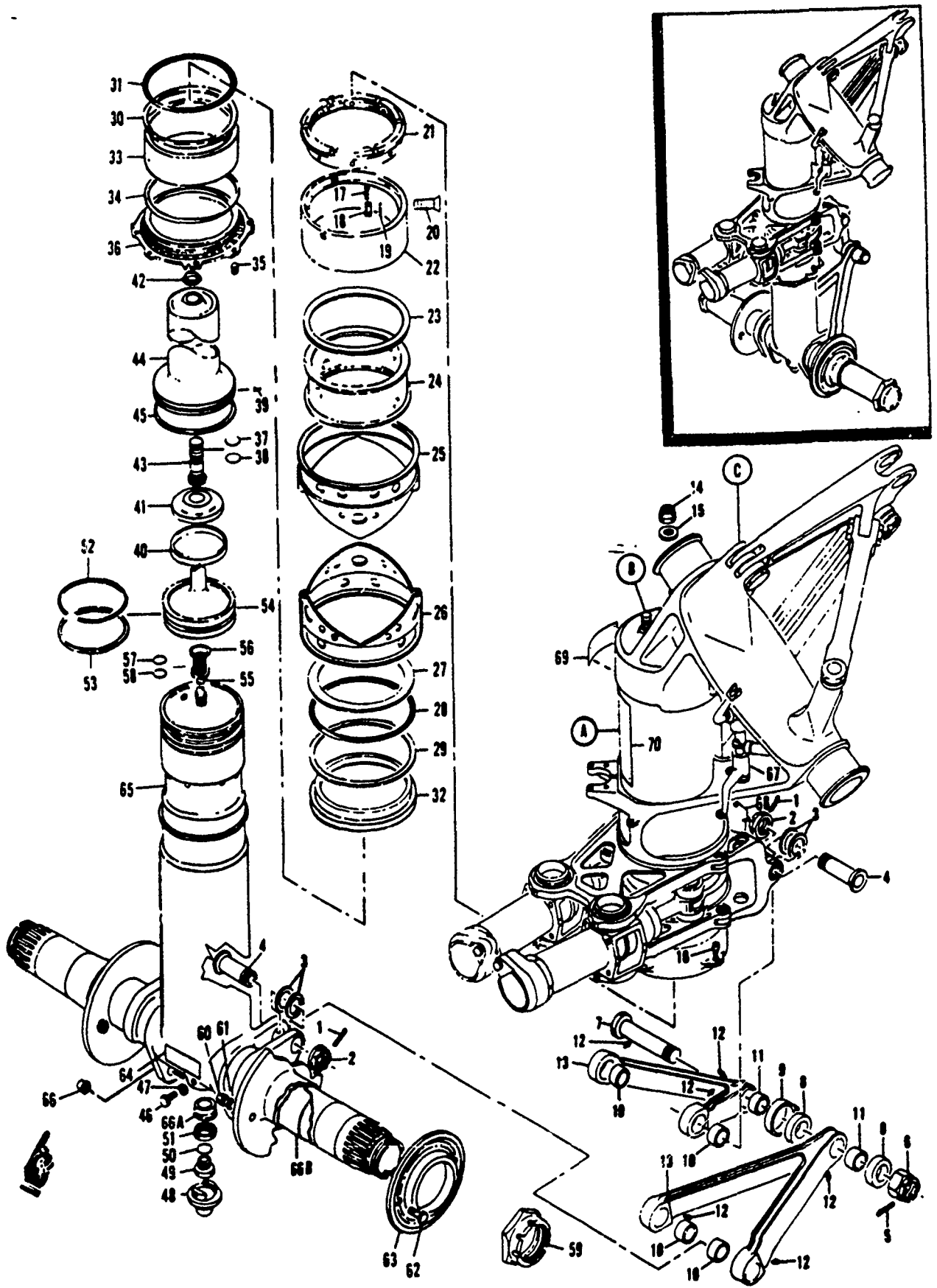


Figure 2-2. Main Landing Gear Strut Assembly (Sheet 2 of 4)

1. Pin	51. Nut	107. Cap Half
2. Nut	52. Packing	108. Tube
3. Washer	53. Ring	108A. Packing, O-ring
4. Bolt	54. Rod	108B. Ring Backup
5. Pin	55. Tube	109. Tube
6. Nut	56. Washer	109A. Packing O-ring
7. Bolt	57. Packing	110. Tube
8. Bearing	58. Ring	110A. Packing O-ring
9. Support	59. Nut	111. Pin
10. Bearing	60. Nut	112. Nut
11. Bearing	61. Washer	113. Washer
12. Fitting	62. Bolt	114. Bolt
13. Link	63. Collar	115. Bolt
14. Nut	64. Metal-Cal	116. Link
15. Washer	65. Cylinder	117. Pin
16. Pin	66. Bushing	118. Nut
17. Pin	66A. Insert	119. Washer
18. Nut	66B. Sleeve	120. Bolt
19. Washer	67. Jackshaft Instl	121. Bolt
20. Bolt	68. Control Instl	122. Nut
21. Nut	69. Metalcal	123. Bolt
22. Bearing	70. Metalcal	124. Link
23. Shim	71. Ring	125. Link
24. Spacer	72. Pin	126. Bushing
25. Cam	73. Ring	127. Bushing
26. Cam	74. Pin	128. Bushing
27. Washer	75. Bolt	129. Bushing
28. Packing	76. Washer	130. Sleeve
29. Ring	77. thru 86. Deleted	131. Connector
30. Ring	87. Fitting	132. Spacer
31. Packing	88. Fitting	133. Bushing
32. Ring	89. Fitting	134. Ring
33. Bearing	90. Link Fitting	135. Packing
34. Scraper	91. Plate	136. Cylinder
35. Sleeve	92. Nut	137. Shipping Plate
36. Nut	93. Washer	138. Screw
37. Ring	94. Screw	139. Bushing
38. Packing	95. Rivet	140. Bushing
39. Rivet	96. Quadrant	141. Bushing
40. Nut	97. Bearing Half	142. Bushing
41. Plate	98. Bearing Half	143. Bushing
42. Nut	99. Bearing Half	144. Holes
43. Bolt	100. Bearing Half	145. Hole
44. Tube	101. Valve	146. Hole
45. Ring	102. Tube	147. Hole
46. Bolt	103. Packing	148. Holes
47. Washer	104. Cap Half	149. Holes
48. Cone	105. Cap Half	150. Holes
49. Plug	106. Cap Half	151. Holes
50. Gasket		

Figure 2-2. Main Landing Gear Strut Assembly (Sheet 1 of 4)

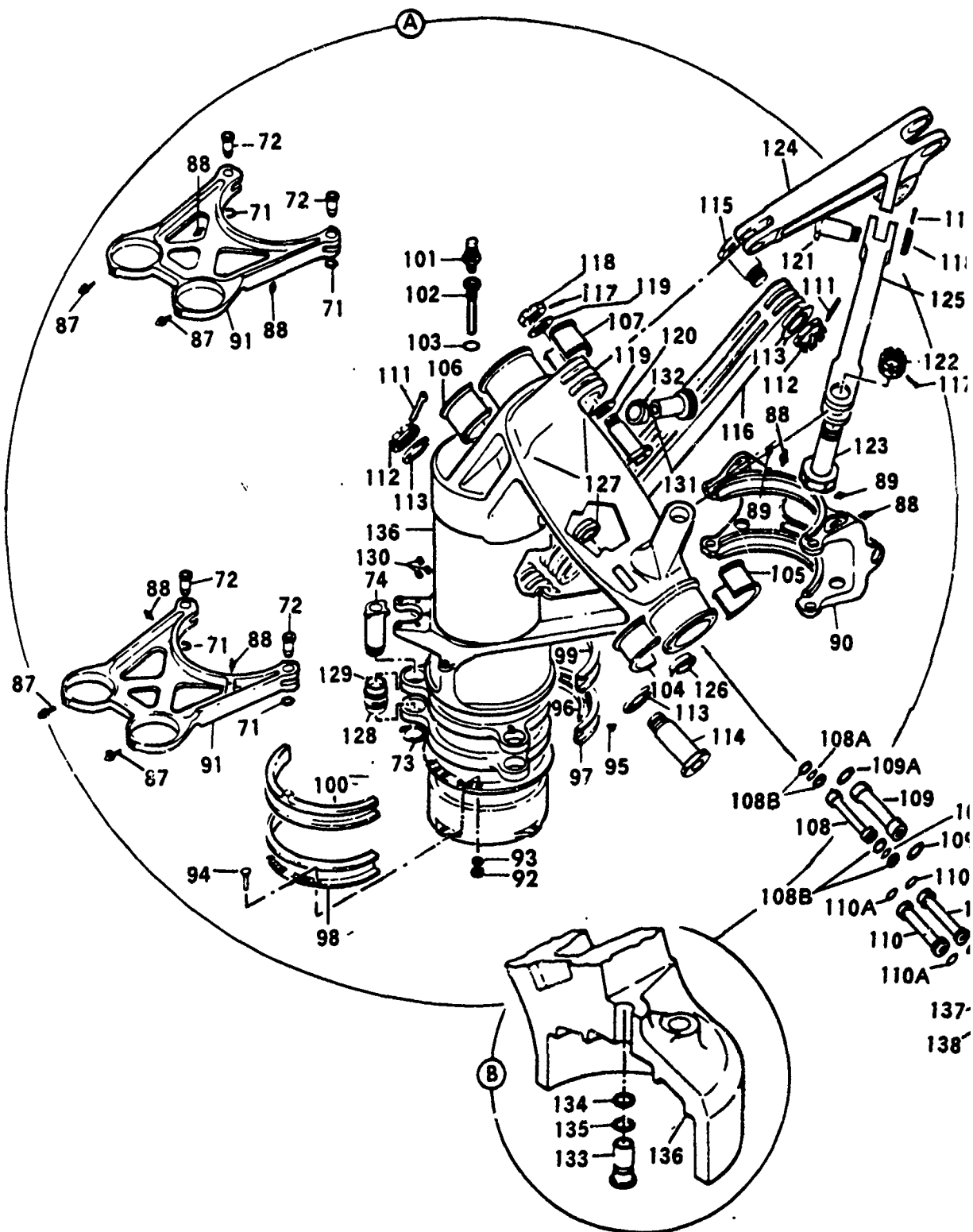


Figure 2-2. Main Landing Gear Strut Assembly (Sheet 3 of 4)

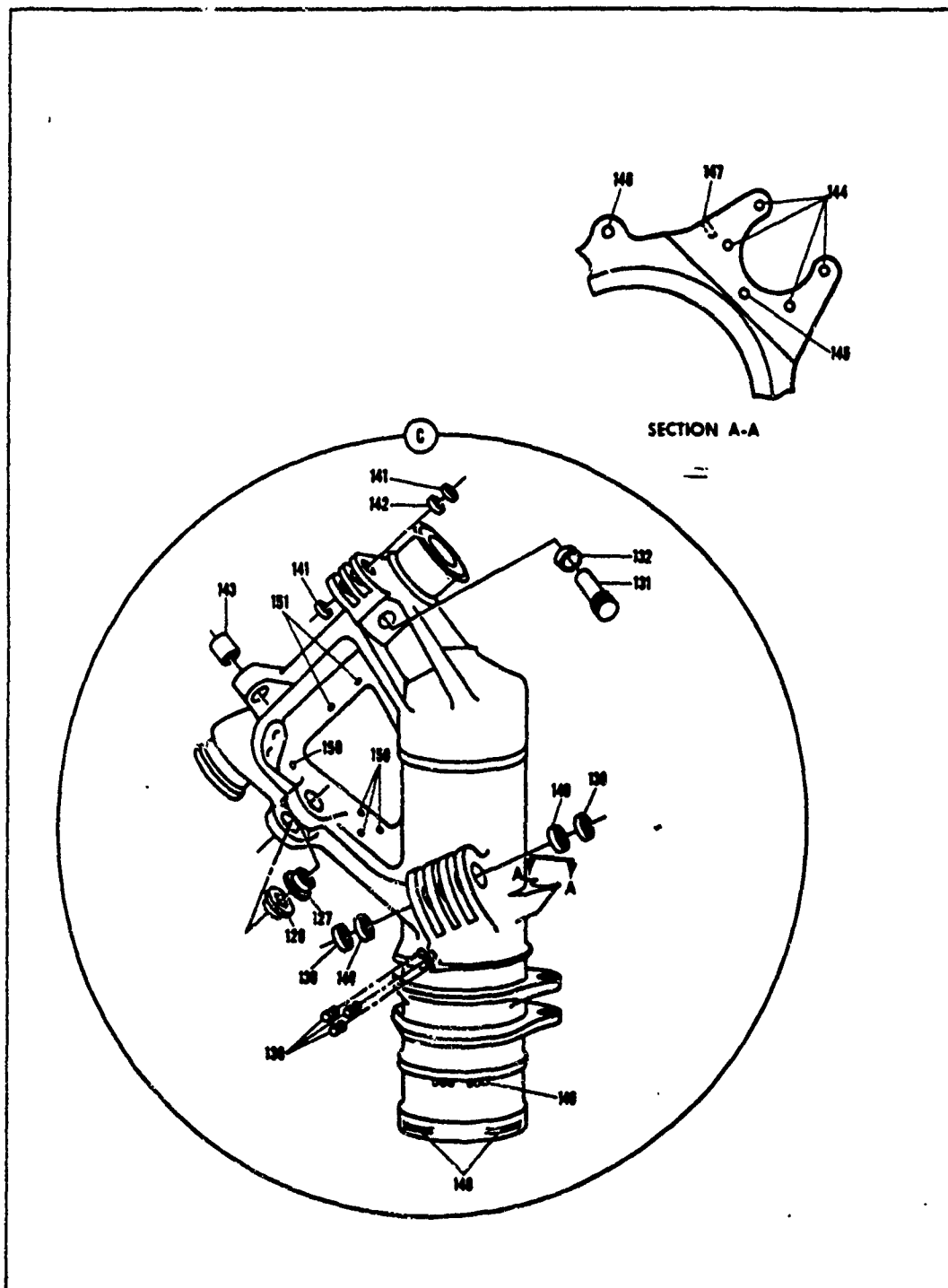


Figure 2-2. Main Landing Gear Strut Assembly (Sheet 4 of 4)

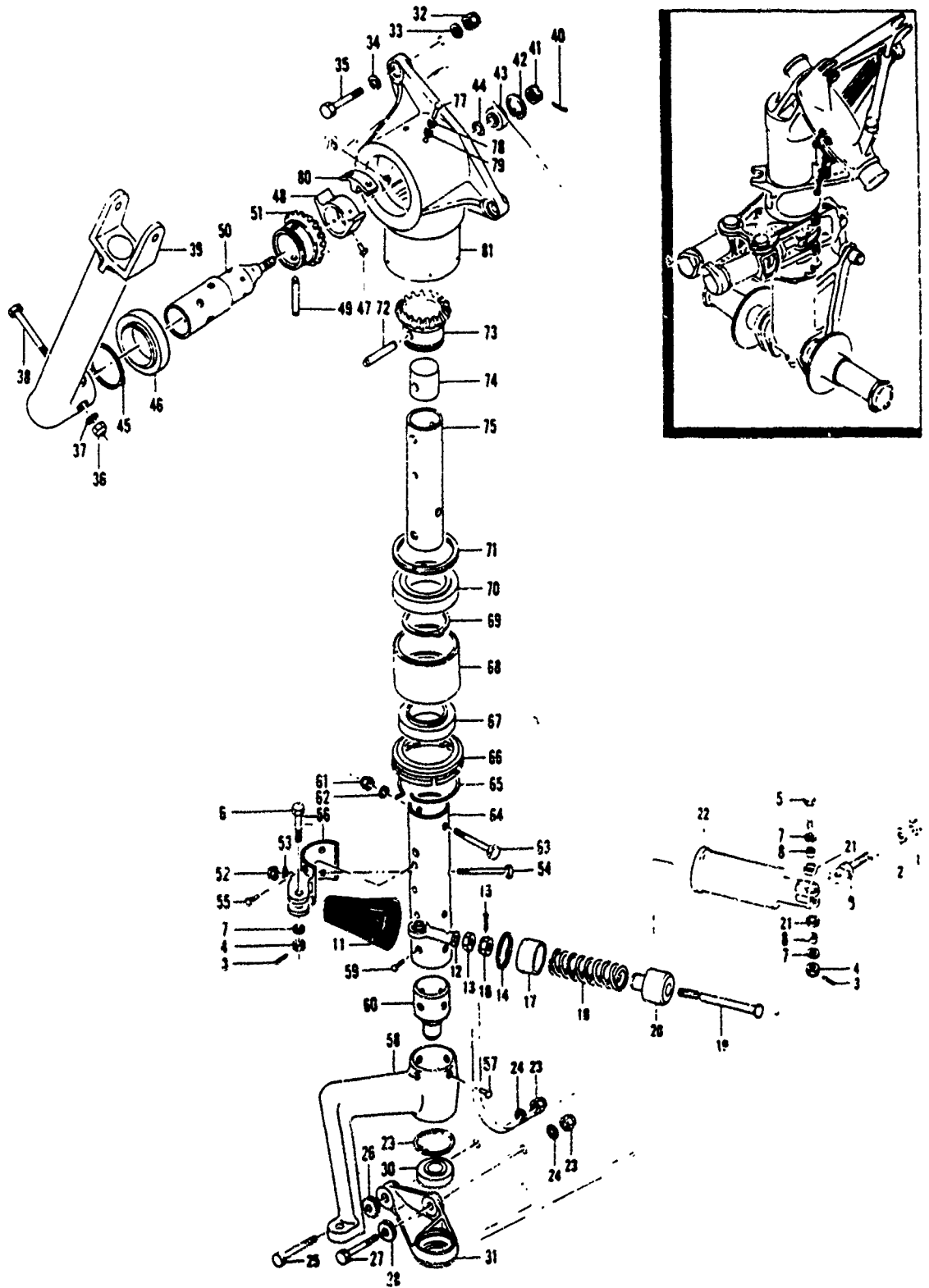


Figure 2-3. Landing Gear Steering Jackshaft Installation (Sheet 1 of 2)

1. Nut	18. Spring	34. Washer	50. Shaft	66. Nut
2. Washer	19. Rod	35. Bolt	51. Gear	67. Bearing
3. Pin	20. Slide	36. Nut	52. Nut	68. Sleeve
4. Nut	21. Bushing	37. Washer	53. Washer	69. Ring
5. Bolt	22. Housing	38. Bolt	54. Bolt	70. Bearing
6. Bolt	23. Nut	39. Arm	55. Rivet	71. Shim
7. Washer	24. Washer	40. Pin	56. Arm	72. Pin
8. Bushing	25. Bolt	41. Nut	57. Rivet	73. Gear
9. Bolt	26. Washer	42. Ring	58. Arm	74. Plug
10. Deleted	27. Bolt	43. Bearing	59. Rivet	75. Shaft
11. Bolt	28. Washer	44. Shim	60. Adapter	76. Collar
12. Bearing	29. Ring	45. Ring	61. Nut	77. Rivet
13. Nut	30. Bearing	46. Bearing	62. Washer	78. Washer
14. Ring	31. Support	47. Rivet	63. Bolt	79. Washer
15. Pin	32. Nut	48. Stop	64. Tube	80. Stop
16. Nut	33. Washer	49. Pin	65. Ring	81. Housing
17. Slide				

Figure 2-3 Landing Gear Steering Jackshaft Installation (Sheet 2 of 2)

1. Nut	20. Washer	39. Washer	58. Screw	77. Bolt
2. Washer	21. Gasket	40. Bearing	59. Washer	78. Washer
3. Spacer	22. Metal-Cal	41. Screw	60. Insulator	79. Nut
4. Pin	23. Cover	42. Nut	61. Actuator	80. Metal-Cal
5. Nut	24. Nut	43. Pin	62. Switch	81. Gasket
6. Bolt	25. Clamp	44. Follower	63. Nut	82. Ring
7. Bolt	26. Nut	45. Actuator	64. Washer	83. Key
8. Terminal	27. Washer	46. Nut	65. Post	84. Bearing
9. Terminal	28. Screw	47. Washer	66. Screw	85. Cam
10. Nut	29. Nut	48. Arm	67. Screw	86. Gear
11. Nut	30. Washer	49. Pawl	68. Washer	87. Spacer
12. Turnbuckle	31. Washer	50. Packing	69. Screw	88. Ring
13. Gasket	32. Screw	51. Shaft	70. Adapter	89. Bearing
14. Bolt	33. Terminal	52. Nut	71. Rivet	90. Bearing
15. Bolt	34. Terminal	53. Screw	72. Shaft	91. Sleeve
16. Bolt	35. Connector	54. Washer	73. Transmitter	92. Sleeve
17. Washer	36. Spring	55. Insulator	74. Screw	93. Sleeve
18. Washer	37. Spring	56. Actuator	75. Washer	94. Housing
19. Screw	38. Screw	57. Switch	76. Cover	

Figure 2-4. Main Gear Position Control Installations (Sheet 1 of 2)

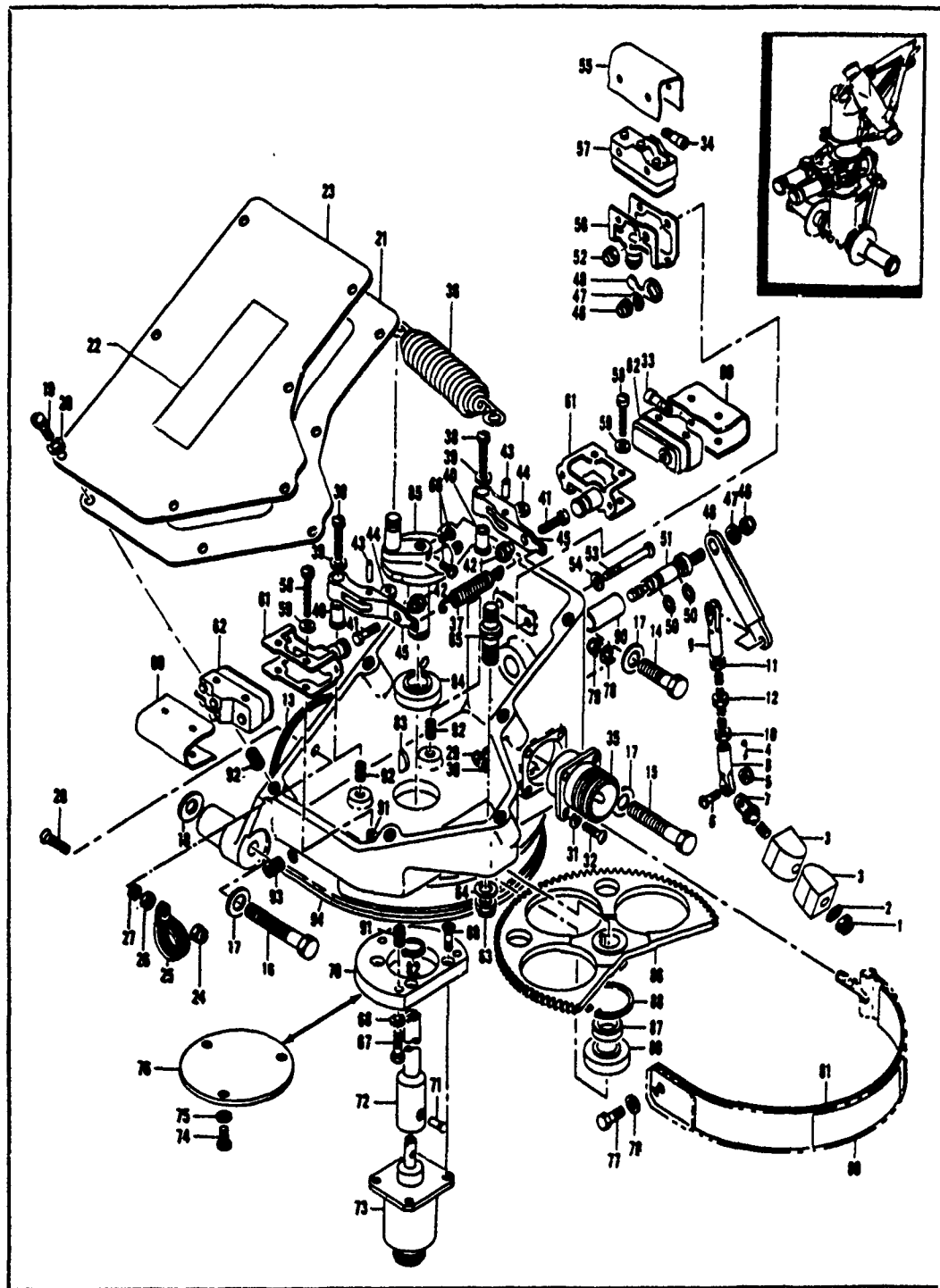


Figure 2-4. Main Gear Position Control Installations (Sheet 2 of 2)

26337A

F15 MLG R/H HW

OPER

TECH S S

W F RF A/R REV

SUB

T X

12 A FA SUPPORT

DOC

DESCRIPTION

BASE

PFD

STD

STEP L L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

STEP	STEP L	STEP R	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS
0000	S	R	35	EA E	X	13204	1.00 PERCENT ENGR 72.4	STRUT ASSY F-15	1.14		1.14
0001		35	01	00			.00	PART NUMBER /NSA	.000	.000	.000
0010						42A410501-2007		1620010360335			
0020						68A410501-2008		1620010360335			
0030						69A410501-2009		1620010672791			
0040						68A410501-2010		1620010799928			
0050						68A410501-2011		1620011671000			
0060						68A410501-2012		1620011670799			
0510		35	01	25			1.00	PAINT MED STRUT ASSY	.582	.146	.728
0010	E			ZLG-HH-02		1.00 LOAD MED STRUT ON O/H CONV		LOAD OVERHEAD CRANE	.02068		.025
0020	E			ZMA-AA-41		1.00 MASK MED MLG STRUT FOR PAINT			.09313		.116
0030	E			ZMF-BF-F2		1.00 FINAL PAINT MED STRUT/PART			.25790		.322
0040	E			RLG-JP-15		1.00 GET STRUT DECALS F/STO CAB			.00493		.008
0050	E			ZMP-UM-01		1.00 UNMASK SM STRUT NOSE OR HAIN			.14520		.181
0060	E			ZLG-HH-01		1.00 UNLOAD OVERHEAD CONVEYOR			.03462		.043
0070	E			KID-IL-AA		1.00 INSTALL DECAL PR SENSITIVE			.01378		.017
0080	E			RJP-PW-R1		1.00 REM RPL PAPERWAK SIGN OFF DOC			.01001		.012
0512		35	01	25			1.00	DECALS	.030	.002	.038
0010	E			RLG-JP-05		1.00 GET STRUT DECALS F/STO CAB			.00493		.008
0020	E			KID-IL-AA		1.00 INSTALL DECAL PR SENSITIVE			.01378		.017
0030	E			RJP-PW-R1		1.00 REM RPL PAPERWAK SIGN OFF DOC			.01001		.012
0040		35	01	25			1.00	FINAL ACCEPTANCE OF W.O.I.	.180	.045	.226
0010	N						1.00	FINAL	.12900		.150
0020	E			GJF-FP-25		1.00		FILL OUT FORM 424 & ATTACH	.05255		.065
0530		35	01	25			1.00	FINAL VISUAL INSPECTION	.137	.034	.171
0010	N						1.00	FINAL VISUAL INSPECTION	.12700		.158
0020	E			RJP-PW-R1		1.00 REM RPL PAPERWAK SIGN OFF DOC			.01001		.012
9000		35	01	25			.01	LABOR STANDARD HISTORY	.000	.000	.000
0011								19MARS5 DOWN GRADED NOT MARKET BASKET			
0012								11MARS6 ADDED PREPAINT ADAPTOR OLD STD 1.60			
0500								J.CALDWELL TECH MANEAA			

TO INTERROGATE LABOR STANDARDS, INPUT

800 FAD NRCF NR

1234567890123456 ELSE PUT IN END



SECTION I
INTRODUCTION

1-1. IDENTIFICATION. (See figure 1-1.)

1-2. This technical manual contains overhaul and test instructions for Left Front Main Landing Gear Strut Assembly, Part No. 25-4200-1, manufactured by The Boeing Company, Wichita, Kansas.

1-3. PURPOSE AND LEADING PARTICULARS. (See figure 1-2.)

1-4. The major components of the left front main landing gear strut assembly are the outer cylinder assembly, inner cylinder assembly, steering actuator assemblies, jackshaft installation, torsion link assemblies, orifice rod assembly, centering cam assembly, and position control installation.

1-5. The torsion link assemblies, attached to the steering plate assembly, are rotated around the outer cylinder assembly by the steering actuator assemblies, and turn the axle attached to the inner cylinder assembly. The inner cylinder assembly

turns on a compressed air bearing within the strut assembly. The orifice rod restricts flow of hydraulic oil to eliminate rapid extension and retraction of the strut assembly caused by aircraft bounce, thus providing shock absorption. The upper and lower centering cams center the wheels when the strut is extended. The jackshaft installation transmits position control from remote sources. The position control installation contains centering switches that are operated by a cam geared to the outer cylinder assembly, and a safety switch.

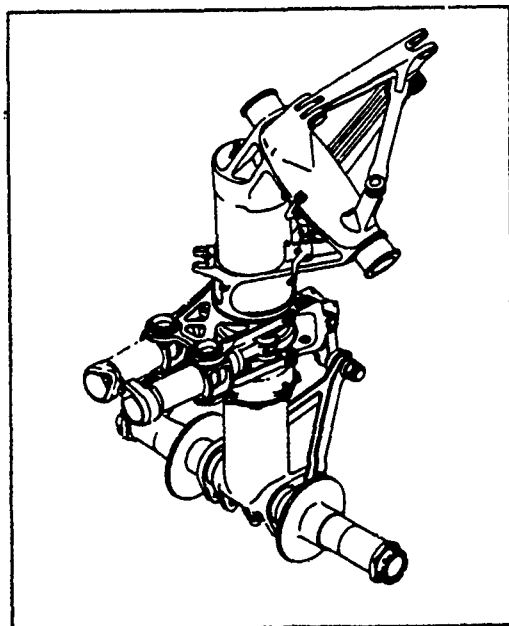


Figure 1-1. Main Landing Gear Strut Assembly

Type	Telescopic oleo shock strut
Oil Capacity	5 US gal (a)
Stroke*	
Extended	55.5
Static	40.0
Compressed	37.5
Operating Pressures	
Extended	506
Taxi	2118
Compressed	4251
Temperature Range	-54° C (-65° F)
	71° C (160° F)
Weight	903

*Measured vertically from center point of inboard trunnion to axle centerline.

Figure 1-2. Table of Leading Particulars

1-6. CONTENTS.

1-7. Sections I, II, and III of this manual contain overhaul and test instructions for Left Front Main Landing Gear Strut Assembly.

FAMILY 6

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECH#
COOP	COOP	16283A		C-141 MLG	DRAG BRACE SHAFT	1628-00-785-6873	3G11500-101	4S1-73-3
MONR	COOP	16296A	-6	H-3 MLG	STRUT ASSY	1628-00-482-1247	S6127-50102-4	4S1-72-3
MONR	COOP	16297A	-6	CH-3 MLG	STRUT ASSY	1628-01-037-4639	S6127-50501-4	4S2-50-3
JENS	RIGB	16298A		F-15 C & D	BRAKE HOUSING	1630-01-065-9469	2006006	4B1-2-11
MONR	ANDE	16301A	-6	F-4 MLG	STRUT ASSY R/H DRY	1628-00-919-6846	53-41400-302	4S1-71-3
MONR	ANDE	16302A	-6	F-4 MLG	STRUT ASSY L/H DRY	1628-00-919-6847	53-41400-301	4S1-71-3
COOP	COOP	16315A		F-16 MLG	AXLE L/H	1628-01-071-0535	2006035-103	4S1-109-
MART	SHEL	16328A		F-15	DRUM ASSY	1005-01-042-9740	205F401	11W1-7-1
MART	SHEL	16331A			ENTRANCE UNIT ASSY	1005-00-397-7834	189F322	11W1-29-
COOP	COOP	16334A		F-16 MLG	AXLE R/H	1628-01-071-0537	2006035-104	4S1-109-
DELE		16352A		C-7 MLG	HOUSING	1628-01-020-8650	17 OCT 88	4S1-81-3
JENS	PRIC	16404A	-J	C-130 MLG	WHEEL (NAVY)	1630-01-014-0656	4B	NAVAIR 0
DELE		16409A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-052-8403	9550402	4B1-2-13
DELE		16411A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-075-4866LC	9541667	4B1-2-13
COOP	COOP	16582A		F-16 MLG	TORQUE ARM-LOWER	1628-01-071-5592	2006629-105	4S2-00-3
MART	SHEL	16613A		F-16	AIM ADAPTER ASSY	1440-01-050-9264AB	16S301-817	11LAB-9-
MART	SHEL	16614A		F-15	UNLOAD DRIVE ASSY	1005-00-100-6969	176F727	11W1-1-1
MART	SHEL	16615A		F-106	DRUM ASSY	1005-00-397-7835	189F336	11W1-29-
COOP	COOP	16623A		C-141 MLG	TORQUE ARM	1628-01-114-6869	3610007-117	4S1-73-3
MART	SHEL	16705A		F-15	LAU 114 LAUNCHER	1440-01-114-9506AB	68A732501-1009	11W1-2-1
COOP	COOP	16727A		F-16 MLG	TORQUE ARM-UPPER	1628-01-124-9137	2006629-111	4S2-00-3
COOP	RIGB	16734A	-J	F-111 MLG	TORQUE PLATE	1630-00-468-1727	4-52	4B1-2-40
COOP	POLL	16743A		C-141 MLG	DOWN LOCK BELLCRANK	1628-00-204-1200	3661100-101	4S2-59-3
COOP	COOP	16744A		F-111 MLG	PIN AXLE	1628-00-084-6044	12L594-7	4A4-1-11
JENS	RIGB	16776A	-J	A-37 MLG	BRAKE ASSY	1630-00-847-3731	9550404	4B1-2-10
JENS	COOP	16777A		C-7A MLG	DRAG BRACE	1628-00-066-2768	5750-15	4S1-82-3
MONR	ANDE	16836A	-6	F-4 MLG	STRUT ASSY R/H WET	1628-00-109-9286	53-41500-1	4S1-71-3
MONR	ANDE	16837A	-6-J	F-4 MLG	STRUT ASSY L/H WET	1628-00-109-9287	53-41500-2	4S1-71-3
JENS	COOP	16915A		KC-135 MLG	TRUCK ASSY	1628-00-940-5066	1583-166A	4A4-12-2
COOP	COOP	17142A	-6-J	B-52 MLG	STRUT ASSY H/W	4628-00-139-0473	7027640-190-150	4S1-57-3
COOP	COOP	17143A	-6-J	B-52 MLG	STRUT ASSY H/W	1628-00-139-0474	7027640-210-170	4S1-57-3
JENS	COOP	17224A	-J	C-7 MLG	HOUSING	1628-00-403-0443	69F27216-02	4S1-81-3
JENS	COOP	17239A	-6-J	KC-135 MLG	TRUNNION	1628-00-679-3440	50-9717-22	4A4-12-2
BENT	COOP	17245A	-6-J	KC-135 MLG	DRAG BRACE	1628-00-652-5472	50-9733-1	4A4-12-2
BENT	COOP	17313A	-6-J	KC-135 MLG	TRUNNION	1628-00-651-0222	50-9717-4	4A4-12-2
BENT	COOP	17314A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1628-00-306-9942	5-84011-1	4A4-12-2
BENT	COOP	17315A	-6-J	KC-135 MLG	UPPER SIDE BRACE	1628-00-306-9943	5-84011-3	4A4-12-2
COOP	TOLM	17324A	-6	F-111 MLG	STRUT ASSY-SHOCK	1628-00-300-2261	7327000-50	4S1-70-3
BENT	COOP	17327A	-6-J	KC-135 MLG	TRUNNION	1628-00-911-0301	50-9717-25	4A4-12-2
COOP	TOLM	17346A	-6	F-111 MLG	AXLE	1628-00-39-3651	12L10021-004	4A4-17-3
BENT	COOP	17347A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1628-00-709-9371	5-84011-1	4A4-12-2
BENT	COOP	17348A	-6-J	KC-135 MLG	UPPER SIDE STRUT	1628-00-711-7771	5-84011-20	4A4-12-2
COOP	COOP	17353A	-6	F-111 MLG	STRUT ASSY	1628-00-545-9395	7430562-10	4A4-10-3
COOP	TOLM	17354A	-6	F-111 MLG	STRUT ASSY	1628-00-545-9439	7430564-10	4A4-14-3
BENT	COOP	17357A	-6-J	KC-135 MLG	BRACE ASSY	M 1628-00-741-9178	65-4829-3	4SA6-5-3
COOP	COOP	17402A	-6-J	F-15 MLG	STRUT ASSY	M 1628-01-062-7002	68A450600-1013	4S2-73-3
BENT	COOP	17107A	-6-J	KC-135 MLG	BOLT TRUNNION	1628-00-992-1498	69-10082-2	4A4-12-2
COOP	TOLM	17410A	-6	F-111 MLG	STRUT ASSY-SHOCK	1628-01-013-5910	7327074-90	4S1-70-3
BENT	COOP	17451A	-6-J	KC-135 MLG	TRUNNION	M 1628-00-651-0221	50-9717-3	4A4-12-2
COOP	TOLM	17461A	-6-J	F-106 MLG	STRUT ASSY	1628-00-592-9638	578100-505	4S1-32-2

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTOR STAND HOURS
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17143A	MKPRW	XKPRW	X	4N	5	.30	1.00	
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FAMILY 6
B-52 MLC

MNPGP	DUJ10	N	H3	5		10.72	1.00	10.0
	P0017	E	H3	5		4.28	1.00	4.0
	P0002	E	3S	5		.54	1.00	
	P0003	E	3S	5		3.08	1.00	3.0
	PS004	E	H3	5		.28	1.00	
	PS021	N	H3	5		.30	1.00	

MNPGW	PM003	E	DJ	5		1.22	1.00	1.0
	WC001	E	KI	5		2.61	1.00	2.6
	WD001	E	H3	5		4.74	1.00	4.7
	WE001	E	OI	5		1.65	1.00	1.6
	WE002	E	OI	5		1.15	1.00	1.1
	WE004	N	OI	5		.37	1.00	
	WE005	N	OI	5		.27	1.00	
	WE006	N	OI	5		.33	1.00	
	WE007	N	OI	5		.30	1.00	
	WE008	N	OI	5		.55	1.00	
	WE009	N	OI	5		.27	1.00	
	WE010	N	OI	5		.23	1.00	
	WE013	N	OI	5		.18	2.00	
	WE014	N	OI	5		.18	1.00	
	XNPGW	X	H3	5		5.93	1.00	5.9

MNPMG	XNPMG	X	JR	1		.20	1.00	2
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MNPNA	NA001	E	DB	2		.19	.10	
	NA002	E	DB	2		.83	1.00	8
	NA005	E	DB	2		.23	1.00	2
	NA006	E	DB	2		.23	1.00	2
	NA007	E	DB	2		.10	1.00	1
	NA008	E	DB	2		2.06	1.00	2.0
	NA009	E	DB	2		.46	.55	2
	NA010	E	DB	2		.10	.96	
	NA013	E	DB	2		.20	.15	
	NA014	E	DB	2		.23	.54	1
	XNPNA	X	DB	2		4.91	1.00	4.9

MNPRA	RA001	E	JA	1		16.27	.59	9.5
	RA002	E	JA	1		4.44	.83	3.6
	RA004	E	JA	1		.86	.63	5
	RA005	E	JA	1		3.94	1.00	3.9

FACTO

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAND HOURS
17143A	MNPRB	RA006	E	JA	1	5.25	1.00	8.
		RA007	E	JA	1	3.20	.96	3.
		RA008	E	JA	1	2.51	1.00	6.
		RA009	E	JA	1	1.28	.08	
		RA010	N	JA	1	.45	1.00	
		RA014	E	JA	1	3.79	.13	
		RA021	E	JA	1	.45	.10	

41.

MNPRB	RB001	N	JA	3	3.48	.08	
	RB002	E	JA	3	18.83	.46	8.
	XNPRB	X	JA	3	2.15	1.00	2.

11.

MNPRC	RC001	E	UP	8	3.09	.83	2.
	RC002	E	UP	8	6.92	.92	6.
	RC004	E	UP	8	.54	1.63	
	RC005	E	UP	8	.64	.96	
	RC006	E	UP	8	.64	1.00	
	RC007	E	UP	8	.75	.92	
	RC008	N	UP	3	13.96	.63	6.
	RC009	E	UP	8	1.69	1.75	2.
	RC010	E	UP	8	1.53	.42	
	RC013	E	UP	8	.54	2.00	1.
	RC014	E	UP	8	.63	.54	
	XNPRC	X	UP	3	4.79	1.00	4.7

30.5

MNPRW	WF001	N	WF	9	15.00	.05	8
	WF005		WF	8	.11	.96	1

9

133.0

BLDG 505/507

B-528 AFT

BILL OF MATERIALS

17143A

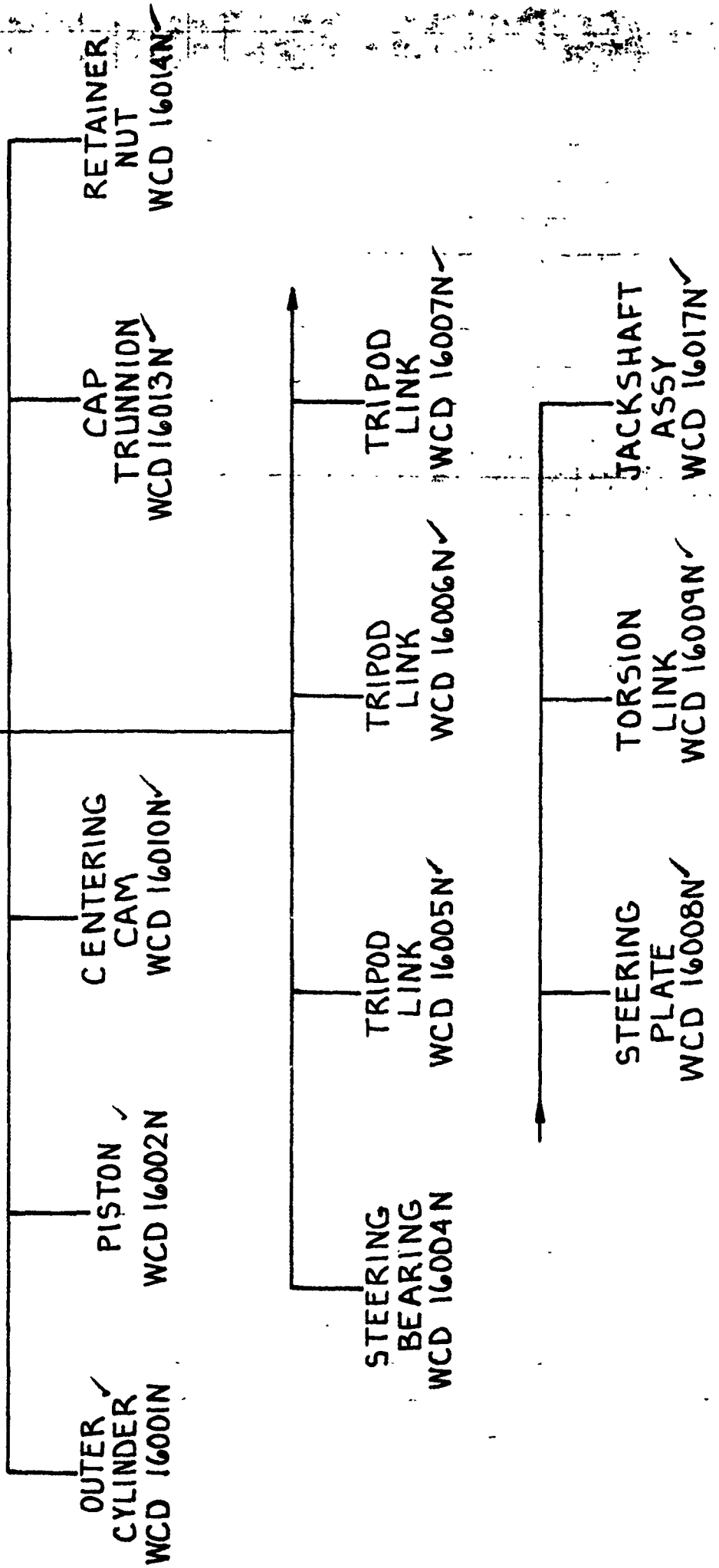
* = MHI

12-May-7

STL-STEEL
AL-ALUMINUM
MAG-MAGNESIUM
TIT-TITANIUM
SS-S STEEL
SYN-SYNTHETIC
LP-LEAD

ROUTED ITEMS	ALUM LEVEL	CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PER OF	IR,D,C	REV	TECH	PENDING	PENDING	PENDING	PENDING
								ASSY	MEAS	CODE	LEVEL	CONTROL	DATE	NUMBER	ACTION
	1..2		125-1951-1300	15310005745213LE	182918	WASHER, DRAIN TUBE LOCK (KIT)	11	1	EA						
	1..2		1628775-214	15330005795163	196906	...PACKING, O-RING (KIT)	11	1	EA						
	1..2		1628774-214	15330005437089	196906	...RING, BACKUP (KIT)	11	1	EA						
BTU	1..1		11-80951	IN.S.L.		...ROD ASSY, REAR ORIFICE	11	1		11NT					
BTU	1..1		11-80951-2	11620000964428	181205	...ROD ASSY, REAR ORIFICE	11	1	EA	11NT					
BTU	1..1		1621025-71	15310008440043	196906	...NUT, AXLE (WITH "X" STAMPED)	12	1	EA						
	1..1		162108154W	15310006807504	181205	...NUT, SELF LOCKING	14	1	EA						
	1..1		16M-7A	15306005159044	188044	...BOLT, MACHINE	14	1	EA						
	1..1		15-71612	15365006963054LE	181205	...COLLAR, AXLE	12	1	EA						
	1..1		16211065-10C	IN.S.L.	110C MFG	...META-CAL	11	1	EA						
	1..1		15-65123-6	11620006582388	181205	...CYLINDER ASSY	11	1	EA						
	1..2		136-7090-1	11620009642818	182918	...INSERT, AXLE	11	1	EA						
	1..2		IN.P.L.	IN.S.L.		...CYLINDER SUBASSY	11	1							
	1..3		16653000-03S01	13120009898163	198747	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16-71444	1312000990418LE	181205	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16829160-25	13120001040181LE	198747	...BUSHING, TORQUE ARM (RPR)	14	1	AR1EA						
	1..3		IN.P.L.	IN.S.L.		...CYLINDER	11	1							
	1..1		125-4204	11620006525469	182918	...CYLINDER ASSY	11	1	EA						
	1..2		136-7090-1	11620009642818	182918	...INSERT AXLE	11	1	EA						
	1..2		IN.P.L.	IN.S.L.		...CYLINDER SUBASSY	11	1							
	1..3		16653000-03S01	13120009898163	198747	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16-71444	1312000990418LE	181205	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16829160-25	13120001040181LE	198747	...BUSHING, TORQUE ARM (RPR)	14	1	AR1EA						
	1..3		IN.P.L.	IN.S.L.		...CYLINDER	11	1							
	1..1		125-4204-1	11620007838023	186276	...CYLINDER ASSY	11	1	EA						
	1..2		136-7090-1	11620009642818	182918	...INSERT AXLE	11	1	EA						
	1..2		IN.P.L.	IN.S.L.		...CYLINDER SUBASSY	11	1							
	1..3		16653000-03S01	13120009898163	198747	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16-71444	1312000990418LE	181205	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16829160-25	13120001040181LE	198747	...BUSHING, TORQUE ARM (RPR)	14	1	AR1EA						
	1..3		IN.P.L.	IN.S.L.		...CYLINDER	11	1							
	1..1		125-4204-4	11620009642818	182918	...CYLINDER ASSY	11	1	EA						
	1..2		136-7090-1	11620009642818	182918	...INSERT AXLE	11	1	EA						
	1..2		IN.P.L.	IN.S.L.		...CYLINDER SUBASSY	11	1							
	1..3		16653000-03S01	13120009898163	198747	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16-71444	1312000990418LE	181205	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16829160-25	13120001040181LE	198747	...BUSHING, TORQUE ARM (RPR)	14	1	AR1EA						
	1..3		IN.P.L.	IN.S.L.		...CYLINDER	11	1							
	1..1		125-4204-4	11620009642818	182918	...CYLINDER ASSY	11	1	EA						
	1..2		136-7090-1	11620009642818	182918	...INSERT AXLE	11	1	EA						
	1..2		IN.P.L.	IN.S.L.		...CYLINDER SUBASSY	11	1							
	1..3		16653000-03S01	13120009898163	198747	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16-71444	1312000990418LE	181205	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16829160-25	13120001040181LE	198747	...BUSHING, TORQUE ARM (RPR)	14	1	AR1EA						
	1..3		IN.P.L.	IN.S.L.		...CYLINDER	11	1							
	1..1		125-4204-4	11620009642818	182918	...CYLINDER ASSY	11	1	EA						
	1..2		136-7090-1	11620009642818	182918	...INSERT AXLE	11	1	EA						
	1..2		IN.P.L.	IN.S.L.		...CYLINDER SUBASSY	11	1							
	1..3		16653000-03S01	13120009898163	198747	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16-71444	1312000990418LE	181205	...BUSHING, TOM LUG (RPR)	12	1	AR1EA						
	1..3		16829160-25	13120001040181LE	198747	...BUSHING, TORQUE ARM (RPR)	14	1	AR1EA						
	1..3		IN.P.L.	IN.S.L.		...CYLINDER	11	1							

B-52 MAIN
LANDING GEAR ASSY (AFT)
PCN 17143A
WCD 16003N



16003N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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 4S-1-182 R491-57-2	9. ITEM SERIAL NO.
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10 MODEL DESIGN SERIES B-52 MAIN	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN STRUT ASSY	17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
7027648-190		1620001398473 17142A			
7027648-210		1620001398474 17143A			
		GOVERNING DIRECTIVES: AFLOR 66-51 MANDI 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 959. 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.			
		REGD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-648-183

16003N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP.			
	001	7027648-190 7027648-210			
	010	*MATCH-UP* ROUTED COMPONENTS NEW/SERVICEABLE REWORK NO REWORK OUTER CYL.		001 MNRGP 002 06 003 MU01	
		16001N PISTON 16002N CAM			
		16010N CAP TRUNNION 16012N PSIN HD NUT			
		16014N N O T E : THERE ARE 12 MISC DOCUMENTS			
	500	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING 958 THIS PACKAGE *C/P MOVE	10	001 MNRGP 002 06 003 MU01	
	501	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FOREIGN MATERIAL PRIOR TO REASSEMBLE. *C/P MOVE	30	001 MNRGP 002 06 003 SA03	
	502	REASSEMBLE INTERNAL PARTS PRIOR TO INSTALLING TRUNNION CAPS COAT THE TRUNNION BEARING AREA WITH MIL-S-81733 CLASS A TYPE 1-1/2 IN ADDITION TO THE ZINC CHROMATE PRIMER TYPE 1-2 IS A SUITABLE SUBSTITUTE IF (CONTINUED)	150	001 MNRGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1968-946-113

16003N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 PAGE 3 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 STRUT ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TYPE 1-1/2 IS NOT AVAILABLE TRUNNION CAP SMALL O.D. 4.746/4.742			
		TRUNNION CAP LARGE O.D. 4.846/4.842 *C/P MOVE			
	504	OK TO CLOSE AND/OR ASSEMBLE *REQD* @*@*@*@*@*@* N O T E "@*@*@*@*@*@*@* USE ONLY AXLE NUT WITH P/N MS21025 OR LETTER "X" STAMPED NUT @*@*@*@*@*@*@*@*@*@*@*@*@*@*@*@*@*@* *C/P MOVE	6	001 MNRGP 002 06 003 SA03	
	505	CAM ALIGNMENT *C/P MOVE *REQD*	3	001 MNRGP 002 06 003 SA0J	
	506	CHECK STROKE IAW T.O. *REQD* *C/P MOVE XXXXXXXXXX((" N O T E "))XXXXXXXXXX TORQUE ALL NUTS & BOLTS IAW T.O. XX	3	001 MNRGP 002 06 003 SA03	
	507	PRESSURE TEST *C/P MOVE *REQD*		001 MNRGP 002 06 003 TL07	
	509	TEST TRUNNION PORTS IAW T.O CHANGE *REQD* *C/P MOVE		001 MNRGP 002 06 003 TL07	
	511	*MATCH-UP* -----ROUTED COMPONENTS----- *REQD* NEW/SERVICEABLE REWORK NO REWORK (CONTINUED)		001 MNRGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1986-846-103

16003N 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 STRUT ASSY						
18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		STEERING BEARINGS 16004N LOWER TRIPOD							
		16005N OUTER TRIPOD							
		16006N INNER TRIPOD							
		16007N STEERING PLATES							
		16008N TORQUE ARM							
		16009N JACK SHAFT ASSY							
		16017N							
	513	PRE-FINAL INSPECTION						001 MNR GP 002 06 003 FA08	
	REQD								
	514	ASSEMBLE		*C/P MOVE				001 MNR GP 002 06 003 FA08	
	REQD								
	515	MASK, PRIME AND PAINT						001 MNR GP 002 09 003 WB03	
	REQD	*C/P MOVE							
	520	DECALS						001 MNR GP 002 09 003 WB03	
	REQD	*C/P MOVE							
	535	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY						001 MNR GP 002 09 003 WB03	
	REQD								
	540	FINAL PRODUCT VISUAL INSPECTION						001 MNR GP 002 09 003 WB03	
	REQD	*C/P MOVE							

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

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

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DATE 89046

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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 1. 45-1-182 2. 451-57-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES R52 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER ASSY	17142A
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18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 7027516-10		NSN C/N 17142A 17143A			

UNIT COST: \$19030.00
 ORDER AND DELIVERY: ...

FPI IAW MIL-SID-2865
 STRIP ANODIZE IAW MIL-SID-87
 SHOT FILM IAW MIL-S-10-55
 ANODIZE IAW MIL-A-48-15

BLAST IAW MIL-SID-1504
 BRUSH PLATE IAW MIL-S-70-865
 45-1-182
 GLOVE IAW MIL-C-5541

FLAME SPRAY IAW MIL-SID-1504

ALL PERSONNEL INVOLVED IN THE WORK PROCEDURE SHOULD BE TRAINED IN THE PROPER BEHAVIOR TO AVOID ACCIDENTS AND FAMILIAR WITH ALL RELEVANT SAFETY PRACTICES AND PROCEDURES.

THE PROTECTIVE EQUIPMENT REQUIRED FOR THIS WORK IS LISTED IN THE APPROPRIATE TECHNICAL DRAWINGS AND SPECIFICATIONS.

WILL ALWAYS BE WORN AND USED IN ACCORDANCE WITH THIS DOCUMENT.
 *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (O/P MOUNTED) BEFORE MOVES BETWEEN OPERATIONS/MAINTENANCE 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/BN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

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

16001N WORK CONTROL DOCUMENT (MEDS)

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 DUTER LYLE INC
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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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		PERSONNEL TO BE EMPLOYED MUST BE EMPLOYED TO PRECLUDE INJURIES.			
--	--	---	--	--	--

		APPROXIMATE DURATION (PERCENT) IN COLUMN 16 IS SUBJECT TO DELTA STAFF			
--	--	---	--	--	--

	001	7072512-10			
--	-----	------------	--	--	--

		1. DISASSEMBLE NOTE: REMOVE ALL BUSHINGS. CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS:		001 MNP SW 002 02 003 AN03 004 45245250	
--	--	--	--	--	--

		25-2101-500 25-2101-500 25-2101-500 25-2101-500		001 MNP SW 002 03 003 45245250	
--	--	--	--	--------------------------------------	--

		2. DISASSEMBLE NOTE: REMOVE ALL BUSHINGS. CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS:		001 MNP SW 002 03 003 45245250	
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		3. DISASSEMBLE NOTE: REMOVE ALL BUSHINGS. CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS:		001 MNP SW 002 03 003 45245250	
--	--	--	--	--------------------------------------	--

		4. DISASSEMBLE NOTE: REMOVE ALL BUSHINGS. CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS:		001 MNP SW 002 03 003 AN03	
--	--	--	--	----------------------------------	--

		5. DISASSEMBLE NOTE: REMOVE ALL BUSHINGS. CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS:	M	001 MNP SW 002 05 003 ZY05	
--	--	--	---	----------------------------------	--

		E & I INSPECTION CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS: (CONTINUED)		001 MNP SW 002 04 003 EI01	
--	--	---	--	----------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-448-160

16001N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89046

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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 ...
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		25-4201-507 25-4201-509 5-60321-12			
--	--	--	--	--	--

		5-4201-1-90 OIL MOTOR OIL CHANGER 1157 FOR BU-1180 ... 5-60321-12			
--	--	--	--	--	--

		1.536/1.251 W/69 1.252 1.536/1.251 W/69 1.252 1.536/1.251			
--	--	---	--	--	--

		1.536/1.251 W/69 1.252 1.536/1.251 1.536/1.251			
--	--	--	--	--	--

		1.536/1.251 W/69 1.252 1.536/1.251 1.536/1.251			
--	--	--	--	--	--

		WEAR 1.2525 ACTUATOR LUG (LARGE) 1.750/1.7510 1.750/1.7525 3-17-111-1 CHECK FOR BAGG METAL			
--	--	---	--	--	--

		1.536/1.251 W/69 1.252 1.536/1.251 1.536/1.251			
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		OUTBOARD TRIPOD LUGS 1.536/1.409 INBOARD TRIPOD LUGS 1.4375/1.4705			
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		LOWER TRIPOD LUGS 1.750/1.784 STEERING LUG 1.750/1.822			
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		ACTUATOR LUG (SMALL) 1.536/1.570			
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(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

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

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 PLATE
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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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		ACTUATOR LINKS (LINK 2, 3, 4, 5, 6, 7)			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			
		DRUM ACTUATOR FIG 2-2 INDEX 144, 145			

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
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1 DATE 89046

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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 DUTY CYLINDER ASSY
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C"
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		REMOVE BURRS FROM HOLES .4308/.4406			
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		NOTE: REMOVE ALL TUSHINGS IF WELL SAWY AND CHECK TO SEE THAT ALL BURRS REMOVED FROM TRUNNION END AND ALL TUSHINGS ARE REMOVED			
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		NOTE: TO A COMPLIANCE OF SHOT PEEN ON O.B. IS MANDATORY. ALL SURFACES TO BE APPROXIMATELY 40-50 AIR UNITS AT LEAST TWO FEET FROM PEENING			
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		*C/P MOVE			
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69	060	OUTBOARD TRUNNION COUNTER BORE REPAIR FIG 2-16 2 15" MACHINE TO ID 1.275 1.085 1.174 270/28.030 63RM *C/P MOVE		001 MNRA 002 03 003 MH04 005 X863363	
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69	065	INBOARD TRUNNION HYDRAULIC TUBE REPAIR AN 1601 2 23 PARA 2-32 FIG 2-15		001 MNRA 002 03 003 MH04 005 X863363	
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69	070	KEYWAYS CENTERING CAM REPAIR MACHINE NEW KEYWAYS TAN FIG 2-24 125 RMS *C/P MOVE		001 MNRA 002 03 003 MH04 005 X863363	
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69	080	REMOVAL OF OLD DAMAGED KEYWAYS TAN FIG 2-24 MACH KEYWAYS WITH A 35 TO 1 RUNOUT TO BOTTOM OF KEYWAYS STAMP AFTER S/N 125 RMS *C/P MOVE		001 MNRA 002 03 003 MH04 005 X863363	
----	-----	--	--	---	--

69	100	OUTBOARD TRUNNION REPAIR REPAIR TAN PAGE 2-30 PARA 2-29 FIG 2-23 T.O. 451-57-3 63RMS (CONTINUED)		001 MNRA 002 03 003 MH04 005 X863363	
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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	16001N
		B	D	

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16001N 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 OUTBOARD TRUNNION RADIUS
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WORK MOVE			
69	110	INBOARD TRUNNION REPAIR. REPAIR TO PAGE 2-30 PARA 2-27 FIG 2-27 T.D. 1.009-1.010 61745 NO/P MOVE		001 MNR RA 002 03 003 MH04 005 X8433620	
69	120	OUTBOARD TRUNNION RADIUS REPAIR TO FIG 2-23; STAMP LETTER "T" 125 PMS NO/P MOVE		001 MNR RA 002 03 003 MH04	
69	130	INBOARD TRUNNION RADIUS REPAIR FIG 2-23 PARA 2-29		001 MNR RA 002 03 003 MH04	
69	240	ORIFICE TUBE HOLE REPAIR IAW FIG 2-27 CLEANUP TO 1.009/1.010 OR 1.145 1.045 FIG 2-27 001.0015 END OF LINE AND ROLL TO MIN I.D. 63 RMS NO/P MOVE		001 MNR RA 002 03 003 MH04 005 X8433620	
69	260	OUTBOARD TRIPOD LUG HOLE REPAIR LINE BORE AND ROLL MAX ID 1.407 63 RMS NO/P MOVE		001 MNR RA 002 03 003 MH04 005 X8433620	
69	280	INBOARD TRIPOD LUG HOLE REPAIR LINE BORE AND ROLL MAX ID 1.705 63 RMS NO/P MOVE		001 MNR RA 002 03 003 MH04 005 X8433620	
69	300	LOWER TRIPOD LUG HOLE REPAIR. LINE BORE AND ROLL MAX ID 1.780 63 RMS NO/P MOVE		001 MNR RA 002 03 003 MH04 005 X8433632	
69	320	STEERING LUG HOLE REPAIR (INBOARD) LINE BORE AND ROLL TO MIN I.D. 1.750 63 RMS PARA 2-38 (CONTINUED)		001 MNR RA 002 03 003 MH04 005 X8433632	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-56-103

16001N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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 4504	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		*C/P MOVE			
69 ✓	340	STEERING LUG HOLE REPAIR (OUTBOARD) LINE BORE AND ROLL TO MIN T.D 63 RMS PARA 2-36 *C/P MOVE		001 MNRRA 002 03 003 MH04 005 X8433632	
69 ✓	360	STEERING LUG COUNTERBORE REWORK IAW PARA 2-36 AND 2-37 AND FABRICATE SPECIAL POSITION FROM FIG 2-19 63RMS *C/P MOVE P/N 29-21477-1 P/N 39-21477-2 P/N 39-21477-8 P/N 39-21477-3		001 MNRRA 002 03 003 MH04 005 X8433632	
		P/N 66-03000-595 P/N 35130-502 P/N 39-21477-10 P/N 39-21477-11			
		P/N 39-21477-12 P/N 66E33000-595			
69 ✓	380	ACTUATOR LUG HOLE REPAIR (SMALL) LINE BORE AND ROLL TO MAX ID 1.501 63 RMS *C/P MOVE		001 MNRRA 002 03 003 MH04 005 X8433632	
69 ✓	400	ACTUATOR LUG HOLE REPAIR (LARGE) LINE BORE AND ROLL TO MAX ID 2.071 63 RMS *C/P MOVE		001 MNRRA 002 03 003 MH04 005 8633632	
69 ✓	420	ACTUATOR LUG KEY SLOT REPAIR IAW PARA 2-36 AND FIG 2-18 AND FABRICATE PLATE FROM 4540 STEEL, HEAT TREAT 160,000/180,000 PSI 63RMS *C/P MOVE P/N 011 (CONTINUED)		001 MNRRA 002 03 003 MH04 005 X8433632	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
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* U.S. GOVERNMENT PRINTING OFFICE: 1989-66-103

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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 QUIET CYL LUG HOLES
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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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		PAN 011			
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69	425	DOOR ACTUATOR LUG REPAIR INDEX 146 REAM HOLES TO P DIA OF .350/.362 ROLL BURNISH HOLES TO A DIA .309/.315 63RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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69	430	DOOR ACTUATOR LUG REPAIR (5 EA) INDEX 144/145 REAM HOLES TO A DIA OF .350/.362 ROLL BURNISH HOLES TO A DIA .309/.315 63RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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69	440	DOOR ACTUATOR LUG HOLE REPAIR (5 EA) INDEX 144/145 MACH TO CLEANUP FOR BURNISHES 2 ROLL BURNISH MACH TO .350/.362 63RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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69	443	REAM LUG HOLE INDEX 147 TO .308/.310 & ROLL BURNISH TO .309/.315 63 RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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69	446	O/S LUG HOLE INDEX 147 TO .312/.313 & ROLL BURNISH TO .3145/.3175 63RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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69	460	REAM LUG HOLE INDEX 148 TO .342/.344 & ROLL BURNISH TO .340/.345 63 RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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69	470	O/S LUG HOLE INDEX 148 TO .370/.380 & ROLL BURNISH TO DIA INCREASE .381/.3815 63RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
----	-----	---	--	---------------------------------	--

69	480	REAM LUG HOLE INDEX 151 TO .257/.259 & ROLL BURNISH TO .2580/.2605 63 RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
----	-----	---	--	---------------------------------	--

69	490	O/S LUG HOLE INDEX 151 TO .2651/.2661 & ROLL BURNISH TO .2694/.2704 63 RMS *C/P MOVE		001 MNFRA 002 03 003 BE01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-348-803

16001N 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 ASST						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	500	REAM LUG HOLE INDEX 150 (4EN) TO .1935/.1955 & ROLL BURNISH TO .1970 COLD WORK FINAL SIZE .2050/.2078 40/P MOVE						001 MNFRA 002 03 003 BE01	
69	502	REAM LUG HOLE INDEX 149 TO .1969/ .1977 IF NOT FOUND GO TO 1ST OR 2ND OR 3RD OR 4TH ROLL BURNISH TO .1970/.1970 2ND OR 3RD ROLL BURNISH TO .1970/.1970 40/P MOVE						001 MNFRA 002 03 003 BE01	
69	504	UPPER STEERING JOURNAL MACHINE OFF ONLY ENOUGH MATERIAL TO REMOVE DEFECT MAX OF .07 INCH DEPTH 40/P MOVE						001 MNFRA 002 03 003 LE13 005 X843362	
69	506	LOWER STEERING JOURNAL MACHINE OFF ONLY ENOUGH MATERIAL TO REMOVE DEFECT MAX OF .07 INCH DEPTH 40/P MOVE						001 MNFRA 002 03 003 LE13 005 X843362	
69	508	NICK AND BURR DAMAGED AREA ONLY LAW T.O. 4S1-57-3 FIG 2-20 AND PARA 2-23 FOR EXTERNAL AND PARA 2-32 FOR INTERNAL						001 MNFRA 002 03 003 BE01	
69	521	POLISH CYLINDER I.D. UPPER BORE NOT TO EXCEED .006 IN DEPTH MAX BTM OF 9.245						001 MNFRA 002 03 003 BE01	
		<div style="background-color: black; width: 100px; height: 15px; margin-bottom: 5px;"></div> <p style="text-align: center;">40/P MOVE</p> <p style="text-align: center;">***** N O T E *****</p> <p style="text-align: center;">IF LAST NO. OPERATION IS COMPLETE</p> <p style="text-align: center;">HERE, TAKE PRODUCTION COUNT.</p> <p style="text-align: center;">*****</p>						001 MNFRA 002 05 003 ZY05	
SG	525	HONE CYL I.D. UPPER BORE MAX. DEFECT 9.245/9.257 40/P MOVE						001 MNFRB 002 03 003 HV04 005 X8745190	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		16001N				
		B	D						

* U.S. GOVERNMENT PRINTING OFFICE: 1968-648-143

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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 DUP-2-1000RHP ASSY	

15 DISPATCH STATION	16 PERFORM RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
25	527	REMOVE ALL RHP MOVES		001 MHP RL 002 03 003 B501	
26	530	SHOT PEEN 1.10 OF OUTBOARD TRUNNION FOR 6M HOLE TO REMOVE CORROSION AS PER MIL PARA 2-30 ALL MOVES		001 MHP RL 002 03 003 B501	
26	540	SHOT PEEN EXTERNAL SURFACES COMPLETE NOTE: 100% COMPLIANCE IS MANDATORY. *C/P MOVE		001 MHP RL 002 01 003 B501	
26	550	SHOT PEEN ID IF PITS ARE LESS THAN .006 IN DEPTH .020/.025 SIZE CW-28 COVERAGE OF 150% TO 400% *C/P MOVE		001 MHP RL 002 01 003 B501	
26	550	SHOT PEEN ALL REMOVED AREAS ONLY *C/P MOVE		001 MHP RL 002 01 003 B501	
26	560	GRIT BLAST AFTER SHOT PEEN TO REMOVE 80% TO 95% OF SHOT PEEN DEPRESSION *C/P MOVE		001 MHP RL 002 03 003 B501	
26	570	POLISH SHOT PEENED BEARING LANDS LARGE TRUNNION LANDS 4.658/4.660 SMALL TRUNNION LANDS 4.658/4.660 *C/P MOVE		001 MHP RL 002 03 003 B501	
26	580	POLISH SHOT PEENED BEARING LANDS STEEL NG BEARING 10.875/10.878 *C/P MOVE		001 MHP RL 002 01 003 B501	
		[REDACTED] *C/P MOVE		001 MHP WW 002 08 003 B502	
		[REDACTED] GRIT BLASTING 180 ALUMINUM OXIDE *C/P MOVE		001 MHP WW 002 08 003 B501	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
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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 ASSY
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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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		USING METCO ALUMINUM TO ALLOW FINAL MACH TO 10.875/10.878 OD 1.810/1.813 WIDTH .09/.12 RADIUS IN SHOULDERS		001 MNFWW 002 08 003 F004 005 X8929475	
--	--	--	--	---	--

		*C/P MOVE			
--	--	-----------	--	--	--

		LOWER JOURNAL USING METCO ALUMINUM TO ALLOW FINAL MACH TO 10.875/10.878 OD 1.810/1.813 WIDTH .09/.12 RADIUS IN SHOULDERS		001 MNFWW 002 08 003 F004 005 X8929475	
--	--	--	--	---	--

		*C/P MOVE			
--	--	-----------	--	--	--

69	610	MACHINE UPPER STEERING JOURNAL TO 10.875/10.878 OD 1.810/1.813 WIDTH A .09/.12 INCH RADIUS IN SHOULDERS 32 RMS FINISH *C/P MOVE		001 MNFWW 002 03 003 LE02 005 X8929475	
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69	615	MACHINE LOWER STEERING JOURNAL TO 10.875/10.878 OD 1.810/1.813 WIDTH A .09/.12 INCH RADIUS IN SHOULDERS 32 RMS FINISH *C/P MOVE		001 MNFWW 002 03 003 LE02 005 X8929475	
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69	620	APPUZZE CYLINDER COMPLETE TYPE LE *C/P MOVE		001 MNFWW 002 03 003 LE02 005 X8929475	
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69	630	ALDINE REMOVED AREAS ONLY *C/P MOVE		001 MNFWW 002 03 003 TA01	
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69	650	FLANGED BUSHINGS INSTALLATION SHALL HAVE A MIN OF 10% FLANGE CONTACT MAX .020 ALLOWABLE GAP. SEAL GAP WITH MIL-S-8802 B-2 81349 REF. 491-57-3		001 MNFWW 002 03 003 LE02	
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69	675	MACHINE INBOARD TRIPOD LUG BUSHING O.D. TO FIT HOLE P/N 35-24491-21 (CONTINUED)		001 MNFWW 002 03 003 LE02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16001N

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U.S. GOVERNMENT PRINTING OFFICE: 1989-508-802

16001N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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 LUG END R ASST
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18. DISPATCH STATION	19. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		P/N 35-24491-22 P/N 35-24491-23 P/N 35-24491-24 P/N 60030001-920			
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69	680	INBOARD TRIPOD LUG BUSHING INSTALLATION 35-24491 FROM 17-18-19-20 FOR CENTER LUG OR MORE TAW FID - P. FINISH REAM 1.250/1.250 0.0001			
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		RECORD WEAR DIM IF REMOVT LIMITS ARE EXCEEDED			
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		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
--	--	--	--	--	--

69	690	MACHINE OUTBOARD TRIPOD LUG BUSHINGS O.D. TO FIT HEADS P/N 35-24491-11 P/N 35-24491-12 P/N 35-24491-13 P/N 35-24491-14 P/N 35-24491-15 P/N 35-24491-16 P/N 35-24491-17 P/N 35-24491-18 P/N 35-24491-19 P/N 35-24491-20 P/N 60030001-920			
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		RECORD WEAR DIM IF REMOVT LIMITS ARE EXCEEDED			
--	--	---	--	--	--

		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
--	--	--	--	--	--

69	700	OUTBOARD TRIPOD LUG BUSHING INSTALLATION P/N 35-24491 FOR CENTER LUG-17-18-19-20 FOR OUTSIDE LUG, OR MORE TAW FID - P. FINISH REAM 1.250/1.250 0.0001			
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		RECORD WEAR DIM IF REMOVT LIMITS ARE EXCEEDED			
--	--	---	--	--	--

		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
--	--	--	--	--	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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DISPATCH	FUNCTIONAL CODE	A	C	16001N	
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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
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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 ASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	710	MACHINE LOWER TRIPOD LUG BUSHINGS O.D. TO FIT HOLES TO FIT MOVE P/N 35-24491-5 P/N 35-24491-3 P/N 35-24491-1		001 MNRA 002 03 003 LEO2	
		P/N 35-24491-5 P/N 35-24491-3 P/N 35-24491-1 P/N 35-24491-1			
69	720	LOWER TRIPOD LUG BUSHING INSTALLATION 35-24491 FOR OUTSIDE LUG 1-1-3-A FOR INSIDE LUG, OR MAKE LUG FIT TO BE USED IN BEAM 1 & 5 (1.625) (PARA 2-56.2) 63RMS		001 MNRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS TO/F MOVE			
69	730	MACHINE INBOARD ACTUATOR LUG BUSHING O.D. TO FIT HOLE TO/F MOVE P/N 39-21477-1 P/N 39-21477-2 P/N 39-21477-3 P/N 66033000-635		001 MNRA 002 03 003 BE01	
69	740	INBOARD ACTUATOR LUG BUSHING INSTALLATION 39-21477 OR MAKE IAW FIG 2-28 PRESS FIT .001/.002. FINISH LINE PEAK 1.750/1.751 (PARA 2-56.2) 63RMS		001 MNRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

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16001N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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 HOPER CYLINDER ASSY
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18. DISPATCH STATION	18. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
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69 y	750	MACHINE OUTBOARD ACTUATOR LUG BUILDING TO FIT HOLES P/N 3-51172-1 P/N 3-51173-1		01 01 RA 02 03 00 1502	
		P/N 392117-2 P/N 39-2117-2 P/N 35E 009-111			

69 C	760	OUTBOARD ACTUATOR LUG BUSHING INSTALLED FOR JN 2 477 MAKE IAW FIG 2-29 1.500/1.501 (DATA 2-56.2) 63RMS		01 01 RA 02 05 00 1501	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			

		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
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69	770	MACHINE STEERING LUG BUSHINGS O.P. TO FIT HOLES.		01 01 RA 02 05 00 1501	
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69	780	STEERING LUG BUSHING INSTALLATION 39 21477 (LONG) (SHORT) OR MAKE IAW FIG 2-29 FINISH LINE ROOM 1.500/1.501 (DATA 2-56.2) 63RMS		01 01 RA 02 05 00 1501	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			

		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

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1 DATE 89046

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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 GUTER (V) INTEL (R) ASBY
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18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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69	720	TAP OUT THREADS 6 EA HOLES IN TRUNNION 1B AND 3 EA ON SIDE. IF REQUIRING HELICOILS GO TO OP 800 100% MOVE		001 MNFRA 002 03 003 BE01	
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69	800	INSTALL HELICOILS AND OTHER STEEL PARTS AS NEEDED 100% MOVE		001 MNFRA 002 03 003 BE01	
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69	810	MACHINE DOOR ACTUATING LUG BUSHING D.G. TO FIT HOLES 100% MOVE P/N 855971 107 P/N 855971 107		001 MNFRA 002 03 003 LE02	
----	-----	--	--	---------------------------------	--

69	820	DOOR ACTUATING LUG BUSHING INSTALLATION (5 EA) INDEX 144/145 MFG FROM 4130 STEEL H.T. 125,000/145,000 PSI (SEE PRINT NAS75-6 PAGE 2-43 PRESS		001 MNFRA 002 03 003 BE01	
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		FIT .0017-.002 FINISH REAM TO L.D. .201-.205 .53 RMS RECORD WEA ITEM IF REMARK LIMITS ARE EXCEEDED			
--	--	--	--	--	--

		RECORD REASON & CAUSE FOR EXCEEDING REMARK LIMITS			
--	--	---	--	--	--

69	840	MACHINE OVERSIZE DRIFTE DUE BUSHING FOR FIG 3-22, 4130, 4840. 4130 STEEL H.T. 125,000/145,000 PSI (SEE PRINT NAS75-6 PAGE 2-43 PRESS		001 MNFRA 002 03 003 LE02	
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		*** ** ** ** ** GAD PLATE AND MAKE 3 HRS AT 350 100% P/N 855971			
--	--	--	--	--	--

		P/N 855971 P/N 010			
--	--	-----------------------	--	--	--

	920	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFRA 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	16001N
		B	D	

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16002N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MHPGP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 1. 4S-1-182 2. 4S1-52-3	9. ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES B-52 MAIN	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN CYLINDER ASSY	17142A

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
5-85123-6		1620006582588 17142A			
25-4204-1		1620006525469 17143A			
25-4204-1		1620007838033			
25-4204-4		N.S.L.			
25-4204-5		N.S.L.			
		***** UNIT COST: \$4664.00 *****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		FMPJ IAW MIL-STD-1949			
		P/D N01561			
		STRIP CHROME IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		GRIT BLAST IAW MIL-STD-1504			
		CHROME PLATE IAW MIL-STD-1501			
		CAD PLATE IAW MIL-STD-870			
		BAKE IAW 4S-1-182			
		MAOI 74-12			
		FPI IAW MIL-STD-6066			
		VAC IVD ALUM PLATE IAW MIL-C-83488A			
		POLYURETHANE PRIMER IAW MIL-P-23377			
		POLYURETHANE PAINT IAW MIL-C-27725			
		ALODINE IAW MIL-C-5541			
		*****STEEL 220,000/240,000 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 (CONTINUED)			

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1989-548-10

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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
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN CYLINDER ASSY
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15 DISPATCH STATION	16 PERP RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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		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 PERSONNE. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
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		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
--	--	---	--	--	--

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	001	5-85123-6 25-4204 25-4204-1 25-4204-4 25-4204-5			
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		DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS. *REQD*		001 MNP GW 002 02 003 MI 03 005 X8745250 006 X8745234	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/EN
DISPATCH	A	16002N
FUNCTIONAL CODE	C	
	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-0-66-185

16002N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 * 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 CYLINDER ASSY						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		CHEM CLEAN *C/P MOVE					001 MNP	GW	
	REQD						002 03		
							003 SLO1		
		BLAST CLEAN ONLY *C/P MOVE					001 MNP	GW	
	REQD						002 03		
							003 BLO1		
		BAKE 4HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNP	GW	
	REQD						002 03		
							003 BK03		
		"NOTE"				M	001 MNP	PNA	
	REQD	WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2 *C/P MOVE					002 05		
							003 ML04		
		E & J INSPECTION					001 MNP	GW	
	REQD	BORE SEAL I.D. 7.732/7.735/7.740 MAX					002 04		
							003 EIO1		
		PISTON O.D. 8.475/8.497							
		PISTON I.D. 7.817/7.826							
		AXLE JOURNAL #1 4.998/4.999							
		AXLE JOURNAL #2 4.998/4.999							
		AXLE JOURNAL #3 5.248/5.249							
		AXLE JOURNAL #4 5.248/5.249							
		TORQUE ARM LUGS I.D 1.751/1.7525							
		JACK PAD BOLT HOLE I.D. .266/.270 (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16002N	
		B	D		

* U.S. GOVERNMENT PRINTING OFFICE: 1968-0-346-183

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DATE 89046

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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 CYLINDER ASSY
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18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		TOWING LUG HOLES I.D. .515/.535 ***** N O T E ***** IF AXLE THREAD AREA IS CRACKED INITIATE OPERATIONS 272 & 630 ***** N O T E ***** * A MINIMUM OF AT LEAST TWO FMPI'S * IS REQUIRED. ***** *C/P MOVE			
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69	100	BRAKE MOUNTING BOLT HOLE CRACK REPAIR: CUT A SLOT .100 INCH WIDE TO REMOVE CRACK. THIS WORK IS ONLY ALLOWED ON 1 EACH HOLE PER SIDE *C/P MOVE		001 MNPRA 002 03 003 MH04	
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69	120	JACK PAD BOSS REPAIR IAW FIG 2-26, 125 RMS *C/P MOVE		001 MNPRA 002 03 003 DR05 005 X874554	
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69	140	WELD SPLATTER REWORK INSIDE DIAMETER MACHINE WELD SPLATTER IAW 4S1-57-3 NOTE: IS NOT MACHINED REFER TO OPERATION #902 AND STAMP TO BE GPIT BLASTED. ALSO OPERATION #990 FOR POLYURETHANE PAINT. *C/P MOVE		001 MNPRA 002 03 003 BE01	
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69	150	MODIFY RETAINER NUT HOLES IAW FIG 2-27B WITH 63 RMS *C/P MOVE		001 MNPRA 002 03 003 DR05	
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69	160	REPAIR RETAINER NUT LOCK BOLT HOLES IAW FIG 2-27B PAGE 2-60C OR 2-60D OR 2-60E OR 2-60F *C/P MOVE		001 MNPRA 002 03 003 DR05	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-124

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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 CYLINDER ASSY
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18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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69	115	DRILL NEW RETAINER NUT LOCK BOLT HOLES I A W FIG 2-27B PAGE 2-60G *C/P MOVE		001 MNPRA 002 03 003 DR04 005 X863360	
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69	220	TORQUE ARM ATTACHING LUG REPAIR OVERSIZE LUG TO DIM OF 1.812/1.831 125 RMS *C/P MOVE		001 MNPRA 002 03 003 DR05	
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69	240	TOW LUG HOLE REPAIR FIRST OVERSIZE TO DIM OF .703/.706 *C/P MOVE		001 MNPRA 002 03 003 DR05	
----	-----	---	--	---------------------------------	--

69	260	TOW LUG HOLE REPAIR SECOND OVERSIZE MAX DIM OF .716 *C/P MOVE		001 MNPRA 002 03 003 DR05	
----	-----	--	--	---------------------------------	--

69	270	REPAIR HYDRAULIC FITTING HOLES 2-27C 300 RMS *C/P MOVE		001 MNPRA 002 03 003 MH04	
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69	272	CRACKS IN THE AXLE THREAD AREA MAYBE REMOVED BY MACHINING A NOTCH, .365/.385 WIDE AND .470/.530 LONG. MACHINE A .178/.198 RADIUS IN THE BASE OF THE NOTCH. NO MORE THAN TWO NOTCHES SHALL BE PERMITTED IN A 90 DEGREE QUADRANT, AND SHALL BE SPACED AT LEAST 1/4 APART. *C/P MOVE		001 MNPRA 002 03 003 MH04	
----	-----	--	--	---------------------------------	--

		REMOVE CRACK OR CRACK INDICATION IN INNER CYLINDER KEYWAY RADIUS BY POLISHING OR LIGHT GRINDING. WORK IN INCREMENTS OF .020 RADIUS UP TO A MAX OF .060 RADIUS 125 RMS NOTE: CHECK OPERATION 020 FOR SIGN (CONTINUED)	M	001 MNPNA 002 05 003 MS06	
--	--	---	---	---------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16002N	
		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 CYLINDER ASSY	

18. DISPATCH STATION	19. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		OFF OF RED DIAGONAL. *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
		[REDACTED] HOLE AND POLISHED THREADED AREA AND KEYWAY RADIUS. NOTE: CHECK OPERATION 020 FOR SIGN	M	001 MNPNA 002 05 003 MSD6	
		OFF OF RED DIAGONAL. *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26	278	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DGD1	
26	279	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	282	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	285	STRIP PISTON O.D. "NOTE" WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L." TO "R" 1-3-4-2 *C/P MOVE			

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		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 CYLINDER ASSY	

15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	300	STRIP AXLE JOURNAL #1 *C/P MOVE		001 MNPRC 002 02 003 SC02	
26	320	STRIP AXLE JOURNAL #2 *C/P MOVE		001 MNPRC 002 02 003 SC02	
26	340	STRIP AXLE JOURNAL #3 *C/P MOVE		001 MNPRC 002 02 003 SC02	
26	360	STRIP AXLE JOURNAL #4 *C/P MOVE		001 MNPRC 002 02 003 SC02	
86	375	FIRST GRIND PISTON O.D. MIN OF 8.481 *C/P MOVE * * * * * N O T E * * * * * WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2 * * * * *		001 MNPRB 002 03 003 GG01	
86	390	FIRST GRIND AXLE JOURNAL #1 MIN O.D. 4.984 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
86	405	FIRST GRIND AXLE JOURNAL #2 MIN O.D. 4.984 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
86	420	FIRST GRIND AXLE JOURNAL #3 MIN O.D. 5.233 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
86	435	FIRST GRIND AXLE JOURNAL #4 MIN O.D. 5.233 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
D:SPATCH	FUNCTIONAL CODE	A	C	16002N
		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 CYLINDER ASSY
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18. DISPATCH STATION	19. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "G"
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8	450	INNER CYLINDER BORE SEAL REWORK. INNER CYLINDER DAMAGE IN SEAL AREA MAY BE HAND POLISHED OR GROUND TO A MAX. DIA I.D. OF 7.740 *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X874518	
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8	465	FIRST GRIND SEAL AREA I.D. TO DIM OF 7.742/7.748 *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X874518	
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8	480	* * * * * "OPTIONAL" HONE PISTON I.D. MAX DIM OF 7.826 * * * * * "N O T E" ONLY IF SEAL AREA I.D. DOES NOT NEED TO BE GROUND		001 MNPRB 002 01 003 HV03 005 X874524	
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8	495	FIRST GRIND PISTON I.D. MAX DIM OF 7.826 *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X874518	
---	-----	---	--	--	--

		ALL MACHINED AND GROUND AREAS TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
--	--	---	---	---------------------------------	--

		* * * * * N O T E * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * + + + + + * * * * + * * * * + * * * * +			
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26B	520	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH 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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		"NOTE" WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2	M	001 MNPNA 002 06 003 ML04	
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		(CONTINUED)			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

BY U.S. GOVERNMENT PRINTING OFFICE: 1989-0-480-103

16002N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89046

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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 CYLINDER ASSY
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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 ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****			
26	550	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 IGO1	
26	560	SHOT PEEN JOURNAL #1 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	570	SHOT PEEN JOURNAL #3 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	580	SHOT PEEN AXLE JOURNAL #2 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	590	SHOT PEEN AXLE JOURNAL #4 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	600	SHOT PEEN KEYWAY INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	610	SHOT PEEN PISTON O.D. INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	620	SHOT PEEN SEAL AREA INTENSITY .006/.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	16002N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1985-048-103

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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 CYLINDER ASSY
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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26	630	SHOT PEEN ALL REWORKED AREA INTENSITY OF .008/.014 *C/P MOVE		001 MNPRC 002 01 003 SPO2	
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26	635	PREPARE SEAL AREA I.D. FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN _____ DATE OUT _____ MECHANIC SIGN OFF REQD _____		001 MNPRC 002 02 003 BE01 005 X7732114	
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26	640	CHROME PLATE SEAL AREA ID TYPE II CLASS 3. SUFFICIENT TO GRIND BACK TO DIM OF 7.732 TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE		001 MNPRC 002 02 003 CP01 005 X7732114 008 CI010	
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26B	650	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	
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26	655	PREPARE PISTON O.D. FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN _____ DATE OUT _____ MECHANIC SIGN OFF RE D _____		001 MNPRC 002 02 003 BE01 005 X7732108	
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26	660	CHROME PLATE PISTON OF CLASS 3 TYPE II TO SUFFICIENT TO GRIND BACK TO DIM OF 8.495/8.497 (CONTINUED)		001 MNPRC 002 02 003 CP01 005 X7732108	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		00800000/SH
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-646-103

16002N 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 CYLINDER ASSY
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18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE			
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		"NOTE"			
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		WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2			
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26	675	PREPARE AXLE JOURNAL #1 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN _____ DATE OUT _____ MECHANIC SIGN OFF REQD _____		001 MNPRC 002 02 003 BED1 005 X7732108	
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26	680	CHROME PLATE AXLE JOURNAL #1 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 4.998/4.999		001 MNPRC 002 02 003 CPD1 005 X7732108	
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		TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE		008 CD020	
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26	690	PREPARE AXLE JOURNAL #3 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN _____ DATE OUT _____ MECHANIC SIGN OFF REQD _____		001 MNPRC 002 02 003 BED1 005 X7732108	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16002N	

		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 CYLINDER ASSY
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15. DISPATCH STATION	16. PERFORM RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	700	CHROME PLATE AXLE JOURNAL #3 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 5.248/5.249		001 MNPRC 002 02 003 CP01 005 X773210	
		TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE		008 CD030	
26	720	PREPARE AXLE JOURNAL #2 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN _____ DATE OUT _____		001 MNPRC 002 02 003 BE01 005 X773210	
		MECHANIC SIGN OFF REQD _____			
26	740	CHROME PLATE AXLE JOURNAL #2 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 4.998/4.999		001 MNPRC 002 02 003 CP01 005 X773210	
		TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE		008 CD040	
26	750	PREPARE AXLE JOURNAL #4 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN _____ DATE OUT _____		001 MNPRC 002 02 003 BE01 005 X773210	
		MECHANIC SIGN OFF REQD _____			
26	760	CHROME PLATE AXLE JOURNAL #4 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 5.248/5.249		001 MNPRC 002 02 003 CP01 005 X773210	
		TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE		008 CD050	

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 CYLINDER ASSY
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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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26B	780	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE 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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BG	790	FINISH GRIND PISTON O.D. FINISH GRIND TO DIM OF 8.495/8.497 16/32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
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		"NOTE" WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2			
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BG	800	FINISH GRIND AXLE JOURNAL #1 FINISH GRIND TO DIM OF 4.998/4.999 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
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BG	810	FINISH GRIND AXLE JOURNAL #2 FINISH GRIND TO DIM OF 4.998/4.999 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
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BG	820	FINISH GRIND AXLE JOURNAL #3 FINISH GRIND TO DIM OF 5.248/5.249 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
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BG	830	FINISH GRIND AXLE JOURNAL #4 FINISH GRIND TO DIM OF 5.248/5.249 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
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B	840	FINISH GRIND I.D. SEAL AREA FINISH DIM OF 7.732/7.735 63 RMS *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X8745180	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

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16002N WORK CONTROL DOCUMENT (MEDS)

DATE 89048

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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 CYLINDER ASSY
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "F"	20. "Q"
26B	880	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	

		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	895	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
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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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26	902	ABRASIVE BLAST WELD SPATTER BELOW INNER SEAL AREA 300% COVERAGE *C/P MOVE		001 MNPRC 002 01 003 BL02	
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26	905	BLAST TO REMOVE RUST OR CORROSION ON I.D. OF AXLE BEFOR CAD PLATE *C/P MOVE		001 MNPRC 002 01 003 BL02	
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26	907	PRIOR TO CAD/IVD PLATE, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
				16002N
		B	D	

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16002N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046.

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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 CYLINDER ASSY
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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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26	910	CAD PLATE CLASS I TYPE II 7.6 SQ FT AT 380-532 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CAD1	
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26B	920	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATING DATE IN _____ TIME IN _____ DATE OUT _____ TIME IN _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
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26	930	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
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	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****	M	001 MNPNA 002 06 003 MLD4	
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26	937	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 920 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
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26	939	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16002N

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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 CYLINDER ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED.	18. MECHANIC	19. "P"	20. "Q"
69	940	JACK PAD BOSS STEEL INSERT. THIS IS DONE ONLY WHEN SHIM WAS INSERTED IN JACK PAD HOUSING. MAKE STEEL INSERT IAW BOEING DRAWING 36-7090-1 125 RMS *C/P MOVE P/N 367090-1		001 MNPRA 002 03 003 LE02	
69	945	INSTALL JACK PAD BOSS STEEL INSERT IAW DWG 36-7090-1		001 MNPRA 002 03 003 BE01	
69	949	MACHINE BUSHING O.D. TO FIT TORQUE ARM ATTACHING LUG .002 PRESS FIT *C/P MOVE P/N 48C29160-25		001 MNPRA 002 03 003 LE02	
69	950	TORQUE ARM ATTACHING LUG BUSHING INSTALLATION. INSTALL PRESS FIT TO .001/.003 FINISH LINE REAM TO DIM OF 1.751/1.752 125 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	959	MACHINE BUSHING O.D. TO FIT TOW LUG, PRESS FIT .001/.002 *C/P MOVE P/N 46C33000-03501 P/N 6-71444		001 MNPRA 002 03 003 LE02	
69	960	TOW LUG BUSHING INSTALLATION OR PRESS FIT .001/.002 FINISH LINE REAM TO .515/.535 125 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
34PP	990	PAINTE WELD SPLATTER WITH 2 EA COATS OF POLYURETHANE PRIMER & 2 COATS OF POLYURETHANE PAINT *C/P MOVE *REQD*		001 MNPGP 002 09 003 PP01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

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

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DATE 89048 PAGE 07 PAGE

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 CYLINDER ASSY
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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	995 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 06 003 SA03	
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	996 *REQD*	FINAL PRODUCT VISUAL INSPECTION # C/P MOVE		001 MNP GP 002 06 003 SA03	
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★ U.S. GOVERNMENT PRINTING OFFICE: 1989-648-113

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

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1 DATE 89046

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPGP	5 DATE SCHED	6 DATE COMPLETED
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7. PART NUMBER	8 TECH DATA 1. 4S-1-182 2. 4S1-57-3	9. ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES B-52 MAIN	11 STOCK NUMBER	12 OPTIONAL
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13. SERIAL NUMBER	14 NOUN CENTERING CAM ASSY	17142A 17142A
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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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P/N 25-4214-501	14-501	NSN 16520 20 31	C/N 17142A 17142A 722616		
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***** UNIT COST: \$774.00 *****
 GOVERNING DIRECTIVES: AFLCR 66-51
 MANOI 66-3
 FMPI IAW MIL-STD-1949

BAKE IAW 4S-1-182
 SILVER PLATE IAW QQ-S-365

PHOSPHATE COAT IAW DOD-P-16232
 BLAST IAW MIL-STD-1504
 STRIP SILVER IAW MIL-STD-871

*****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 (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
 (CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
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U.S. GOVERNMENT PRINTING OFFICE: 1989-64-143

16010N 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 CENTERING CAM ASSY
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18. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	25-4214-501			
		[REDACTED] DISASSEMBLE *C/P MOVE			001 MNPBW 002 02 003 MD03 005 X874523 006 X874525
	REQD				
		[REDACTED] CHEM CLEAN *C/P MOVE			001 MNPBW 002 03 003 SL01
	REQD				
		[REDACTED] BLAST CLEAN ONLY *C/P MOVE			001 MNPBW 002 03 003 RL01
	REQD				
		[REDACTED] BAKE 4 HRS AT 350-400F			001 MNPBW 002 03 003 BK03
	REQD	DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		[REDACTED]			001 MNPNA 002 05 003 MS03
	REQD	NOTE: IF CRACKED RECHECK ON OPERATION 130 AFTER MACHINING (CONTINUED)	M		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1968-648-143

16010N WORK CONTROL DOCUMENT (MEDS)

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 CENTERING CAM ASSY
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18. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		OPERATION. *C/P MOVEMENT SECTION			
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		E AND I INSPECTION IAW 2-21-14, PAGE 2-24B *C/P MOVE		001 MNP GW 002 04 003 EIO1	
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26	070	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DGO1	
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26	080	STRIP SILVER FROM FACE OF CAMS *C/P MOVE		001 MNPRC 002 03 003 SS01	
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69	100	CENTERING CAM KEY REPAIR IAW FIG 2-25 MACHINE A 45 CHAMFER 1/4 TO 3/8 IN LONG ON SILVER PLATED END OF LOWER CAM KEYS *C/P MOVE		001 MNPRA 002 03 003 BED1	
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69	105	CENTERING CAM KEY REPAIR IAW FIG 2-25 MACHINE A RADIUS ON KEYS OF LOWER & UPPER CAM TO REMOVE CRACK *C/P MOVE		001 MNPRA 002 03 003 BED1	
----	-----	--	--	---------------------------------	--

69	110	ELECTRO ETCH INDEX MARKS TO INDICATE POSITION TO MAX DEPTH .0002 RENUMBER LOWER CAM TO P/N 25-4214-501 *C/P MOVE		001 MNPRA 002 03 003 BED1	
----	-----	---	--	---------------------------------	--

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 MLO4	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
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DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-646-143

16010N WORK CONTROL DOCUMENT (MEDS)

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 CENTERING CAM ASSY						
15. DISPATCH STATION	16. PERFORM/RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "G"	
26	132	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 DGO1		
26	134	PREPARE FOR SILVER PLATE, MASK/FIXTURE/ETC. *C/P MOVE					001 MNPRC 002 03 003 BE01		
26	136	PREPARE FOR SILVER PLATE, GRIT BLAST ALL AREAS TO BE SILVER PLATED. *C/P MOVE					001 MNPRC 002 01 003 BLO4		
26	140	SILVER PLATE FACE OF LOWER CAM .0004/.0006 THICK TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 SID1		
26B	150	BAKE 48 HRS 350-400F WITHIN 4 HRS OF SILVER PLATING DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK02		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	155	PRIOR TO PHOSPHATE COAT, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED. *C/P MOVE					001 MNPRC 002 01 003 BLO2		
26	170	PHOSPHATE COAT TYPE M ***NOTE: DO NOT PLATE FACES*** TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 PH01		
26B	180	BAKE 8 HRS AT 210-225F AFTER COATING DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK02		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-648-163

WORK CONTROL DOCUMENT (MEDS)

16013N

DATE

89046

PAGE 1 OF 2 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 CAP ARMY TRUNION
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18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	13. MECHANIC	19. "P"	20. "Q"
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		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
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		MANY OF THE FOLLOWING PROCEDURES...			
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		WHILE THE FOLLOWING PROCEDURES...			
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		APPROXIMATELY 1000 HRS AT 250/400F			
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	001	9-507/2 9-5-87			
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		DISASSEMBLE		001 MNR6W	
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	REQD			002 03	
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		CHEM CLEAN		001 MNR6W	
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	REQD			002 03	
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		BLAST CLEAN ONLY		001 MNR6W	
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	REQD			002 03	
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21. FINAL DESTINATION	COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	A	16013N
FUNCTIONAL CODE	B	
	C	
	D	

U.S. GOVERNMENT PRINTING OFFICE: 1985-048-180

16013N

WORK CONTROL DOCUMENT (MEDS)

1 DATE

89046

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 CAP ASSY TRUNNION
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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26	040	CAD PLATE TYPE II CLASS I I.D. AND OUTSIDE FACES ONLY TIME IN TIME OUT		001 MNPRC 002 03 003 CA01	
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26A	041	DATE TIME WITHIN # OF ... AT ...		001 MNPRC 002 02 003 BPO1	
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		DATE TIME TIME IN TIME OUT			
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26	042	INSIDE *C/P MOVE		001 MNPRC 002 01 003 BPO1	
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		[REDACTED] *C/P MOVE		001 MNPRC 002 03 003 BPO1	
--	--	----------------------	--	---------------------------------	--

.65		[REDACTED]			
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26	043	USE THE CAD PLATE CLASS I I.D. AND OUTSIDE FACES ONLY ALUMINUM PLATE CLASS I I.D. AND OUTSIDE FACES ONLY *C/P MOVE		001 MNPRC 002 03 003 BPO1	
----	-----	--	--	---------------------------------	--

		DATE TIME TIME IN TIME OUT			
--	--	----------------------------	--	--	--

26	049	ALODINE IVD ALUM PLATE CLASS I I.D. AND OUTSIDE FACES ONLY *C/P MOVE		001 MNPRC 002 03 003 BPO1	
----	-----	---	--	---------------------------------	--

26BP	050	BRUSH PLATE I.D. OF BEARING C-15 WITH THE CAD I.D. & OUTSIDE FACES ONLY *C/P MOVE		001 MNPRC 002 02 003 BPO1	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
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DISPATCH	FUNCTIONAL CODE	A	C	16013N	
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		B	D		
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U.S. GOVERNMENT PRINTING OFFICE: 1969-549-123

16014N

WORK CONTROL DOCUMENT (MEDS)

1 DATE

89046

PAGE 2 OF 2 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 NUT, RETAINER UPPER OLEO BRG
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
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MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS

WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFETY PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.

*REQUT (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO "O" STAMP

	001	3-507.4 J			
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		DISASSEMBLE			
				001 MHPW	
				02 02	
				003 HLO2	
				005 X2745250	
				006 X2745250	

		DRY CLEAN			
		REPAIR		001 MHPW	
				02 03	
				03 HLO1	

		PLAS CLEAN			
				001 MHPW	
				02 03	
				003 HLO7	

		BAKE 4 HRS AT 350-400F			
				001 MHPW	
				02 03	
				003 BK03	

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

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16014N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-548-713

16014N

WORK CONTROL DOCUMENT (MEDS)

DATE 89046

PAGE 5 OF 5 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	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
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		***** NO I E * * * * * IF LAST NOJ OPERATION IS COMPLETED HERE, TAKE ROUND FOR COUNT.			
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		***** NO I E OPERATION IS COMPLETED HERE, TAKE ROUND FOR COUNT.			
--	--	---	--	--	--

		***** NO I E OPERATION IS COMPLETED HERE, TAKE ROUND FOR COUNT.			
--	--	---	--	--	--

20	1000	REPLACE IN PLACE CLAMP P. 1000			
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20	1000	REPLACE IN PLACE CLAMP P. 1000			
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20	1000	REPLACE IN PLACE CLAMP P. 1000			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16014N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-183

16004N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89089 PAGE 1 OF 1 PAGES

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 4S1-57-3		9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES B-52 MAIN	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN STEERING BEARING ASSY (M)	

171424

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
9-52299-505	UPPER	162009256842 171424			
9-52532-501	LOWER	162009256842 171424			
		*** UNIT COST: \$195.97/\$477.56***			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOT 66-3			
		BLAST IAW MIL-STD-1504			
		CAD PLATE IAW MIL-STD-870			
		BRUSH PLATE IAW MIL-STD-865 4S-1-182			
		STRIP IAW MIL-STD-871			
		IVI ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		***** BRASS*****			
		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			
		(CONTINUED)			

★ U.S. GOVERNMENT PRINTING OFFICE: 1969-646-183

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

16004N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89089

PAGE 2 OF 2 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 BEARING ASSY (M)	

18. DISPATCH STATION	19. 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 16 IS EQUIVALENT TO DELTA STAMP.			
	001	9-52299-505 9-52532-501			
		DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 MIP03 005 X8745234 006 X8745250	
		REQD			
		DEGREASE ONLY *C/P MOVE		001 MNPGW 002 02 003 DG02	
		REQD			
		BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 GL07	
		REQD			
		E & I INSPECTION BEARING WIDTH 1.495/1.506 *C/P MOVE		001 MNPGW 002 04 003 EIO1	
		REQD			
26	015	STRIP CAD PLATE *C/P MOVE		001 MNPRC 002 02 003 CS01	
69	020	STEERING BEARING HOLE REPAIR. INSTALL IN JIG AND DRILL 12 HOLES I.D. .191/.1945 COUNTERSINK HOLES (CONTINUED)		001 MNPRA 002 04 003 IPO3 005 X8745619	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-183

16004N WORK CONTROL DOCUMENT (MEDS)

DATE 89089

PAGE 3 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 BEARING ASSY (M)	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		100 DEGREES TO A DIA. OF .400/.430 *C/P MOVE			
		(NOTE ASSEMBLED ON STRUT FOR O/S) 1ST OVERSIZE STEERING BEARING HOLE REPAIR, DRILL HOLES OVERSIZE TO CLEANUP .208 MAX, COUNTERSINK HOLES 100 DEGREES TO A DIA OF .400/.430 (NOTE ASSEMBLED ON STRUT FOR O/S)			
		2ND OVERSIZE STEERING BEARING HOLE REPAIR, DRILL HOLES OVERSIZE TO CLEANUP .230 MAX, COUNTERSINK HOLES			
69	080	STEERING BEARING END RADIUS AND CHAMFER, RADIUS CHAMFER IAW FIG 2-30. ELECTRO ETCH OR METAL STAMP AS PER NOTE 2. * C/P MOVE		001 MNPRA 002 04 003 BE01	
26	083	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	087	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	090	CAD PLATE TYPE II CLASS I .47 SQ FT AT 23.5-32.9 AMPS TIME IN _____ DATE IN _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26BP	100	CAD PLATE BEARING BRUSH CAD PLATE .47 SQ FT AT 23.5-32.9 AMPS *C/P MOVE		001 MNPRC 002 02 003 BP01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988-846-113

16004N WORK CONTROL DOCUMENT (MEDS)

DATE 89089

PAGE 4 OF 4 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/R/C	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 BEARING ASSY (M)	

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	120	IRIDITE (CHROME CONVERSION COATING) *C/P MOVE		001 MNPRC 002 02 003 IR01	
26	125	VAC IVD ALUM PLATE CLASS 2 TYPE 1I *C/P MOVE		001 MNPRC 002 03 003 IVD1	
26	130	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
	140	CHANGE P/N IAW FIG 2-30 *C/P MOVE		001 MNPBP 002 06 003 FA08	
69	160	INSTALL AND MATCH DRILL GEAR QUADRANT, P/N 9-52273 IAW PARA 2-62 AND FIG 2-30 PAGES 2-64-65 OF T.O. *C/P MOVE		001 MNPKA 002 04 003 BE01	
		P/N 9-52273 P/N MS20426DD5-6 P/N MS2042605-6			
	190	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS: 958		001 MNPBP 002 06 003 FA08	
	200	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNPBP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1968-648-113

16005N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPOP	5 DATE SCHED	6 DATE COMPLETED
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7. PART NUMBER	8 TECH DATA 4S-1-182 4S1-57-3	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES B-52 MAIN	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 AOUN LOWER TRIPOD LINK	17142A

18. DISPATCH STATION	19. PERP/RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 25-4211		NSN - C/N 160006099886 17142A 17143A 90400A			
		***** UNIT COST: 1462.00 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 C.M.P.I. IAW MIL-STD-1949 P/O NO1561 CAD PLATE IAW MIL-STD-870 BLAST IAW MIL-STD-150A JVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 BAKE IAW 4S-1-182 MAOI 74-12 *****STEEL 220,000/240,000 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	16005N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1983-544-113

16005N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

PAGE 2 OF 2 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 LOWER TRIPOD LINK
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15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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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	25-4211				
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		DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNP GW 002 02 003 MID3 005 X874523 006 X874525	
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		CHEM CLEAN *C/P MOVE		001 MNP GW 002 03 003 SLO1	
--	--	----------------------	--	----------------------------------	--

		BLAST CLEAN ONLY *C/P MOVE		001 MNP GW 002 03 003 BLO1	
--	--	----------------------------	--	----------------------------------	--

		BAKE 4 HRS AT 350-400F		001 MNP GW 002 03 003 BK03	
--	--	------------------------	--	----------------------------------	--

		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1989-649-183

16005N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 LOWER TRIPOD LINK	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C"
		[REDACTED] *C/P MOVE	M	001 MNPNA 002 05 003 MSD3	
	REQD	E & I INSPECTION		001 MNPBW 002 04 003 EID1	
	REQD	LUG (G) I.D. 1.625/1.626 WEAR 1.627			
		LUG (H) I.D. 1.625/1.626 WEAR 1.627 ***** N O T E ***** * A MINIMUM OF AT LEAST TWO FMPI'S * * IS REQUIRED. *			
		***** *C/P MOVE			
		[REDACTED] ANY LINK UNDER 200 RSI/ROCKWELL C-43 WILL BE CONDEMNED RECORD HARDNESS		001 MNPWW 002 03 003 TR15	
		*C/P MOVE			
69	070	REMOVE BUSHINGS STA 34 CAN NOT REMOVE *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	100	MACHINE LUG (G) OVERSIZE TO CLEANUP MAX I.D. 1.685/1.725 *C/P MOVE		001 MNPRA 002 03 003 MH06	
69	120	MACHINE LUG (H) OVERSIZE TO CLEANUP MAX I.D. 1.685/1.725 * /P MOVE		001 MNPRA 002 03 003 MH06	
26	123	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-048-14

16005N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 LOWER TRIPOD LINK	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	127	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	130	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	135	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	140	CAD PLATE TYPE II CLASS 1 4.5 SQ FT AT 225-315 AMPS TIME OUT DATE OUT *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	160	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	
26	200	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
	165	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-004-164

16005N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

PAGE 5 OF 5 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 LOWER TRIPPOD LINK
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	213	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 160 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
26	217	ALDGINE IVD ALUM PLATE CLAS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	219	MACHINE LOWER LINK LUG G BUSHING O.D TO FIT HOLE .0005/ .0015 PRESS FIT *C/P MOVE P/N 68C29160-13 P/N 68C29160-15		001 MNPRA 002 03 003 LED2	
69	220	LOWER LINK LUG (G) BUSHING INSTALLATION 68C29160-13 OR -15 PRESS FIT .0005/ .0015		001 MNPRA 002 03 003 BED1	
69	225	FINISH LINE REAM OR HONE ID 1.625/ 1.626 NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 03 003 MH06	
69	235	MACHINE LOWER LINK LUG (H) BUSHING, O.D. TO FIT HOLE .0005/ .0015 PRESS FIT *C/P MOVE P/N 68C29160-17		001 MNPRA 002 03 003 LED2	
69	240	LOWER LINK LUG (H) BUSHING INSTALLATION 68C29160-17 PRESS FIT .0005/ .0015 (CONTINUED)		001 MNPRA 002 03 003 BED1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-646-183

16005N WORK CONTROL DOCUMENT (MEDS)

DATE 89048 PAGE 4 OF 6 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 TRIPOD LINK						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		NOTE: BUSHING OF WALL THICKNESS MUST NOT BE LESS THAN .030 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
69	245	FINISH LINE REAM OR HONE I.D. OF LOWER LINK LUG (H) BUSHING 1.625/1.626 *C/P MOVE						001 MNPRA 002 03 003 MH06	
	270	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQU*						001 MNP GP 002 06 003 FA08	
	280	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE *REQU*						001 MNP GP 002 06 003 FA08	

U.S. GOVERNMENT PRINTING OFFICE: 1969-340-104

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16005N	
		B	D		

16006N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

PAGE 01 OF 0001

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 1. 4S-1-182 2. 4S1-57-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES B-52 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN LINK, DRAG STRUT O/B TRIPOD	17142A
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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		NSN	C/N		
5-36035-3		1620006207642	17142A		
5-36035-2		N.S.L.	17143A		

***** UNIT COST: \$751.70 *****
 GOVERNING DIRECTIVES: AFLCR 66-51
 MANDI 66-3
 FMPI IAW MIL-STD-1949
 P/D N01551
 CAD PLATE IAW MIL-STD-870
 BLAST IAW MIL-STD-1504
 BAKE IAW 4S-1-182
 MAOT 74-12
 VAC IVD ALUM PLATE IAW MIL-C-83488A
 ALODINE IAW MIL-C-5541
 *****180,000/200,000 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)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-540-104

16006N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

PAGE 3 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 NUMMR	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN LINK, DRAG STRUT O/B TRIPOD
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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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		E AND I INSPECTION		001 MNPBW	
	REQD	LUG (A) 1.250/1.251 WEAR 1.252		002 04	
		LUG (B) 1.625/1.626 WEAR 1.627		003 EID1	
		LUG (C) 2.000/2.001 WEAR 2.002			
		LUG (D) 1.250/1.251 WEAR 1.252 ***** N O T E ***** * A MINIMUM OF AT LEAST TWO FMPJ'S * * IS REQUIRED. *			
		***** *C/P MOVE			

69	080	REMOVE BUSHINGS STA 34 COULD NOT *C/P MOVE		001 MNPRA	
				002 03	
				003 BED1	

69	100	OVERSIZE REPAIR LUG (A) .015 MIN WALL RUSHING		001 MNPRA	
		ONE SIDE .590 OPPOSITE SIDE .590		002 03	
		MIN WALL		003 MV00	
		ONE SIDE .585 OPPOSITE SIDE .600		005 X863362	
		MIN WALL			
		ONE SIDE .580 OPPOSITE SIDE .610			
		MIN WALL *C/P MOVE			

69	120	OVERSIZE REPAIR LUG (B) MACHINE TO CLEANUP I.D. 1.695/1.705		001 MNPRA	
		*C/P MOVE		002 03	
				003 MV00	
				005 X863362	

69	140	OVERSIZE REPAIR LUG (C) MACHINE TO CLEANUP I.D. 2.060/2.100		001 MNPRA	
		*C/P MOVE		002 03	
				003 MV00	
				005 X863362	

21. ORIGINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/EN
FUNCTIONAL CODE	A	C
	B	D
		16006N

16006N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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 LNK, DRAG STRUT O/R TRIPOD
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	160	OVERSIZE REPAIR LUG (D) MACHINE TO CLEANUP I.D. 1.310/1.350 *C/P MOVE		001 MN 002 03 003 MV00 005 XB53362	PRA
26	163	DEGREASE *C/P MOVE		001 MN 002 03 003 DC01	PRC
26	167	STRIP CAD *C/P MOVE		001 MN 002 02 003 CS01	PRC
26	170	STRIP RUST *C/P MOVE		001 MN 002 02 003 CS02	PRC
26	175	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MN 002 01 003 BL02	PRC
26	180	CAD PLATE TYPE II CLASS I 3.3 SQ FT AT 165-231 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MN 002 03 003 CA01	PRC
26B	200	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MN 002 02 003 BK01	PRC
26	240	IRIDITE *C/P MOVE		001 MN 002 02 003 IR01	PRC

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SK
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

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

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 LINK, DRAG STRUT O/B TRIPOD
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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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	.65	*C/P MOVE ***** N O T E ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 MLD4	
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26	253	VAC IVD ALUM PLATE CLASS 2 TYPE 1/1 NOTE: OPERATION 200 MUST BE ACCOMPLISHED IF PRIOR PLAINING REWORK IS DONE, BEFORE USING IVD OPTION.		001 MNPRC 002 03 003 IVD1	
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		*C/P MOVE			
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26	257	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TAD1	
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69	259	MACHINE LUG (B) BUSHING O.D. TO FIT HOLE .0005/.0015 PRESS FIT *C/P MOVE P/N 68C29160-01 P/N 68C29160-15		001 MNPRA 002 03 003 LED2	
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69	260	LUG (B) BUSHING INSTALLATION. P/N 68C29160-01 OR -15. PRESS FIT .0005/.0015 FINISH HONE BUSHINGS I.D. 1.625/1.626		001 MNPRA 002 03 003 BED1	
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		NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030			
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		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS (CONTINUED)			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N

		B	D	
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U.S. GOVERNMENT PRINTING OFFICE: 1965-646-143

16006N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 LINK, DRAG STRUT O/B TRIPOD
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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			
69	265	FINISH HONE LUG (B) BUSHING I.D. 1.625/1.616 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X863362	
69	275	MACHINE LUG (C) BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 68C29160-03		001 MNPRA 002 03 003 LE02	
69	280	LUG (C) BUSHING INSTALLATION. P/N 68C29160-03 PRESS FIT .0005/.0015 FINISH HONE BUSHING I.D. 2.000/2.001 NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030		001 MNPRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	285	FINISH HONE LUG (C) BUSHING I.D. 2.000/2.001 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X863362	
69	295	MACHINE LUG (D) BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 68C29160-05		001 MNPRA 002 03 003 LE02	
69	290	LUG (D) BUSHING INSTALLATION. PRESS FIT .0005/.0015 NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030		001 MNPRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1989-56-143

16006N WORK CONTROL DOCUMENT (MEDS)

1 DATE 8904A

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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 LINK, DRAG STRUT O/B TRIPOD
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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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		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
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69 /	305	FINISH HONE LUG (D) BUSHING I.D. 1.250/1.251 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X853362	
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69 /	310	MACHINE LUG (A) BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 68C29160-27		001 MNPRA 002 03 003 LE02	
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69 /	320	LUG (A) BUSHING INSTALLATION. MAKE FROM 4130 180,000 PSI. PRESS FIT .0005/.0015 LENGTH .495/.497 DR USE BUSHING		001 MNPRA 002 03 003 BE01	
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		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
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		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
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69 /	325	FINISH HONE LUG (A) BUSHING I.D. 1.250/1.251 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X853362	
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	350	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNPBP 002 06 003 FA08	
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	360	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE *REQD*		001 MNPBP 002 06 003 FA08	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	16006N	

		B	D		
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U.S. GOVERNMENT PRINTING OFFICE: 1989-040-104

16007N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

PAGE 1 OF 1 PAGES

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 1. 45-1-182 2. 451-57-3	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES B-52 MAIN	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN LINK, DRAG STRUT I/B TRIPOD	17142A
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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 5-35964-3		NSN C/N 1620000922837 17142A 17143A 34456A			
		***** UNIT COST: \$187.00 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949 P/O N01561			
		CAD PLATE IAW MIL-STD-870 BLAST IAW MIL-STD-1504 BAKE IAW 45-1-182 MAOI 74-12			
		IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541			
		*** STEEL 200,000/220,000***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THE 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 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

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

16007N WORK CONTROL DOCUMENT (MEDS)

DATE 8904

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 LINK, DRAG STRUT I/E TRIPOD
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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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		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.			
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	001	5-35964-3			
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	REQD	DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPBW 002 02 003 MD03 005 X874523 006 X874525	
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	REQD	CHEM CLEAN *C/P MOVE		001 MNPBW 002 03 003 SL01	
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	REQD	BLAST CLEAN ONLY *C/P MOVE		001 MNPBW 002 03 003 BL01	
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		BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ (CONTINUED)		001 MNPBW 002 03 003 BK03	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-143

16007N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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			LINK, DRAG STRUT I/B TRIPOD				
15. DISPATCH STATION	16. PERP 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 MNPRA	002 05	003 MS03
	REQD	E AND I INSPECTION						001 MNP6W	002 04	003 EI01
	REQD	LUG (E) I.D. 1.312/1.313 WEAR 1.314								
		LUG (F) I.D. 1.250/1.251 WEAR 1.252 ***** NOTE ***** * A MINIMUM OF AT LEAST TWO FMPI'S * * IS REQUIRED. *								
		***** *C/P MOVE								
69	070	REMOVE BUSHINGS STA 34 CAN NOT REMOVE *C/P MOVE						001 MNPRA	002 03	003 BE01
26	075	VAPOR DEGREASE *C/P MOVE						001 MNPRC	002 03	003 DG01
26	080	STRIP CAD *C/P MOVE						001 MNPRC	002 02	003 CS01
26	090	STRIP RITS Rust *C/P MOVE						001 MNPRC	002 02	003 CS02
69	100	MAXIMUM (E) OVERSIZE TO CLEANUP MAXIMUM 1.372/1.393 *C/P MOVE						001 MNPRA	002 03	003 MH06

U.S. GOVERNMENT PRINTING OFFICE: 1989-648-143

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16007N	
		B	D		

16007N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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
	LINK, DRAG STRUT I/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	120	MACHINE LUG (F) OVERSIZE TO CLEANUP MAX I.D. 1.310/1.350 *C/P MOVE		001 MNPRA 002 03 003 MH06	
26	130	VAPOR DECREASE *C/P MOVE		001 MNPRA 002 03 003 DG01	
26	135	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRA 002 01 003 BL02	
26	140	CAD PLATE TYPE II CLASS I 1.2 SQ FT AT 60-84 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRA 002 03 003 CA01	
26B	160	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRA 002 02 003 BK01	
26	200	IRIDITE *C/P MOVE		001 MNPRA 002 02 003 IR01	
	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****	M	001 MNPRA 002 06 003 ML04	
26	213	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION--160 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)		001 MNPRA 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-846-183

16007N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 LINK, DRAG STRUT I/B TRIPOD						
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	217	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE						001 MNPRC 002 03 003 TA01	
69	218	MACHINE LUG (E) BUSHING *C/P MOVE P/N 68C29160-09						001 MNPRA 002 03 003 LE02	
69	219	INSTALL LUG (E) BUSHING *C/P MOVE						001 MNPRA 002 03 003 BE01	
69	220	LUG (E) BUSHING REAM P/N 68C29160-09 PRESS FIT .0005/.0015 FINISH LINE BORE OR HONE I.D. 1.312/1.313						001 MNPRA 002 03 003 HH00	
		NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030							
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
69	238	MACHINE LUG (F) BUSHING *C/P MOVE P/N 68C29160-11						001 MNPRA 002 03 003 LE02	
69	239	INSTALL LUG (F) BUSHING *C/P MOVE						001 MNPRA 002 03 003 BE01	
69	240	LUG (F) BUSHING REAM P/N 68C29160-11 PRESS FIT .0005/.0015 FINISH LINE BORE OR HONE I.D. (CONTINUED)						001 MNPRA 002 03 003 HH00	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16007N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1989-500-124

16008N WORK CONTROL DOCUMENT (MEDS)

DATE 8904

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPPG	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 1. 4S-1-182 2. 4S1-57-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES B-52 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STEERING PLATES ASSY	17142A
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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 5-68457-5		NSN 1620006052768	C/N 17142A 17143A 69855A			
		GOVERNING DIRECTIVES:	AFLCR 66-51 MANOI 66-3 IAW 4S-1-182 MAOI 74-12			
		BAKE	IAW 4S-1-182 MAOI 74-12			
		FMPI	IAW MIL-STD-1949 P/D N01561			
		FLASH CHROME PLT	IAW MIL-STD-1501 P/D N41321			
		DRY FILM LUBE	IAW MIL-L-46010 MIL-L-46147			
		CAD PLATE	IAW MIL-STD-870			
		BRUSH PLATE	IAW MIL-STD-865 4S-1-182			
		STRIP CHROME	IAW MIL-STD-866			
		IVD ALUM PLATE	IAW MIL-C-83488A			
		ALODINE	IAW MIL-C-5541			
		BLAST	IAW MIL-STD-1504			
		*****UNIT COST	\$2500.00*****			
		*****STEEL 4340	180,000/240,000*****			
		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 IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLI-				
		(CONTINUED)				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1959-O-046-123

1600BN WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

PAGE 2 OF 2 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 ASSY
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CABLE 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	5-68457-5			
		DISASSEMBLE C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPBW 002 02 003 MD03 005 X8745250 006 X8745234	
	REQD				
		CHEM CLEAN C/P MOVE		001 MNPBW 002 03 003 SL01	
	REQD				
		BLAST CLEAN ONLY C/P MOVE		001 MNPBW 002 03 003 BL01	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	1600BN
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-548-130

16008N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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 STEERING PLATES ASSY
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15. DISPATCH STATION	16. PERF ACC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		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 MLD4	

		E AND I INSPECTION		001 MNP GW	
	REQD	BEARING AREA I.D. 11.273/11.282		002 04	
				003 EI01	

		WIDTH OF BEARING ON (91) 1.488/1.4906			
		WIDTH OF BEARING ON (90) 1.480/1.4861			

		MOUNTING BOLT HOLES .875/.876/.877			
		STEERING LUGS 3.9988/3.9998/4.0008			

		4.0008 TO 4.004 BRUSH NICKEL PLATE			
		TORQUE ARM LUGS 1.751/1.752			
		WEAR 1.753			
		*C/P MOVE			

26	070	VAPOR DECREASE	*C/P MOVE	001 MNPRC	
				002 03	
				003 DG01	

26	080	STRIP CAD	*C/P MOVE	001 MNPRC	
				002 02	
				003 CS01	

26	090	STRIP RUST	*C/P MOVE	001 MNPRC	
				002 02	
				003 CS02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
				16008N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-608-103

16008N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046

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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 PLATES ASSY
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	100	STRIP CHROME FROM BEARING AREA *C/P MOVE		001 MNPRC 002 02 003 SC02	
69	120	DRILL TWO HOLES IN BOTTOM PLATE IF NOT PREVIOUSLY DONE IAW FIG 2-21 *C/P MOVE		001 MNPRA 002 03 003 MV00	
69	140	MOUNTING BOLT HOLES OVERSIZE REPAIR USE SHOP SPECIAL STEERING PLATE FIXTURE REAM TO CLEANUP .9397/.957 250 RMS *C/P MOVE		001 MNPRA 002 03 003 DR03 005 XB633628	
69	160	TORQUE ARM LUG HOLES OVERSIZE REPAIR REAM OVERSIZE TO CLEANUP 1.813/1.831 250 RMS *C/P MOVE		001 MNPRA 002 03 003 DR03 005 XB633629	
69	180	NICK AND BURR AND REMOVE PITTING IAW PARA 2-44 & (NOTE) *C/P MOVE		001 MNPRA 002 03 003 BE01	
		WORKED AREAS	M	001 MNPNA 007 06 003 TE03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
26B	190	BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		*C/P MOVE ***** NOTE ***** (CONTINUED)	M	001 MNPNA 002 06 003 MLD4	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

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

16008N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 PLATES ASSY						
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	220	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DGD1	
26	230	PREPARE FOR CHROM PLATE, GRIT BLAST *C/P MOVE						001 MNPRC 002 01 003 BLD2	
26	235	PREPARE FOR FLASH CHROME PLATE OF CHROME PLATED BEARING SURFACES, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED						001 MNPRC 002 02 003 BED1	
26	240	FLASH CHROME PLATE CLASS III PLATING THICKNESS .0005/.0007 CHROME PLATED BEARING SURFACES TIME OUT _____ DATE OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE						001 MNPRC 002 02 003 CPD2 008 CDD10	
26B	250	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC 002 02 003 BKD1	
26	255	GRIT BLAST ALL AREAS TO BE CAD PLATED/IVD ALUM PLATED "N D T E" GRIT 3.999 STEERING ACTUATOR HOLES O.D. IF CORROSION FORMS A CIRCULAR PATTERN *C/P MOVE						001 MNPRC 002 01 003 BLD2	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C					16008N	
		B	D						

* U.S. GOVERNMENT PRINTING OFFICE: 1988-648-128

1600BN WORK CONTROL DOCUMENT (MEDS)

DATE

8904

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 ASSY
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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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26	260	CAD PLATE TYPE II CLASS I 6.2 SQ FT AT 310-434 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
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26B	280	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATING DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

	165	*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	302	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
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26	303	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 280 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
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26BP	305	BRUSH PLATE STEERING LUGS USING HIGH SPEED NICKEL TO MAINTAIN FINISH I.D. OF 3.9988/3.9998 *C/P MOVE		001 MNPRC 002 02 003 BP01	
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26	320	DRY FILM LUBE CHROME PLATED AREAS IAW MIL-L-46010 OR MIL-L-46147 *****NOTE***** (CONTINUED)		001 MNPRC 002 03 003 EL01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	1600BN	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1968-649-143

16008N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 STEERING PLATES ASSY
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18. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
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		DO NOT DRY FILM LUBE STEERING LUGS IF LUGS HAVE BEEN BRUSH PLATED WITH HIGH SPEED NICKEL. *C/P MOVE			
--	--	--	--	--	--

26B	340	BAKE IAW MANUFACTURES FILM LUBE SPECIFICATION 1 HR AT 400 DEG DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK02	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

26	360	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
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26	370	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TAD1	
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69	398	MACHINE MOUNTING BOLT HOLE BUSHING *C/P MOVE P/N 68C29160-21 P/N 68C29160-23		001 MNPRA 002 03 003 LE02	
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69	400	MOUNTING BOLT HOLE BUSHING INSTALLATION P/N 68C29160-23 OR -21 PRESS FIT .0005/.015 KEEP MATCHED AFTER REWORK 250 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
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69		MACHINE MOUNTING BOLT HOLE BUSHING *C/P MOVE		001 MNPRA 002 03 003 IR03 005 X8333628	
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69		MOUNTING BOLT HOLE BUSHING *C/P MOVE P/N 68C29160-25		001 MNPRA 002 03 003 LE02	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16008N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1985-0-285-889

16008N WORK CONTROL DOCUMENT (MEDS)

DATE 89046

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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 PLATES ASSY						
18. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	420	TORQUE ARM LUG BUSHING INSTALLATION P7N 28C29160-25 PRESS FIT .001/.02 250 RMS					001 MNPRA 002 03 003 BE01		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
69	425	TORQUE ARM LUG BUSHING FINISH I.D. 1.751/1.752 *C/P MOVE					001 MNPRA 002 03 003 DR03 005 X8633629		
	430	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP 002 06 003 FA08		
	440	FINAL PRODUCT VISUAL INSPECTION *REQD* * C/P MOVE					001 MNP GP 002 06 003 FA08		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16008N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1989-408-102

16009N WORK CONTROL DOCUMENT (MEDS)

1 DATE: 87048

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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 4S-1-182 4S1-57-3	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES B-52 MAIN	11. STOCK NUMBER	12 'OPTIONAL
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13. SERIAL NUMBER	14 NOUN LINK ASSY TORSION	17142A
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15. DISPATCH STATION	16. PERM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 1-80721-1		NSN C/N 1620003170530 17142A 17143A			

***** UNIT COST: \$152.14 *****
 GOVERNING DIRECTIVES: AFLCR 66-51
 MANOI 66-3
 FMPI IAW MIL-STD-1949

P/O N01561
 CAD PLATE IAW MIL-STD-870
 BAKE IAW 4S-1-182
 MAOI 74-12

IVD ALUM PLATE IAW MIL-C-83488A
 ALODINE IAW MIL-C-5541
 BLAST IAW MIL-STD-1504
 *****STEEL 180,000/200,000 PSI*****

ALL PERSONNEL INVLOVED 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	16009N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-000-100

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 LINK ASSY TORSION
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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	1-80721-1			
		DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS. *REQD*		001 MNP GW 002 02 003 MD03 005 X8745234 006 X8745250	
		CHEM CLEAN *C/P MOVE *REQD*		001 MNP GW 002 03 003 SLD1	
		BLAST CLEAN ONLY *C/P MOVE *REQD*		001 MNP GW 002 03 003 BLD1	
		BAKE 4 HRS AT 350-400F *REQD* 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
DISPATCH	FUNCTIONAL CODE	A	C	16009N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1969-548-102

16009N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89046

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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 LINK ASSY TORSION						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		[REDACTED] *C/P MOVE				M	001 MNPNA		
	REQD						002 05		
		E & I INSPECTIONS					003 MLD4		
	REQD	APEX BUSHING I.D. 1.250/1.2515					001 MNPGW		
		BASE BOSS HOLE I.D. 2.120/2.1205					002 04		
		***** N O T E *****					003 EID1		
		* A MINIMUM OF AT LEAST TWO FMPI'S *							
		* IS REQUIRED. *							

		*C/P MOVE							
26	085	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DGO1		
26	090	STRIP CAD *C/P MOVE					001 MNPRC		
							002 02		
							003 CS01		
26	093	STRIP RUST *C/P MOVE					001 MNPRC		
							002 02		
							003 CS02		
26	095	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					001 MNPRC		
							002 01		
							003 BL02		
26	100	CAD PLATE TYPE II CLASS I .9 SQ FT AT 45-63 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC		
							002 03		
							003 CAD1		
26B	120	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ (CONTINUED)					001 MNPRC		
							002 02		
							003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16009N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1988-0-46-103

16009N WORK CONTROL DOCUMENT (MED)

PAGE 5 OF 10

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 LINK ASSY TORSION
-------------------	-------------------------------

18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT _____ TIME OUT _____			

26	140	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
----	-----	----------------------	--	---------------------------------	--

	165	*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	160	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 120 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
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26	170	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
----	-----	--	--	---------------------------------	--

69	178	MACHINE APEX BOSS BUSHING I.D. 1.250/1.251 *C/P MOVE P/N 4-80724-1		001 MNPRA 002 03 003 LE02	
----	-----	--	--	---------------------------------	--

69	80	APEX BOSS BUSHING INSTALLATION BASE METAL 1.4997 1.500 BUSHING 4-80724-1 DRILL GREASE HOLE AND FINISH HONE BUSHING I.D. 1.250/1.251 125 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16009N	
		B	D		

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

16017N

WORK CONTROL DOCUMENT (MEDS)

DATE

8904

PAGE 6 OF 7 PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
B 52M	4S1-1-182	

13. SERIAL NUMBER	14. NOUN	17142A
	JACKSHAFT ASSY	

18. DISPATCH STATION	19. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED		18. MECHANIC	19. "P"	20. "Q"
P/N 5-68470-2		NSN 1620003079442	C/N 17142A 17143A 18.5IN			
		GOVERNING DIRECTIVES: AFLOCK 66-51 MAYDI 66-3 FMPI IAW MIL-STD-1949 P70 RC1581				
		FP. IAW MIL-STD-6846 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT				
		HAVE BEEN THOROUGHLY TRAINED & ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES/HAZARDS CONTAINED IN THE BULLETIN/TECHNICAL ORDER & TOOL SUPPLY				
		BOOKS/REFERENCES IN PERS. TO BE APPLIED TO ALL WORK. RESPONSIBILITY & SUPERVISOR WILL ALWAYS BE USED IN CONDUCTING ALL WORK.				
		EMPLOYER WILL BE RESPONSIBLE FOR ALL & PROPER WORK PROCEDURES/OPERATIONS/DISPATCH STATIONS (FC/P MUSE)				
		*****A P N I N *****				
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRING THE USE OF EQUIPMENT/PROCESSES/CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQ-				
		UATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.				
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16017N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-0-348-108

16017N

WORK CONTROL DOCUMENT (MEDS)

89046

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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
	JACKSHAFT ASSY

18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP.			
	001	5-688 70-2			
	REDD	BLAST CLEAN *C/P MOVE		001 MNPBW 002 03 003 BLO1	
	REDD	DISASSEMBLE *C/P MOVE		001 MNPBW 002 04 003 FACH	MANV
	REDD	DEGREASE, (HAND WASH) *C/P MOVE		001 MNPBW 002 06 003 FACH	OP
	REDD	*C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
	REDD	*C/P MOVE	R	001 MNPNA 002 05 003 0002	
	REDD	*C/P MOVE		001 MNPNA 002 05 003 DG01	PG1
	050	ASSEMBLE *C/P MOVE		001 MNPBP 002 06 003 FACH	
	REDD	ALIGN USING EXISTING FIXTURING AND FREE PLAY CHECK *C/P MOVE		001 MNPBP 002 06 003 FACH	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16017N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1968-548-188

TRUT B-52 MLG

RCC MIPRA

4S1-57-3

F PF A/R REV

T K D L	NR A K	FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY PC
					STORED			SUPPLEMENTAL	
E	JA	EA	1	J 85204	.59 PERCENT ENGR 95.6	MACH REP OUTER CYL B52 507	16.27		9.60
	JA	01	00		.00	PART NUMBER/NSN	.000	.000	.000
					7027516-10	162000241544			
	JA	01	15		.05	O/D TRUNNION C/BORE REWORK	1.062	.008	.061
E				RML-SU-V3	.33 S/U VERT MIL BORE FXTR HOIST	PROPRATE OP 060.080 & 100	1.03687		.393
E				RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181
E				RML-AL-BB	1.00 ALIGN VERTICAL AXIS CLAMP		.11975		.137
E				RML-AL-BA	1.00 ALIGN HORIZ AXIS CLAMP		.05541		.063
E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087
E				RML-BA-CM	1.00 BORE HOLE 2 X 6 GROUP 1		.30098		.346
E				RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC		.01001		.011
	JA	01	15		.05	I/B TRUNNION C/BORE REWORK	1.062	.008	.061
E				RML-SU-V3	.33 S/U VERT MIL BORE FXTR HOIST	PROPRATE OP 060.080 & 100	1.03687		.393
E				RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181
E				RML-AL-BB	1.00 ALIGN VERTICAL AXIS CLAMP		.11975		.137
E				RML-AL-BA	1.00 ALIGN HORIZ AXIS CLAMP		.05541		.063
E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087
E				RML-BA-CM	1.00 BORE HOLE 2 X 6 GROUP 1		.30098		.346
E				RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC		.01001		.011
	JA	01	15		.05	MACH NEW KEYWAYS	1.491	.011	.086
					H				
E				RML-SU-V3	.33 S/U VERT MIL BORE FXTR HOIST	PROATED OVER 060.070 & 080	1.03687		.393
E				RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181
E				RML-AL-AC	2.00 ALIGN HOLE TO SPINDLE ROD	2 EA. KEYWAYS	.07609		.175
E				RML-AL-BB	2.00 ALIGN VERTICAL AXIS CLAMP	2 EA KEYWAYS	.11975		.275
E				RML-AL-BA	2.00 ALIGN HORIZ AXIS CLAMP	2 EA KEYWAYS	.05541		.127
E				RML-BA-AM	2.00 BORE HOLE 1 X 6 GROUP 1	2 EA KEYWAYS	.23942		.550
E				RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC		.01001		.011
	JA	01	15		.15	BEP DAMAGED CAM KEYWAYS	1.778	.040	.307
E				RML-SU-V3	.33 S/U VERT MIL BORE FXTR HOIST	PROPRATE OP 060.080 & 100	1.03687		.393
E				RML-HP-CC	.10 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.018
E				RML-AL-AC	2.00 ALIGN HOLE TO SPINDLE ROD	2 EA. KEYWAYS	.07609		.175
E				RML-AL-BB	2.00 ALIGN VERTICAL AXIS CLAMP	2 EA KEYWAYS	.11975		.275
E				RML-AL-BA	2.00 ALIGN HORIZ AXIS CLAMP	2 EA KEYWAYS	.05541		.127
E				RML-BA-BM	2.00 BORE HOLE 1.5 X 6 GROUP 1	2 EA KEYWAYS	.27020		.621
					2.00	BURNISH REMOVED KEYWAYS 2EA	.10800		.248
E				RLA-FF-AG	5.00 FACE FINISH (1/2 DIA GRP 4 5 BUSHINGS		.03033		.174
E				RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC		.01001		.011
	JA	01	15		.08	O/D TRUNNION REPAIR	1.191	.014	.110
E				RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST	PROPRATE OP 450.460.480 & 500	1.03687		.298
E				RML-AL-BB	2.00 ALIGN VERTICAL AXIS CLAMP	2 EA HOLES HYD LINES	.11975		.275
E				RML-AL-BA	2.00 ALIGN HORIZ AXIS CLAMP	2 EA HOLES HYD LINES	.05541		.127
E				RML-AL-AC	2.00 ALIGN HOLE TO SPINDLE ROD	2 EA HOLES HYD LINES	.07609		.175
E				RML-BA-AF	2.00 BORE HOLE 1 X 3 GROUP 1	2 EA HOLES HYD LINES	.20666		.475
E				RLG-HP-V1	1.00	ROTATE FIXTURE TO NEXT HOLE	.00612		.007
E				RJP-PW-R1	1.00 REM RPL PAPERWK SIGN OFF DOC		.01001		.011
					.05	I/B TRUNNION REPAIR	1.191	.009	.068
E				RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST	PROPRATE OP 450.460.480 & 500	1.03687		.298
E				RML-AL-BB	2.00 ALIGN VERTICAL AXIS CLAMP	2 EA HOLES HYD LINES	.11975		.275

0030 E	RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA HOLES HYD LINES	.05541	.127
0035 E	RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA HOLES HYD LINES	.07609	.175
0040 E	RML-BA-AF	2.00	BORE HOLE 1 X 3 GROUP 1	2 EA HOLES HYD LINES	.20666	.475
0045 E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0120	JA 01	15	.05	OBORD TRUNNION RADIUS REP	1.066	.008 .061
0010 E	RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOISTPRORATE OP 450,460,480 & 500		1.03687	.298
0020 E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030 E	RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA SIDES RADIUS	.05541	.127
0035 E	RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA SIDES TO TRUNION	.07609	.175
0040 E	RML-BA-HA	2.00	BORE HOLE 4.5 X 1/2 GROUP 1	2 EA SIDES RADIUS PER TRUN	.20242	.465
0042 E	GID-SA-A1	1.00	STAMP WITH METAL STAMP	STAMP LETTER 'T'	.00342	.003
0045 E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0130	JA 01	15	.05	I/B TRUNNION RADIUS REP	1.056	.008 .061
0010 E	RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOISTPRORATE OP 450,460,480 & 500		1.03687	.298
0020 E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030 E	RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA SIDES TO TRUNION	.05541	.127
0035 E	RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA SIDES TO TRUNION	.07609	.175
0040 E	RML-BA-HA	2.00	BORE HOLE 4.5 X 1/2 GROUP 1	2 EA RADIUS PER TRUNION	.20242	.465
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0240	JA 01	15	.22	ORFICE TUBE REPAIR	.971	.032 .246
0010 E	RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRORATE OP 240,260&280		1.03687	.393
0015 E	RML-HP-CC	.33	HOIST HANDLE NO WRAP 2 CLAMPPRORATE OP 240,260&280		.15776	.059
0020 E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030 E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040 E	RML-BA-BC	1.00	BORE HOLE 1.5 X 1.5 GROUP 1		.19798	.227
0045 E	KAL-SH-31	1.00	SPOT-FACE OR COUNTERBORE	SPOTFACE	.02004	.023
0046 E	RLA-RC-BA	1.00	RECESS /O2 - 1 DIA 1/8 DP	G1CUT RADIUS	.04181	.048
0050 E	RPL-MA-B1	1.00		ROLBURNISH	.00335	.057
0055 E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXTHOLE	.00612	.007
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0260	JA 01	15	.50	O/S MACH O/B TRIPOD LUGS	.933	.070 .537
0010 E	RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRORATE OP 240,260&280		1.03687	.393
0015 E	RML-HP-CC	.33	HOIST HANDLE NO WRAP 2 CLAMPPRORATE OP 240,260&280		.15776	.059
0020 E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030 E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040 E	RML-BA-BF	1.00	BORE HOLE 1.5 X 3 GROUP 1		.22205	.255
0050 E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0055 E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0280	JA 01	15	.36	O/S MACH I/B TRIPOD LUGS	.919	.050 .381
0010 E	RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRORATE OP 240,260&280		1.03687	.393
0015 E	RML-HP-CC	.33	HOIST HANDLE NO WRAP 2 CLAMPPRORATE OP 240,260&280		.15776	.059
0020 E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030 E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040 E	RML-BA-BE	1.00	BORE HOLE 1.5 X 2.5 GROUP 1		.21403	.246
0050 E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0300	JA 01	15	.43	O/S LOWER TRIPOD LUGS	.821	.053 .406
0010 E	RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTPRORATE OP 300,320,340,360, 380 & 400		1.03687	.202
0015 E	RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400		.15776	.030

0040	E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0050	E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0060	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040	E	RML-BA-CH	1.00	BORE HOLE 2 X 6 GROUP 1		.30098	.346
0050	E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0055	E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0060	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011
0320	JA 01	15	.15		O/S STEERING LUG I/B	.758	.017
0010	E	RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400		1.03687	.202
0015	E	RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400		.15776	.030
0020	E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030	E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040	E	RML-BA-CF	1.00	BORE HOLE 2 X 3 GROUP 1		.23744	.273
0050	E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0055	E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0060	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011
0340	JA 01	15	.22		O/S STEERING LUG O/B	.758	.025
0010	E	RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400		1.03687	.202
0015	E	RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400		.15776	.030
0020	E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030	E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040	E	RML-BA-CF	1.00	BORE HOLE 2 X 3 GROUP 1		.23744	.273
0050	E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0055	E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0060	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011
	JA 01	15	.05		STEERING LUG COUNTER BORE	1.095	.008
0010	E	RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400		1.03687	.202
0015	E	RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400		.15776	.030
0020	E	RML-AL-BB	2.00	ALIGN VERTICAL AXIS CLAMP 2 EA LUGS IB & OB		.11975	.275
0030	E	RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP 2 EA LUGS IB & OB		.05541	.127
0035	E	RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD 2 EA LUGS IB & OB		.07609	.175
0040	E	RML-BA-DA	2.00	BORE HOLE 2.5 X 1/2 GROUP 1 2 EA LUGS IB & OB		.18706	.430
0055	E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0060	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011
0380	JA 01	15	.05		O/S ACTUATOR LUG <SMALL>	.715	.005
0010	E	RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400		1.03687	.202
0015	E	RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400		.15776	.030
0020	E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030	E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040	E	RML-BA-CB	1.00	BORE HOLE 2 X 1 GROUP 1		.19508	.224
0050	E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0055	E	RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612	.007
0060	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011
0400	JA 01	15	.05		O/S ACTUATOR LUG <LARGE>	.725	.005
0010	E	RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400		1.03687	.202
0015	E	RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400		.15776	.030
0020	E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975	.137
0030	E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541	.063
0035	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609	.087
0040	E	RML-BA-DC	1.00	BORE HOLE 2.5 X 1.5 GROUP 1		.21121	.242
0050	E	RPL-MA-B1	15.00		ROLBURNISH	.00335	.057
0060	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011
0420	JA 01	15	.08		ACTUATOR KEYSLOT REPAIR	2.147	.026

0019	E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03487		1.192	
	E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776		.181	
	E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP	.11975		.137	
0035	E	RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP	.05541		.063	
0040	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07409		.087	
0050	E	RML-BC-BA	1.00	BORE HOLE 1.5 X 1/2 GROUP 3	.24267		.279	
0060	E	RML-BA-AB	1.00	BORE HOLE 1 X 1 GROUP 1 BOLT HOLD	.18482		.212	
0070	N	GTL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA	.01427		.016	
0080	E		1.00	MFG PLATE	.25000		.287	
0425	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
			.05	DOOR ACTUATOR LUG #146	.120	.001	.007	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATED HOLES 146,148,151	.27525		.079	
0020	E	RLA-DR-DA	1.00	DRILL HOLE 1/4-1/2 DIA (1/21/4	.03811		.043	
0030	E	RPL-MA-B1	1.00	ROLL BURNISH	.00335		.003	
0430	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOCDOC	.01001		.011	
			.08	DOOR ACTUATOR LUG REPAIR	.520	.006	.048	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE OP430,440,443,446	.27525		.079	
0020	E	RLA-DR-DA	5.00	DRILL HOLE 1/4-1/2 DIA (1/25 EA HOLES	.03811		.219	
0030	E	RPL-MA-B1	75.00	OCC ROLBURNISH 5 HOLES	.00335		.288	
0440	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
			.05	2ND O/S DOOR ACT LUG REP	.520	.004	.030	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE OP430,440,443,446	.27525		.079	
0020	E	RLA-DR-DA	5.00	DRILL HOLE 1/4-1/2 DIA (1/25 EA HOLES	.03811		.219	
0030	E	RPL-MA-B1	75.00	OCC ROLBURNISH 5 HOLES	.00335		.288	
0443	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
			.05	REAM HOLE #147 & ROLLBURNISH	.167	.001	.010	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE OP430,440,443,446	.27525		.079	
	E	RLA-DR-DA	1.00	DRILL HOLE 1/4-1/2 DIA (1/2	.03811		.043	
	E	RPL-MA-B1	15.00	ROLLBURNISH	.00335		.057	
0446	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
			.05	O/S HOLE #147 & ROLL BURNISH	.167	.001	.010	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE OP430,440,443,446	.27525		.079	
0020	E	RLA-DR-DA	1.00	DRILL HOLE 1/4-1/2 DIA (1/2	.03811		.043	
0030	E	RPL-MA-B1	15.00	ROLL BURNISH	.00335		.057	
0460	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
			.05	REP LUG HOLE 148	.234	.002	.013	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATED 4 EA HOLES	.27525		.079	
0020	E	RLA-DR-DA	4.00	DRILL HOLE 1/4-1/2 DIA (1/2DRILL 4 EA HOLES	.03811		.175	
0030	E	RPL-MA-B1	1.00	ROLL BURNISH	.00335		.003	
0470	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOCSIGN	.01001		.011	
			.05	O/S HOLE 148	.244	.002	.014	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATED 4 EA HOLES	.27525		.079	
0020	E	RLA-DR-DA	4.00	DRILL HOLE 1/4-1/2 DIA (1/24 EA HILES	.03811		.175	
0030	E	RPL-MA-B1	4.00	ROLBURNISH 4 EA HOLES	.00335		.015	
0480	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOCSIGN	.01001		.011	
			.05	REP LUG HOLE 151	.230	.002	.013	
0010	E	RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL 2 EA HOLES	.27525		.158	
0020	E	RLA-DR-DA	2.00	DRILL HOLE 1/4-1/2 DIA (1/22 EA HOLES	.03811		.087	
0030	E	RPL-MA-B1	2.00	ROLBURNISH 2 EA HOLES	.00335		.007	
0490	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOCSIGN	.01001		.011	
			.05	O/S LUG HOLE 2 EA	.230	.002	.013	
0010	E	RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL O/S 2 EA HOLES # 151	.27525		.158	
0020	E	RLA-DR-DA	2.00	DRILL HOLE 1/4-1/2 DIA (1/20/S	.03811		.087	
	E	RPL-MA-B1	2.00	ROLLBURNISH 2 EA HOLES	.00335		.007	
0500	JA 01	RJP-PW-R1	15	1.00 REM RPL PAPWRK SIGN OFF DOCSIGN	.01001		.011	
			.05	REP LUG HOLE #150 4 EA	.244	.002	.014	

0010 E	RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL	PRORATED 4 EA HOLES	.27525	.079
0020 E	RLA-DR-DA	4.00 DRILL HOLE 1/4-1/2 DIA (1/24 EA HOLES		.03811	.175
0030 E	RPL-MA-B1	4.00	ROLL BURNISH 4 EA HOLES	.00335	.015
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOCSIGN		.01001	.011
0502	JA 01	15	.05 REAM LIG HOLE 149 12 EA	.535	.004 .031
0010 E	RBW-SU-G1	.10 S/U FOR BENCH WORK GENERAL	PRORATED 12 EA HOLES	.27525	.031
0020 E	RLA-DR-DA	12.00 DRILL HOLE 1/4-1/2 DIA (1/2 DRILL 12 EA HOLES		.03811	.525
0030 E	RPL-MA-B1	12.00	ROLL BURNISH 12 EA HOLES	.00335	.046
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOCSIGN		.01001	.011
0504	JA 01	15	.15 MACH UPPER STEERING JOURNAL	1.986	.045 .343
0010			FOR FLAME SPRAY		
0020 E	RML-SU-V3	.50	S/U LARGE LATHE W/FIXTURE	1.03687	.596
0025			PRORATE OP 0160 & 0140		
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254
0040 E	KML-TA-JC	2.00 DIA 5.00-6.00 REM .033-.250 11 IN. O.D.		.09193	.211
0050 E	KML-TA-JD	2.00 DIA 6.0 REM .250 ADD INCH 11 IN. O.D.		.02665	.061
0060 N		1.00	LOCAL REWORK PITS IN FLANGE	1.00000	1.150
0070			AREA W/GRINDING MOTOR & FILE		
0080 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0506	JA 01	15	.15 MACH LOWER STEERING JOURNAL	1.322	.030 .228
0010			FOR FLAME SPRAY		
0020 E	RML-SU-V3	.50	S/U LARGE LATHE W/FIXTURE	1.03687	.596
0025			PRORATE OP 0160 & 0140		
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254
0040 E	KML-TA-JC	2.00 DIA 5.00-6.00 REM .033-.250 11 IN. O.D.		.09193	.211
0050 E	KML-TA-JD	2.00 DIA 6.0 REM .250 ADD INCH 11 IN. O.D.		.02665	.061
0060 E	RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525	.316
0070 E	RSG-JP-03	1.00 PREP HAND DRILL FOR USE		.00861	.009
0080 E	KAL-SM-F1	1.00 ROTARY FILE PER 1ST IN USE		.00611	.007
0090 E	KAL-SM-F2	10.00 ROTARY FILE PER ADDL IN USE		.00459	.052
0100 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0508	JA 01	15	.79 NICK & BURR	.441	.052 .401
0010 E	RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525	.316
0020 E	RLG-RS-N2	1.00 NICK & BURR LGE STRUT PARTS		.15614	.179
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0521	JA 01	15	.79 POLISH CYL ID UPPER BORE	.497	.059 .452
0010 E	RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525	.316
0020 E	ZPO-BP-C3	1.00 BUTTERFLY POLISH LRG CYL I.D.HONE/POLISH I.D.		.21256	.244
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0610	JA 01	15	.08 MACH UPPER STEERING JOURNAL	3.130	.038 .288
0010			AFTER FLAME SPRAY		
0020 E	RML-SU-V3	.50 S/U VERT MIL BORE FXTR HOIST	PRORATE OP 610 & 615	1.03687	.596
0030 E	RLA-HP-C4	1.00 IRREG PART IN 4 JAW CHUCK		.22097	.254
0040 E	KML-TD-JC	2.00 DIA 5.00-6.00 REM .033-.250 11 IN. O.D.		.40208	.924
0050 E	KML-TD-JD	2.00 DIA 6.00 REM .250 ADD INCH 11 IN. O.D.		.24071	.553
0060 E	RLA-FR-NG	2.00 FACE ROUGH 9 - 10 DIA. GRP 411 IN. O.D. REMOVE F/SPRAY		.04424	.101
0070 E	RLA-FR-NH	2.00 FACE ROUGH 9 - 10 ADD 1/8 IN. 11 IN. O.D. REMOVE F/SPRAY		.02050	.047
0080 E	RLA-FF-NG	2.00 FACE FINISH 9 - 10 GROUP 4 11 IN O.D. REMOVE F/SPRAY		.08910	.204
0090 E	RLA-FF-NH	2.00 FACE FINISH 9-10 ADD 1/8 IN. 11 IN O.D. REMOVE F/SPRAY		.04101	.094
0095 E	RLA-RC-NA	2.00 RECESS 6-6.5 DIA. 1/8 DP 61 11 IN. O.D. MACH RADIUS		.04670	.107
0110 E	RBW-SU-G1	.50 S/U FOR BENCH WORK GENERAL	PRORATE OP 610 & 615	.27525	.158
0111			REMOVE F/SPRAY FROM KEYWAYS		
0112			& OD OF FLANGE W/GRINDING MOTOR & FILE		
0120 E	KAL-SM-F1	1.00 ROTARY FILE PER 1ST IN USE		.00611	.007
0130 E	KAL-SM-F2	10.00 ROTARY FILE PER ADDL IN USE OCC FOR LENGTH		.00459	.538
0140 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001	.011

	JA 01	15	.05	MACH LOWER STEERING JOURNAL	3.130	.023	.180
				AFTER FLAME SPRAY			
0							
00 E				RML-SU-V3 .50 S/U VERT MIL BORE FXTR HOISTPRORATE OP 610 & 615	1.03687		.596
0030 E				RLA-HP-C4 1.00 IRREG PART IN 4 JAW CHUCK	.22097		.254
0040 E				KML-TD-JC 2.00 DIA 5.00-6.00 REM .033-.250 11 IN. O.D.	.40208		.924
0050 E				KML-TD-JD 2.00 DIA 6.00 REM .250 ADD INCH 11 IN. O.D.	.24071		.553
0060 E				RLA-FR-N6 2.00 FACE ROUGH 9 - 10 DIA. GRP 411 IN. O.D. REMOVE F/SPRAY	.04424		.101
0070 E				RLA-FR-NH 2.00 FACE ROUGH 9 - 10 ADD 1/8 IN.11 IN. O.D. REMOVE F/SPRAY	.02050		.047
0080 E				RLA-FF-N6 2.00 FACE FINISH 9 - 10 GROUP 4 11 IN. O.D. REMOVE F/SPRAY	.08910		.204
0090 E				RLA-FF-NH 2.00 FACE FINISH 9-10 ADD 1/8 IN.11 IN. O.D. REMOVE F/SPRAY	.04101		.094
0095 E				RLA-RC-NA 2.00 RECESS 6-6.5 DIA. 1/8 DP 61 11 IN. O.D. MACH RADIUS	.04670		.107
0110 E				RBW-SU-G1 .50 S/U FOR BENCH WORK GENERAL PRORATE OP 610 & 615	.27525		.158
0111				REMOVE F/SPRAY FROM KEYWAYS			
0112				1/2 OD OF FLANGE W/GRINDING MOTOR & FILE			
0114 E				KAL-SM-F1 1.00 ROTARY FILE PER 1ST IN USE	.00611		.007
0120 E				KAL-SM-F2 102.00 ROTARY FILE PER ADDL IN USE OCC FOR LENGTH	.00459		.538
0130 E				RJP-PW-R1 1.00 REM RPL PAPERWK SIGN OFF DOC	.01001		.011
0675	JA 01	15	.65	I/B TRIPOD BUSH INSTALLATION	.454	.044	.340
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-DA 1.00 DIA 1.00-1.50 REMOVE (.033	.05535		.063
0035 E				KML-TA-DB 2.00 DIA 1.5 REMOVE .032 ADD INCH2 ADD INCHES	.00627		.014
0040 E				RLA-BO-CA 1.00 BORE HOLE 1 - 1 1/2 DIA 1 DP	.08663		.099
0045 E				RLA-BO-CB 2.00 BORE HOLE 1-1.5 DIA. ADD IN 2 ADD INCHES	.01254		.028
0050 E				RLA-FF-CA 1.00 FACE FINISH 1 - 1.5 GROUP 1 FACE TO LENGTH	.03023		.034
0055 E				RPL-AL-S1 1.00 ALODINE 1ST SMALL ALUM PART	.09953		.114
0090 E				RJP-PW-R1 1.00 REM RPL PAPERWK SIGN OFF DOC	.01001		.011
	JA 01	15	.65	I/B TRIPOD BUSH INSTALLATION	.507	.049	.379
00 E				RBW-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053
0060 E				RBW-BU-B2 .50 REBUSH A SET OF 2 BOSSES 1 BUSHING	.22231		.127
0070 E				RBW-SU-G1 1.00 S/U FOR BENCH WORK GENERAL S/U TO HONE BUSH	.27525		.316
0080 N				ZHO-SU-S3 1.00 HAND HONE BUSHING(ADD TIME)	.06450		.074
0090 E				RJP-PW-R1 1.00 REM RPL PAPERWK SIGN OFF DOC	.01001		.011
0690	JA 01	15	.65	MACH BUSH O/B TRIPOD LUG	.819	.080	.613
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 CHUCK3 BUSHINGS	.01006		.034
0030 E				KML-TA-DA 3.00 DIA 1.00-1.50 REMOVE (.033 3 BUSHINGS	.05535		.190
0040 E				RLA-BO-CA 3.00 BORE HOLE 1 - 1 1/2 DIA 1 DP3 BUSHINGS	.08663		.298
0050 E				RLA-FF-CA 3.00 FACE FINISH 1 - 1.5 GROUP 1 FACE TO LENGTH	.03023		.104
0055 E				RPL-AL-S1 1.00 ALODINE 1ST SMALL ALUM PART	.09953		.114
0056 E				RPL-AL-S2 2.00 ALODINE EA ADD SMALL PART 2 ADD. BUSHINGS	.01927		.044
0080 E				RJP-PW-R1 1.00 REM RPL PAPERWK SIGN OFF DOC	.01001		.011
0700	JA 01	15	.65	O/B TRIPOD BUSH INSTALL	.729	.071	.546
0057 E				RBW-BU-S1 .25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053
0058 E				RBW-BU-B2 1.50 REBUSH A SET OF 2 BOSSES 3 BUSHINGS	.22231		.383
0060 E				RBW-SU-G1 1.00 S/U FOR BENCH WORK GENERAL S/U TO HONE BUSHINGS	.27525		.316
0070 N				ZHO-SU-S3 1.00 HAND HONE BUSHINGS(ADD.TIME)	.06450		.074
0080 E				RJP-PW-R1 1.00 REM RPL PAPERWK SIGN OFF DOC	.01001		.011
0710	JA 01	15	.65	MACH BUSH LOWER TRIPOD LUG	1.021	.100	.763
0010 E				RLA-SU-S3 .25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143
0020 E				RLA-HP-C1 4.00 1ST PART IN-OUT SCROLL CHUCK4 BUSHINGS	.01006		.046
0030 E				KML-TA-EA 4.00 DIA 1.50-2.00 REMOVE (.033 4 BUSHINGS	.05535		.254
0040 E				RLA-BO-DA 4.00 BORE HOLE 1 1/2 - 2 DIA 1 DP4 BUSHINGS	.08663		.398
00 E				RLA-FF-DA 4.00 FACE FINISH 1.5 - 2 GROUP 1 FACE TO LENGTH 4 EA.	.03023		.139
00 E				RPL-AL-S1 1.00 ALODINE 1ST SMALL ALUM PART	.09953		.114
0057 E				RPL-AL-S2 3.00 ALODINE EA ADD SMALL PART 3 ADD BUSHINGS	.01927		.066

00 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
JA 01	15	.45	LOWER TRIPOD BUSH INSTALL	.841	.082	.629	
0058 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0060 E	RBW-BU-R2	2.00	REBUSH A SET OF 2 BOSSES	.22231		.511	
0070 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
0080 N	ZHO-SU-S3	1.00	HAND HOME BUSINGS (ADD.TIME)	.06450		.074	
0090 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0730	JA 01	15	.65	MACH BUSH I/B ACT LUG	1.852	.181	1.385
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143	
0020 E	RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK4 BUSHINGS	.01006		.046	
0030 E	KML-TA-EA	4.00	DIA 1.50-2.00 REMOVE (.033	.05535		.254	
0040 E	RLA-BJ-DA	4.00	BORE HOLE 1 1/2 - 2 DIA 1 DP4 BUSHINGS	.08663		.398	
0050 E	RLA-FF-DA	4.00	FACE FINISH 1.5 - 2 GROUP 1 FACE TO LENGTH 4 EA.	.03023		.139	
0055 E	RPL-AL-S1	1.00	ALODINE 1ST SMALL ALUM PART	.09953		.114	
0057 E	RPL-AL-S2	3.00	ALODINE EA ADD SMALL PART	.01927		.066	
0058 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0060 E	RBW-BU-B2	2.00	REBUSH A SET OF 2 BOSSES	.22231		.511	
0070 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
0080 N	ZHO-SU-S3	1.00	HAND HOME BUSINGS (ADD.TIME)	.06450		.074	
0090 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0740	JA 01	15	.93	I/B ACT BUSH INSTALLATION	.515	.072	.551
0065 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0070 E	RBW-BU-B1	.50	REBUSH A SET OF 2 BOSSES	.23835		.137	
0080 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
0090 N	ZHO-SU-S3	1.00	HAND HOME BUSHING (ADD.TIME)	.06450		.074	
0100 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
01 E	JA 01	15	.93	MACH BUSH O/B ACTUATOR LUG	.587	.082	.628
0015 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030 E	KML-TD-DA	1.00	DIA 1.00-1.50 REMOVE (.033	.09677		.111	
0040 E	RLA-BO-CG	1.00	BORE HOLE 1 - 1 1/2 DIA 1 DP	.17094		.196	
0050 E	RLA-FR-CG	1.00	FACE ROUGH 1 - 1.5 DIA GRP 4FACE FLANGE	.01810		.020	
0060 E	RLA-FF-CG	1.00	FACE FINISH 1- 1.5 GROUP 4 FACE FLANGE	.03679		.042	
0070 E	RLG-RS-B1	1.00	BRUSH PLATE SPOT OR HOLE	.09546		.109	
0110 E	KAL-MS-06	1.00	SEAL SPOT OR FASTENER- 1ST	.02449		.028	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0760	JA 01	15	.93	O/B ACT BUSH INSTALLATION	.515	.072	.551
0075 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0080 E	RBW-BU-B1	.50	REBUSH A SET OF 2 BOSSES	.23835		.137	
0090 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	
0100 N	ZHO-SU-S3	1.00	HAND HOME BUSHING (ADD.TIME)	.06450		.074	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0770	JA 01	15	.93	MACH BUSH STEERING LUG	2.042	.285	2.184
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143	
0015 E	RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK4 BUSHINGS	.01006		.046	
0020 E	KML-TD-EA	4.00	DIA 1.50-2.00 REM (.033	.11664		.536	
0030 E	RLA-BO-CG	4.00	BORE HOLE 1 - 1 1/2 DIA 1 DP4 BUSHINGS	.17094		.786	
0040 E	RLA-FR-DG	4.00	FACE ROUGH 1.5 - 2 DIA GRP 4FACE FLANGES	.01953		.089	
0050 E	RLA-FF-DG	4.00	FACE FINISH 1.5 - 2 GROUP 4 FACE FLANGES	.03970		.182	
0060 E	RLG-RS-B1	4.00	BRUSH PLATE SPOT OR HOLE	.09546		.439	
0070 E	KAL-MS-06	4.00	SEAL SPOT OR FASTENER- 1ST	.02449		.112	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
01 E	JA 01	15	.93	STEERING LUG BUSH INSTALL	.937	.131	1.003
0080 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0080 E	RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES	.23835		.548	
0090 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	.27525		.316	

0100 N	ZHO-SU-S3	2.00	HOME 2 SETS OF BUSHINGS	.06450	.148
10 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011
JA 01	15	.10	CLEAN THRED HOLES	.413	.006 .048
0010 E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL TAP HOLES 9 EA	.27525	.316
0020 E	GTL-TH-A1	9.00	TAP HOLE TO 0.25 IN THRD DIATAP HOLES	.01427	.147
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOCSIGN PAPER	.01001	.011
0800	JA 01	15	.86	INSTALL HELICOILS	.486 .063 .481
0010 E	RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS	.31093	.357
0020 E	RBW-TR-H1	6.00	INSTALL HELICOIL INSERT 6 EA HELICOILS	.02763	.190
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011
0810	JA 01	15	.08	MACH BUSH DOOR ACTUATOR LUG	2.181 .026 .201
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE 4 PARTS	.49962	.143
0020 E	RLA-HP-C1	5.00	1ST PART IN-OUT SCROLL CHUCKS BUSHINGS	.01006	.057
0030 E	KNL-TD-BA	5.00	DIA .251-.500 (.033 5 BUSHINGS	.06193	.356
0040 E	KNL-CD-P1	5.00	CENTER DRILL 5 BUSHINGS	.01519	.087
0050 E	RLA-DR-TB	5.00	DRILL HOLE 1/8-1/4 DIA X 1 5 BUSHINGS	.08030	.461
0060 E	RLA-BO-AG	5.00	BORE HOLE (1/2 DIA 1 IN DP 5 BUSHINGS	.10123	.582
0070 E	RLA-FR-AG	5.00	FACE ROUGH (1/2 DIA, GRP, 45 BUSHINGS	.01487	.085
0080 E	RLA-FF-AG	5.00	FACE FINISH (1/2 DIA GRP 4 5 BUSHINGS	.03033	.174
0090 E	RLG-RS-B1	5.00	BRUSH PLATE SPOT OR HOLE BRUSH PLATE 5 BUSHINGS	.09546	.548
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011
0820	JA 01	15	.08	DOOR ACT LUG BUSH INSTALL	.612 .007 .056
0100 E	RBW-BU-S1	.25	SET UP TO REMUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053
0105 E	RBW-BU-B2	2.50	REBUSH A SET OF 2 BOSSES 5 BUSHINGS	.22231	.639
0110 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011
0840	JA 01	15	.43	MFG 2ND O/S ORIFICE BUSHING	1.558 .101 .771
0005 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE 4 PARTS	.49962	.143
0010 E	RLA-HP-C1	.20	1ST PART IN-OUT SCROLL CHUCK2 BUSHINGS	.01006	.002
0020 E	KNL-TD-DA	2.00	DIA 1.00-1.50 REMOVE (.033 2 BUSHINGS	.09677	.222
0030 E	KNL-TD-DB	1.00	DIA 1.50 REM .033 ADD INCH 1 BUSHING	.03661	.042
0040 E	RLA-RC-DG	1.00	RECESS 1.5-2 DIA. 1/8 DP G4 MACH GROOVE 1 BUSHING	.06122	.070
0050 E	KNL-CD-P1	2.00	CENTER DRILL 2 BUSHINGS	.01519	.034
0060 E	RLA-DR-VB	2.00	DRILL HOLE 1/2-2 DIA 1 DEEP 2 BUSHINGS	.12554	.288
0070 E	RLA-BO-BA	2.00	BORE HOLE 1/2 TO 1 DIA 1 DP 2 BUSHINGS	.08663	.199
0080 E	RLA-BO-BB	1.00	BORE HOLE 1/2 - 1 DIA ADD IN1 BUSHING	.01254	.014
0090 E	RLA-FR-DG	2.00	FACE ROUGH 1.5 - 2 DIA GRP 42 BUSHINGS	.01955	.044
0100 E	RLA-FF-DG	2.00	FACE FINISH 1.5 - 2 GROUP 4 2 BUSHINGS	.03970	.091
0110 E	RLG-RS-B1	2.00	BRUSH PLATE SPOT OR HOLE 2 BUSHINGS	.09546	.219
0120 E	RHT-BE-S1	1.00	BAKE SMALL PART	.06868	.078
0130 E	RBW-BU-S1	.25	SET UP TO REMUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053
0140 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	.23835	.274
0150 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011
0900	JA 01	15	1.00		.000 .000 .000
0900			CLINTON BENTLEY TECH MANEL 3357		
9000	JA 01	00	.01	LABOR STANDARD HISTORY	.000 .000 .000
0010			PRIOR HISTORY ON OO-ALC 494 FORM		
0020			24FEB83 NEW OCC. FACTOR STUDY 9.45		
0021			31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>8.83		
0022			23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> 9.39		
0023			25AUG86-MOVED SUBOPS 0140 TO 504--0160 TO 0504--		
0024			0520 TO 0508--0510 TO 0521--OLD STD WAS 12.03		
0025			20 FEB 87 NEW OCC FACTORS & REVIEW OLD STD 9.99		
0026					
0027			23 SEPT 87 ADDS SUB OPS 425,460,470,480,490,500		
			AND 502 NOT ON 958 ADDED TO REQ OLD STD 15.32		
			21OCT87 DROPEB SUBOP 0220 NO LONGER IN TO 9.09		

17143A STRUT B-52 MLG

RCC MNFRA

451-57-3

TECH S S W F PF A/R REV

SUB	TK	NR	FA	SUPPORT	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT								
7 L	K C	DC	ELEMENT	FACT	STOR	SUPPLEMENTAL				C								
32	S	E	JA	EA 1	J	88229	.83	PERCENT ENGR 97.5	MACH INNER CYL B52M	4.44	3.68							
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0					
						0010		5-85123-6	162006582588									
0120			JA	01	15		.50		BRAKE MOUNTING HOLE REP	1.051	.079	.605	14					
						0020	E	RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOISTPRORATE OVER 2 OPERATIONS	1.03687		.596					
						0030	E	RML-HP-CD	.50	HOIST HANDLE WRAPPED 2 CLAMPPRORATE OVER 2 OPERATIONS	.18155		.104					
						0040	E	RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD	.06265		.072					
						0041	E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146					
						0050	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087					
						0060	N		1.00	CUT SLOT	.16700		.192					
						0070	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011					
0120			JA	01	15		.05		REPAIR JACKPAD BOSS	1.462	.011	.004	2					
						0010	E	RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOISTPRORATE OVER 2 OPERATIONS	1.03687		.596					
						0015	E	RML-HP-CD	.50	HOIST HANDLE WRAPPED 2 CLAMPPRORATE OVER 2 OPERATIONS	.18155		.104					
						0018	E	RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD	.06265		.072					
						0020	E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146					
						0030	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087					
						0040	E	RML-BD-GB	1.00	BORE HOLE 4 X 1 GROUP 4	.57729		.663					
						0050	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011					
0140			JA	01	15		.05		WELD SPLATER REWORK	.404	.003	.023	1					
						0010	E	REW-SU-G1	.50	S/U FOR BENCH WORK GENERAL PRORATED 2 EA AREAS OF REWRK	.27525		.158					
						0020	E	GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL	.00678		.007					
						0030	N		1.00	REMOVE WELD SPLATTER	.25000		.287					
						0040	E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011					
								JA	01	15		.05		REP RETAIN NUTLOCK BOLT HOLE	.454	.003	.026	1
												.20		S/U TO O/S BOSSES RAD DRILL PRORATE OVER 5 OPERATIONS	.56378		.129	
												.20		HOIST HANDLE WRAPPED 2 CLAMPPRORATE OVER 5 OPERATIONS	.18155		.041	
												3.00		ALIGN HOLE TO SPINDLE ROD 3 HOLES	.07609		.262	
												1.00		SPOT-FACE OR COUNTERBORE SPOTFACE HOLE	.02004		.023	
												2.00		REPOSITION OBJECT 80-130 LBSREPOSITION FOR 2 MORE HOLES	.00369		.008	
												2.00		SPOT-FACE OR COUNTERBORE 2 EA ADD HOLES SPOTFACED	.02004		.046	
												1.00		REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0160			JA	01	15		.47		REP RETAIN NUTLOCK BOLT HOLE	.454	.032	.246	6					
												.20		S/U TO O/S BOSSES RAD DRILL PRORATE OVER 5 OPERATIONS	.56378		.129	
												.20		HOIST HANDLE WRAPPED 2 CLAMPPRORATE OVER 5 OPERATIONS	.18155		.041	
												3.00		ALIGN HOLE TO SPINDLE ROD 3 HOLES	.07609		.262	
												1.00		SPOT-FACE OR COUNTERBORE SPOTFACE HOLE	.02004		.023	
												2.00		REPOSITION OBJECT 80-130 LBSREPOSITION FOR 2 MORE HOLES	.00369		.008	
												2.00		SPOT-FACE OR COUNTERBORE 2 EA ADD HOLES SPOTFACED	.02004		.046	
												1.00		REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0165			JA	01	15		.47		REP RETAIN NUTLOCK BOLT HOLE	.454	.032	.246	6					
												.20		S/U TO O/S BOSSES RAD DRILL PRORATE OVER 5 OPERATIONS	.56378		.129	
												.20		HOIST HANDLE WRAPPED 2 CLAMPPRORATE OVER 5 OPERATIONS	.18155		.041	
												3.00		ALIGN HOLE TO SPINDLE ROD 3 HOLES	.07609		.262	
												1.00		SPOT-FACE OR COUNTERBORE SPOTFACE HOLE	.02004		.023	
												2.00		REPOSITION OBJECT 80-130 LBSREPOSITION FOR 2 MORE HOLES	.00369		.008	
												2.00		SPOT-FACE OR COUNTERBORE 2 EA ADD HOLES SPOTFACED	.02004		.046	
												1.00		REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0220			JA	01	15		.62		O/S TORQUE ARM LUG	1.252	.116	.093	20					
												1.00		T.O. RESEARCH	.03471		.039	
												.20		S/U TO O/S BOSSES RAD DRILL PRORATE OVER 5 OPERATIONS	.56378		.129	
												.20		HOIST HANDLE WRAPPED 2 CLAMPPRORATE OVER 5 OPERATIONS	.18155		.041	
												1.00		ALIGN HOLE TO SPINDLE ROD	.07609		.087	

		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
		RDR-BO-A2	1.00	O/S ADML STP RMR RAD DR		.14687		.168	
0060 E		KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBSTURN PART 100 %		.00369		.004	
0065 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0070 E		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0075 E		RDR-BO-A2	1.00	O/S ADML BOSS STP RMR RAD DR		.14687		.168	
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0085 E	JA 01	15	.25	TOW LUG 1ST O/S		.964	.036	.277	6
0010 E		RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 5 OPERATIONS		.56378		.129	
0015 E		RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP PRORATE OVER 5 OPERATIONS		.18155		.041	
0020 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0030 E		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0040 E		KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE		.02004		.023	
0050 E		KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBSTURN PART 100 %		.00369		.004	
0060 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0070 E		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0080 E		KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE		.02004		.023	
0090 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0260	JA 01	15	.08	TOW LUG 2ND O/S		.954	.011	.088	2
0010 E		RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 5 OPERATIONS		.56378		.129	
0015 E		RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP PRORATE OVER 5 OPERATIONS		.18155		.041	
0020 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0030 E		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0040 E		KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE		.02004		.023	
0050 E		KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBSTURN PART 100 %		.00369		.004	
0060 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0070 E		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0075 E		KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE		.02004		.023	
0270	JA 01	15	.05	MACH HYD FITTING HOLES		1.948	.015	.112	3
0010 E		RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST PRORATE 2 PARTS		1.03687		.596	
0020 E		RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP		.18155		.208	
0030 E		RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD	ALIGN HORIZ	.06265		.072	
0035 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	
0040 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	SPOTFACE 1ST HOLE	.27100		.311	
0045 E		KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBS	REPOSITION TO 2ND HOLE	.00369		.004	
0050 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	2ND HOLE	.07609		.087	
0060 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	SPOTFACE 2ND HOLE	.27100		.311	
0070 E		KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBS	REPOSITION TO 3RD HOLE	.00369		.004	
0080 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0090 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	SPOTFACE 3RD HOLE	.27100		.311	
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0272	JA 01	15	.05	MACH CRACK AXLE THREAD AREA		1.354	.010	.078	2
0010 E		RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST PRORATE 2 PARTS		1.03687		.596	
0020 E		RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP		.18155		.208	
0030 E		RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.06265		.072	
0040 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0050 E		RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	MACH W/BALL END MILL	.27100		.311	
0060 E		RBW-SU-01	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158	
0070 E		RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART	FILE THREAD AREA & POLISH	.04595		.052	
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0090 E	JA 01	15	1.00	TURN BUSHING GROUP 4/STEEL		.399	.060	.459	10
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-TD-EC	1.00	DIA 1.50-2.00 REM .033-.250		.17225		.198	
0040 E		KML-TD-ED	1.00	DIA 2.00 REM .250 ADD INCH		.08233		.094	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060 E	JA 01	15	1.00	INST STRAIGHT BUSH NO POLISH		.077	.012	.089	2
0070 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0080 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	

	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.01001	.011	
0010 E	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.211	.032 .244
0020 E				PRORATE OVER 4 PARTS	.49962	.143
0030 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.01006	.011	
0040 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.06699	.077	
	KML-TA-EC	1.00	DIA 1.50-2.00 REM .033-.250	.01001	.011	
	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.278	.042 .321	7
	JA 01	15	1.00	INST/REAM SET STRAIGHT BUSH	.18669	.053
0 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.22231	.255	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.01001	.011	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.289	.043 .332	7
0959	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.49962	.143
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.01006	.023	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.06699	.154	
0030 E	KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250	.01001	.011	
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.278	.042 .321	7
0960	JA 01	15	1.00	INST/REAM SET STRAIGHT BUSH	.18669	.053
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.22231	.255	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.01001	.011	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC	.000	.000 .000	0
9000	JA 01	15	.01	LABOR STANDARD HISTORY		
0010				PRIOR HISTORY ON OO-ALC 494 FORM		
0020				24FEB83 OCC. FACTOR STUDY UPDATE	4.28	
0021				31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	3.76	
0022				18AUG84 ADD SUB O/P 0272-OCC ESTIMATE<OLD STD>	4.81	
0023				23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	4.96	
0024				19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	4.93	
0900				CLINTON BENTLEY TECH MANEL 3357		

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17143A STRUT B-52 MLG

ECH S S W F PF A/R REV

SUB	STEP	D L	T K	# R	A FA	SUPPORT	OCC	DESCRIPTION		BASE HOURS	PFD TIME	STD HOURS
								STOR	SUPPLEMENTAL			
RA004	S	E	JA	EA	1	J	B5204	.63	PERCENT ENGR 99.9	MACH STEER BEAR OCC.2EA 604	.91	.57
0001			JA	01		00		.00	PART NUMBER/NSN		.000	.000
	0010								9-52299-505	1620009665426		
	0020								9-52532-501	1620009072897		
0020		JA	01			15		1.00	DRILL & C/SINK STEER BRGNS		.704	.106
	0010	E						.33	S-U DR PRS W-VISE FIXT DV-HDPRORATE OP 020.040 & 060		.42803	.162
	0020	E						12.00	DRILL HOLE 1/16-1/8 DIA (1/212 EA HOLES		.04188	.577
	0030	E						1.00	COUNTERSINK HOLE TO 1/4 INCH		.00205	.002
	0040	E						11.00	COUNTERSINK ADDL HOLE 1/4 IN11 EA HOLES		.00104	.013
	0050	E						1.00	DEBURR HOLE FIRST BOTH SIDES		.00449	.005
	0060	E						11.00	DEBURR HOLE ADDL BOTH SIDES 11 EA HOLES		.00294	.037
	0070	E						1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0080		JA	01			15		.06	RADIUS STEERING BEARING		.705	.006
	0010	E						1.00	S/U FOR BENCH WORK GENERAL		.27525	.316
	0015	E						1.00	SET UP & DISMANTLE AIR DRILL		.00678	.007
	0020	E						64.00	ROTARY FI'E PER 1ST IN USE 8 TIMES X 8 CORNERS		.00611	.449
	0025	E						1.00	STAMP WITH METAL STAMP		.00342	.003
	0027	E						10.00	STAMP W/METAL STAMP ADDL 10 ADD. NUMBERS		.00187	.021
	0030	E						1.00	REM RPL PAPWRK SIGN OFF DOC		.01001	.011
0160		JA	01			15		1.00	MATCH DRL GEAR TO LOWER BRG		.050	.008
	0010	E						.25	PREP HAND DRILL FOR USE PRORATED OVER 4 PARTS		.00861	.002
	0020	E						2.00	DRILL HOLE W/PORTABLE DRILL DRILL 2 HOLES		.00924	.021
	0030	E						1.00	SPOT-FACE OR COUNTERBORE		.02004	.023
	0040	E						1.00	REM RPL PAPWRK SIGN OFF DOC.		.01001	.011
9000		JA	01			15		.01	LABOR STANDARD HISTORY		.000	.000
	0010								PRIOR HISTORY ON 00-ALC 494 FORM			
	0020								24FEB83 NEW OCC. FACTOR STUDY		.38	
	0021								31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>		.28	
	0022								23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>		.68	
	0023								02APR86 DELETE SUB OP 0040.0060 <OLD STD>		.54	
	0024								02APR86 CHG SUBOP 0020 TO 100Z EST TIL NEXT STUDY			
	0900								MANEL CLINTON BENTLEY MRP II 7-3255			

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OPER	TECH	S	S	W	F	P	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								
RA005	S	E	JA	EA	1	J	85204	1.00	PERCENT ENGR 99.9	REP LOWER TRIPOD LINK	507	8.93								8.93	
0001			JA	01	00		.00		PART NUMBER/NSN		.000	.000	.000								
0010								25-4211	162006099886												
0070			JA	01	15		.05		REMOVE BUSHINGS		.335	.003	.019								
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316									
0030	E					RLG-RS-KB	6.00	K/O SINGLE BUSH 1-3 IN DIA	OCC FOR 6 BUSHINGS	.00836		.057									
0050	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									
0100			JA	01	15		.60		MACH LUG "G"		1.484	.134	1.024								
0010	E					RML-SU-T1	.50	SET UP TOBIN ARP BORING	MACHPRORATE "G" & "H" LUGS	.80267		.461									
0020	E					RML-HP-AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062									
0025	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087									
0030	E					RML-BD-BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 42	LUGS 1/2 LONG	.29250		.672									
0040	E					RML-BD-BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	1 LUG 1 IN LONG	.35729		.410									
0050	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									
0120			JA	01	15		.60		MACHINE LUG "H"		1.613	.145	1.114								
0010	E					RML-SU-T1	.50	SET UP TOBIN ARP BORING	MACHPRORATE "G" & "H" LUGS	.80267		.461									
0020	E					RML-HP-AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062									
0025	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087									
0030	E					RML-BD-BB	3.00	BORE HOLE 1.5 X 1 GROUP 4	3 LUGS	.35729		1.232									
0040	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									
0219			JA	01	15		.82		MACH BUSH LUG 6		1.666	.205	1.572								
0010	E					RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE "G" & "H" LUGS	.49962		.287									
0020	E					RLA-HP-C5	3.00	PUT PART IN & OUT OF COLLET	3 BUSHINGS	.00642		.022									
0030	E					KML-TD-EA	3.00	DIA 1.50-2.00 REN (.033	3 BUSHINGS	.11664		.402									
0040	E					RLA-BD-DG	3.00	BORE HOLE 1 1/2 - 2 DIA 1	DP3 BUSHINGS	.21069		.726									
0050	E					RLA-FF-DG	3.00	FACE FINISH 1.5 - 2 GROUP 4	3 BUSHINGS	.03970		.136									
0060	E					RLG-RS-B1	3.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 3 BUSHINGS	.09546		.329									
0080	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									
0220			JA	01	15		.82		INSTALL BUSHING LUG "G"		.165	.020	.156								
0065	E					RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE OVER "G" & "H" LUGS	.18669		.107									
0070	E					RBW-BU-AA	3.00	INSTALL ONE STRAIGHT BUSHING	3 BUSHINGS	.02062		.071									
0080	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									
0225			JA	01	15		.82		FINISH LINE REAM OR HONE		1.408	.173	1.328								
0075	E					RML-SU-T1	.50	SET UP TOBIN ARP BORING	MACHPRORATE "G" & "H" LUGS	.80267		.461									
0076	E					RML-HP-AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062									
0077	E					RML-BD-BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 41	BUSH 1/2 LONG	.29250		.672									
0078	E					RML-BD-BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	1 BUSH 1 INCH LONG	.35729		.410									
0080	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									
0235			JA	01	15		1.00		MACH BUSH LUG H		1.666	.250	1.917								
0010	E					RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE "G" & "H" LUGS	.49962		.287									
0020	E					RLA-HP-C5	3.00	PUT PART IN & OUT OF COLLET	3 BUSHINGS	.00642		.022									
0030	E					KML-TD-EA	3.00	DIA 1.50-2.00 REN (.033	3 BUSHINGS	.11664		.402									
0040	E					RLA-BD-DG	3.00	BORE HOLE 1 1/2 - 2 DIA 1	DP3 BUSHINGS	.21069		.726									
0050	E					RLA-FF-DG	3.00	FACE FINISH 1.5 - 2 GROUP 4	3 BUSHINGS	.03970		.136									
0060	E					RLG-RS-B1	3.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 3 BUSHINGS	.09546		.329									
0080	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011									

JA 01	15	1.00	INSTALL BUSHING LUG "H"	.165	.025	.190	
S E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES PRORATE OVER "G" & "H" LUGS	.18669		.107	
0 E	RBW-BU-A4	3.00	INSTALL ONE STRAIGHT BUSHING3 BUSHINGS	.02062		.071	
0080 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
0245	JA 01	15	1.00	FINISH LINE REAM OR HONE	1.408	.211	1.619
0075 E	RML-SU-T1	.50	SET UP TOBIN ARP BORING MACHPRORATE "G" & "H" LUGS	.80267		.461	
0076 E	RML-HP-AA	1.00	HAND HANDLE MORAP SIMPL FXTR	.05454		.062	
0077 E	RML-BD-BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 42 BUSH 1/2 LONG	.29250		.672	
0078 E	RML-BD-BB	1.00	BORE HOLE 1.5 X 1 GROUP 4 1 BUSH 1 IN LONG	.35729		.410	
0080 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000
0010			PRIOR HISTORY ON 00-ALC 494 FORM				
0020			24FEB83 NEW OCC. FACTOR STUDY	4.34			
0021			31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	3.72			
0022			23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	6.68			
0023			19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	7.61			
0900			CLINTON BENTLEY TECH MANEL 3357				

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17143A STRUT B-S2 MLG

OPER	TECH	S	S	W	F	PF	A/R	REV	SUB	T	K	R	A	FA	SUPPORT	OCC	←	DESCRIPTION	→	BASE	PFD	STD	DLY
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	HOURS	DLY									
RA006	S	E	JA	EA	1	J	85204	1.00	PERCENT ENGR 96.6	REP OUTBOARD LINK B52M 507	8.24			8.24									
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000											
	0010							5-36035-3	1620006207642														
0080			JA	01	15		.15		REMOVE BUSHINGS	.318	.007	.055											
	0010	E				RBM-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316											
	0030	E				RLG-RS-KB	4.00	K/O SINGLE BUSH 1-3 IN DIA	OCC FOR 7EA BUSHINGS	.00836		.038											
	0050	E				RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011											
0100			JA	1	15		.15		O/S LUG "A"	.701	.016	.121											
	0010	E				RML-SU-T1	.25	SET UP TOBIN ARP BORING MACHPRORATE OVER 4 PARTS		.80267		.230											
	0020	E				RML-HP-AA	1.00	HAND HANDLE WRAP SIMPL FXTR		.05454		.062											
	0030	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087											
	0040	E				RML-BC-BD	1.00	BORE HOLE 1.5 X 2 GROUP 3		.36029		.414											
	0050	E				RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011											
0120			JA	01	15		.59		O/S LUG "B"	1.050	.093	.713											
	0010	E				RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR1 OF 4 LUGS		.80167		.230											
	0020	E				RJP-TC-A2	.25	FIXT TO & FROM STORAGE ROOM 1 OF 4 LUGS		.20388		.058											
	0030	E				RML-HP-CA	.25	HAND HANDLE NO WRAP 2 CLAMPS1 OF 4 LUGS		.08531		.024											
	0040	E				RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137											
	0050	E				RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063											
	0060	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087											
	0070	E				RML-BC-CF	1.00	BORE HOLE 2 X 3 GROUP 3		.51647		.593											
	0080	E				RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011											
0140			JA	01	15		.42		O/S LUG "C"	1.128	.071	.545											
	0010	E				RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR1 OF 4 LUGS		.80167		.230											
	0020	E				RJP-TC-A2	.25	FIXT TO & FROM STORAGE ROOM 1 OF 4 LUGS		.20388		.058											
	0030	E				RML-HP-CA	.25	HAND HANDLE NO WRAP 2 CLAMPS1 OF 4 LUGS		.08531		.024											
	0040	E				RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137											
	0050	E				RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063											
	0060	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087											
	0070	E				RML-BC-DF	1.00	BORE HOLE 2.5 X 3 GROUP 3		.59423		.683											
	0080	E				RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011											
0160			JA	01	15		.59		O/S LUG "D"	.855	.076	.580											
	0010	E				RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR1 OF 4 LUGS		.80167		.230											
	0020	E				RJP-TC-A2	.25	FIXT TO & FROM STORAGE ROOM 1 OF 4 LUGS		.20388		.058											
	0030	E				RML-HP-CA	.25	HAND HANDLE NO WRAP 2 CLAMPS1 OF 4 LUGS		.08531		.024											
	0040	E				RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137											
	0050	E				RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063											
	0060	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087											
	0070	E				RML-BC-BC	1.00	BORE HOLE 1.5 X 1.5 GROUP 3		.32109		.369											
	0080	E				RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011											
0259			JA	01	15		.92		HACH BUSH LUG "B"	1.072	.148	1.135											
	0010	E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE 4 LUGS		.49962		.143											
	0020	E				RLA-HP-C5	2.00	PUT PART IN & OUT OF COLLET 2 BUSHINGS		.00642		.014											
	0030	E				KML-TD-EA	2.00	DIA 1.50-2.00 REN (.033 2 BUSHINGS		.11664		.268											
	0040	E				RLA-BD-D6	2.00	BORE HOLE 1 1/2 - 2 DIA 1 DP2 BUSHINGS		.21069		.484											
	0050	E				RLA-FF-DG	2.00	FACE FINISH 1.5 - 2 GROUP 4 2 BUSHINGS		.03970		.091											
	0060	E				RLG-RS-B1	2.00	BRUSH PLATE SPOT OR HOLE 2 BUSHINGS		.09546		.219											
	0070	E				RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011											
0260			JA	01	15		.92		INSTALL BUSH LUG "B"	.079	.011	.084											

0070 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0080 E		RBW-BU-A2	1.00 INSTALL SET STRAIGHT BUSHING		.02299		.026
10 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.92	FINISH HONE LUG 'B' BUSH	.299	.041	.316
0090 E		RDR-SU-R1	.33 S/W TO O/S BOSSES RAD DRILL	PRORATE 3 LUGS	.56378		.213
0100 E		ZPO-BU-01	1.00	HONE BUSHINGS TO SIZE	.10304		.118
0110 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0275	JA 01	15	.92	MACH BUSH LUG 'C'	1.218	.168	1.289
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS	.49962		.143
0020 E		RLA-HP-C5	2.00 PUT PART IN & OUT OF COLLET	2 BUSHINGS	.00642		.014
0030 E		KHL-TD-FA	2.00 DIA 2.00-3.00 REMOVE (.033	2 BUSHINGS	.14659		.337
0035 E		RLA-BO-EG	2.00 BORE HOLE 2 - 2 1/2 DIA 1 DP2	BUSHINGS	.25045		.576
0040 E		RLA-FF-EG	2.00 FACE FINISH 2 - 2.5 GROUP 4	2 BUSHINGS	.04293		.098
0050 E		RLG-RS-B1	2.00 BRUSH PLATE SPOT OR HOLE	2 BUSHINGS	.09546		.219
0100 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0280	JA 01	15	.92	INSTALL BUSH LUG 'C'	.079	.011	.084
0060 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0070 E		RBW-BU-A2	1.00 INSTALL SET STRAIGHT BUSHING		.02299		.026
0100 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0285	JA 01	15	.92	FINISH HONE LUG 'C' BUSH	.299	.041	.316
0080 E		RDR-SU-R1	.33 S/W TO O/S BOSSES RAD DRILL	PRORATE 3 LUGS	.56378		.213
0090 E		ZPO-BU-01	1.00	HONE BUSHINGS TO SIZE	.10304		.118
0100 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0295	JA 01	15	.84	MACH BUSH LUG 'D'	.541	.068	.523
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS	.49962		.143
0020 E		RLA-HP-C5	1.00 PUT PART IN & OUT OF COLLET		.00642		.067
0030 E		KHL-TD-DA	1.00 DIA 1.00-1.50 REMOVE (.033		.09677		.111
0040 E		RLA-BO-CG	1.00 BORE HOLE 1 - 1 1/2 DIA 1 DP		.17094		.196
0050 E		RLA-FF-CG	1.00 FACE FINISH 1- 1.5 GROUP 4		.03679		.042
0060 E		RLG-RS-B1	1.00 BRUSH PLATE SPOT OR HOLE	BRUSH PLATE BUSHING	.09546		.109
0110 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0300	JA 01	15	.84	INSTALL BUSH LUG 'D'	.077	.010	.075
0070 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0080 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023
0110 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0305	JA 01	15	.84	FINISH HONE LUG 'D' BUSH	.299	.038	.289
0090 E		RDR-SU-R1	.33 S/W TO O/S BOSSES RAD DRILL	PRORATE 3 LUGS	.56378		.213
0100 E		ZPO-BU-01	1.00	HONE BUSHING TO SIZE	.10304		.118
0110 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0310	JA 01	15	1.00	MACH BUSH LUG 'A'	.947	.142	1.090
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS	.49962		.143
0020 E		RLA-HP-C5	2.00 PUT PART IN & OUT OF COLLET	2 BUSHINGS	.00642		.014
0030 E		KHL-TD-DA	2.00 DIA 1.00-1.50 REMOVE (.033	2 BUSHINGS	.09677		.222
0040 E		RLA-BO-CG	2.00 BORE HOLE 1 - 1 1/2 DIA 1 DP2	BUSHINGS	.17094		.393
0050 E		RLA-FF-CG	2.00 FACE FINISH 1- 1.5 GROUP 4	2 BUSHINGS	.03679		.084
0060 E		RLG-RS-B1	2.00 BRUSH PLATE SPOT OR HOLE	2 BUSHINGS	.09546		.219
0130 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0901			K.HANSEN TECH.				
0320	JA 01	15	1.00	INSTALL BUSH LUG 'A'	.079	.012	.092
0070 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0080 E		RBW-BU-A2	1.00 INSTALL SET STRAIGHT BUSHING		.02299		.026
0130 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0901			K.HANSEN TECH.				
	JA 01	15	1.00	FINISH HONE LUG 'A' BUSH	.815	.122	.938
090 E		RDR-SU-R1	1.00 S/W TO O/S BOSSES RAD DRILL		.56378		.648
0100 E			1.00	HONE BUSHING TO SIZE	.24200		.278

0130 E
701

RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC
K.HANSEN TECH.

.01001 .011

JA 01 15

.01

LABOR STANDARD HISTORY

.000 .000 .000

0010
0020
0021
0022
0023
0900

PRIOR HISTORY ON OO-ALC 494 FORM
24FEB83 NEW OCC. FACTOR STUDY 4.24
31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>4.13
23JUL85 NEW OCC FACTORS & REVIEW<OLD STD> 6.14
19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD 6.20
CLINTON BENTLEY TECH MANEL 3357

TG INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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00 E		RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011
	JA 01	15	1.00		FINISH LINE BORE OR HONE ID	.182	.027	.209
0080 E		ZHO-SU-S2	.50	SETUP SUNNEN HONE STROKER	PRORATE OVER 'E' & 'F' LUGS	.21517		.123
0090 M		ZHO-SU-S3	1.00	HONE SMALL PART-SUNNEN HONE		.06450		.074
0100 E		RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011
9000	JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000	.000
0005				PRIOR HISTORY ON OO-ALC 494 FORM				
0010				24FEB83 NEW OCC. FACTOR STUDY	2.08			
0011				31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	2.34			
0012				23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	2.43			
0013				23 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	2.74			
0900				MANEL NRP II CLINTON BENTLEY 7-3255				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPRA

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17143A STRUT B-52 MLG

OPER	TECH	S	S	W	F	P	A/R	REV										
SUB	T	K	#	R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PF	STD						
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY					
A008	S	E	JA	EA	1	J	88231	1.00	PERCENT ENGR 99.6	6.50		6.50						
0001			JA	01	00			.00	MACH STEERING PLATES PART NUMBER/NSM	.000	.000	.000						
0010									5-68457-5 1620006052768									
0120			JA	01	15			.14	DRILL BOTTOM PLATE	1.206	.025	.194						
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		2.00	ALIGN VERTICAL AXIS ROD	.12699		.292						
0040	E					RML-AL-AC		2.00	ALIGN HOLE TO SPINDLE ROD	.07609		.175						
0050	E					RML-BA-CD		2.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21626		.497						
0060	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0140			JA	01	15			.27	O/S MOUNTING BOLT HOLES	1.059	.043	.329						
0010	E					RDR-SU-R1		.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378		.162						
0020	E					RDR-BO-A1		1.00	O/S BOSS W/STEP RMR RAD DRL	.30463		.350						
0030	E					RDR-BO-A2		4.00	O/S ADML BOSS STP RMR RAD DR OCCURANCE = 4 HOLES	.14687		.675						
0040	E					RBW-DB-A1		4.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.019						
0050	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0160			JA	01	15			.27	O/S TORQUE ARM HOLES	.757	.031	.235						
0010	E					RDR-SU-R1		.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378		.162						
0020	E					RDR-BO-A1		1.00	O/S BOSS W/STEP RMR RAD DRL	.30463		.350						
0030	E					RDR-BO-A2		2.00	O/S ADML BOSS STP RMR RAD DR OCCURANCE = 2 HOLES	.14687		.337						
0040	E					RBW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.009						
0050	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0180			JA	01	15			.20	NICK & BURR	.459	.014	.106						
0010	E					RBW-SU-G1		1.00	S/U FOR BENCH WORK GENERAL	.27525		.316						
0020	E					RLG-RS-N3		1.00	NICK & BURR MED STRUT PART	.2711		.077						
0030	E					GTL-EP-A2		1.00	SET UP & DISMANTLE AIR DRILL	.12678		.007						
0040	N							1.00	REMOVE DEEP PITTING	.10000		.115						
0050	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0398			JA	01	15			1.00	MACH MOUNTING BOLT BUSH	.876	.131	1.008						
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143						
0020	E					RLA-HP-CS		12.00	PUT PART IN & OUT OF COLLET00642		.088						
0030	E					KML-TA-DA		12.00	DIA 1.00-1.50 REMOVE (.033 DIA 1.00-1.50 REM .033-.250	.05535		.763						
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0400			JA	01	15			1.00	INST MOUNTING BOLT BUSH	.221	.033	.255						
0010	E					RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	.18669		.107						
0020	E					RBW-BU-A4		1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023						
0030	E					RBW-BU-A3		11.00	INST ADML STRAIGHT BUSHING	.00886		.112						
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0405			JA	01	15			1.00	FINISH MOUNTING BOLT BUSH	2.268	.340	2.609						
0010	E					RDR-SU-R1		.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378		.162						
0020	E					RDR-BO-A1		1.00	O/S BOSS W/STEP RMR RAD DRL	.30463		.350						
0030	E					RDR-BO-A2		12.00	O/S ADML BOSS STP RMR RAD DR 12 BUSHINGS	.14687		2.026						
0040	E					RBW-DB-A1		12.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.058						
0050	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						
0418			JA	01	15			.94	MACH TORQUE ARM BUSH	.428	.060	.463						
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143						
0020	E					RLA-HP-CS		4.00	PUT PART IN & OUT OF COLLET	.00642		.029						
0030	E					KML-TA-EC		4.00	DIA 1.50-2.00 REM .033-.250 4 BUSHINGS	.06699		.308						
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011						

	JA 01	15	.94	INST TORQUE ARM BUSH	.148	.021	.161
0110 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053
0020 E		RBW-BU-A2	4.00	INSTALL SET STRAIGHT BUSHING NO POLISH	.02299		.105
0030 E		RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011
0425	JA 01	15	.94	FINISH TORQUE ARM BUSH	1.059	.149	1.146
0010 E		RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378		.162
0020 E		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463		.350
0030 E		RDR-BO-A2	4.00	O/S ADML BOSS STP RMR RAD DR 4 BUSHINGS	.14687		.675
0040 E		RBW-DB-A1	4.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.019
0050 E		RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000
0010				PRIOR HISTORY ON OO-;LC 494 FORM			
0020				24FEB83 NEW OCC, FACTOR STUDY	8.67		
0030				25MAY83 ADD RJPPWR1 ELEMENT TO SUB OP 0020 & 0030			
0040				25MAY83	TIME WAS 7.21		
0041				31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	7.21		
0042				23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	5.85		
0043				19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	8.01		
0900				CLINTON BENTLEY TECH MANEL 3357			

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MRPRA

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17143A STRUT B-52 ML6

JPER	TECH	S	S	W	F	PF	A/R	REV			DESCRIPTION		BASE	PFD	STD	
SUB	T	K	#R	A	FA	SUPPORT	OCC	←-----	-----→				HOURS	TIME	HOURS	DLI
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL							
RA009	S	E	JA	EA	1	J	85204	.08	PERCENT ENGR 94.2	REP TORQUE ARM 2EA.852H 507			1.27			.10
0001			JA	01	00			.00		PART NUMBER/NSH			.000	.000		.000
0010									1-80721-1	1620003170530						
0178			JA	01	15			1.00		REP ARM			.643	.097		.740
0035	E					RLA-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS			.49962			.287
0040	E					RLA-HP-C5		1.00	PUT PART IN & OUT OF COLLET				.00642			.007
0050	E					KML-TD-DA		1.00	DIA 1.00-1.50 REMOVE (.033				.09677			.111
0060	E					KML-TD-DB		1.00	DIA 1.50 REM .033 ADD INCH				.03661			.042
0070	E					RLA-BO-C6		1.00	BORE HOLE 1 - 1 1/2 DIA 1 DP				.17094			.196
0080	E					RLA-BO-CH		1.00	BORE HOLE 1-1.5 DIA. ADD IN				.07326			.084
0150	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC				.01001			.011
0180			JA	01	15			1.00		REP ARM			.469	.070		.539
0010	E					RBW-SU-61		.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS			.27525			.158
0020	E					RSG-JP-03		.50	PREP HAND DRILL FOR USE	PRORATE 2 PARTS			.00861			.004
0030	N					ZHO-SU-S3		1.00	HONE SMALL PART-SUNNEN HONE	HONE LUG TO SIZE			.06450			.074
0090	E					RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE 2 PARTS			.18669			.107
0100	E					KPA-AC-A1		3.75	PAINT-AEROSOL-PER SQ INCH	L X D 2.5 X 1.5			.00007			.000
0110	E					RBW-BU-B2		.50	REBUSH A SET OF 2 BOSSES	1 BUSHING			.22231			.127
0120	E					GTL-EP-A2		.50	SET UP & DISMANTLE AIR DRILL	PRORATE 2 PARTS			.00678			.003
0130	E					RLA-DR-DB		1.00	DRILL HOLE 1/4-1/2 DIA X 1	DRILL GREASE HOLE			.04300			.049
0140	E					RBW-DB-B1		1.00	DEBURR HOLE BURRQUICK TOOL				.00142			.001
0150	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
0010									PRIOR HISTORY ON 00-ALC 494 FORM							
0020									24FEB83 NEW OCC. FACTOR STUDY		2.73					
0021									31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>		2.59					
0022									23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>		.17					
0900									HANEL MRP II CLINTON BENTLEY 7-3255							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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17143A STRUT B-52 ML6

RCC MNPRA

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OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD
SUB	T	K	#R	A	FA	SUPPORT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	HOURS	TIME	HOURS
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	HOURS	TIME	HOURS
RA010	E	N	JA	EA	1	J	88232	1.00	PERCENT ENGR	.0			.44
0001			JA	01	00			1.00			.000	.000	.000
0010									25-4214-501	1620007330993			
0100			JA	01	00			.96		CAM KEY REPAIR	.333	.000	.320
0010	N							1.00		45 DEGREE CHAMFER	.33300		.333
0105			JA	01	00			.10		CAM KEY REPAIR	.333	.000	.033
0010	N							1.00		RADIUS ON KEYS	.33300		.333
0110			JA	01	15			1.00		ETCH MARKS & RENUMBER	.083	.012	.095
0010	N							1.00		ELECTRO ETCH & RENUMBER	.08300		.095
9000			JA	01	15			.05		LABOR STANDARD HISTORY	.000	.000	.000
0001									31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	.15			
0010									PRIOR HISTORY ON DD-ALC 494 FORM				
0020									24FEB83 NEW OCC FACTOR STUDY UPDATE	.15			
0021									10DEC84 ADD SUB OP 0110&0125 OCC EST.<OLD STD>	.09			
0022									23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	.10			
0023									04FEB86 DELETE SUB OP 0120,0125 <OLD STD>	.15			
0024									19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	.15			
0900									CLINTON BENTLEY TECH MANEL 3357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD
SUB	T	K	#R	A	FA	SUPPORT	FACT	STO	DESCRIPTION	HOURS	TIME	HOURS	DL
STEP	D	L	K	C	DC	ELEMENT	FACT	STO	DESCRIPTION	HOURS	TIME	HOURS	DL
17143A	STRUT B-52	MLG											
RA014	S	E	JA	EA	1	J	88244	.13	PERCENT ENGR 99.9	PISTON HEAD NUT B52 MLG	3.78		.49
0001			JA	01	00			.00		PART NUMBER/MSN	.000	.000	.000
0010									3-80736-3	5310006035970LE			
0023			JA	01	15			1.00		REPAIR KEYWAY SLOT	3.294	.494	3.789
0010	E					RML-SU-V1		.20	S/U VERT MILL BORE SMAL FXTPRORATED 5 EA PARTS AT TIME		.75732		.174
0020	E					RML-AL-BA		6.00	ALIGN HORIZ AXIS CLAMP	6 EA SLOTS	.05541		.382
0030	E					RML-AL-BB		6.00	ALIGN VERTICAL AXIS CLAMP	6 EA SLOTS	.11975		.826
0035	E					RML-AL-AC		6.00	ALIGN HOLE TO SPINDLE ROD	6 EA SLOTS	.07609		.525
0040	E					RML-BD-AA		6.00	BORE HOLE 1 X 1/2 GROUP 4	6 EA SLOTS	.27100		1.869
0050	E					RJP-PW-R1		1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011
0900									K.HANSEN TECH				
9000			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000
0010									PRIOR HISTORY ON OO-ALC 494 FORM				
0020									24FEB83 NEW OCC. FACTOR STUDY				.18
0021									31JUL84 NEW OCC FACTOR STUDY <OLD STD>				.25
0022									23JUL85 NEW OCC FACTOR STUDY & REVIEW <OLD STD.51				

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RCC MNPRA

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S S W F PF A/R REV

T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
D	L	K	C	DC	ELEMENT	FACT	STORIED	HOURS	TIME	HOURS	DLY PCT C
							SUPPLEMENTAL				
E	JA	EA	1	J	85260	.10	PERCENT ENGR 99.9			.04	
	JA	01	00			.00	REP STOP ASSEMBLY, JACKSHAFT	.45			
							PART NUMBER/NSN	.000	.000	.000	0
)							4-80884				
	JA	01	15			1.00	1620003079347				
)							DRILL 4 EA HOLES	.391	.059	.451	100
)	E			RDR-SU-V1		.50	S-U DR PRS W-VISE FIXT DU-HDRORATE 2 PARTS	.42803		.246	
)	E			KNL-CD-P1		4.00	CENTER DRILL	.01519		.069	
)	E			GAE-TL-01		4.00	DRILL W/DRILL PRESS TO 1/4 DRILL 4 HOLES	.02228		.102	
)	E			KTL-DB-A1		4.00	DEBURR HOLE FIRST BOTH SIDES 4 HOLES	.00449		.020	
0	E			RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC	.01001		.011	
	JA	01	15			.01	LABOR STANDARD HISTORY	.000	.000	.000	0
)							12SEP85 NEW OPERATION-NO HISTORY				
0							MANEL MRP II CLINTON BENTLEY 7-3255				

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPRB

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17143A STRUT B-52 MLG

OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	
SUB	T	K	#R	A	FA	SUPPORT	FACT		STO	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY
STEP	D	L	K	C	DC	ELEMENT								
<NPRB	E	X	JA	EA	3	K 87278	1.00	PERCENT ENGR	.0	RECYCLE TIME	2.15		2.15	
0010			JA	01	00		1.00			REWORK TIME	2.150	.000	2.150	
0010	N						1.00			RECYCLE	2.15000		2.150	
0020										REWORK TIME IDENTIFIED BY RCC FOREMAN				
9000			JA	00	00		.00			LABOR STANDARD HISTORY	.000	.000	.000	
0001										5 OCT 87 INITIAL INPUT				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	
SUB	T	K	#R	A	FA	SUPPORT	FACT	STO	DESCRIPTION	HOURS	TIME	HOURS	DLY	
STEP	D	L	K	C	DC	ELEMENT	FACT	STO	DESCRIPTION	HOURS	TIME	HOURS	DLY	
RB001	S	N	JA	EA	3	J	85204	.08	PERCENT ENGR 55.3	REP OUTER CYL B52 MLG 507	3.47		.27	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	
0010									7027516-10	162000241544				
0525			JA	01	15			1.00		HONE CYL I.D.	3.022	.453	3.476	
0010	E					RHO-SU-V2		1.00	SET UP VERY LARGE HONE		.79152		1.140	
0020	E					RHO-MM-F1		1.00	ADJUST HONING FIXTURE		.17589		.202	
0030	E					RHO-HP-L1		1.00	LOAD UNLOAD HONE WITH HOIST		.17802		.204	
0040	E					RHO-MM-H3		1.00	CHANGE STONES ON VERY LARGE		.19652		.225	
0050	E					RHO-MM-S1		1.00	ADJUST STOPS LARGE VERT HONE		.01422		.016	
0060	N							1.00		HONE I.D.	1.35000		1.552	
0070	E					RGR-MM-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	
9000			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010									01MAR84 NEW OPERATION - NO HISTORY					
0011									31JUL84 NEW OCC FACTOR <OLD STD>					
0012									23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> .15					
0013									25AUG86-MOVED SUBOP 0515 TO 0525:OLD STD 3.20					
0020									20NOV86 CHANGE FACILITY CODE TO 3/NO TIME CHANGE					
0900									MANEL MRP II CLINTON BENTLEY 7-3255					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC FRD NROP NR

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OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	DLY
SUB	T	K	#R	A	FA	SUPPORT	FACT	STO	DESCRIPTION	HOURS	TIME	HOURS		
STEP	D	L	K	C	DC	ELEMENT	FACT	STO	DESCRIPTION	HOURS	TIME	HOURS		
RB002	S	E	JA	EA	3	J	85204	.46	PERCENT ENGR 99.9	GRIND INNER CYL 852 MLG 507	18.88		8.68	
0010			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000	
0010									5-85123-6	1620006582588				
9000										LABOR STANDARD HISTORY				
0375			JA	01		15		.37		1ST GRIND INNER O.D.	8.656	.480	3.684	
0010	E						RGR-SU-61	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						RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS		.04777		.054	
0040	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0050	E						KMG-OD-RE	7.00	GRIND .010 9DIA X 3 LONG 21.75 X 8.5 O.D.		.76185		6.132	
0060	E						RGR-GE-D2	9.00	DWELL (GAP GRINDER STEEL OD)8 TO 9 INCH DIA		.01014		.104	
0070	E						RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES		.08334		.191	
0080	E						RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0090	E						RGR-SU-A1	1.00	SET UP INTERNAL ATT GAP GRND		.78266		.900	
0100	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0110	E						KMG-OD-RC	1.00	GRIND .010 9DIA X 2 LONG GRIND FLANGE AREA 2 X 8.5 OD		.52384		.602	
0120	E						RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES		.08334		.191	
0130	E						RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0140	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011	
			JA	01		15		.28		1ST GRIND AXLE JOURNAL #1	1.295	.054	.417	
J10	E						RGR-SU-61	.25	SET UP A GAP GRINDER	PRORATE O/P420,440,460 & 480	1.05938		.304	
0020	E						RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P420,460	.13653		.078	
0030	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0040	E						KMG-OD-LC	2.00	GRIND .010 5 OD X 2 L 4 X 4.98 O.D.		.29334		.674	
0050	E						RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5 IN O.D.		.01014		.058	
0060	E						RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES		.08334		.191	
0070	E						RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0080	E						RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011	
0405			JA	01		15		.37		1ST GRIND AXLE JOURNAL #2	1.298	.072	.552	
0010	E						RGR-SU-61	.25	SET UP A GAP GRINDER	PRORATE O/P420,440,460 & 480	1.05938		.304	
0020	E						GOH-MH-01	.50	TURN OBJECT OVER USING MOISTPRORATE 2 JOURNALS TO SIDE		.00445		.002	
0030	E						RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 440 & 480	.13653		.078	
0040	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0050	E						KMG-OD-LC	2.00	GRIND .010 5 OD X 2 L 4 X 4.98 O.D.		.29334		.674	
0060	E						RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5 IN O.D.		.01014		.058	
170									24.0X8.0					
0080	E						RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES		.08334		.191	
0090	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	
0420			JA	01		15		.37		1ST GRIND AXLE JOURNAL #3	1.429	.079	.608	
0010	E						RGR-SU-61	.25	SET UP A GAP GRINDER	PRORATE O/P420,440,460 & 480	1.05938		.304	
0020	E						RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 460 & 420	.13653		.078	

		RGR-GE-D2	5.00 DWELL (GAP GRINDER STEEL OD)5 IN O.D.	.01014		.000
		RGR-WD-G2	2.00 WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES	.08334		.191
		RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102		.093
		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0435	JA 01	15	.46	1ST GRIND AXLE JOURNAL #4	1.429	.099 .756
		RGR-SU-G1	.25 SET UP A GAP GRINDER PRORATE O/P420.440.460 & 480	1.05938		.304
		RGR-HP-L1	.50 LOAD LARGE PART GAP GRINDER PRORATE O/P 480 & 440	.13653		.078
		KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077
		KMG-OD-LD	2.00 GRIND .010 FROM 5 IN OD X2.5L5 IN X 5.23 O.D.	.36000		.828
		RGR-GE-D2	5.00 DWELL (GAP GRINDER STEEL OD)5 IN O.D.	.01014		.058
		RGR-WD-G2	2.00 WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES	.08334		.191
		RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102		.093
		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0450	JA 01	15	.91	INNER CYL BORE SEAL AREA	1.973	.269 2.065
		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	.27525		.316
		RSG-JP-O3	1.00 PREP HAND BRILL FOR USE	.00861		.009
		ZPO-BP-C1	1.00 BUTTERFLY POLISH SM CYL I.D.	.06549		.075
		RGR-SU-P1	.80 SET UP PLANETARY GRINDER GROUND APROX 80% THE TIME	.82175		.756
		RML-SU-F3	.80 LRG FIXTUR TO/FRM MACH HOISTGROUND APROX 80% THE TIME	.45621		.419
		RML-HP-H3	.80 PART ON/OFF MACH HOIST NORAPGROUND APROX 80% OF THE TIME	.10313		.094
		RML-AL-CC	.80 ALIGN HOLE TO SPINDLE MAG BSGROUND APROX 80% OF THE TIME	.07261		.066
		KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077
		KMG-ID-OB	.80 GRIND OUT .010 8.00 ID X 1 GROUND APROX 80% OF THE TIME	.37365		.343
		KMG-DW-ID	.80 DRESS INTERNAL WHEEL GROUND APROX 80% OF THE TIME	.02458		.022
		RGR-HM-C2	.80 HANDLE & MEAS LENGTH 1 TO 5 GROUND APROX 80% OF THE TIME	.08102		.074
		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0465	JA 01	15	.28	1ST GRIND SEAL AREA	1.320	.055 .425
		RGR-SU-P1	.50 SET UP PLANETARY GRINDER PRORATE O/P 390 & 410	.82175		.472
		RML-SU-F3	.50 LRG FIXTUR TO/FRM MACH HOISTPRORATE O/P 390 & 410	.45621		.262
		RML-HP-H3	.50 PART ON/OFF MACH HOIST NORAPPRORATE O/P 390 & 410	.10313		.059
		RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS	.07261		.083
		KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077
		KMG-ID-OB	1.00 GRIND OUT .010 8.00 ID X 1 1 X 8 I.D.	.37365		.429
		KMG-DW-ID	1.00 DRESS INTERNAL WHEEL	.02458		.028
		RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5	.08102		.093
		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0495	JA 01	15	.10	1ST GRIND INNER I.D.	8.569	.129 .985
		RGR-SU-P1	.50 SET UP PLANETARY GRINDER PRORATE O/P 390 & 410	.82175		.472
		RML-SU-F3	.50 LRG FIXTUR TO/FRM MACH HOISTPRORATE O/P 390 & 410	.45621		.262
		RML-HP-H3	.50 PART ON/OFF MACH HOIST NORAPPRORATE O/P 390 & 410	.10313		.059
		RML-AL-CC	1.00 ALIGN HOLE TO SPINDLE MAG BS	.07261		.083
		KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077
		KMG-ID-OB	11.00 GRIND OUT .010 8.0 ID X 2.0 L 22 IN X 7.9 O.D.	.67681		8.561
		RGR-WD-G2	2.00 WHEEL DRESS GAP GRINDER ALLOW 2 WHEEL DRESSES	.08334		.191
		RGR-HM-C5	1.00 HANDLE & MEAS LENGTH 24 - 36	.11700		.134
		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0790	JA 01	15	.37	FINISH GRIND INNER O.D.	12.728	.706 5.416
		RGR-SU-G1	1.00 SET UP A GAP GRINDER	1.05938		1.218
		RGR-HP-L1	1.00 LOAD LARGE PART GAP GRINDER	.13653		.157
		RML-SU-A1	1.00 DIAL ONE AXIS LONG OR CROSS	.04777		.054
		KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077
		KMG-OD-RK	7.00 GRIND .040 9DIA X 3 LONG 21.75 X 8.5 O.D.	1.22619		9.870
		RGR-GE-D3	9.00 DWELL (GAP GRINDER CHROM OD)8 TO 9 INCH DIA.	.02029		.210
		RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122

	KMG-OD-RH	1.00	GRIND .040 9DIA X 2 LONG	GRIND FLANGE AREA 2 X 8.5 OD	.94502	.971
	RGR-WD-G2	3.00	WHEEL DRESS GAP GRINDER	3 WHEEL DRESSES	.08334	.287
	RGR-GE-D3	9.00	DWELL (GAP GRINDER CHROM OD) 8 TO 9 INCH DIA		.02029	.210
0130 E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674	.122
0140 E	GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL		.00678	.007
0150 E	RLG-RS-P4	2.00	POLISH PLATED SURF INNER CYL2 AREAS		.14667	.337
50 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011
JA 01	15	.28		FINISH GRIND AXLE JOURNAL #1	1.587	.067 .511
0010 E	RGR-SU-G1	.25	SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938	.304
0020 E	RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 840 & 860	.13653	.078
0030 E	RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS		.04777	.054
0040 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761	.077
0050 E	KMG-OD-LH	2.00	GRIND .040 FROM 5 IN OD X 2 L4 X5 IN O.D.		.47334	1.088
0060 E	RGR-GE-D3	5.00	DWELL (GAP GRINDER CHROM OD) 5 INCH DIA		.02029	.116
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102	.093
0080 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011
0810	JA 01	15	.37	FINISH GRIND AXLE JOURNAL #2	1.587	.088 .676
0010 E	RGR-SU-G1	.25	SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938	.304
0020 E	RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 850 & 870	.13653	.078
0030 E	RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS		.04777	.054
0040 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761	.077
0050 E	KMG-OD-LH	2.00	GRIND .040 FROM 5 IN OD X 2 L4 X 5 IN O.D.		.47334	1.088
0060 E	RGR-GE-D3	5.00	DWELL (GAP GRINDER CHROM OD) 5 IN DIA		.02029	.116
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102	.093
0080 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011
0820	JA 01	15	.37	FINISH GRIND AXLE JOURNAL #3	2.094	.116 .891
0010 E	RGR-SU-G1	.25	SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938	.304
0020 E	RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 840 & 860	.13653	.078
0030 E	RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS		.04777	.054
0040 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761	.077
0050 E	KMG-OD-LJ	2.00	GRIND .040 FROM 5 OD X 2 1/25 IN X 5.23 O.D.		.58001	1.334
0060 E	RGR-GE-D3	5.00	DWELL (GAP GRINDER CHROM OD) 5 INCH DIA		.02029	.116
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102	.093
0080 E	RLG-RS-P4	2.00	POLISH PLATED SURF INNER CYLAXLE JOURNALS 1 & 3		.14667	.337
0090 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011
0830	JA 01	15	.46	FINISH GRIND AXLE JOURNAL #4	2.094	.145 1.108
0010 E	RGR-SU-G1	.25	SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938	.304
0020 E	RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 870 & 850	.13653	.078
0030 E	RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS		.04777	.054
0040 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761	.077

0050 E	KMG-OD-LJ	2.00	GRIND .040 FROM 5 OD X 2 1/25 IN X 5.23 O.D.		.58001	1.334
0060 E	RGR-GE-D3	5.00	DWELL (GAP GRINDER CHROM OD) 5 IN DIA		.02029	.116
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102	.093
0080 E	RLG-RS-P4	2.00	POLISH PLATED SURF INNER CYLAXLE JOURNALS 2 & 4		.14667	.337
0090 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001	.011
0100			K.HANSEN TECH.			

0840	JA 01	15	.28	FINISH GRIND I.D. SEAL AREA	2.453	.103 .790
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER		.82175	.945
0020 E	RML-SU-F3	1.00	LRG FIXTUR TO/FRM MACH HOIST		.45621	.524
0030 E	RML-HP-H3	1.00	PART ON/OFF MACH HOIST MORAP		.10313	.118
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261	.083
0050 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761	.077
0060 E	KMG-ID-OG	1.00	GRIND OUT .040 8 ID X 1	1 X 8 I.D.	.76764	.882
0070 E	KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	ALLOWED 3 WHEEL DRESSES	.02458	.084

HISTORY ON OO-ALC 494 FORM
 25FEB83 NEW OCC. FACTOR STUDY UPDATE 11.80
 25MAY83 REMOVE ALL RJPPWF1 ELEMENTS <OLD STD> 8.95
 01AUG84 REWRITE STD W/NEW OCC FACTORS<OLD STD>8.95
 23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> 10.56
 19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD 12.93
 20NOV86 CHANGE FACILITY CODE FROM 1 TO 3
 CLINTON BENTLEY TECH MANEL 3357

0430
 0031
 332
 J33
 0040
 0900

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPGR

09/06/88
4S1-57-3

A-E046B-WM1-BY-M45 PA

OPER	TECH	S	S	W	F	PF	A/R	REV										
SUB	T	K	#R	A	FA	SUPPORT	OCC		DESCRIPTION		BASE	PF	STD					
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS					
PH003	S	E	DI	EA	5	J 88229	1.00	PERCENT ENGR 99.9	MATCH UP STRUT B-52H		1.22		1.22					
0001			DI	01	00		.00		PART NUMBER/NSM		.000	.000	.000					
								7027648-190	1620001398473									
								7027648-210	1620001398474									
0010			DI	01	21		1.00		MATCH UP		1.010	.212	1.223					
0110	E					RLG-MU-01	1.00	MATCH UP PARTS FOR ASSEMBLY			.52681		.637					
0120	E					GCE-JP-TO	1.00	T.O. RESEARCH			.19359		.234					
0130	E					RJP-PW-R1	28.00	REM RPL PAPRMRK SIGN OFF DCOCC FOR 14 EA 958			.01001		.339					
0140	E					RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC			.01001		.012					
9000			DI	01	21		.01		LABOR STANDARD HISTORY		.000	.000	.000					
0010									PRIOR HISTORY ON 00-ALC 494 FORM									
0020									18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW	.93								
0030									08MAR83 ADD SUB OP.0002 FOR PARTS HANDLING OF NOUN									
0040									ROUTED PARTS	TIME WAS	.93							
0041									01AUG84 2 YEAR REVIEW	<OLD STD>	1.35							
0042									24JUL85 2 YEAR REVIEW	<OLD STD>	1.36							

TO INTERROGATE LABOR STANDARDS. INPUT

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

05/10/89
4S1-57-3

A-E046B-MM1-DY-M45 PAGE

PS004	S	E	HB	EA	5	J	88230	1.00	PERCENT ENGR 99.9	MOD NEW BEARING B52H	.28		.28
0001			HB	01	00			.00		PART NUMBER/NSN	.000	.000	.000
0010									9-52299-505	1620009665426			
0020									9-52532-501	1620009072897			
0140			HB	01	15			1.00		REIDENTIFY / METAL STAMP	.099	.015	.114
0010 E								.25	S/U FOR BENCH WORK GENERAL	PPORATE OVER 4 PARTS	.27525		.079
0020 E								1.00	STAMP WITH METAL STAMP		.00342		.003
0030 E								9.00	STAMP W/METAL STAMP ADDL	NINE ADDITIONAL NUMBERS	.00187		.019
0040 E								1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0170			HB	01	21			.50		RIVET GEAR TO BEARING	.275	.029	.166
0010 E								1.00	JOB PREP GENERAL FOR S & M		.22079		.267
0020 E								1.00	DRL 10 HLS IN S/S 3-9 IN SP		.02001		.024
0030 E								2.00	INST FIRST RIVET EASY ACCESS2 EA. RIVETS		.01262		.030
0040 E								5.00		2RIVETS 2 SIDES & ALIGNMENT	.00182		.011
9000			HB	01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000
0010									17 AUG 88 INITIAL INPUT				
0011									MOVED FROM MNPGR 000100018				

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MHPGP

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17143A STRUT B-52 ML6

OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	
SUB	T	K	#R	A	FA	SUPPORT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	
PS021	E	N	HB	EA	5	J	88235	1.00	PERCENT ENGR	.0			.30	.30
0001			HB	01	00			.00			.000	.000	.000	
0010								4-80884	1620003079347					
0025			HB	01	21			1.00	RIVET STOP ASSY		.250	.053	.303	
0010	N							1.00	RIVET STOP		.25000		.302	
9000			HB	01	00			.00	LABOR STANDARD HISTORY		.000	.000	.000	
0010									22 AUG 88 INITIAL INPUT					
0900									DOLORES HENDRICKS					

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17143A STRUT B-52 M.L.G

RCC MNP6P

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TECH S S W F PF A/R REV
 T K #R A FA SUPPORT OCC <----- DESCRIPTION ----->
 STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL BASE PFD STD
 HOURS TIME HOURS DLY PCT

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT
0017	S	E	HB	EA	5	J 09235	1.00	PERCENT ENGR 99.9	DISSY-ASSY JACKSHAFT B52M		4.28		4.28	
0001			HB	01	00		.00		PART NUMBER/NSN		.000	.000	.000	0
						0010		5-68470-2	1620003079442					
0006			HB	01	21		1.00		HAND CLEAN		1.646	.346	1.993	47
0010	E					RLG-CS-T1	1.00	CL BSKT STRUT PTS IN TRICAL			.08559		.103	
0020	E					RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART/			.04595		.055	
0025	E					GCE-ME-11	1.00		MOVE PARTS TO BLAST		.17191		.208	
0030	E					RLG-EI-C6	3.00	CHK ALL WARE AREAS BY MESRNG/3 EACH PARTS			.44779		1.625	
0007			HB	01	21		1.00		DISASSEMBLE JACKSHAFT		.582	.122	.705	16
0005	E					GCE-JP-TO	1.00	T.O. RESEARCH			.19359		.234	
0010	E					GLM-FB-DA	8.00	REMOVE BOLT, WASHER AND NUT /REMOVE 8 EA BOLTS			.01059		.102	
0020	E					ANF-CP-D1	5.00	REMOVE COTTERPIN WITH PLIERS/REMOVE COTTER PINS 5 EACH			.00568		.034	
0030	E					GLM-FN-DA	4.00	REMOVE NUT AND WASHER /4 EACH NUTS AND WASHERS			.00948		.045	
0040	E					KMF-TL-D5	2.00	REMOVE PART W/HAMMER & DRIFT/REMOVE 2 SHAFT ENDS			.00305		.007	
0050	E					GNF-LR-D2	6.00	REMOVE LOCK RINGS OR KEEPERS/REMOVE 6 LOCKRINGS			.00895		.064	
0050	E					RLG-DS-SC	1.00	REMOVE GLAND NUT /			.02910		.035	
0070	E					KMF-TL-D5	3.00	REMOVE PART W/HAMMER & DRIFT/REMOVE 3 INTERNAL PARTS			.00305		.011	
0090	E					GLM-AE-DA	2.00	REMOVE STAND-OFF OR SPACER /REMOVE SHIMS 2 SETS			.00530		.012	
0090	E					GDF-EB-DA	9.00	REMOVE BEARING /REMOVE 9 BEARINGS			.01437		.156	
0050			HB	01	21		1.00		ASSEMBLE JACK SHAFT		1.219	.256	1.475	34
0005	E					GCE-JP-TO	1.00	T.O. RESEARCH			.19359		.234	
0010	E					GDF-EB-AA	9.00	INSTALL BEARING	INSTALL BEARINGS		.03745		.407	
0020	E					GTE-ET-A5	2.00	INSTALL SHIMS	INSTALL SHIMS 2 EA		.01428		.034	
0030	E					KLJ-SE-01	3.00	LUBE SPOT WITH BRUSH, ETC	LUBRICATE PARTS 3 EA		.00087		.003	
0040	E					RY-Y-AS-C1	1.00		INSTALL INNER PARTS		.61286		.741	
0050	E					RLG-AS-SC	1.00	INST PACKING GLAND NUT CONST/			.02279		.027	
0060	E					GNF-LR-A1	6.00	INSTALL LOCK RING OR KEEPERS/			.00289		.020	
0080	E					RLG-AM-05	2.00	INST MAT PT W/MALLET BLOWS /2 EACH ENDS			.00212		.005	
0055			HB	01	00		1.00		CHECK ALIGNMENT		.109	.000	.109	3
0010	E					RLG-EI-AC	1.00	CHECK ALIGNMENT			.06483		.064	
0020	E					GLM-FN-AB	1.00	INSTALL NUT AND WASHER			.01692		.016	
0030	E					ANF-CP-A1	1.00	INSTALL COTTERPIN W/PLIERS			.00737		.007	
0040	E					GLM-FB-AA	1.00	INSTALL BOLT - NORMAL ACCESS			.01015		.010	
0050	E					RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC			.01001		.010	
9000			HB	01	21		.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010									PRIOR HISTORY ON OO-ALC 494 FORM					
0020									18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW	5.47				
0021									01AUG84 2-YEAR REVIEW <OLD STD>	5.46				
0022									24JUL85 2 YEAR REVIEW <OLD STD>	5.47				
0023									18FEB86 MOVE SUB OP 0040 TO OP PP010<OLD STD>	5.47				
0024									31 MARCH 87 DELETED STEP 0020 SUBOP 0020 NO BLAST					
0025									DONE BY MNP6P, DELETED STEP 0070 SUBOP 0030 PAINT					
0026									DONE BY JS SKILL CODE, ADDED STEPS 0020 & 0025					
0027									SUBOP 0020 NICK & BURR AND MOVE PARTS TO BLAST					
0028									ENGINEERED TIME STEP 0040 SUBOP 0030 INSTALL					
0029									INNER PARTS <OLD STD 5.13>					
0000									KERRY COOP MANEL TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MRP GP

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OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL					
00010	E	N	HB	EA	5	J 88229	1.00	PERCENT ENGR	.6	STRUT ASSY B-52H	10.71		10.71	
0001			HB	01	00		.00			PART NUMBER/NSN	.000	.000	.000	
0010								7027648-190		1620001398473				
0020								7027648-210		1620001398474				
0501			HB	01	21		1.00			PRE ASSY CLEAN	1.000	.210	1.210	
0010	N						1.00			CLEAN PARTS	1.00000		1.210	
0502			HB	01	21		1.00			ASSY INTERNAL PARTS	1.500	.315	1.815	
0010	N						1.00			ASSY PARTS	1.50000		1.815	
0504			HB	01	21		1.00			OK TO CLOSE/ASSEMBLE	3.000	.630	3.630	
0010	N						1.00			ASSEMBLE	3.00000		3.630	
0505			HB	01	21		1.00			CAM ALIGNMENT	.404	.085	.489	
0010	N						1.00			ALIGN CAM	.40400		.488	
0506			HB	01	21		1.00			CHECK STROKE	.500	.105	.605	
0010	N						1.00			CHECK STROKE	.50000		.605	
0507			HB	01	21		1.00			PRESSURE TEST	.493	.104	.597	
0010	N						1.00			TEST	.49300		.596	
0509			HB	01	21		1.00			TEST TRUNNION PORTS	.500	.105	.605	
0010	N						1.00			TEST PORTS	.50000		.605	
0510			HB	01	21		1.00			INSTALL STEERING BEARING	.304	.064	.368	
0010	N						1.00			INSTALL BEARINGS	.30400		.367	
			HB	01	00		1.00			INSTALL EXTERNAL PARTS	.750	.000	.750	
0010	N						1.00			INSTALL PARTS	.75000		.750	
0513			HB	01	00		1.00			CHECK STATUS OF PARTS ON 958	.250	.000	.250	
0010	N						1.00			SIGN OFF PARTS	.25000		.250	
0535			HB	01	25		1.00			FINAL ACCEPTANCE OF W.C.D.	.180	.045	.226	
0010	N						1.00			FINAL	.12800		.160	
0020	E					GJP-FP-B5	1.00			FILL OUT FORM 424 & ATTACH	.05255		.065	
0540			HB	01	25		1.00			FINAL VISUAL INSPECTION	.137	.034	.171	
0010	N						1.00			FINAL VISUAL INSPECTION	.12700		.158	
0020	E					RJP-PW-R1	1.00	REM RPL PAPWRK	SIGN OFF DOC		.01001		.012	
9000			HB	01	21		.01			LABOR STANDARD HISTORY	.000	.000	.000	
0010										PRIOR HISTORY ON OO-ALC 494 FORM				
0020										18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW	9.18			
0030										20OCT83 REVIEW <OLD STD>	9.18			
0031										01AUG84 2 YEAR REVIEW <OLD STD>	8.90			
0032										24JUL85 2 YEAR REVIEW <OLD STD>	8.90			
0033										20OCT86 ADDED TIME TO INSTALL PINS				
0034										& DROPED PAINT TIME OLD STD	8.90			

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17143A STRUT B-52 MLG
OPER TECH S S W F PF A/R REV

OPER	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					DL
PP003	S	E	3S	EA	5	J	88229	1.00	PERCENT ENGR 93.2	PAINT STRUT ASSY B-52	3.07		3.07					
0001			3S	01	00			.00		PART NUMBER/NSN	.000	.000	.000					
	0010								7027648-190	1620001398473								
	0020								7027648-210	1620001398474								
0515			3S	01	25			1.00		FINAL PAINT	2.391	.598	2.989					
	0010	E				ZLG-HP-09		1.00	UNLOAD STRUT FROM CART		.02016		.025					
	0020	E				ZLG-PF-04		1.00	PAINT & FINAL V/LARGE STRUT		1.61131		2.014					
	0030	E				ZMA-MN-M1		1.00	MASK MED MLG STRUT FOR PAINT	ADDITIONAL MASK TIME	.09313		.116					
	0050	E				ZMP-SP-P4		1.00	PRIMER PAINT V/LRG STRUT/PT		.15498		.193					
	0060	E				ZMP-SP-P1		1.00	PRIMER PAINT SMALL STRUT	ADDITIONAL PRIMER PAINT	.08690		.108					
	0070	E				ZMP-SP-F2		1.00	FINAL PAINT MED STRUT/PART	ADDITIONAL FINAL COAT	.25790		.322					
	0080	N						1.00		FINAL VISUAL INSPECTION	.16700		.208					
0520			3S	01	25			1.00		DECALS	.072	.018	.090					
	0010	E				RLG-JP-DS		1.00	GET STRUT DECALS F/STO CAB		.00693		.008					
	0020	E				KID-DL-AA		4.00	INSTALL DECAL PR SENSITIVE	ADDITIONAL DECALS	.01378		.068					
	0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012					
9000			3S	01	25			.01		LABOR STANDARD HISTORY	.000	.000	.006					
	0010								PRIOR HISTORY ON 00-ALC 494 FORM									
	0020								18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW	2.82								
	0021								01AUG84 2 YEAR REVIEW <OLD STD>	2.82								
	0022								12OCT84 REWRITE STD <OLD STD>	2.82								
	0023								24JUL85 2 YEAR REVIEW <OLD STD>	3.54								
	0024								10FEB86 ADD SUB 0030 FOR PAINT JACKSHAFT<OLD	3.54								

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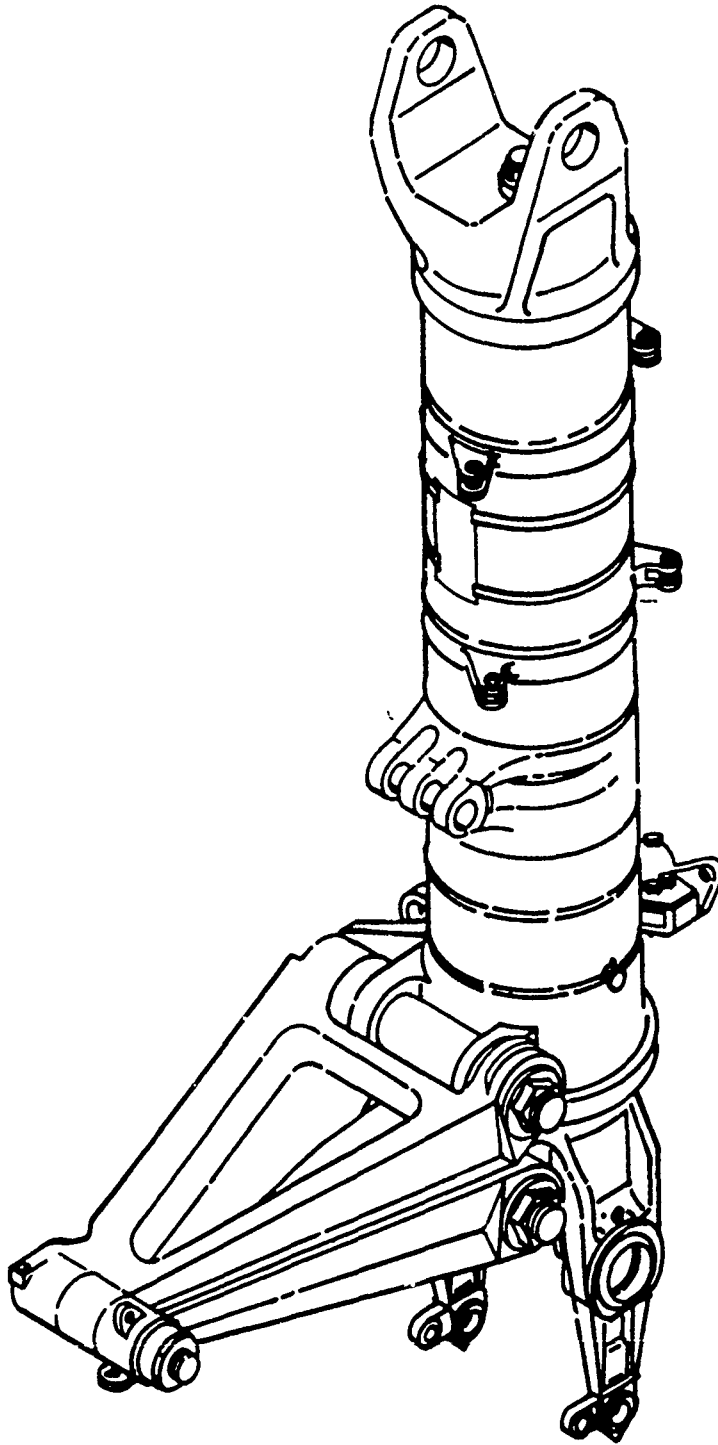


Figure 1-2. Main Gear Oleo Assembly

KEY TO FIGURE 2-1.

- | | | |
|---------------------------|------------------------|-----------------------|
| 1. Air Changing Valve | 19A. Shim (AR) | 37. Retaining Nut |
| 2. Plug & Bleeder | 20. Back-up ring | 38. Scraper |
| 3. Gasket | 21. Gasket | 39. Lower bearing nut |
| 4. Nut | 22. Cotter pin | 40. Nut |
| 5. Bolt | 23. Nut | 41. Clamp |
| 6. Bolt | 24. Screw | 42. Retaining Nut |
| 7. Lubefitting | 25. Retaining Nut | 43. Nut |
| 8. Up-Lock roller pin | 26. Piston head washer | 44. Bolt |
| 9. Bushing | 27. Upper bearing | 45. Insert |
| 10. Up-Lock roller | 28. Washer | 46. Plate |
| 11. Nut | 29. Spacer | 47. Rod |
| 12. Bolt | 30. Lower bearing | 47A. Bolt |
| 13. Door Operator bracket | 30A. Spacer | 48. Pin |
| 14. Nut | 31. Back-up ring | 49. Packing |
| 15. Washer | 32. T Seal | 50. Back-up ring |
| 16. Bolt | 33. Packing Adapter | 51. Fitting |
| 17. Lockplate | 34. Back-up ring | 52. Bushing |
| 18. Cotter pin | 35. T Seal | 53. Bushing |
| 19. Nut | 36. Feltwipe | 54. Bushing |
| | | 55. Bushing |
| | | 56. Bushing |
| | | 57. Inner Cylinder |
| | | 58. Bushing |
| | | 59. Bushing |
| | | 60. Fitting |
| | | 60A. Retainer |
| | | 61. Bushing |
| | | 62. Bushing |
| | | 63. Bushing |
| | | 64. Outer Cylinder |

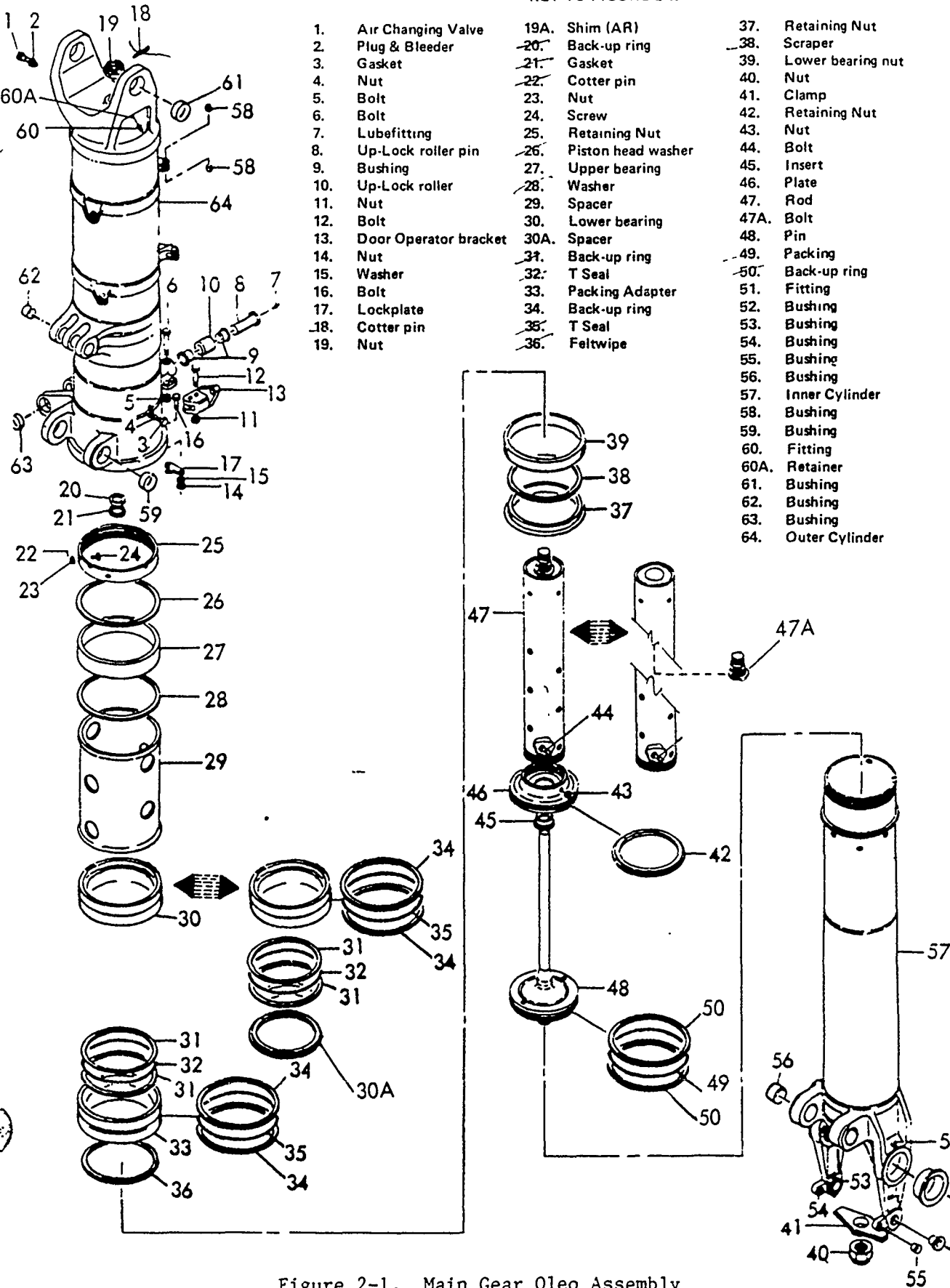


Figure 2-1. Main Gear Oleo Assembly

KEY TO FIGURE 2-2.

30. Nut	46. Bolt	60. Bolt
31. Bolt	47. Nut	61. Deleted
32. Nut	48. Washer	62. Bolt
33. Washer	49. Washer	63. Bushing
34. Bolt	50. Bolt	64. Spacer Assy
35. Spacer	51. Shim	65. Nut
36. Plug	52. Shim	66. Bolt
37. Nut	53. Spacer half	67. Nut
38. Bolt	54. Spacer half	68. Washer
39. Bolt	55. Spacer	69. Bolt
40. Spacer	56. Nut	70. Fitting
41. Bushing	57. Bolt	71. Bushing
42. Spacer Assy	58. Nut	72. Bushing
43. Nut	59. Washer	73. Link
44. Washer		
45. Washer		

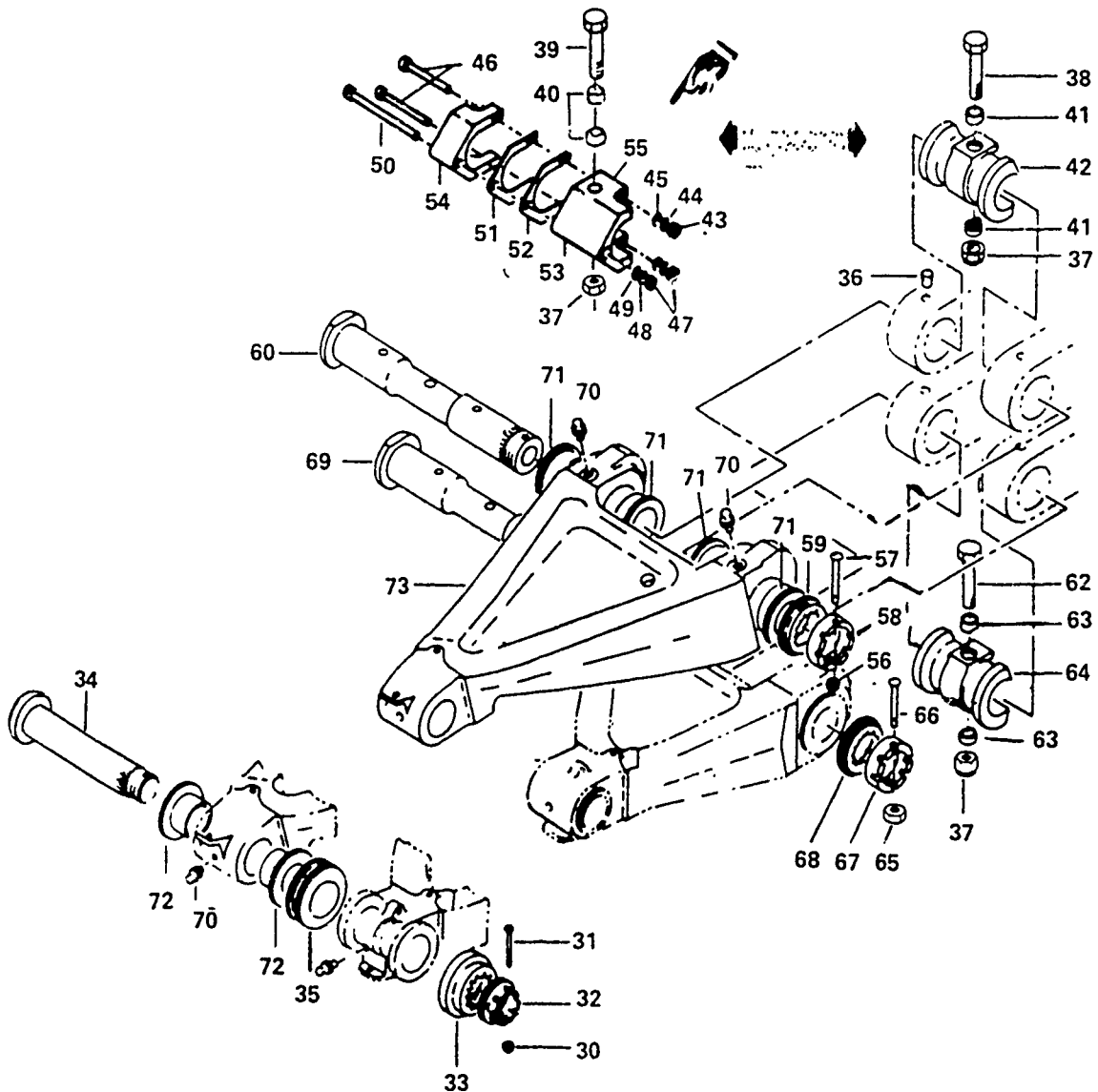
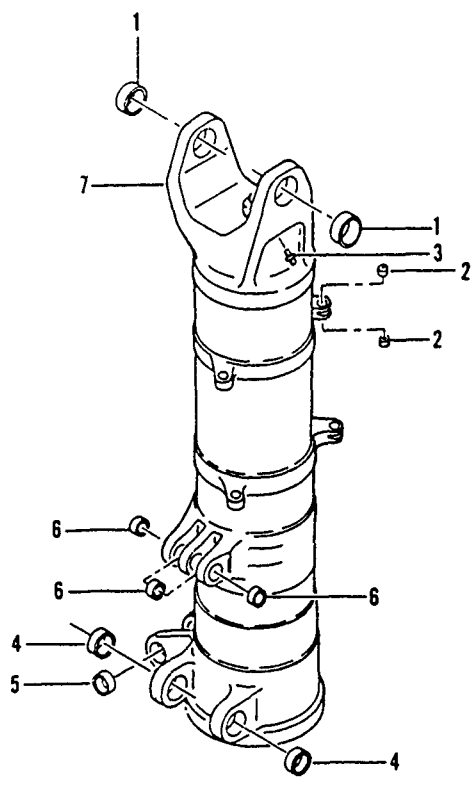
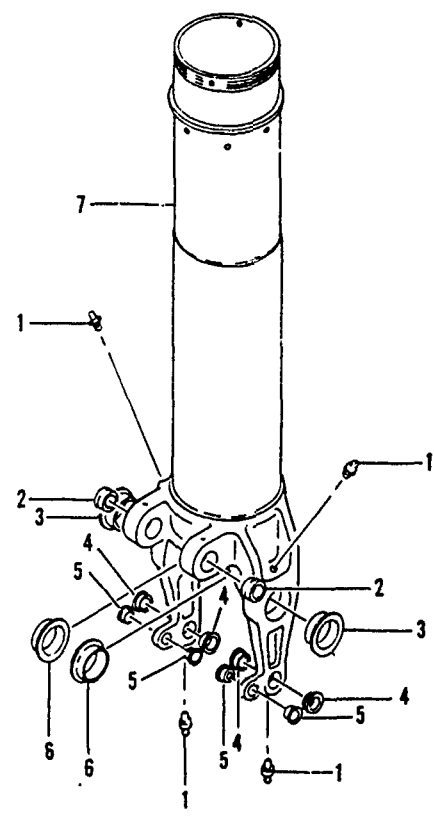


Figure 2-2. Torsion Link Assembly



KEY TO FIGURE 2-3	
1. BUSHING	4. BUSHING
2. BUSHING	5. BUSHING
3. LUBRICATION FITTING	6. BUSHING
	7. OUTER CYLINDER

Figure 2-3. Outer Cylinder Assembly



KEY TO FIGURE 2-4	
1. LUBRICATION FITTING	4. BUSHING
2. BUSHING	5. BUSHING
3. BUSHING	6. BUSHING
	7. INNER CYLINDER

Figure 2-4. Inner Cylinder Assembly

- KEY TO FIGURE 2-5
- 1 PISTON ROD RING
 - 2 NUT
 - 3 BOLT
 - 4 ORIFICE PLATE INSERT
 - 5 ORIFICE PLATE
 - 6 PISTON ROD
 - 7 BOLT

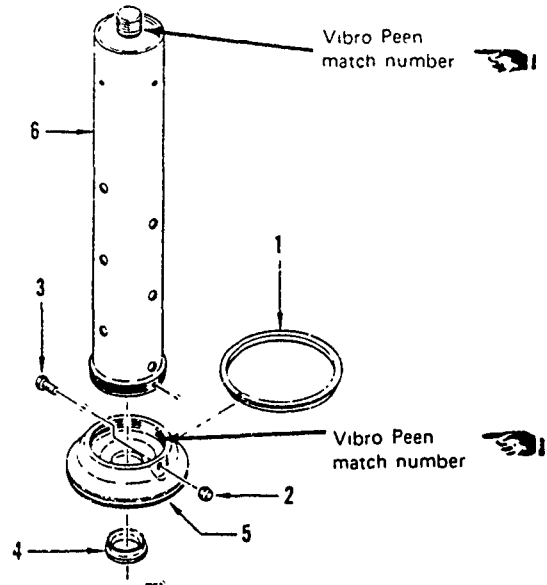


Figure 2-5. Piston Rod Assembly

- KEY TO FIGURE 2-6
- 1. BUSHING
 - 2. ROLLER

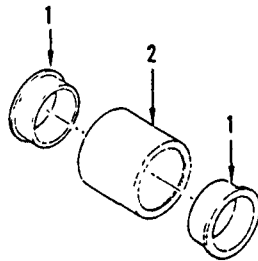


Figure 2-6. Up-Lock Roller Assembly

- KEY TO FIGURE 2-7
- 1. LUBRICATION FITTING
 - 2. UP-LOCK ROLLER PIN

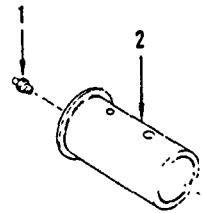


Figure 2-7. Up-Lock Roller Pin Assembly

SECTION I

INTRODUCTION

1-1. IDENTIFICATION. The Main Gear Oleo Assembly is a compression strut which absorbs takeoff and landing impact shocks, and is the principal structural member of the main landing gear of the airplane. See figure 1-1 for leading particulars of the Main Gear Oleo Assembly.

Type	Air-Oil
Fluid	Hydraulic Fluid, Specification MIL-H-5606
Length	
Compressed	67.19 Inch
Taxi	70.19 Inch
Extended	89.19 Inch
Weight	600 Pounds

Figure 1-1. Leading Particulars

1-2. CONTENTS. This technical manual contains overhaul, inspection, and test instructions for the Main Gear Oleo Assembly, part Nos. 65-1263, all dash numbers, and 7531273, all dash numbers, manufactured by The Boeing Company, Renton, Washington. Information in this manual will enable overhaul personnel to return the Main Gear Oleo Assembly to a condition that meets all original design requirements while

maintaining component parts interchangeability. Overhaul, reassembly, and instructions are provided in Sections VI, VII and VIII.

1-3. HOW TO USE MANUAL. The following instructions are recommended as a guide for maximum utilization of this manual.

a. Consult figure 1-3 for index chart of landing gear parts.

b. Perform all operations, as far as possible, in accordance with sequence as given, i.e., disassemble, clean, strip paint, inspect, etc.

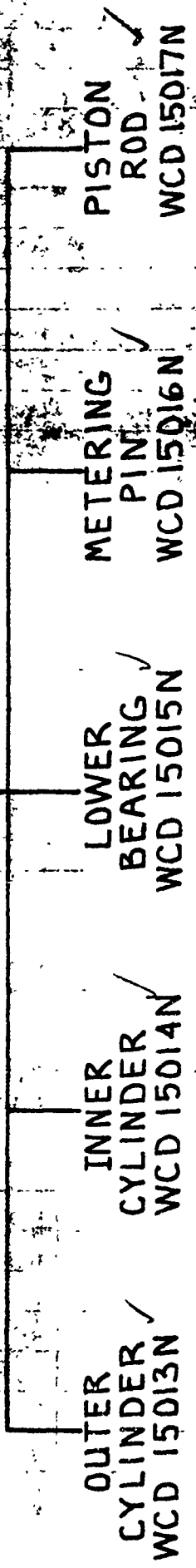
c. Identify basic material of each component. Basic material is that metal used for part fabrication and constitutes main structure foundation. See figure 6-1 for Material Identification Chart.

CAUTION

Steel parts heat-treated 220 ksi and above require strict adherence to rework instruction. Improper rework procedures can expose these parts to early failures. It is recommended that parts in the 220 ksi and above heat-treat range be tagged for easy identification.

KC-135 MAIN
LANDING GEAR ASSEMBLY

PCN 69657A ✓
WCD 15043N



OUTER
CYLINDER ✓
WCD 15013N

INNER
CYLINDER ✓
WCD 15014N

LOWER
BEARING ✓
WCD 15015N

METERING
PIN ✓
WCD 15016N

PISTON
ROD ✓
WCD 15017N

n/s

n/s

n/s

FAMILY 3

CONTROL NUMBER LIST

LABO TECH	FORM TECH	CONTROL NUMBER	JOB DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDE
DELE		69568A		C-130 MLG	PISTON	1620-00-954-8000	25 NOV 86	452-23-3
BENT POLL		69569A		C-130 MLG	TORQUE STRUT ASSY	1620-00-605-8495	388064-1	451-69-13
DELE		69572A		C-130 MLG	CYLINDER	1620-00-623-8912	25 NOV 86	451-37-3
COOP POLL		69573A		C-130 MLG	TORQUE STRUT	1620-00-623-8913	388065-7	451-69-13
BENT POLL		69577A		C-130 MLG	BRACE ASSY	1620-00-976-3391	371689-12	45A6-7-3
BENT POLL		69578A		C-130 MLG	STRUT ASSY	1620-01-143-1155	7926487-30	452-23-3
JENS PRIC		69589A	-J	F-100 MLG	WHEEL	1630-00-067-4924	3-1000	4W3-7-1023
JENS PRIC		69591A	-J	F-100 MLG	WHEEL	1630-00-696-3570	218A381	4W3-7-1293
RIGB PRIC		69595A		B-52	MAIN WHEEL	1630-00-212-0942	3-1192-1	4B1-4-133
DELE		69602A		F-106	GONE SWITCH	1440-00-942-1047AA	11 JULY 86	11L1-3-14-1
COVI SHEL		69603A		F-111	INERTIA REEL	1377-01-141-8911	0103157-77	11P9-11-3
HART SHEL		69621A		A-37	CONTROL BOX ASSY	1005-00-051-8781	DCK-144A378-9	11W1-15-12
BENT POLL		69626A		C-130 MLG	STRUT ASSY	1620-00-505-1184	3303591-3	452-23-3
BENT POLL		69651A		C-130 MLG	STRUT ASSY	1620-00-623-8911	370438-1	451-37-3
BENT POLL		69652A		C-130 MLG	STRUT ASSY	1620-00-111-1418	695001-9A	451-37-3
BENT POLL		69653A		C-130 MLG	COLLAR	1620-00-697-0191	352604	452-23-3
JENS RIGB		69654A	-G-J	F-15	BRAKE ASSY	1630-01-118-3642	5003063-6	4B1-2-1163
JENS POLL		69655A	-G-J	C-130	BALLSCREW	1620-01-065-4867	843012	1663-2-87-3
JENS COOP		69657A		KC-135 MLG	STRUT ASSY L/H	1620-01-038-9102	7531273-90	
BENT COOP		69658A		KC-135 MLG	STRUT ASSY R/H	1620-01-038-9101	7531273-100	451-56-3
JELE		69697J		C-141 MLG	ORIFICE TUBE	1620-00-202-5315	2 JAN 85	451-73-3
COOP COOP		69707A		F-15 MLG	LOWER BRACE	1620-00-305-1849	68A450771-1001	452-73-4
COOP POLL		69775A	-G	C-141 MLG	ROOT PIN	5315-00-500-6801LE	7430214-01	451-73-3
COOP TOLM		69777A		B-52 MLG	LOWER LINK	1620-00-217-4961	1-80604	451-28-4
JENS PRIC		69794A	-J	F-15 MLG	WHEEL	1630-01-141-4695	5000064-9	4W1-8-73
ONR TOLM		69803A		CH-3 MLG	STRUT ASSY	1620-01-168-0338	8341139-10	452-50-3
JENS RIGB		69807A	-J	F-15 MLG	A/B BRAKE ASSY	1630-01-018-2118	5000913-10	4B1-2-1123
ONR ANDE		69825A		C-5A MLG	UPPER BEARING	3120-00-251-7338LE	78869	452-67-3
JELE		69826A		F-16 MLG	DRAG STRUT	1620-01-101-1700	16 APR 86	45A6-32-3
COOP TOLM		69833A		F-111 MLG	STRUT ASSY-SHOCK HW	1620-01-103-1950	1130100-503	451-87-3
JELE		69834A		F-16 MLG	DRAG STRUT	1620-01-070-9360	26MAR 86	45A6-32-3
JELE		69853A		B-52	BOX END CROSSOVER	1005-00-898-9671	28 OCT 86	11F8-3-7-3
COOP TOLM		69855A	-G	B-52 MLG	STEERING PLATE	1620-00-605-2768	5-68457-5	451-57-3
HART SHEL		69857A		A-10	EQUALIZER GAU-8	1005-01-055-0315	205F469	11W1-7-14-3
JELE		69865A		A-10	DRUM ASSY GAU-8	1005-01-003-1436	05-20-87	11W1-7-14-3
JELE		69873A	-J	C-47 MLG	BRAKE	1630-00-959-2052	25 NOV 86	4B1-5-23
JELE		69875A		F-111 MLG	UPPER TRUNNION ASSY	1620-01-065-3417	10 OCT 80	4A4-15-3-2
COOP TOLM		69887A		B-52 TIP	OUTER CYLINDER	1620-00-705-7261	5-96453-501	456-2-3
ONR ANDE		69898A		C-5A MLG	FORWARD DRAG LINK	1620-00-115-7433	4651437-107A	452-67-3
ONR ANDE		69899A		C-5A MLG	LOWER BEARING	3120-00-158-1799LE	4694453-101B	452-67-3
JELE		69915A		B-52	AMMO CAN	1005-00-21-3225	28 OCT 86	11W1-34-3-1
JELE		69928A		F-16 MLG	STRUT ASSY	1620-01-098-2749	20 FEB 87	452-00-3
ALD TOLM		71069A		F-111 MLG	LINK ASSY	1620-00-415-0200	12L9548-13	4A4-15-3
JELE		72827A		C-5A MLG	COMP. LINK	1620-00-109-1076	12 DECEMBER 86	451-94-3
JELE		72836A		C-5A MLG	LOWER SIDE BRACE ARM	1620-00-115-7387	5-OCT-87	451-93-3
JELE		72846A	-G	C-5A MLG	FLUID TRANS HOUSING	1620-00-115-7419	12 DECEMBER 86	451-93-3
ONR ANDE		72848A		C-5A MLG	UPPER TORQUE ARM	1620-00-115-7431	4651432-101A	452-67-3
ONR ANDE		72852A		C-5A MLG	TRUNNION PIN	1620-00-116-2099	4612400-101A	451-93-3
ONR ANDE		72877A	-G	C-5A MLG	STRUT ASSY	M 1620-00-432-5651	4651403-1036	452-67-3
ONR ANDE		72879A		C-5A MLG	OUTER CYLINDER	M 1620-00-446-3776	4611415-107A	451-93-3

FACTORED

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAND HOURS
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[REDACTED]	MNPGP	00010	N	HS	5	0.10	1.00	6.10
		PP043	E	3S	5	1.53	1.00	1.63

FAMILY 3 *

KC-135
MLG

MNPGW	PM043	N	DJ	5		.95	1.00	98
	WC001	E	KI	5		1.62	1.00	1.62
	WD001	E	HS	5		3.09	1.00	3.09
	WE013	N	DI	5		1.70	1.00	1.80
	WE014	N	DI	5		.83	1.00	88
	WE015	N	DI	5		.17	1.00	17
	WE016	N	DI	5		.13	1.00	13
	WE017	E	DI	5		.08	1.00	8
	XNPGW	X	HS	5		1.94	1.00	1.94

10.69

MNPNA	NA013	E	DB	2		1.20	1.00	1.20
	NA014	E	DB	2		1.08	1.00	1.08
	NA016	E	DB	2		.15	.35	5
	XNPNA	X	DB	2		2.60	1.00	2.60

4.93

MNPRA	RA013	E	JA	1		9.14	.05	45
	RA014	E	JA	1		7.29	.05	36
	RA015	N	JA	1		2.63	.20	52
	RA017	E	JA	1		.22	1.00	22

1.55

MNPRB	RB013	N	JA	3		13.37	.05	69
	RB014	E	JA	3		9.99	.05	49

1.18

MNPRC	RC013	E	UP	8		5.19	.05	25
	RC014	N	UP	8		5.53	.05	27
	RC015	E	UP	8		.54	.35	18
	RC016	E	UP	8		.36	.35	12
	XNPRC	X	UP	8		2.09	1.00	2.09

2.91

*

[REDACTED]

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2 JOB ORDER NO.	3 QUANTIT.	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S1-56-3	9. ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES KC-135 MLG	11 STOCK NUMBER	12 OPTIONAL 25325A 69657A 25326A 69658A
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"
P/N		NSN C/N			
7531273-80		1620010389103 25325A			
7531273-70		1620010389100 25326A			
7531273-90		1620010389102 69657A			
7531273-100		1620010389101 69658A			
		GOVERNING DIRECTIVES: AFMOR 66-51 MANDI 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 B 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 PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA (CONTINUED)			

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15043N
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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 STRUT ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP,			
	001	7531273-70 7531273-80 7531273-90 7531273-100			
	010	*MATCH-UP* -----ROUTED COMPONENTS----- NEW/SERVICEABLE REWORK NO REWORK		001 MNRGP 002 06 003 MU01	
		OUTER CYLINDER 15013N INNER CYLINDER 15014N			
		BEARING (LOWER) 15015N PIN, METERING 15016N			
		PISTON ROD 15017N			
	500	FINAL ACCEPTANCE OF WCD PACKAGE FOR COMPLETNESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *C/P MOVE		001 MNRGP 002 06 003 SA03	
	501	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FORIEGN MATERIAL PRIOR TO REASSEMBLE *C/P MOVE		001 MNRGP 002 06 003 SA03	
	502	OK TO CLOSE AND/OR ASSEMBLE I.A.W. T.O. 491-56-3 *C/P MOVE		001 MNRGP 002 06 003 SA03	
	504	TORQUE ALL NUTS, BOLTS, AND SCREWS AS REQUIRED I.A.W. T.O. 491-56-3		001 MNRGP 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		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	16. PERFORM. RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	505	CHECK STROKE IAW T.O. 451-56-3 *C/P MOVE					001 MNP GP 002 06 003 SA03		
	506	PRESSURE TEST I.A.W. T.O. 451-56-3 *C/P MOVE					001 MNP GP 002 06 003 TL07		
	510	MASK, PRIME AND PAINT *C/P MOVE					001 MNP GP 002 09 003 WB03		
	512	DECALS *C/P MOVE					001 MNP GP 002 09 003 WB03		
	515	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*					001 MNP GP 002 09 003 WB03		
	516	FINAL PRODUCT VISUAL INSPECTION *REQD*					001 MNP GP 002 09 003 WB03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		15043N				
		B	D						

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNPBP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S1-56-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES KC-135 MLG	11. STOCK NUMBER	12. OPTIONAL 69657A
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	69658A 2532b 25325A
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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		NSN C/N			
65-5763-17		1620009274739 69657A L / H			
65-5763-18		1620009592078 69658A R / H			
50-9712-32		1620007871750 25325A R / H			
50-9712-31		1620007871749 25326A L / H			
		***UNIT COST \$49579.05**			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		BLAST IAW MIL-STD-1504			
		NICKEL PLATE IAW MIL-STD-868			
		FMPI IAW MIL-STD-1949 P/D N01561			
		FPI IAW MIL-STD-6866			
		CAD PLATE IAW MIL-STD-870			
		CHROME PLATE IAW MIL-STD-1501			
		TEMP ETCH IAW MIL-STD-867			
		SHOTPEEN IAW MIL-S-13165			
		GRIT BLAST IAW MIL-STD-1504			
		BAKE IAW 4S-1-182 MADI 74-12			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		STEEL - AMS 6407 220/240 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 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 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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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 OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		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 PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	65-5763-17 65-5763-18 50-9712-32 50-9712-31			
	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745188	
	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNP GW 002 03 003 SL01	
	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNP GW 002 03 003 BL01	
	011 *REQD*	BAKE 4HRS AT 350-400F DATE IN _____ TIME IN _____ (CONTINUED)		001 MNP GW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N.
		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 AL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
18. DISPATCH STATION	16. PERFORM RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		DATE OUT _____ TIME OUT _____ RC/P MOVE							
		[REDACTED] RC/P MOVE							001 MNP NA 002 05 003 ML04
	030	E & J **NOTE: HAND TYPE POWER TOOLS SHALL NOT BE USED TO REPAIR DAMAGE OF CORROSION PAGE 6-4, PARA 6-70.							001 MNP GW 002 04 003 EI01
		LOWER ROPE 11.00/11.003 IN WEAR 11.005 IN REPAIR MAX 11-040 IN							
		UPPER ROPE 10.625/10.630 IN WEAR 10.632 IN REPAIR MAX 10.680 IN							
		****IRONION LUGS****							
		I.D. 2.687/2.689 IN WEAR 2.691 IN REPAIR MAX 2.820 IN							
		LUG WIDTH 1.24/1.26 IN REPAIR MIN 1.20/1.22 IN							
		FACE TO FACE 9.500/9.505 IN REPAIR MAX 9.540/9.545 IN							
		OVERALL 11.980/12.025 IN REPAIR MIN 11.940/11.985 IN							
		****DRAG STRUT LUGS (BASE METAL)****							
		I.D. 1.625/1.626 IN. REPAIR MAX 1.806 IN (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	15013N	
		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 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"
		BUSHING I.D. 1.500/1.501 IN WEAR 1.502 IN			
		CENTER LUG WIDTH .996/.998 IN REPAIR MIN .996/.998 IN OUTSIDE LUGS WIDTH .99/1.01 IN REPAIR MIN .96/.98 IN			
		FACE TO FACE 1.312/1.314 IN REPAIR MAX 1.342/1.344 IN			
		*****SIDE BRACE LUGS***** I.D. 2.125/2.126 IN REPAIR MAX 2.185 IN			
		BUSHING I.D. 2.000/2.002 WEAR 2.004 IN LUG WIDTH .877/.89 IN REPAIR MIN .855/.875 IN (INSIDE FACE ONLY)			
		FACE TO FACE 4.000/4.004 IN REPAIR MAX 4.035 IN			
		*****TORQUE ARM LUGS***** I.D. 2.625/2.626 IN REPAIR MAX 2.677 IN			
		BUSHING 2.500/2.502 IN WEAR 2.504 IN			
		OVERALL 9.120/9.124 IN REPAIR MIN 9.080/9.084 IN			
		BOLT HOLE .6397/.646 IN *****UNLOCK SOCKET***** (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		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 OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED					18 MECHANIC	19 "P"	20 "Q"
		I.D. 1.938/1.939 IN WEAR 1.940 IN 1ST O.S. MAX 1.945 IN 2ND O.S. MIN 1.965 IN FOR MAX REPAIR LIMIT, MAINTAIN MIN WALL THICKNESS OF .190 IN. IN LINE WITH CROSS PIN HOLE, CROSS PIN HOLE .313/.314 IN *****HYD LINE AFT HOLES***** .442/.438 IN FLANGE THICKNESS .740/.745 IN *****GLAND NUT LOCK PLATE HOLES***** I.D. .312/.316 IN *****DOOR BRKT BOLT HOLES***** I.D. .3746/.3754 IN BUSHING ID .250/.2515 *****ORIFICE TUBE HOLE***** I.D. 1.875/1.877 IN WEAR 1.879 IN REPAIR MAX 1.998/2.000 IN. NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE							
QVC	032	100% INSPECTION OF LOWER BORE THREADS IAW T.D. 451-56-3 PAGE *REQD* 4-3 NOTES: I & K *C/P MOVE							001 MNP GW 002 04 003 EI01
69	035	REMOVE BUSHINGS NOT PREVIOUSLY REMOVED *C/P MOVE							001 MNP RA 002 04 003 BE01
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/EN				
DISPATCH	FUNCTIONAL CODE	A	C	15013N					
		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 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	036	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	037	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	038	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
B	040	TRUNNION LUGS GRIND OFF CORROSION OR NICKEL FROM LUG FACE. NOT TO EXCEED 1.200/1.220 MAX REMOVAL PER SIDE .020 FACE TO FACE 9.540 9.545 OVERALL 11.940/11.985 *C/P MOVE		001 MNPRB 002 02 003 GJ02	
B	050	DRAG STRUT LUGS GRIND OFF CORROSION OR NICKEL FROM LUG FACE, NOT TO EXCEED CENTER LUG .996/.998 OUTSIDE LUGS .960/.980. FACE TO FACE MAX 1.342/1.344 MAX REMOVAL PER FACE .015 *C/P MOVE		001 MNPRB 002 02 003 GJ02	
B	060	SIDE BRACE LUG GRIND OFF CORROSION OR NICKEL FROM LUG FACE (INSIDE FACE ONLY). NOT TO EXCEED .855/.875 FACE TO FACE MAX 4.035 MAX REMOVAL PER FACE .015 *C/P MOVE		001 MNPRB 002 02 003 GJ02	
B	070	OR NICKEL FOR LUG FACE, NOT TO EXCEED 9.080/9.084 (CONTINUED)		001 MNPRB 002 02 003 GJ02	

31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		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 OUTER CYLINDER	

18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26	080	UPPER BORE STRIP CHROME FROM UPPER BORE *C/P MOVE		001 MNPRC 002 02 003 SC02 005 XB120589	
26	090	LOWER BORE STRIP CHROME FROM LOWER BORE *C/P MOVE		001 MNPRC 002 02 003 SC02 005 XB120589	
26	100	TRUNNION LUGS GRIT BLAST LUGS TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	110	DRAG STRUT LUGS GRIT BLAST LUGS TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	120	TORQUE ARM LUGS GRIT BLAST LUGS TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNPRC 002 01 003 BL02	
34E	130	E & I DETERMINE ROUTE FOR LUG FACE REPAIR *C/P MOVE		001 MNPRC 002 04 003 EI01	
69	140	TRUNNION LUGS *NOTE* HAND TYPE POWER TOOLS SHALL NOT BE USED TO REPAIR DAMAGE OR CORROSION PAGE 6-4, PARA 6-72. MACH LUGS FOR BUSHINGS NOT TO EXCEED 2.820 IN *C/P MOVE		001 MNPRC 002 04 003 MH02	
69	150	DRAG STRUT LUGS MACH LUGS FOR BUSHINGS NOT TO EXCEED 1.806 IN. *C/P MOVE		001 MNPRC 002 04 003 MH02	

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 OUTER CYLINDER							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"	
69	160	SIDE BRACE LUGS MACH LUGS FOR BUSHINGS NOT TO EXCEED 2.185 IN. C/P MOVE						001 MNPRA	002 04	003 MH02
69	170	TORQUE ARM LUGS 1ST REPAIR COUNTER BORE LUGS NOT TO EXCEED 2.677 IN TO A DEPTH OF 1.95/1.96 TERMINATE COUNTER BORE WITH A 0.125 RADIUS *C/P MOVE						001 MNPRA	002 04	003 RF01
69	180	TORQUE ARM LUGS 2ND REPAIR MACH ENTIRE LENGTH OF LUGS NOT TO EXCEED 2.677 IN. *C/P MOVE						001 MNPRA	002 04	003 MH02
69	190	UPLOCK SOCKET 1ST REPAIR MACH UPLOCK SOCKET NOT TO EXCEED 1.945 IN. *C/P MOVE						001 MNPRA	002 04	003 MH02
69	200	UPLOCK SOCKET 2ND REPAIR MACH UPLOCK SOCKET MINIMUM 1.965 IN FOR MAX LIMIT MAINTAIN MIN WALL THICKNESS OF .190 IN. IN LINE WITH CROSS PIN HOLE. *C/P MOVE						001 MNPRA	002 04	003 MH02
69	205	DOOR ATTACH LUG HOLES. MACHINE IAW T.O. 4S1-56-3 .0005/.0015 PRESS FIT *C/P MOVE						001 MNPRA	002 04	003 LE02
69	210	ORIFICE TUBE HOLE MACH ORIFICE TUBE FOR BUSHING NOT TO EXCEED 1.998/2.000 IN. *C/P MOVE						001 MNPRA	002 04	003 MH02
8	260	UPPER BORE GRIND UPPER BORE FOR CHROME PLATE NOT TO EXCEED 10.680 IN (CONTINUED)						001 MNPRA	002 01	003 GI01 005 X8022698

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		006 0000 0000 0000	
DISPATCH	FUNCTIONAL CODE	A	C	15013N	
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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			
B	270	LOWER BORE GRIND LOWER BORE FOR CHROME PLATE NOT TO EXCEED 11.040 IN. *C/P MOVE		001 MNPFB 002 01 003 GI01 005 X8022698 006 X8022696	

		REWORKED AREAS		001 MNPFA 002 06 003 TE03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE	M		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			

26B	290	BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH DATE IN _____ TIME IN _____		001 MNPFC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNPFA 002 06 003 ML04	
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26	305	VAPOR DEGREASE *C/P MOVE		001 MNPFC 002 03 003 DB01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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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. PERM RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	310	SHOTPEEN REWORKED AREAS *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	313	PREPARE UPPER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	315	PREPARE TO CHROME PLATE UPPER BORE FIXTURE/MASK/ETC MECHANIC SIGN OFF REQUIRED-----		001 MNPRC 002 02 003 BE01 005 XB 20589	
26	320	CHROME PLATE UPPER BORE SUFFIC- JENT TO GRIND BACK TO 10.625/10.630 TIME OUT _____ DATE OUR _____ MECHANIC SIGN OFF REQUIRED----->		001 MNPRC 002 02 003 CP01 005 XB 20589	
		*C/P MOVE		008 CI010	
26B	330	BAKE 4HRS AT 350-400F WITHIN 4HRS OF CHROME PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	333	PREPARE LOWER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	335	PREPARE TO CHROME PLATE LOWER BORE FIXTURE/MASK/ETC MECHANIC SIGN OFF REQUIRED-----		001 MNPRC 002 02 003 BE01 005 XB 20589	
26	340	CHROME PLATE LOWER BORE SUFFIC- JENT TO GRIND BACK TO 11.000/11.003 TIME OUT _____ DATE OUR _____ (CONTINUED)		001 MNPRC 002 02 003 CP01 005 XB 20589	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DISPATCHER/INITIATOR
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SIC/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"
		MECHANIC SIGN OFF REQUIRED → *C/P MOVE							
26B	350	BAKE 4HRS AT 350-400F WITHIN 4HRS OF CHROME DATE IN _____ TIME IN _____						001 MNP RC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	353	PREPARE TRUNNION LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE						001 MNP RC 002 03 003 BE01	
26	357	PREPARE TRUNNION LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE						001 MNP RC 002 01 003 BL02	
26	360	TRUNNION LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO 1.24/1.26 IN. FACE TO FACE 9.500/9.505 IN OVERALL 11.980/12.025 IN HARD NICKEL ROCKWELL C-35/C-37 DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNP RC 002 03 003 NP01 008 ND010	
26B	370	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN _____ TIME IN _____						001 MNP RC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *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
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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 DRAG STRUT LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNHRC 002 03 003 BE01	
26	377	PREPARE DRAG STRUT LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNHRC 002 01 003 BL02	
26	380	DRAG STRUT LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO: CENTER LUG .996/.998 IN OUTSIDE LUGS .997/1.01 IN FACE TO FACE 1.312/1.314 IN HARD NICKEL ROCKWELL C-35/C-39		001 MNHRC 002 03 003 NP01 008 ND020	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26B	390	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN _____ TIME IN _____		001 MNHRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	393	PREPARE SIDE BRACE LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNHRC 002 03 003 BE01	
26	397	PREPARE SIDE BRACE LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNHRC 002 01 003 BL02	
26	400	SIDE BRACE LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO .87/.89 IN (CONTINUED)		001 MNHRC 002 03 003 NP01 008 ND030	

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 OUTER CYLINDER
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		FACE TO FACE 4.000/4.004 IN HARD NICKEL ROCKWELL C-35/C-39 DATE OUT _____ TIME OUT _____ *C/P MOVE			

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26B	410	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN _____ TIME IN _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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26	413	PREPARE TORQUE ARM LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	
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26	417	PREPARE TORQUE ARM LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
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26	420	TORQUE ARM LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO 9.120/9.124 IN HARD NICKEL ROCKWELL C-35/C-39		001 MNPRC 002 03 003 NP01 008 N0040	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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26B	430	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN _____ TIME IN _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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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"	
B	440	TRUNNION LUGS FINISH GRIND LUG FACE LUG 1.24/1.26 IN FACE TO FACE 9.500/9.505 IN OVERALL 11.980/12.025 IN *C/P MOVE					001 MNPRB 002 02 003 GJ02		
B	450	DRAG STRUT LUGS FINISH GRIND LUG FACE CENTER LUG .996/.998 IN OUTSIDE LUG .99/1.01 IN FACE TO FACE 1.312/1.314 IN *C/P MOVE					001 MNPRB 002 02 003 GJ02		
B	460	SIDE BRACE LUGS (INSIDE FACE ONLY) FINISH GRIND LUG FACE .87/.89 IN FACE TO FACE 4.000/4.004 IN *C/P MOVE					001 MNPRB 002 02 003 GJ02		
B	470	TORQUE ARM LUGS FINISH GRIND LUG FACE 9.120/9.124 IN *C/P MOVE					001 MNPRB 002 02 003 GJ02		
B	480	UPPER BORE FINISH GRIND BORE 10.625/10.630 IN *C/P MOVE					001 MNPRB 002 01 003 G101 005 X8022678 006 X8022696		
B	490	LOWER BORE FINISH GRIND BORE 11.000/11.003 IN *C/P MOVE					001 MNPRB 002 01 003 G101 005 X8022698 006 X8022696		

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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
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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"
26B	500	BAKE 4HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNP RC 002 02 003 BK01	

		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 MNP NA 002 06 003 ML04	
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26	515	VAPOR DEGREASE *C/P MOVE		001 MNP RC 002 03 003 DG01	
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		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNP NA 002 06 003 ZS01	
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26	525	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNP RC 002 01 003 BL02	
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26	530	CAD PLATE CLASS I TYPE II DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNP RC 002 03 003 CA01	
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26B	550	BAKE 23HRS AT 350-400F WITHIN 4HRS OF CAD PLATE DATE IN _____ TIME IN _____ (CONTINUED)		001 MNP RC 002 02 003 BK01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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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 TICH 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"
		DATE OUT _____ TIME OUT _____ C/P MOVE			

26	555	IRIDITE *C/P MOVE*		001 MNPRC 002 02 003 IR01	
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	165	*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	563	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 550 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
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26	567	ALUMINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
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69	568	MACHINE TRUNNION LOGS P/N 66C-32323-01		001 MNPRA 002 04 003 LE02	
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69	570	TRUNNION LOGS MACH & INST BUSHING P/N 66C-32323-01 OR -03 PRESS FIT 0.001/0.003 FINISH DIM 2.687/2.689 IN *C/P MOVE		001 MNPRA 002 04 003 BE01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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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"
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69 ✓	573	MACHINE DOOR ATTACH LUG BUSHING P/N NAG 75 4-008		001 MNPRA 002 04 003 LE02	
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69 ✓	575	DOOR ATTACH LUGS INST BUSHING P/N NAG 75 4-008 .0005/.0015 PRESS FIT. *C/P MOVE		001 MNPRA 002 04 003 BE01	
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69 ✓	578	MACHINE DRAG STRUT LUGS BUSHING P/N 68J29645-97A-99P		001 MNPRA 002 04 003 LE02	
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69 ✓	580	DRAG STRUT LUGS INST BUSHING P/N 68J29645-97A-99P PRESS FIT 0.0007/0.0015		001 MNPRA 002 04 003 BE01	
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		FINISH DIM 1.500/1.501 IN *C/P MOVE			
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69 ✓	585	MACHINE SIDE BRACE LUGS BUSHING P/N 65A30315-70		001 MNPRA 002 04 003 LE02	
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69 ✓	590	SIDE BRACE LUGS INST BUSH P/N 65A30315-70 PRESS FIT 0.0007 FINISH DIM 2.000/2.002 IN		001 MNPRA 002 04 003 BE01	
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		*C/P MOVE			
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69 ✓	598	MACHINE TORQUE ARM LUG BUSHING P/N 7127910		001 MNPRA 002 04 003 LE02	
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69 ✓		TORQUE ARM LUGS INST BUSH P/N 7127910-02 PRESS FIT 0.001/0.003 (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	15013N	
		B	D		

* U.S. GOVERNMENT PRINTING OFFICE: 1969-648-18

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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"	
		FINISH DIM 2.500/2.502 IN *C/P MOVE							
69	608	MACHINE UNLOCK SOCKET 2ND REPAIR P/N 65A30315-71						001 MNPRA 002 04 003 LE02	
69	610	UNLOCK SOCKET 2ND REPAIR TAW DWD 7729420 INST BUSH P/N 65A30315-71 FINISH DIM 1.939/1.938 IN CROSS BOLT HOLE .313/.314 IN *C/P MOVE						001 MNPRA 002 04 003 BE01	
69	618	MACHINE ORIFICE TUBE HOLE BUSHING MFG BUSHING PER FIG 6-4 PAGE 6-11						001 MNPRA 002 04 003 LE02	
69	620	ORIFICE TUBE HOLE MFG BUSH & INST PER FIG 6-4 PAGE 6-11 FINISH DIM 1.875/1.877 *C/P MOVE						001 MNPRA 002 04 005 BE01	
	640	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958						001 MNP GP 002 06 003 SA03	
	650	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE						001 MNP GP 002 06 003 SA03	

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-125

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	15013N	
		B	D		

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DATE 89037 PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNP69	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 45-1-182 451-56-3	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES KC-135 MLG	11 STOCK NUMBER	12 OPTIONAL 69658A 25326A 69657A 25325A
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		NSN C/N			
65-1265-7		1620009816337 69658A			
65-1265-8		1620000842104 69657A 25325A 25326A			

UNIT COST \$4493.00

- GOVERNING DIRECTIVES:
- AFLCR 66-51
 - MANOI 66-3
 - BLAST IAW MIL-STD-1504
 - FPI IAW MIL-STD-6866
 - FMPI IAW MIL-STD-1949
 - P/O N01561
 - CHROME IAW MIL-STD-1501
 - CADMIUM IAW MIL-STD-870
 - TEMP ETCH IAW MIL-STD-867
 - SHOTPEEN IAW MIL-S-13165
 - NICKEL IAW MIL-STD-868
 - BAKE IAW 45-1-182
 - MAOI 74-12
 - IVD ALUM PLATE IAW MIL-C-83488A
 - ALODINE IAW MIL-C-5541

AMS 6407 STEEL 220/240 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 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 AND PROTECTED (C/P MOVE) FOR (CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-549-143

15014N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

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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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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. "WARNING"			
--	--	--	--	--	--

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

		REQU (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
--	--	---	--	--	--

	001	65-1265-7 65-1265-8			
--	-----	------------------------	--	--	--

	005	DISASSEMBLE *C/P MOVE			
	REQU				
				001 MNP GW	
				002 02	
				003 LG02	
				005 X8745233	
				006 X8745188	

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

	009	BLAST CLEAN ONLY *C/P MOVE			
	REQU				
				001 MNP GW	
				002 03	
				003 BL01	

	011	BAKE 4HRS AT 350-400F			
	REQU	DATE IN _____ TIME IN _____			
		(CONTINUED)			
				001 MNP GW	
				002 03	
				003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980-448-110

15014N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

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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"	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE				M		001 MNP NA 002 05 003 ML04	
	REQD								
	030	E & I NOTE: HAND TYPE POWER TOOLS SHALL NOT BE USED (PER PAR 6-7C, PG 6-4)						001 MNP GW 002 04 003 EI01	
		O.D. 9.993/9.996 WEAR 9.989 IN REPAIR MIN 9.974 IN.							
		I.D. 9.450/9.490 WEAR 9.492 IN.							
		SULKHEAD SEAL 9.375/9.378 IN							
		*****TORQUE ARM LUGS***** 2.500/2.502 WEAR 2.504 IN. REPAIR MAX 2.677 IN.							
		FACE TO FACE 4.360/4.363 IN. OVERALL 9.124/9.120 IN REPAIR MIN 2.080/2.084 IN							
		LUG WIDTH 1.88 IN REPAIR MIN 1.86 IN.							
		*****PIVOT LUG*****							
		BASE METAL 3.7500/3.7515 IN. 3.775 MAX BUSH I.D. 3.376/3.378 IN. WEAR 3.385 IN.							
		BUSHING FACE/FACE 10.000/10.007 FACE TO FACE 10.250/10.255 IN. LUG WIDTH 1.685/1.690 IN. (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	15014N	
		B	D		

* U.S. GOVERNMENT PRINTING OFFICE: 1985-545-110

15014N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89037

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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"
----------------------	--------------------	-----------------------------	--------------	---------	---------

		NOTE: NO O.S. AUTHORIZED PER NOTE 1 PAGE 5-10, FIG 5-2. *BRAKE EQUALIZER ROD ATT LUG*** BASE METAL I.D. 1.750/1.751 IN.			
--	--	--	--	--	--

		BUSH I.D. 1.625/1.626 IN. WEAR 1.622 IN. REPAIR MAX 1.8710 IN. LUG WIDTH 1.120/1.25 IN.			
--	--	--	--	--	--

		*****SNUBBER ATT LUG***** BASE METAL .8115/.8125 IN.			
--	--	---	--	--	--

		BUSH I.D. .625/.6265 WEAR .628 IN. REPAIR MAX .9325 IN. LUG WIDTH 1.120/1.125 IN.			
--	--	--	--	--	--

		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
--	--	--	--	--	--

		*C/P MOVE			
--	--	-----------	--	--	--

26	035	VAPOR DECREASE	*C/P MOVE		001 MNPRC 002 03 003 LG01
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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
----	-----	------------	-----------	--	---------------------------------

26	050	STRIP CHROME CYLINDER O.D. *C/P MOVE			001 MNPRC 002 02 003 SC02
----	-----	---	--	--	---------------------------------

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	15014N	
		B	D		

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* U.S. GOVERNMENT PRINTING OFFICE: 1980-046-113

15014N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89037

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 INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	060	STRIP CHROME CYLINDER I.D. *C/P MOVE					001 MNP RC	002 02 003 SC02	
26	070	GRIT BLAST TORQUE ARM LUGS (FACE) TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE					001 MNP RC	002 01 003 BL02	
34E	080	E & I DETERMINE ROUTE FOR LUG FACE REPAIR *C/P MOVE ***NOTE: HAND TYPE POWER TOOLS SHALL NOT BE USED PER PAGE 6-4, PARA 6-72.					001 MNP RW	002 04 003 EI01	
69	105	MACH PIVOT LUGS. FOR BUSHINGS NOT TO EXCEED 3.775 32 RMS *C/P MOVE					001 MNP RA	002 04 003 MH02	
69	110	MACH TORQUE ARM LUGS. FOR BUSHINGS NOT TO EXCEED 2.77 IN. 32 RMS *C/P MOVE					001 MNP RA	002 04 003 MH02	
69	120	MACH BRAKE EQUALIZER ROD ATT LUG FOR BUSHINGS NOT TO EXCEED 1.8710 IN. 32 RMS *C/P MOVE					001 MNP RA	002 04 003 MH02	
69	130	MACH SNUBBER ATT LUG FOR BUSHING NOT TO EXCEED .9325 IN. 32 RMS *C/P MOVE					001 MNP RA	002 04 003 MH02	
B	140	GRIND TORQUE ARM LUG (FACE) LUG FACE FOR NICKEL PLATE NOT TO EXCEED 1.86 IN. MAX REMOVAL PER FACE .020 IN. OVERALL REPAIR 9.080/9.084 IN. 32 RMS *C/P MOVE					001 MNP RB	002 02 003 GS03	
21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C		15014N				
		B	D						

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

15014N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89037

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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
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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	150	GRIND CYLINDER O.D. FOR CHROME NOT TO EXCEED 9.974 IN. 32 RMS *C/P MOVE		001 MNP RB 002 03 003 GE08	
---	-----	---	--	----------------------------------	--

B	160	GRIND CYL. I.D. (BULKHEAD SEAL AREA) NOT TO EXCEED MIN. WALL THICKNESS OF .283 IN. FIG 6-7, PAGE 6-14, AREA F 32 RMS *C/P MOVE		001 MNP RB 002 02 003 GI04	
---	-----	---	--	----------------------------------	--

		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE*	M	001 MNP NA 002 06 003 TE03	
--	--	--	---	----------------------------------	--

		***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****			
--	--	---	--	--	--

26B	180	BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH DATE IN _____ TIME IN _____		001 MNP RC 002 02 003 BK01	
-----	-----	---	--	----------------------------------	--

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

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

		***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
--	--	---	--	--	--

26	195	VAPOR DEGREASE *C/P MOVE		001 MNP RC 002 03 003 DG01	
----	-----	--------------------------	--	----------------------------------	--

26	200	SHOTPEEN REWORKED AREAS *C/P MOVE		001 MNP RC 002 01 003 SP02	
----	-----	--------------------------------------	--	----------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	15014N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1988-648-143

15014N 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.
----------------	--------------	--------------------

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

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	205	PREPARE TO CHROME PLATE CYLINDER O.D. FIXTURE/MASK/ETC MECHANIC SIGN OFF REQUIRED----->		001 MNPRC 002 02 003 BE01 005 X8120899	
26	210	CHROME PLATE CYLINDER O.D. SUFFICIENT TO GRIND BACK TO 9.993/9.996 TIME OUT _____ DATE OUR _____ MECHANIC SIGN OFF REQUIRED----->		001 MNPRC 002 02 003 CP01 005 X8120899	
		*C/P MOVE		008 C0010	
26B	220	BAKE 23HRS AT 350/400 WITHIN 4HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
26	223	IF CHROME PLATE REQUIRED PREPARE TO CHROME PLATE CYLINDER I.D. (BULKHEAD SEAL AREA) MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----->		001 MNPRC 002 02 003 BE01 005 X8120873	
26	225	CHROME PLATE CYLINDER I.D. (BULKHEAD SEAL AREA) SUFFICIENT TO GRIND BACK TO 9.375/9.378 IAW 4S1-56-3 * NOTE ON PAGE 6-8* TIME OUT _____ DATE OUR _____ MECHANIC SIGN OFF REQUIRED----->		001 MNPRC 002 02 003 CP01 005 X8120873	
26	226	PREPARE FOR NICKEL PLATE MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1989-048-113

15014N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

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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 INNER CYLINDER	

15 DISPATCH STATION	16 PERFORM RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
26	228	PREPARE FOR NICKEL PLATE, GRIT BLAST ALL AREAS TO BE NICKEL PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	230	IF NICKEL PLATE REQUIRED NICKEL PLATE CYLINDER I.D. (BULKHEAD SEAL AREA) SUFFICIENT TO GRIND BACK TO 9.375/9.378		001 MNPRC 002 03 003 NP01 006 NI010	
		IAW 4S1-56-3 * NOTE ON PAGE 6-8 * DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	235	NICKEL PLATE TORQUE ARM LUG FACES SUFFICIENT TO GRIND TO 9.124/9.120 IAW 4S1-56-3 DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 03 003 NP01 008 NO010	
26B	245	BARE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL PLATE OR CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
B	250	FINISH GRIND TORQUE ARM LUG FACE OVERALL 9.124/9.120 IN. LUG WIDTH 1.88 IN 32 RMS *C/P MOVE		001 MNPRC 002 02 003 BS03	
B	260	FINISH GRIND CYLINDER I.D. 9.993/9.996 IN 32 RMS *C/P MOVE		001 MNPRC 002 03 003 GE08	
B	270	CYLINDER I.D. (BULKHEAD SEAL AREA) FINISH GRIND SEAL AREA 9.375/9.378 IN. 32 RMS *C/P MOVE		001 MNPRC 002 02 003 GI04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1969-50-103

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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. RCUN 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"
26B	280	BAKE 4HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNP RC 002 02 003 BK01	

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

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNP NA 002 06 003 Z501	
--	--	---	---	----------------------------------	--

26	305	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNP RC 002 01 003 BL02	
----	-----	--	--	----------------------------------	--

26	310	CAD PLATE CLASS I TYPE II I.A.W T.O. 4S1-56-3 PAGE 6-2 FIG 6-1 DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNP RC 002 03 003 CA01	
----	-----	--	--	----------------------------------	--

26B	330	BAKE 23HRS AT 350-400F WITHIN 4HRS OF CAD DATE IN _____ TIME IN _____		001 MNP RC 002 02 003 BK01	
-----	-----	--	--	----------------------------------	--

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

26	332	IRIDITE *C/P MOVE*		001 MNP RC 002 02 003 IR01	
----	-----	-----------------------	--	----------------------------------	--

	.65	*C/P MOVE ***** NOTE ***** (CONTINUED)	M	001 MNP NA 002 06 003 ML04	
--	-----	--	---	----------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-643-103

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15014N WORK CONTROL DOCUMENT (MEDS)

8903

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE	
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						
18. 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	337	VAC IVD ALUM PLATE CLASS 2 TYPE 1I NOTE: OPERATION---220 OR 225 MUST BE ACCOMPLISHED IF PRIOR PLAING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE						001 MNRRC 002 03 003 IV01	
26	338	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE						001 MNRRC 002 03 003 TA01	
69	339	MACHINE TORQUE ARM LUG BUSHINGS P/N530995-01 **						001 MNRRA 002 04 003 LE02	
69	340	INSTALL TORQUE ARM LUGS BUSH P/N 7530995-01 FIN DIM 2.50/2.502 IN. .001/.003 PRESS FIT 32 RMS *C/P MOVE						001 MNRRA 002 04 003 BE01	
69	348	MACHINE PIVOT LUG BUSHINGS P/N 66-10615-1 P/N 8121215-0/S						001 MNRRA 002 04 003 LE02	
69	350	INSTALL PIVOT LUG BUSHINGS P/N 66-10615-1 3.376/3.378 P/N 8121215 0/S PRESS FIT .001/.003 32 RMS *C/P MOVE						001 MNRRA 002 04 003 BE01	
69	358	MACHINE BRAKE EQUALIZER ROD ATTACH LUGS BUSHING P/N 67C30360						001 MNRRA 002 04 003 LE02	
69	360	INSTALL BRAKE EQUALIZER ROD ATTACH LUGS BUSH P/N 67C30360 FINISH DIM 1.625/1.626 IN. 32 RMS (CONTINUED)						001 MNRRA 002 04 003 BE01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C	B	D	15014N			

U.S. GOVERNMENT PRINTING OFFICE: 1969-08-15

15014N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89037

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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	

19. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.0017/.002 PRESS FIT *C/P MOVE			
69 ✓	368	MACHINE SNUBBER ATTACH LUGS BUSHING P/N 67C30359-3 P/N 67C30359-1		001 MNPRA 002 04 003 LE02	
69 ✓	370	INSTALL SNUBBER ATT LUGS BUSH P/N 67C30359-3 & 67C30359-1 FINISH DIM .6250/.6265 IN. 32 RMS		001 MNPRA 002 04 003 BE01	
		.0007/.0013 PRESS FIT *C/P MOVE			
	380	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGR 002 06 003 SA03	
	390	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNPGR 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

PRINTING OFFICE 1588-448-10

15015N WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP69	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S1-56-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES KC-135 MLG	11. STOCK NUMBER	12. OPTIONAL 69658A
13. SERIAL NUMBER	14. NOUN BEARING (LOWER)	69657A 25326A 25325A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P7N		NSN C7N 3120010403938 69658A 69657A 25325A 25326A			
7653528-01		***UNIT COST \$ 155.03*** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 CADMIUM PLATE IAW MIL-STD-870 FPI IAW MIL-STD-6866 IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 *****			
		ALUM NICKEL BRONZE AMS 4640 AMS 4880 *****			
		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 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 AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-546-183

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15015N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

PAGE 2 OF 2 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.
----------------	--------------	--------------------

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

13. SERIAL NUMBER	14. NOUN BEARING (LOWER)
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		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	7653528-01			
341	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745188	
341	006 *REQD*	DEGREASE ONLY *C/P MOVE		001 MNP GW 002 02 003 DG02	
	REQD	[REDACTED] *C/P MOVE	M	001 MNP NA 002 05 003 ZY05	
	020 *REQD*	E & I I.D. 10.003/10.006 WEAR 10.008 IN.		001 MNP GW 002 04 003 EI01	
		D.D. 10.994/10.997 WEAR 10.992 IN *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988-048-12

15015N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

PAGE 3 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 BEARING (LOWER)
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	028	MODIFY IAW DWG 7653528 P/N 69-11379		001 MNFRA 002 04 003 LE02	
69	030	REIDENTIFY 7653528-01 *C/P MOVE		001 MNFRA 002 04 003 BE01	
26	033	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
26	037	STRIP CAD *C/P MOVE		001 MNFRC 002 02 003 CS01	
26	038	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNFRC 002 01 003 BL04	
26	040	CAD PLATE CLASS II TYPE I *C/P MOVE		001 MNFRC 002 03 003 CA01	
26	042	IRIDITE *C/P MOVE		001 MNFRC 002 02 003 IR01	
26	044	VAC IVD ALUM PLATE CLASS 2 TYPE II *C/P MOVE		001 MNFRC 002 03 003 IV01	
26	046	ALDINE IVD ALUM PLATE CLASS IA *C/P MOVE		001 MNFRC 002 03 003 TA01	
	050	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95		001 MNFRC 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1988-048-102

15016N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP69	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S1-56-3	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES KC-135 MLG	11. STOCK NUMBER	12. OPTIONAL 69658A
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13. SERIAL NUMBER	14. NOUN PIN, METERING	69657A
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P7N		NSN C7N			
65-5735		1620007390166 69658A			25325A
		69657A			
		25325A			
		25326A			25326A

UNIT COST \$ 433.36
GOVERNING DIRECTIVES: AFLCR 66-51
MANOI 66-3

FPI IAW MIL-STD-6866
ANODIZE IAW MIL-A-8625
*****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 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 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 PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO
(CONTINUED)

31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/N
DISPATCH	FUNCTIONAL CODE	A	C	15016N
		B	D	

15016N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

PAGE 02 OF 02

1. JOB ORDER NO.		2. 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. NOMENCLATURE PIN, METERING						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PRECLUDE INJURIES.							
		REQUI (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	65-5735							
	005	DISASSEMBLE		*C/P MOVE				001 MNRGW 002 02 003 LG02 005 X8745233 006 X8745188	
		REQUI							
	006	DEGREASE ONLY		*C/P MOVE				001 MNRGW 002 02 003 DG02	
		REQUI							
		[REDACTED]							
		*C/P MOVE				M		001 MNRNA 002 05 003 ZY05	
		REQUI							
	020	E & I		SEAL GROOVE 8.926/8.930 IN.				001 MNRGW 002 04 003 EI01	
		REQUI *C/P MOVE							
26	030	STRIP ANODIZE		*C/P MOVE				001 MNRRC 002 03 003 AN04	
		[REDACTED]							
		*C/P MOVE (CONTINUED)				M		001 MNRNA 002 06 003 ZA02	

31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/EN	
DISPATCH	FUNCTIONAL CODE	A	B	C	D

15016N

15016N WORK CONTROL DOCUMENT (MEDS)

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
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13. SERIAL NUMBER	14. NOUN PIN, METERING
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
--	--	--	--	--	--

26	040	ANDDIZE *C/P MOVE		001 MN/RC 002 03 003 AS03	
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	060	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MN/RC 002 06 003 SA03	
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	070	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MN/RC 002 06 003 SA03	
--	-----	--	--	---------------------------------	--

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/ID
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DISPATCH	FUNCTIONAL CODE	A	C	15016N
		B	D	

15017N WORK CONTROL DOCUMENT (MEDS)

DATE 89037

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP G9	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S1-56-3	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES KC-135 MLG	11. STOCK NUMBER	12. OPTIONAL 69658A 25325A 25326A 69657A
13. SERIAL NUMBER	14. NOUN PISTON ROD	

18. DISPATCH STATION	19. PERFORM NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P7N		NSN C7N			
7531269	-30	1620010273442 69658A 25325A 25326A 69657A			
		*****UNIT COST \$1772.00***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-8866 *****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 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 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 PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15017N
		B	D	

15J17N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89037

PAGE 2 OF 2 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.
----------------	--------------	--------------------

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECLUDE INJURIES; *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	7531269-30			
	005 *REQD*	DISASSEMBLE	*C/P MOVE	001 MNP GW 002 02 003 LG02 005 X8745233 006 X8745188	
	006 *REQD*	DEGREASE ONLY	*C/P MOVE	001 MNP GW 002 02 003 DG02	
			*C/P MOVE	M 001 MNP NA 002 05 003 ZY05	
	020 *REQD*	E & I	*C/P MOVE	001 MNP GW 002 04 003 EI01	
				001 MNP RA 002 04 003 BE01	
	030 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 950		001 MNP UP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/ID
DISPATCH	FUNCTIONAL CODE	A	B	15017N
		C	D	

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7A STRUT KC135 MLG L/H
 PER TECH S'S W F PF A/R REV
 T K #R A FA SUPPORT
 EP D L K C DC ELEMENT

RCC MNPRA

451-56-3 038-9102

83083

RAO13	S	E	JA	EA	1	J	83083	.95	PERCENT ENGR 89.5	MACHINE OUTER CYLINDER 303E	9.13		8.67		
0001		JA	01	00				.00		PART NUMBER/MSN	.000	.000	.000		0
0010									65-5763-17	1620009274739					
0020									65-5763-18	1620009592078					
0030									50-9712-32	1620007871750					
0040									50-9712-31	1620007871749					
0035		JA	01	15				.25		REMOVE BUSHINGS	.296	.011	.085		1
0010 E								1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020 E								1.00	REN BUSHING (1ST OR SINGLE)		.01099		.012		
0030 E								1.00	REN BUSHING (2ND OR ADDL)		.00413		.004		
0040 E								1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0140		JA	01	15				.35		MACH TRUN LUGS	1.475	.077	.594		7
0010 E								.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020 E								1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030 E								2.00	BORE HOLE 3 X 1 GROUP 4 2 HOLES		.48623		1.118		
0040 E								6.00	NIKE TEL GAGE ID NIKE CALPR 6 TIMES		.00966		.066		
0050 E								1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0060 E								3.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.017		
0070 E								1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0150		JA	01	15				.32		MACH DRAG STRUT LUGS	1.701	.082	.626		7
0010 E								.30	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.357		
0020 E								1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030 E								9.00	NIKE TEL GAGE ID NIKE CALPR 9 TIMES		.00966		.099		
0040 E								3.00	BORE HOLE 2 X 1 GROUP 4 3 HOLES		.40027		1.380		
0050 E								1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0060 E								3.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.017		
0070 E								1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0160		JA	01	15				.38		MACH SIDE BRACE LUGS	1.303	.074	.570		6
0010 E								.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020 E								1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030 E								2.00	BORE HOLE 2 X 1 GROUP 4 2 HOLES		.40027		.920		
0040 E								6.00	NIKE TEL GAGE ID NIKE CALPR 6 TIMES		.00966		.066		
0050 E								1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0060 E								3.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.017		
0070 E								1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0170		JA	01	15				.25		MACH TOR ARM LUGS 1ST	1.820	.068	.523		6
0010 E								.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020 E								1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030 E								2.00	BORE HOLE 2.5 X 2 GROUP 4 2 HOLES		.65881		1.515		
0040 E								6.00	NIKE TEL GAGE ID NIKE CALPR 6 TIMES		.00966		.066		
0050 E								6.00	GAGE DIMENSION W/SCALE/RULE 6 TIMES		.00161		.011		
0060 E								1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0070 E								1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0080 E								1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0180		JA	01	15				.25		MACH TOR ARM LUGS 2ND	1.810	.068	.521		6
0010 E								.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020 E								1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030 E								2.00	BORE HOLE 2.5 X 2 GROUP 4 2 LUGS		.65881		1.515		
0040 E								6.00	NIKE TEL GAGE ID NIKE CALPR 6 TIMES		.00966		.066		
0050 E								1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0060 E								1.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.005		

0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0010 E	RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE	1.03687		.393	
0020 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINBLE MAG BS	.07261		.083	
0030 E	RML-BD-CB	1.00	BORE HOLE 2 X 1 GROUP 4	.40027		.460	
0040 E	RTL-MH-M2	3.00	NIKE TEL GAGE ID NIKE CALPR 3 TIMES	.00966		.033	
0050 E	RBW-DB-K1	1.00	DEBURR 3 INCH HOLE W/KNIFE	.00534		.006	
0200	JA 01	15	MACH UPLOCK SOCET 2ND	1.554	.019	.143	2
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687		1.192	
0020 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINBLE MAG BS	.07261		.083	
0030 E	RML-BD-CB	1.00	BORE HOLE 2 X 1 GROUP 4	.40027		.460	
0040 E	RTL-MH-M2	3.00	NIKE TEL GAGE ID NIKE CALPR	.00966		.033	
0050 E	RBW-DB-K1	1.00	DEBURR 3 INCH HOLE W/KNIFE	.00534		.006	
0060 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0205	JA 01	15	MACH DOOR ATT LUG HOLES	.680	.022	.172	2
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0025 E	ZPO-BP-B1	2.00	BUTTERFLY POLISH BUSHING I.D2 LUGS	.00591		.013	
0030 E	RLA-BO-DE	1.00	BORE HOLE 1 1/2 - 2 DIA 1 DP	.14959		.172	
0040 E	KTL-DB-A2	1.00	DEBURR HOLE ADDL BOTH SIDES	.00294		.003	
0050 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006	
0210	JA 01	15	MACH ORIFICE TUBE HOLE	1.672	.125	.962	11
0010 N		.50	SET UP RMLSUW3	1.15000		.661	
0020 N		1.00	LOAD PART RMLHPCD	.20000		.230	
0030 N		1.00	ALIGN HOLE RMLALCC	.08000		.092	
0040 N		1.00	ALIGN AXIS RMLALCA	.07000		.080	
0050 N		1.00	BORE ID RMLBDCE	.73100		.840	
0060 E	RBW-DB-K1	2.00	DEBURR 3 INCH HOLE W/KNIFE 2 PLACES	.00534		.012	
0070 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006	
0068	JA 01	15	MACH TRUN LUG BUSHING	.438	.059	.454	5
0010 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE PRO RATE	.49962		.114	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030 E	RLA-BO-EE	1.00	BORE HOLE 2 - 2 1/2 DIA 1 DP	.17205		.197	
0040 E	KML-TD-FA	1.00	DIA 2.00-3.00 REMOVE (.033	.14659		.168	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0570	JA 01	15	INST TRUN LUG BUSH	.350	.047	.362	4
0050 E	RBW-BU-S1	.20	SET UP TO REBUSH BOSSES PRO RATE	.18669		.042	
0055 E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	.23835		.274	
0060 E	KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO	.06442		.074	
0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0573	JA 01	15	MACHINE DOOR ATTACH LUGS	.265	.038	.290	3
0010 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	.49962		.114	
0015 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0020 E	RLA-BO-DE	1.00	BORE HOLE 1 1/2 - 2 DIA 1 DP	.14959		.172	
0030 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006	
0575	JA 01	15	INST DOOR ATT LUGS	.265	.038	.290	3
0010 E	RBW-BU-S1	.20	SET UP TO REBUSH BOSSES PRO RATE	.18669		.042	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255	
0030 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006	
0578	JA 01	15	MACHINE DRAG STRUT BUSHING	.441	.060	.457	5
0010 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE PRO RATE	.49962		.114	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030 E	RLA-BO-DE	1.00	BORE HOLE 1 1/2 - 2 DIA 1 DP	.14959		.172	
0040 E	KML-TD-EC	1.00	DIA 1.50-2.00 REN .033-.250	.17225		.198	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0080	JA 01	15	INST DRAG STRUT BUSH	.269	.036	.279	3

0050 E	RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE	.18669	.042	
0060 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231	.255	
0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0010 E	JA 01	15	.95	MACHIN SIDE BRACE BUSHING	.464	.066	.507
0020 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962	.114	
0030 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0040 E	RLA-BO-EE	1.00	BORE HOLE 2 - 2 1/2 DIA 1 DP		.17205	.197	
0050 E	KML-TD-EC	1.00	DIA 1.50-2.00 REN .033-.250		.17225	.198	
0590	JA 01	15	.95	INST SIDE BRACE BUSH	.483	.069	.528
0040 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669	.214	
0050 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231	.255	
0060 E	KTL-RH-B2	1.00	REAM BUSHING W ADJUST LEMPCO		.06442	.074	
0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0598	JA 01	15	.86	MACH BUSH TORQ ARM LUG	.375	.048	.372
0010 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962	.114	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	RLA-BO-FE	1.00	BORE HOLE 2 1/2 - 3 DIA 1 DP		.25592	.294	
0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0600	JA 01	15	.86	INST TOR ARM BUSH	.395	.051	.391
0070 E	RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE	.18669	.042	
0080 E	RBW-BU-R1	1.00	REBUSH A SET OF 2 BOSSES		.23835	.274	
0090 E	KML-TD-FD	1.00	DIA 3.00 REN .250 ADD INCH		.10968	.126	
0100 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0608	JA 01	15	.92	MACH UPLOCK SOCKET 2ND REP	.266	.037	.282
0010 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962	.114	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006	.011	
0030 E	KML-TD-FA	1.00	DIA 2.00-3.00 REMOVE (.033		.14659	.168	
0040 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0610	JA 01	15	.92	INSTALL UPLOCK SOCKET BUSH	.207	.029	.220
0040 E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRO RATE	.18669	.107	
0050 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062	.023	
0060 E	RBW-BU-R3	1.00	REAM BUSHING SET W/STEP RMR		.08361	.096	
0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0618	JA 01	15	.75	MACHINE ORIFICE TUBE BUSHING	.222	.025	.192
0010 E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962	.114	
0020 E	KML-TD-EA	1.00	DIA 1.50-2.00 REN (.033		.11664	.134	
0060 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601	.006	
0620	JA 01	15	.75	INST ORIFICE TUBE BUSH	.296	.033	.256
0030 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669	.214	
0040 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062	.023	
0050 E	RBW-BU-R3	1.00	REAM BUSHING SET W/STEP RMR		.08361	.096	
0060 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601	.006	
0990	JA 01	15	.01	LABOR STD HISTORY	.000	.000	.000
0010				INITIAL INPUT MARCH 1983			
0020				20APR85 DOWNGRADE TO N STD-TIME WAS 7.91HRS			
0990				HANEL CLINTON BENTLEY MRP II 7-3253			

TO INTERROGATE LABOR STANDARDS, INPUT

PRD NROP NR
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 1. 90123456 ELSE PUT IN END

OPER	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						
RA014	S	E	JA	EA	1	J	83083	.80	PERCENT ENGR 89.5	MACHINE PISTON KC135M	303E	7.80								6.24	
0001			JA	01	00		.00		PART NUMBER/NSN			.000	.000							.000	0
								65-1265-7	1620009816337												
								65-1265-8	1620000842104												
0105			JA	01	15		.75		MACH PIVOT LUGS			1.283	.144							1.107	14
0010	E					RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE				1.03687								.393	
0020	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS				.07261								.083	
0030	E					RML-BD-CB	2.00	BORE HOLE 2 X 1 GROUP 4 2 HOLES				.40027								.920	
0040	E					RTL-MM-M2	6.00	HIKE TEL GAGE ID MIKE CALPR 6 TIMES				.00966								.066	
0050	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001								.011	
0110			JA	01	15		.50		MACH TORQUE ARM LUGS			1.920	.144							1.104	14
0010	E					RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE				1.03687								.393	
0020	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS				.07261								.083	
0030	N						2.00	BORE 2 PLCS RMLBDD				.70900								1.630	
0040	E					RTL-MM-M2	6.00	HIKE TEL GAGE ID MIKE CALPR 6 TIMES				.00966								.066	
0050	E					KIT-MC-B3	6.00	GAGE DIMENSION W/SCALE/RULE 6 TIMES				.00161								.011	
0060	E					RBW-DB-K1	1.00	DEBURR 3 INCH HOLE W/KNIFE				.00534								.006	
0070	E					RBW-DB-K2	1.00	DEBURR ADDTNL 3 INCH HOLE				.00502								.005	
0080	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001								.011	
			JA	01	15		.75		MACH BRAKE EQUAL ROD			1.304	.147							1.125	14
0010	E					RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE				1.03687								.393	
0020	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS				.07261								.083	
0030	E					RML-BD-CB	2.00	BORE HOLE 2 X 1 GROUP 4 2 HOLES				.40027								.920	
0040	E					RTL-MM-M2	6.00	HIKE TEL GAGE ID MIKE CALPR 6 TIMES				.00966								.066	
0050	E					RBW-DB-K1	4.00	DEBURR 3 INCH HOLE W/KNIFE 4 PLACES				.00534								.024	
0060	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001								.011	
0130			JA	01	15		.35		MACH SNUBBER ATT LUG			.447	.023							.180	2
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL				.27525								.316	
0020	E					RBW-BU-R2	2.00	REAM WITH LENPCD REAMER 2 LUGS				.07337								.168	
0030	E					ZPO-BP-B1	2.00	BUTTERFLY POLISH BUSHING I.D2 LUGS				.00591								.013	
0040	E					KTL-DB-A1	1.00	DEBURR HOLE FIRST BOTH SIDES				.00449								.005	
0050	E					KTL-DB-A2	1.00	DEBURR HOLE ADDL BOTH SIDES				.00294								.003	
0060	E					RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC				.00601								.006	
0339			JA	01	15		.80		MACH BUSH TORQUE ARM LUG			1.137	.137							1.047	13
0010	E					RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE PRO RATE				.49962								.114	
0020	E					RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK				.01006								.011	
0030	E					RLA-BO-FE	1.00	BORE HOLE 2 1/2 - 3 DIA 1 DP				.25592								.294	
0040	E					RLA-BO-FF	1.00	BORE HOLE 2.5-3 DIA. ADD IN				.13721								.157	
0050	E					KHL-TD-FC	1.00	DIA 2.00-3.00 REN .033-.250				.21212								.243	
0060	E					KHL-TD-FD	1.00	DIA 3.00 REN .250 ADD INCH				.10968								.126	
0065	E					KTL-RM-B2	1.00	REAM BUSHING W ADJUST LENPCD				.06442								.074	
0080	E					RBW-BU-R1	1.00	REBUSH A SET OF 2 BOSSES				.23835								.274	
0090	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001								.011	
0340			JA	01	15		.80		INST TOR ARM LUG BUSH			.350	.042							.322	4
0070	E					RBW-BU-S1	.20	SET UP TO REBUSH BOSSES PRO RATE				.18669								.042	
0080	E					RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES				.23835								.274	
0085	E					KTL-RM-B2	1.00	REAM BUSHING W ADJUST LENPCD				.06442								.074	
0900	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001								.011	
0348			JA	01	15		.95		MACH PIVOT LUG BUSHING			.585	.083							.639	8

0010	E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962		.114	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	RLA-BO-EE	1.00	BORE HOLE 2 - 2 1/2 DIA 1 DP		.17205		.197	
0040	E	KML-TD-FA	2.00	DIA 2.00-3.00 REMOVE (.033	2 SETS	.14659		.337	
0045	E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0350	JA 01	15	.95		INST PIVOT LUG BUSH	.561	.080	.613	8
0050	E	RBW-RU-S1	.40	SET UP TO REBUSH BOSSES	PRO RATE	.18669		.095	
0060	E	RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES	2 SETS	.23835		.548	
0070	E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0358	JA 01	15	.75		MACH BRAKE EQUAL ROD ATT LUG	.551	.062	.476	6
0010	E	RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962		.114	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E	RLA-BO-DG	2.00	BORE HOLE 1 1/2 - 2 DIA 1 DP2 LUGS		.21069		.484	
0040	E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0070	E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0360	JA 01	15	.75		INST BRAKE EQUAL BUSH	.350	.039	.302	4
0040	E	RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE	.18669		.042	
0050	E	RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES		.23835		.274	
0060	E	KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO		.06442		.074	
0070	E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0370	JA 01	15	.75		INST SNUBBER ATT BUSH	.431	.048	.372	5
0010	E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0020	E	RBW-RU-B1	1.00	REBUSH A SET OF 2 BOSSES		.23835		.274	
0030	E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0990	JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000	.000	0

INITIAL INPUT MARCH 1983

20APR85 DOWNGRADE TO N STD TIME WAS 4.36 HRS

MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

69657A STRUT KC135 MLG L/H RCC MNPRA 4S1-56-3 038-9102 83083

TECH S S W F PF A/R REV

JOB	T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACV	STOR	HOURS	TIME	HOURS	DLY PCT C
RA015	E	N	JA	EA	1	J	83083	.20 PERCENT ENGR 12.6	303N	2.63	.52	
0001			JA	01	00			.00		.000	.000	0
			0010					7653528-01				
								3120010403938				
0028			JA	01	15			1.00		2.000	.300	2.300 87
			0010	N				1.00		2.00000		2.300
0030			JA	01	15			1.00		.288	.043	.332 13
			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
			0030	E		RJP-PW-R1		1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011
0990			JA	01	15			.01		.000	.000	.000 0
			0010					INITIAL INPUT MARCH 83				
			0990					K W SHIPLEY MANEAA 63357				
			0999					MANEL CLINTON BENTLEY MRP II 7-3255				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

69657A STRUT KC135 MLG L/H

RCC MRPRA

4S1-56-3 038-9102 83083

TECH S S W F PF A/R REV

JOB	STEP	T D L	K C DC	#R A FA	SUPPORT ELEMENT	OCC FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT
RA017	S E	JA EA 1	J	83083	1.00	PERCENT ENGR 99.9		KC 135 MLG PISTON ROD		.21		.21	
0001		JA 01	00		.00			PART NUMBER/NSN		.000	.000	.000	0
	0010					7531269-30		1620010273442					
	0025	JA 01	15		1.00			CHECK STRAIGHTNESS		.188	.028	.217	100
	0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL		PRGRATE OVER 4 PARTS		.27525		.079	
	0020	E		GIG-GM-C6	1.00	CHECK CONCENTRICITY				.10960		.126	
	0030	E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.011	
	0990	JA 01	15		.01			LABOR STANDARD HISTORY		.000	.000	.000	0
	0010							INITIAL INPUT MRP II FEBRUARY 88					
	0999							HANEL CLINTON BENTLEY MRP II 7-3255					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

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0010
0020
0990

INITIAL INPUT MAR 1983
20APR85 DOWNGRADE TO N STD - WAS 7.23 HRS
MANEL CLINTON BENTLEY MRP II 7-3255

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

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69657A STRUT KC135 MLG L/H RCC MNFRB 451-56-3 038-9102 83083

TECH S S W F PF A/R REV

T K #R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT STORED DESCRIPTION SUPPLEMENTAL JASE PFD STD A

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	JASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RB013	S	N	JA	EA	3	J	83083	.75	PERCENT ENGR 79.1	GRIND CYLINDER ASSY	307E	13.87	10.40	
0001			JA	01	00			.00	PART NUMBER/NSN		.000	.000	.000	0
									65-5763-17	1620009274739				
									65-5763-18	1620009592070				
									50-9712-32	1620007871750				
									50-9712-31	1620007871749				
0040			JA	01	15			.10	GND MCKL. OR CORRO. FR. TRUN. FA		3.711	.056	.427	3
								.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
0010 E								1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0020 E								2.00	ALIGN HORIZ AXIS ROD	2 LUGS	.06265		.144	
0030 E								2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053	
0040 E								4.00	GRIND 4 LUG FACES		.75000		3.450	
0050 N								1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0060 E								1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0070 E								.10	GND. MCKL. OR CORRO. FRM DRG S.		4.611	.069	.530	4
0050			JA	01	15			.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
								1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0010 E								2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144	
0020 E								2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053	
0030 E								6.00	GRIND 6 LUG FACES		.65000		4.485	
0040 E								1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0050 N								1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0060 E								.10	GND MCKL OR CORR. FRM. S. B. FAC		2.161	.032	.249	2
0070 E								.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
								1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0010 E								2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144	
0020 E								2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053	
0030 E								2.00	GRIND 2 FACES		.72500		1.667	
0040 E								1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0050 N								1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0060 E								.10	GND MCKL. OR CORRO. FRM. TOR. L. F		3.757	.056	.432	3
0070 E								.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
								1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0010 E								2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144	
0020 E								4.00	DRESS EXTERNAL WHEEL	4 TIMES	.02308		.106	
0030 E								4.00	GRIND 4 FACES		.75000		3.450	
0040 E								1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0050 N								1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0060 E								.38	GRD UPBORE FR CHROME PLATE		6.111	.348	2.671	19
0070 E								.50	SET UP LRG INTERNAL GRINDER		1.53372		.881	
0080 E								.50	LRG FIXTUR TO/FRM MACH HOIST		.45621		.262	
								1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0010 E								1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0020 E								4.00	GRIND OUT .010 10 ID X 3	4 X LENGTH	1.19745		5.508	
0030 E								1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0040 E								1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0050 E								.28	GRD LOCKE FR CHROME PLATE		3.717	.156	1.197	9
0060 E								.50	SET UP LRG INTERNAL GRINDER PRO RATE		1.53372		.881	
0070 E								.50	LRG FIXTUR TO/FRM MACH HOIST		.45621		.262	
0080 E								1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
								1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0010 E								2.00	GRIND OUT .010 10 ID X 3	2 TIMES LENGTH	1.19745		2.754	
0020 E								1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	

0080 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0440	JA 01	15	.10	FIN GND TRUN LUG FACE	4.534	.068	.521	4
0010 E	RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E	RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 LUGS	.06265		.144	
0040 E	KMG-DW-OD	3.00	DRESS EXTERNAL WHEEL	3 TIMES	.02308		.079	
0050 N		4.00		GRIND 4 LUG FACES	.95000		4.370	
0060 E	RGR-HM-CS	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0070 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0450	JA 01	15	.10	FIN GRD DRAG STRUT LUG FACES	5.211	.078	.599	4
0010 E	RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E	RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144	
0040 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053	
0050 N		6.00		GRIND 6 LUG FACES	.75000		5.175	
0060 E	RGR-HM-CS	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0070 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0460	JA 01	15	.10	FIN GRD SIDE BRACE LUG FACE	2.561	.038	.295	2
0010 E	RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E	RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144	
0040 E	KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053	
0050 N		2.00		GRIND 2 LUG FACES	.92500		2.127	
0060 E	RGR-HM-CS	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0070 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0470	JA 01	15	.10	FIN GND TOR LUG FACE	4.457	.067	.513	4
0010 E	RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E	RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144	
0040 E	KMG-DW-OD	4.00	DRESS EXTERNAL WHEEL	4 TIMES	.02308		.106	
0050 N		4.00		GRIND 4 LUG FACES	.92500		4.255	
0060 E	RGR-HM-CS	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0070 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0480	JA 01	15	.38	FIN GRIND UPPER BORE	10.408	.593	4.548	33
0010 E	RGR-SU-I2	.50	SET UP LRG INTERNAL GRINDER PRO RATE		1.53372		.881	
0020 E	RML-SU-F3	.50	LRG FIXTUR TO/FRM MACH HOIST		.45621		.262	
0030 E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0050 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E	KMG-ID-SK	4.00	GRIND OUT .040 10 ID X3	4 TIMES LENGTH	2.27158		10.449	
0070 E	RGR-HM-CS	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0080 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0490	JA 01	15	.28	FIN GRIND LOWER BORE	5.865	.246	1.889	14
0010 E	RGR-SU-I2	.50	SET UP LRG INTERNAL GRINDER PRO RATE		1.53372		.881	
0020 E	RML-SU-F3	.50	LRG FIXTUR TO/FRM MACH HOIST		.45621		.262	
0030 E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157	
0050 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E	KMG-ID-SK	2.00	GRIND OUT .040 10 ID X3	2 X LENGTH	2.27158		5.224	
0070 E	RGR-HM-CS	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0080 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0990	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				INITIAL INPUT MAR83				
0990				MANEL CLINTON BENTLEY MRP II 7-3255				

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69657A STRUT KC135 MLG L/H

RCC MNPRB

4S1-56-3 038-9102 83083

TECH S S W F PF A/R REV

JOB T K #R A FA SUPPRT OCC <----- DESCRIPTION -----> BASE PFD STD A
STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

RB014	S	E	JA	EA	3	J	83083	.75	PERCENT ENGR 80.5	GRIND PISTON KC135 MLG 303E	9.98		7.48		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
									65-1265-7	1620069816337					
									65-1265-8	1620000842104					
0140			JA	01	15			.10		1ST GND TORQUE LUG FACE	3.757	.056	.432		4
0010	E					RGR-SU-J3		.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298		
0020	E					RML-HP-CC		1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E					RML-AL-AA		2.00	ALIGN HORIZ AXIS ROD 2 TIMES		.06265		.144		
0040	E					KMG-DW-OD		4.00	DRESS EXTERNAL WHEEL 4 TIMES		.02308		.106		
0050	N							4.00	GRIND 4 FACES		.75000		3.450		
0060	E					RGR-HM-C5		1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E					RJP-PW-F1		1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0150			JA	01	15			.50		1ST GRIND PISTON O D	4.463	.335	2.566		26
0010	E					RGR-SU-G1		.50	SET UP A GAP GRINDER PRO RATE		1.05938		.609		
0020	E					RGR-HP-L3		1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414		
0030	E					RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER PRO RATE		.02632		.015		
0040	E					KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E					KMG-OD-SE		4.00	GRIND .010 1ODIA X 3 LONG		.85335		3.925		
0060	E					RGR-HM-C5		1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E					RJP-PW-F1		1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0160			JA	01	15			.50		1ST GRIND SEAL AREA	1.840	.138	1.058		11
0010	E					RGR-SU-P1		.50	SET UP PLANETARY GRINDER PRO RATE		.82175		.472		
0020	E					RGR-HP-L1		1.00	LOAD LARGE PART GAP GRINDER		.13653		.157		
0030	E					KMG-DW-ID		1.00	DRESS INTERNAL WHEEL		.02458		.028		
0040	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E					KMG-ID-RE		1.00	GRIND OUT .010 9 ID X 3		1.07779		1.239		
0060	E					RGR-HM-C5		1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E					RJP-PW-F1		1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0250			JA	01	15			.10		FIN GRING TORQUE LUG FACES	4.457	.067	.513		5
0010	E					RGR-SU-J3		.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298		
0020	E					RML-HP-CC		1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E					RML-AL-AA		2.00	ALIGN HORIZ AXIS ROD 2 TIMES		.06265		.144		
0040	E					KMG-DW-OD		4.00	DRESS EXTERNAL WHEEL 4 TIMES		.02308		.106		
0050	N							4.00	GRIND 4 FACES		.92500		4.255		
0060	E					RGR-HM-C5		1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E					RJP-PW-F1		1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0260			JA	01	15			.50		FIN GRIND CYL OD	6.589	.494	3.789		38
0010	E					RGR-SU-G1		.50	SET UP A GAP GRINDER PRO RATE		1.05938		.609		
0020	E					RGR-HP-L3		1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414		
0030	E					RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER PRO RATE		.02632		.015		
0040	E					KMG-DW-OD		3.00	DRESS EXTERNAL WHEEL 3 TIMES		.02308		.079		
0050	E					KMG-OD-SK		4.00	GRIND .040 FROM 10 IN D X 3		1.37336		6.317		
0060	E					RGR-HM-C5		1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E					RJP-PW-F1		1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0270			JA	01	15			.50		FIN GRIND SEAL AREA	2.831	.212	1.628		16
0010	E					RGR-SU-P1		.50	SET UP PLANETARY GRINDER PRO RATE		.82175		.472		
0020	E					RGR-HP-L1		1.00	LOAD LARGE PART GAP GRINDER		.13653		.157		
0030	E					KMG-DW-ID		2.00	DRESS INTERNAL WHEEL 2 TIMES		.02458		.056		
0040	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	N							1.00	GRIND SEAL KMGIDRK		2.04400		2.350		
0060	E					RGR-HM-C5		1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E					RJP-PW-F1		1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0990			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0

PER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT
0010	E	N	HB	EA	5	J 88174	1.00	PERCENT ENGR	.0	ASSY STRUT KC-135	6.09		6.09	
0001			HB	00	00		.00			PART NO/NSN	.000	.000	.000	0
0010								7531273-80	1620010389103					
0020								7531273-70	1620010389100					
0030								7531273-90	1620010389102					
0040								7531273-100	1620010389101					
0501			HB	01	00		1.00			PRE-ASSY CLEAN	.235	.000	.235	4
0010	N						1.00			CLEAN	.23500		.235	
0502			HB	01	00		1.00			OK TO CLOSE/ASSEMBLE	3.400	.000	3.400	56
0010	N						1.00			ASSEMBLE	3.40000		3.400	
0504			HB	01	00		1.00			TORQUE ALL	.500	.000	.500	8
0010	N						1.00			TORQUE PARTS A/R	.50000		.500	
0505			HB	01	00		1.00			CHECK STROKE	1.500	.000	1.500	25
0010	N						1.00			STROKE	1.50000		1.500	
0506			HB	01	00		1.00			PRESSURE TEST	.460	.000	.460	2.4
0010	N						1.00			TEST	.46000		.460	8
9000			HB	01	21		.01			LABOR STANDARD HISTORY	.000	.000	.000	0

INITIAL INPUT MARCH 1983
 20APR85-DOWNGRADE TO N STD-TIME WAS 3.24 HRS
 24 MAY 85 - MOVED TEST FROM SKILL CODE TO
 TO SKILL CODE HB - TIME WAS 3.24 HRS
 K W SHIPLEY MANEAA 63357

TO INTERROGATE LABOR STANDARDS, INPUT

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69657A STRUT KC135 MLG L/H

RCC MHPGP

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PK	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						
PK043	S	N	DI	EA	5	J 88173	1.00	PERCENT ENGR 64.7									MATCH UP STRUT KC 135	.98		.98	
0001			DI	00	00		.00		PART NO/NSN	.000	.000	.000			0						
	0010							7531273-80	1620010389103												
	0010		DI	01	21		1.00		MATCH UP STRUT	.813	.171	.985		100							
			0010	N			1.00		SORT/STORE NON RTD PART	.20700		.347									
			0020	E		RLG-MU-01	1.00	MATCH UP PARTS FOR ASSEMBLY		.52681		.637									
	9000		DI	01	21		.01		LABOR STD HISTORY	.000	.000	.000		0							
			0010						INITIAL INPUT MARCH 83												
			0020						20APR85-DOWNGRADE TO N STD- TIME WAS 0.81 HRS												
			0990						K W SHIPLEY MANEAA 63357												

TO INTERROGATE LABOR STANDARDS, INPUT

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69657A STRUT KC135 MLG L/H

RCC MNPGP

4S1-56-3 03B-9102 83086

TECH S S W F PF A/R REV

JOB	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					
PP043	S	E	3S	EA	5	J 88173	1.00 PERCENT ENGR 80.4		1.62	1.62		
0001			3S	00	00		.00		.000	.000	.000	0
	0010					7531273-80	1620010389103					
0510		3S	01		25		1.00		.956	.239	1.196	4.0 73
	0010	E		ZLG-HH-03		1.00 LOAD LRG STRUT ON O/H CONV	LOAD OVERHEAD CRANE		.03515		.043	
	0020	E		ZMA-MN-L1		1.00 MASK LRG MLG STRUT FNL PAINT			.30702		.383	
	0030	E		ZMP-SP-F3		1.00 FINAL PAINT LRG STRUT/PART			.40789		.509	
	0040	E		RLG-JP-DS		1.00 GET STRUT DECALS F/STO CAB			.00693		.008	
	0050	E		ZMP-UM-03		1.00 UNMASK LRG STRUT AFTER PAINT			.14110		.176	
	0060	E		ZLG-HH-U1		1.00 UNLOAD OVERHEAD CONVEYOR			.03462		.043	
	0070	E		KID-DL-AA		1.00 INSTALL DECAL PR SENSITIVE			.01378		.017	
	0080	E		RJP-PW-R1		1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.012	
0512		3S	01		25		1.00		.030	.008	.038	2
	0010	E		RLG-JP-DS		1.00 GET STRUT DECALS F/STO CAB			.00693		.008	
	0020	E		KID-DL-AA		1.00 INSTALL DECAL PR SENSITIVE			.01378		.017	
	0030	E		RJP-PW-R1		1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.012	
0515		3S	01		24		1.00		.180	.043	.224	14
	0010	N					1.00		.12800		.158	
	0020	E		GJP-FP-B5		1.00 FILL OUT FORM 424 & ATTACH			.05255		.065	
0516		3S	01		24		1.00		.137	.033	.170	10
	0010	N					1.00		.12700		.157	
	0020	E		RJP-PW-R1		1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.012	

TO INTERROGATE LABOR STANDARDS, INPUT

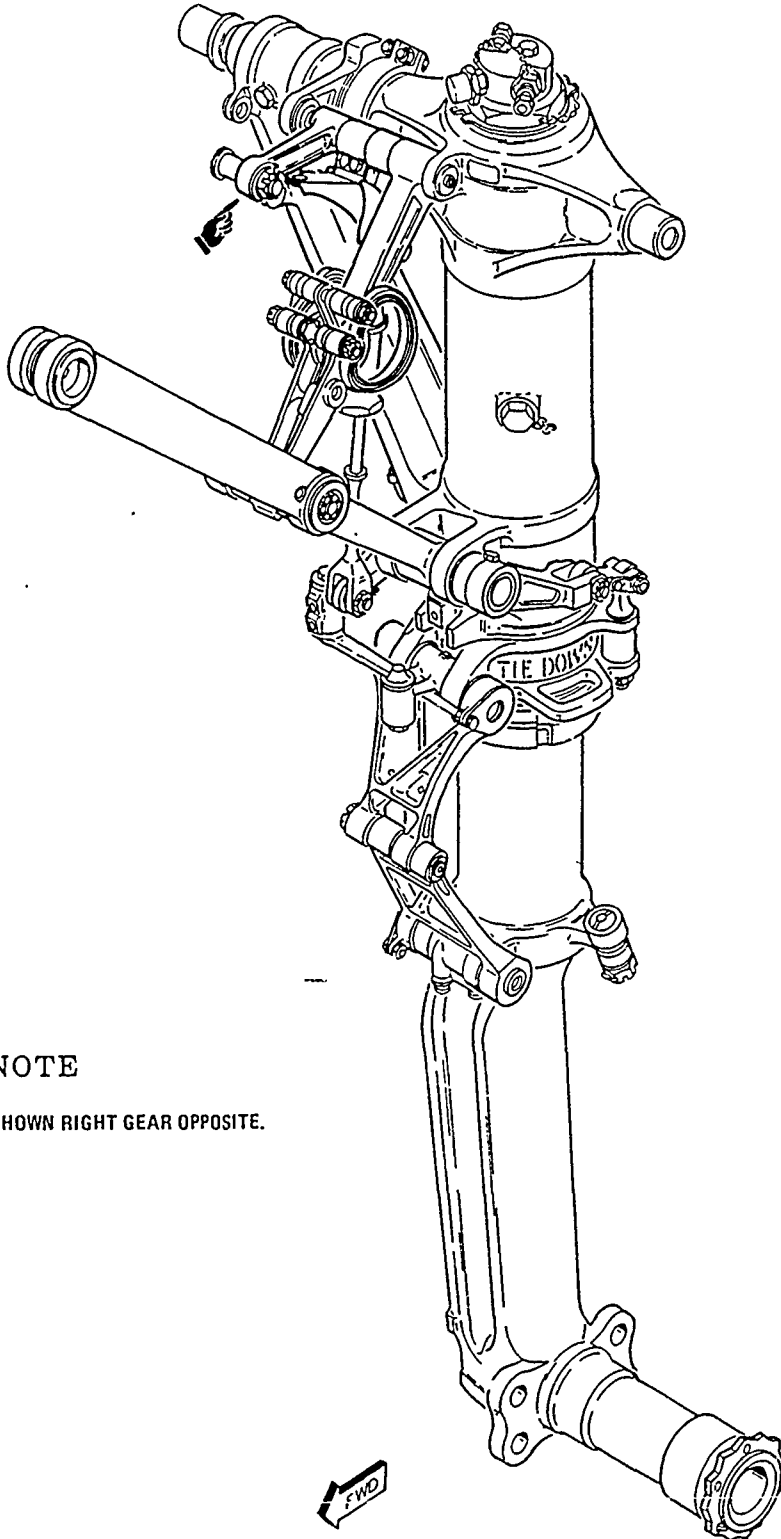
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F-15 MLG



NOTE

1. LEFT GEAR SHOWN RIGHT GEAR OPPOSITE.

4A4-22-3-121E

Main Landing Gear Assembly

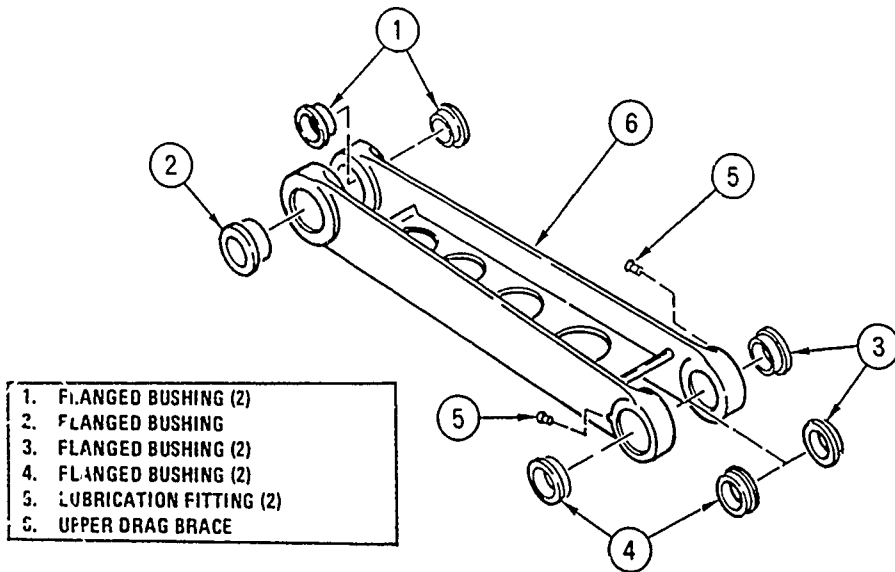


Figure 3-1. Upper Drag Brace Assembly

- | | | | |
|-----|---------------------|-----|------------------|
| 1. | COTTER PIN | 14. | CLAMP UP BUSHING |
| 2. | NUT | 15. | JAM NUT |
| 3. | LUBRICATION FITTING | 16. | LOCKING DEVICE |
| 4. | BOLT | 17. | NUT |
| 5. | WASHER | 18. | SPRING DISC (25) |
| 6. | BRACKET | 19. | SPACER |
| 7. | WASHER (3) | 20. | PACKING |
| 8. | BUSHING | 21. | PACKING |
| 9. | COTTER PIN | 22. | CAP |
| 10. | NUT | 23. | BUNGEE ROD |
| 11. | WASHER | 24. | FLANGED BUSHING |
| 12. | LUBRICATION FITTING | 25. | BUNGEE CYLINDER |
| 13. | BOLT | | |

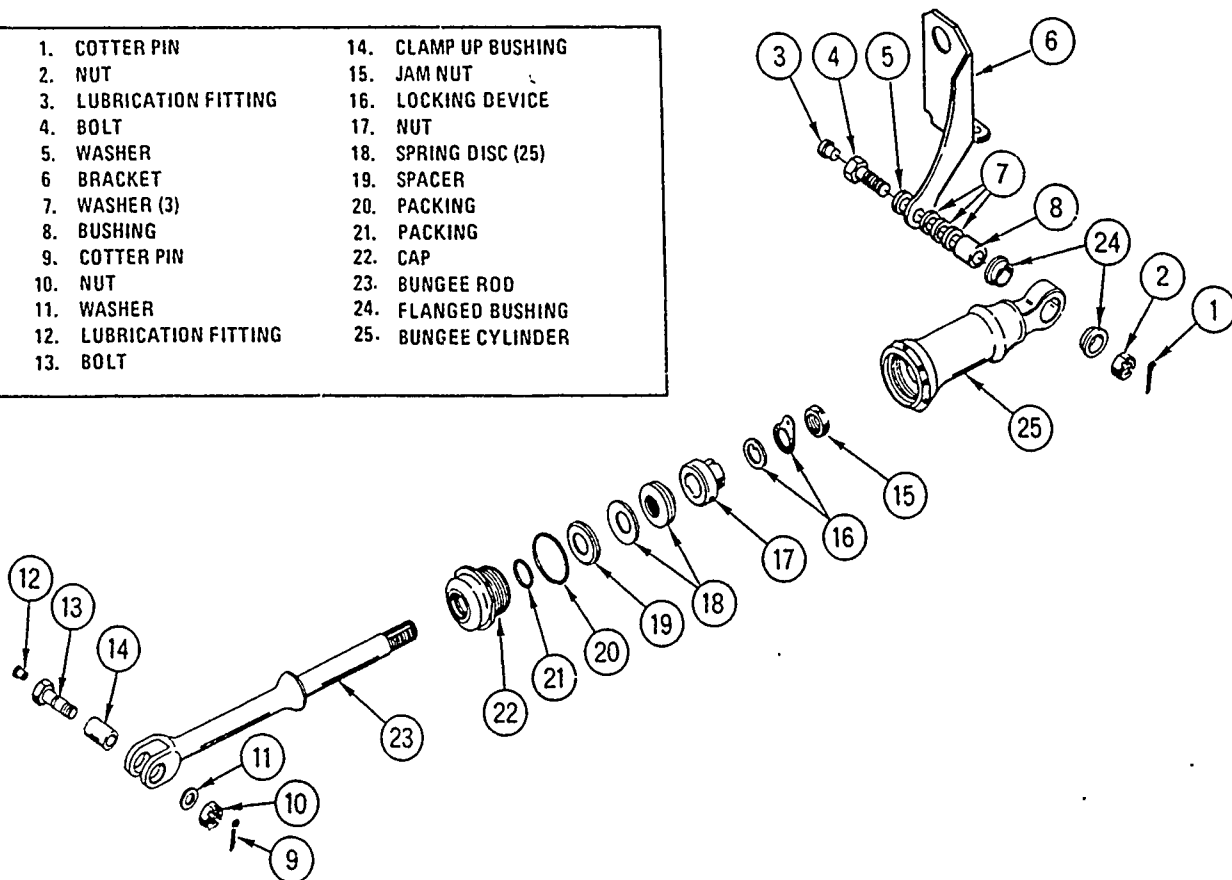


Figure 3-2. Bungee Assembly

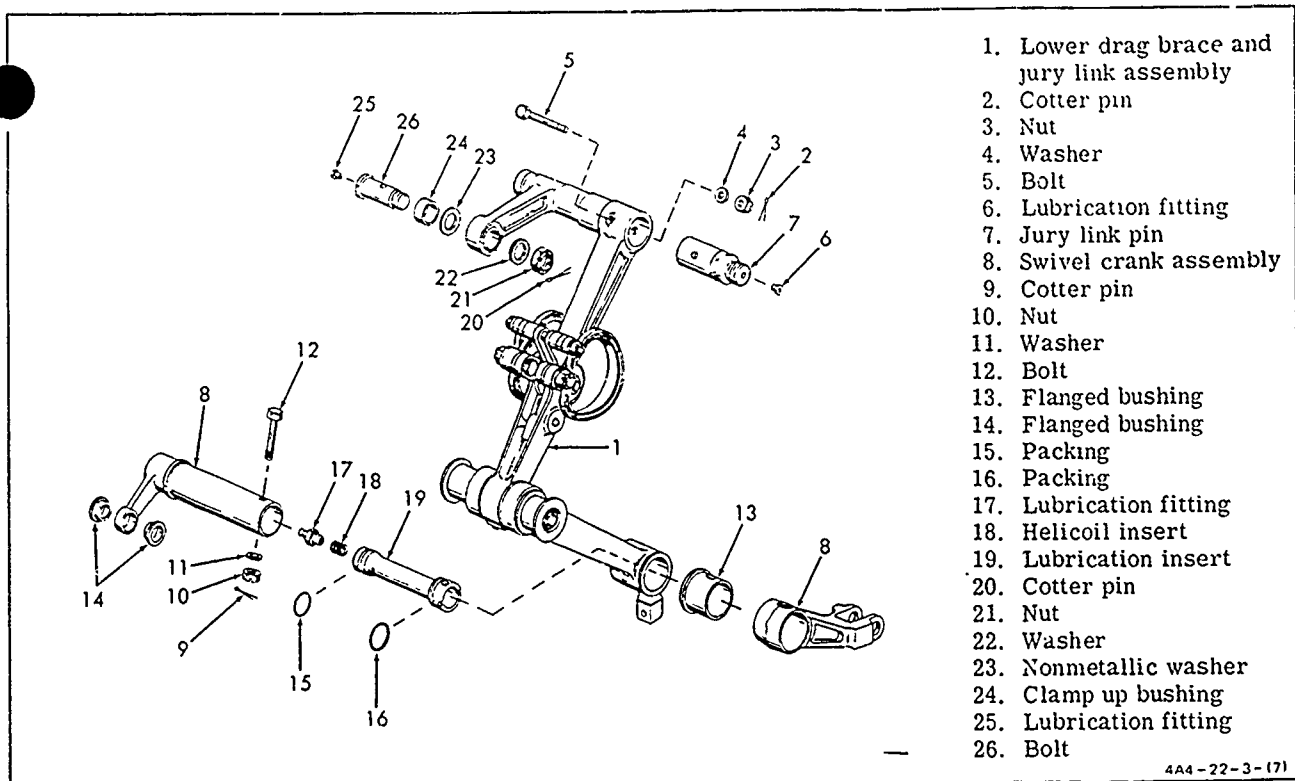


Figure 3-3. Lower Drag Brace and Jury Link

CAUTION

To prevent damage to parts, lugs must be supported when removing bushings.

g. Do not remove flanged bushings (33), sleeve bushing (34), or lubrication fitting (35) from lower jury link (32). If replacement of bushings is necessary, drive out bushings.

h and i. Deleted

CAUTION

To prevent damage to parts, lugs must be supported when removing bushings.

j. Do not remove flanged bushings (43), spherical bearing (42), or lubrication fitting (44) from upper jury link (41). If replacement of bushings is necessary, drive out bushings. If replacement of spherical bearing is necessary, refer to section V for replacement procedures.

3-8. DISASSEMBLING SWIVEL CONNECTING LINK.

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 cotter pin (1), nut (2), tang washer (3), and shim washer (4) securing collar spindle (15) to collar on strut cylinder. Remove collar spindle with swivel link (26) assembled.

b. Remove lockwire from nut (6) if installed, and remove nut (6), washer (7) and bolt (8); remove locking plate (5) from swivel link (26).

CAUTION

To prevent damage to parts, lugs must be supported when removing bushings.

c. Remove cotter pin (9), nut (10), washer (11), and eccentric bolt (12); separate collar spindle (15) from swivel link (26). Do not remove lubrication fitting (13) or flanged bushings (14) from collar spindle. If necessary to replace bushings, drive out bushings.

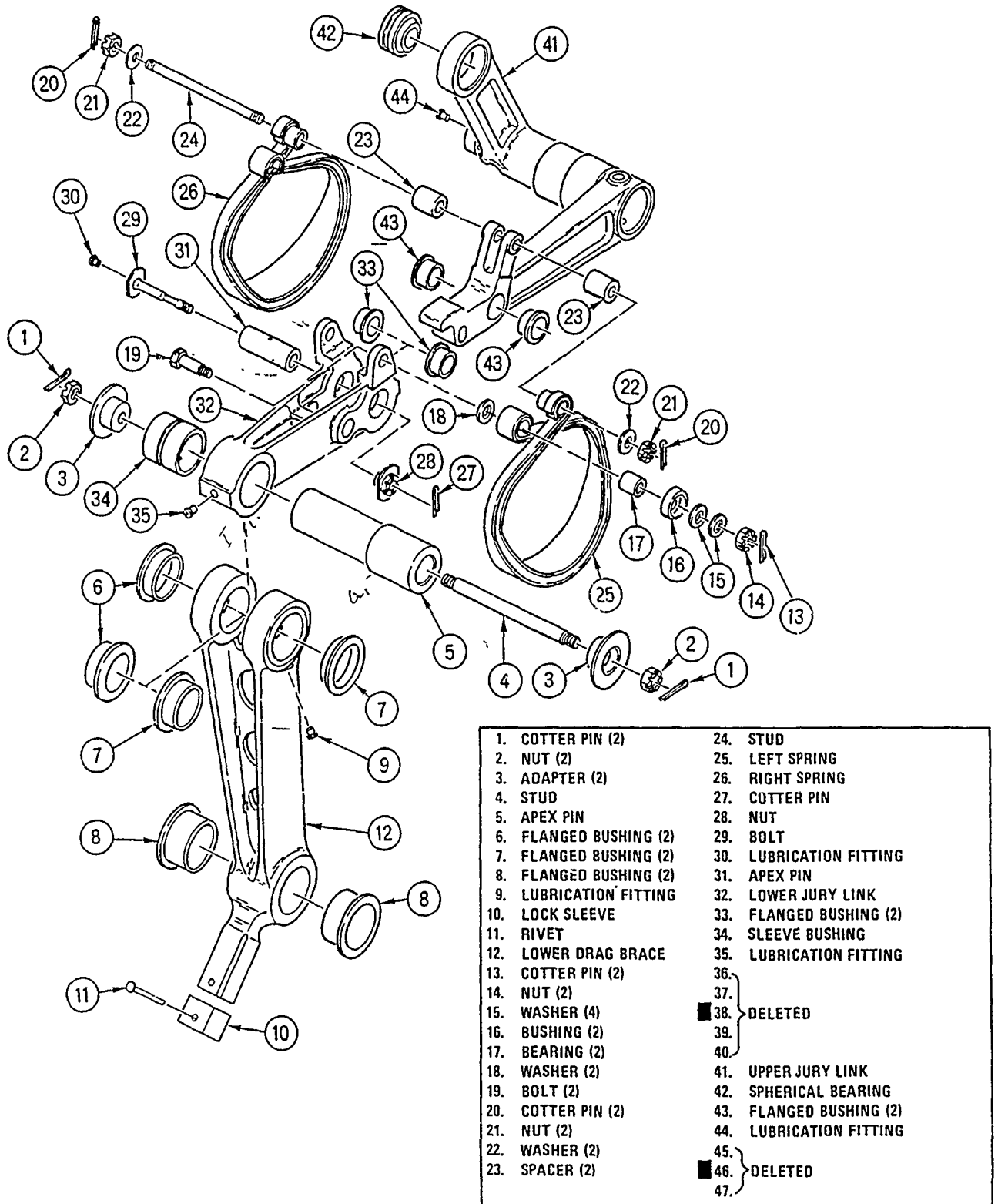
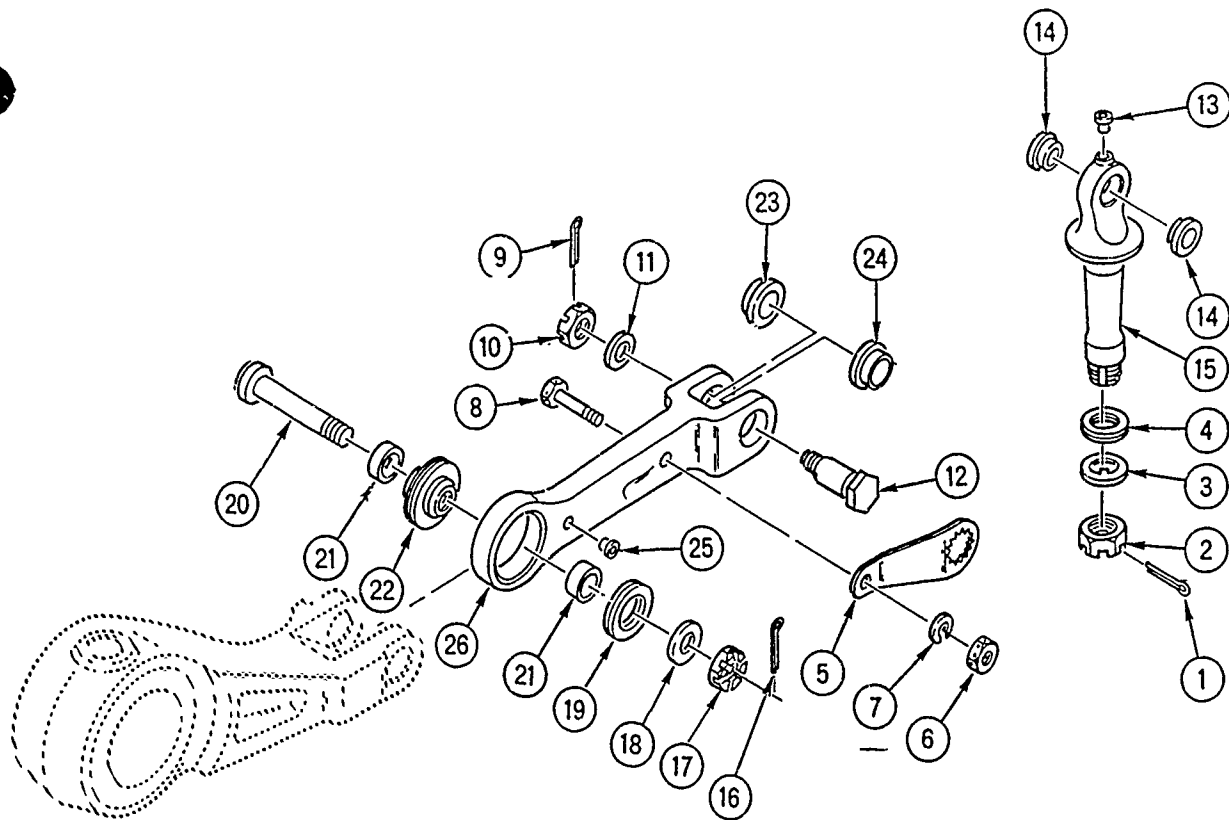


Figure 3-4. Lower Drag Brace and Jury Links

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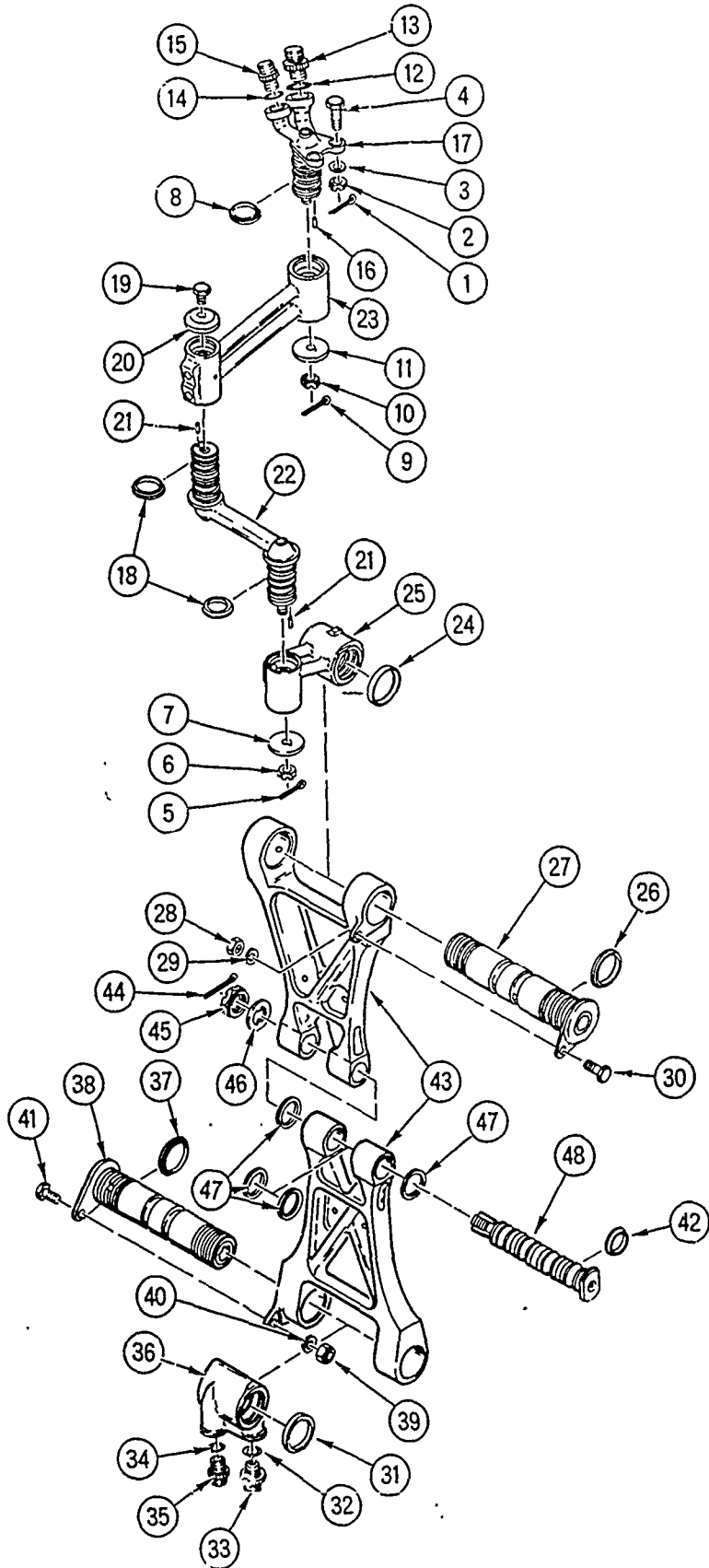


- | | |
|-------------------------|-------------------------|
| 1. COTTER PIN | 14. FLANGED BUSHING (2) |
| 2. NUT | 15. COLLAR SPINDLE |
| 3. TANG WASHER | 16. COTTER PIN |
| 4. SHIM WASHER | 17. NUT |
| 5. LOCKING PLATE | 18. WASHER |
| 6. NUT | 19. SHIM WASHER |
| 7. WASHER | 20. SWIVEL APEX BOLT |
| 8. BOLT | 21. SLEEVE BUSHING (2) |
| 9. COTTER PIN | 22. SPHERICAL BEARING |
| 10. NUT | 23. FLANGED BUSHING |
| 11. WASHER | 24. FLANGED BUSHING |
| 12. ECCENTRIC BOLT | 25. LUBRICATION FITTING |
| 13. LUBRICATION FITTING | 26. SWIVEL LINK |

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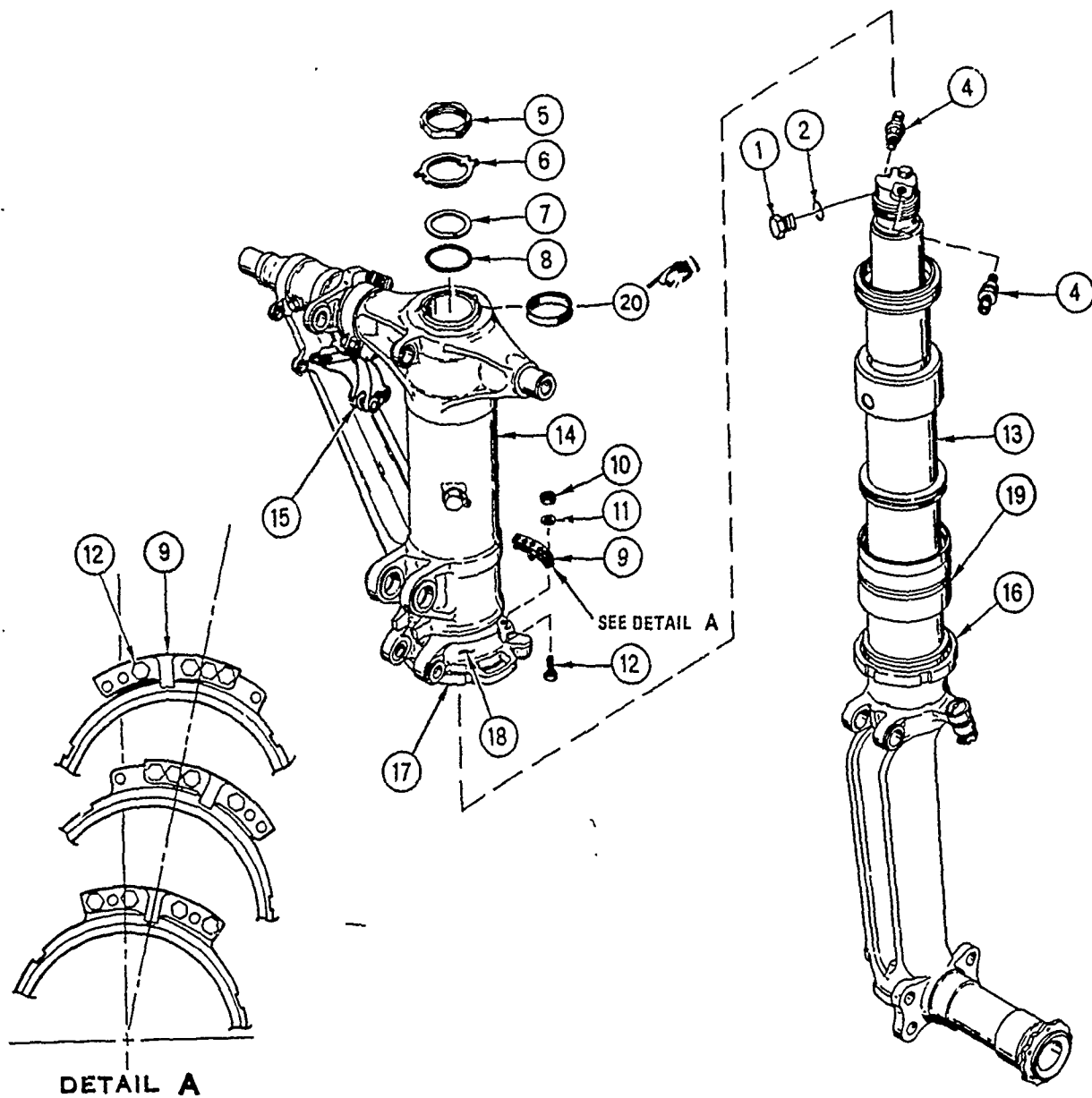
Figure 3-5. Swivel Connecting Link

1. COTTER PIN (2)
2. NUT (2)
3. FLAT WASHER (LAMINATED SHIM) (2)
4. BOLT (2)
5. COTTER PIN
6. NUT
7. WASHER
8. T-SEAL (4)
9. COTTER PIN
10. NUT
11. WASHER
12. PACKING
13. HYDRAULIC FITTING
14. PACKING
15. HYDRAULIC FITTING
16. DOWEL PIN
17. SWIVEL SHAFT
18. T-SEAL
19. BOLT
20. WASHER
21. PIN
22. HYDRAULIC TRANSFER CRANK
23. HYDRAULIC TRANSFER LINK
24. T-SEAL (4)
25. UPPER MANIFOLD
26. T-SEAL (8)
27. TORQUE ARM PIN
28. NUT
29. WASHER
30. BOLT
31. T-SEAL (4)
32. PACKING
33. HYDRAULIC FITTING
34. PACKING
35. HYDRAULIC FITTING
36. LOWER MANIFOLD
37. T-SEAL (8)
38. TORQUE ARM PIN
39. NUT
40. WASHER
41. BOLT
42. T-SEAL (8)
43. TORQUE ARM (2)
44. COTTER PIN
45. NUT
46. TANG WASHER
47. LUBE WASHER (4)
48. APEX BOLT



4A4-22-3-(8)

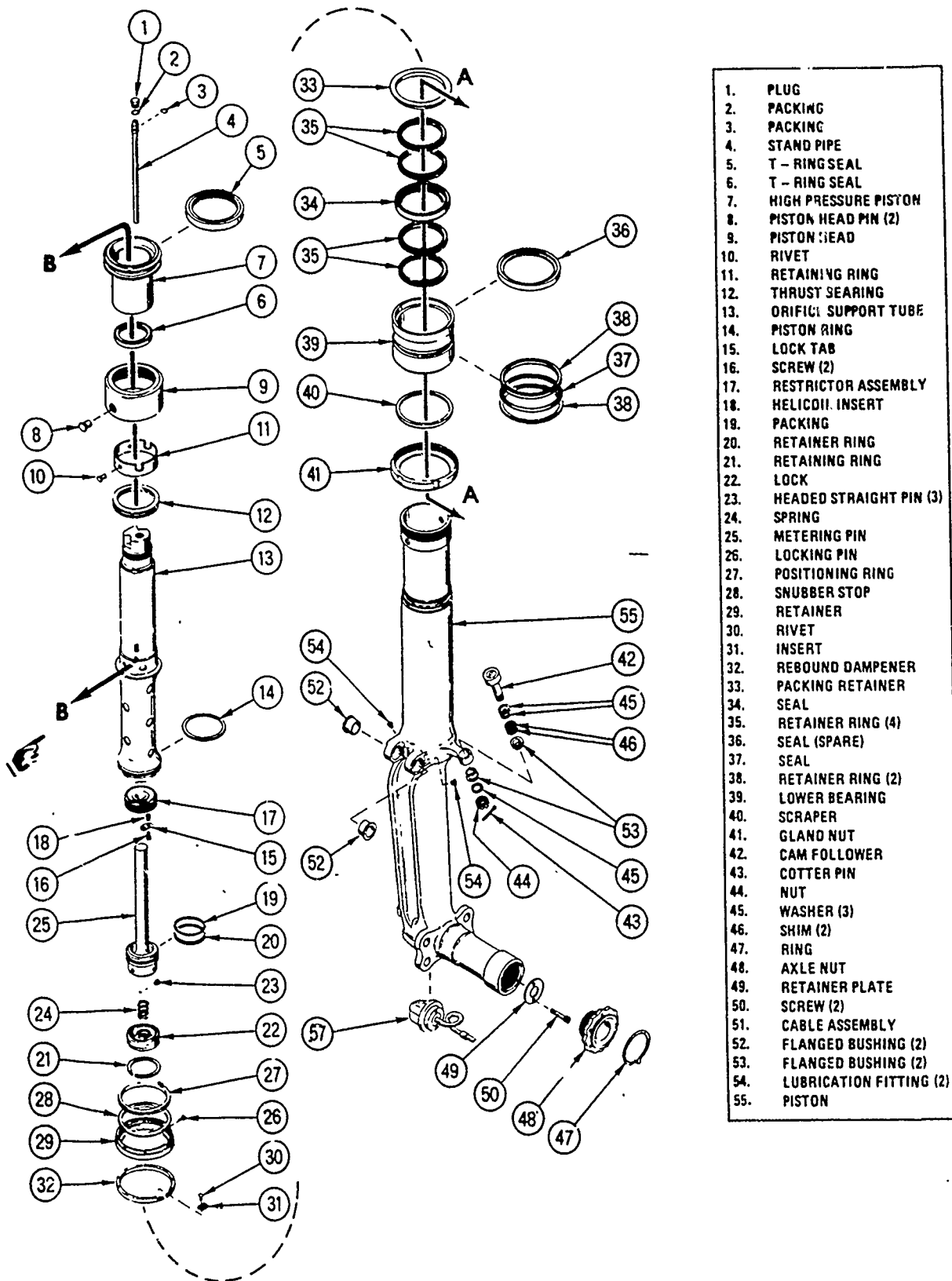
Figure 3-6. Torque Arms, Crank, and Link Assembly



DETAIL A
 LOCK TAB (9) AND BOLTS (12) MUST
 BE INSTALLED IN ONE OF THESE
 POSITIONS

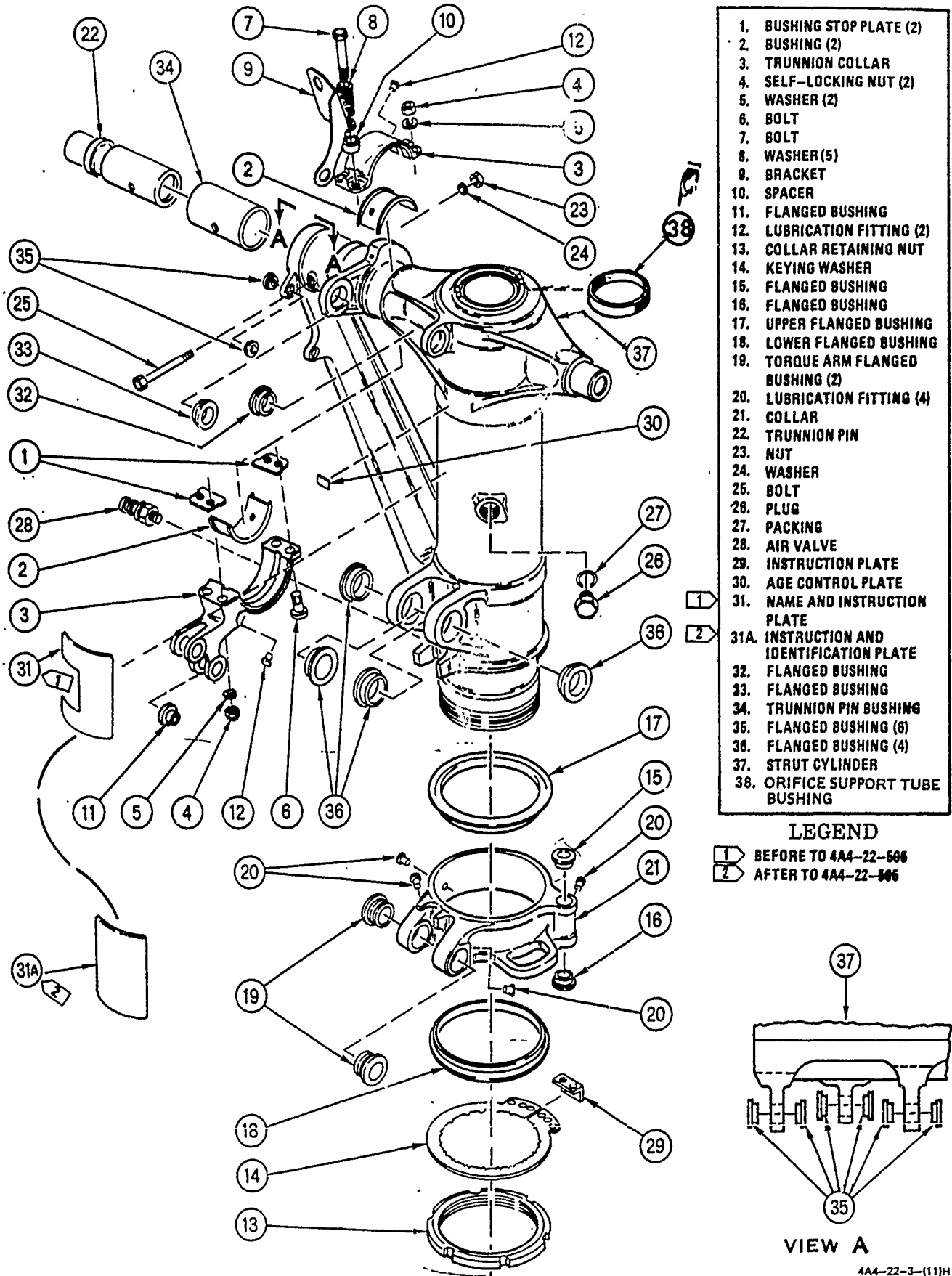
- | | |
|------------------|--|
| 1. PLUG | 11. WASHER (4) |
| 2. PACKING | 12. BOLT (4) |
| 3. DELETED | 13. PISTON AND ORIFICE SUPPORT TUBE ASSEMBLY |
| 4. AIR VALVE (2) | 14. STRUT CYLINDER ASSEMBLY |
| 5. NUT | 15. BRACKET |
| 6. RETAINER | 16. GLAND NUT |
| 7. RETAINER RING | 17. COLLAR RETAINING NUT |
| 8. PACKING | 18. COLLAR |
| 9. LOCK TAB | 19. LOWER BEARING |
| 10. NUT (4) | 20. ORIFICE SUPPORT TUBE BUSHING |

Figure 3-7. Piston and Orifice Support Tube Assembly



1. PLUG
2. PACKING
3. PACKING
4. STAND PIPE
5. T - RING SEAL
6. T - RING SEAL
7. HIGH PRESSURE PISTON
8. PISTON HEAD PIN (2)
9. PISTON HEAD
10. RIVET
11. RETAINING RING
12. THRUST SEARING
13. ORIFICE SUPPORT TUBE
14. PISTON RING
15. LOCK TAB
16. SCREW (2)
17. RESTRICTOR ASSEMBLY
18. HELICOID. INSERT
19. PACKING
20. RETAINER RING
21. RETAINING RING
22. LOCK
23. HEADED STRAIGHT PIN (3)
24. SPRING
25. METERING PIN
26. LOCKING PIN
27. POSITIONING RING
28. SNUBBER STOP
29. RETAINER
30. RIVET
31. INSERT
32. REBOUND DAMPENER
33. PACKING RETAINER
34. SEAL
35. RETAINER RING (4)
36. SEAL (SPARE)
37. SEAL
38. RETAINER RING (2)
39. LOWER BEARING
40. SCRAPER
41. GLAND NUT
42. CAM FOLLOWER
43. COTTER PIN
44. NUT
45. WASHER (3)
46. SHIM (2)
47. RING
48. AXLE NUT
49. RETAINER PLATE
50. SCREW (2)
51. CABLE ASSEMBLY
52. FLANGED BUSHING (2)
53. FLANGED BUSHING (2)
54. LUBRICATION FITTING (2)
55. PISTON

Figure 3-8. Piston and Orifice Support Tube Assembly and High Pressure Seal (Sheet 1 of 2)



1. BUSHING STOP PLATE (2)
2. BUSHING (2)
3. TRUNNION COLLAR
4. SELF-LOCKING NUT (2)
5. WASHER (2)
6. BOLT
7. BOLT
8. WASHER (5)
9. BRACKET
10. SPACER
11. FLANGED BUSHING
12. LUBRICATION FITTING (2)
13. COLLAR RETAINING NUT
14. KEYING WASHER
15. FLANGED BUSHING
16. FLANGED BUSHING
17. UPPER FLANGED BUSHING
18. LOWER FLANGED BUSHING
19. TORQUE ARM FLANGED BUSHING (2)
20. LUBRICATION FITTING (4)
21. COLLAR
22. TRUNNION PIN
23. NUT
24. WASHER
25. BOLT
26. PLUG
27. PACKING
28. AIR VALVE
29. INSTRUCTION PLATE
30. AGE CONTROL PLATE
31. NAME AND INSTRUCTION PLATE
- 31A. INSTRUCTION AND IDENTIFICATION PLATE
32. FLANGED BUSHING
33. FLANGED BUSHING
34. TRUNNION PIN BUSHING
35. FLANGED BUSHING (8)
36. FLANGED BUSHING (4)
37. STRUT CYLINDER
38. ORIFICE SUPPORT TUBE BUSHING

Figure 3-9. Strut Cylinder Assembly

SECTION I

GENERAL INFORMATION

1-1. PURPOSE.

1-2. The right and left main landing gears provide support for the aircraft during landing and ground operations. This is accomplished through three functional subassemblies: the shock strut, the drag brace, and the linear actuating cylinder assembly.

1-3. GENERAL INFORMATION.

1-4. This publication covers overhaul procedures for the left and right main retractable landing gears. Each landing gear consists principally of a shock strut, with brace structure, an upper drag brace, and a linear actuating cylinder. Each is a separate line replaceable unit and is handled accordingly herein except that the linear actuating cylinder is covered in TO 9H2-2-105-3.

1-5. FUNCTION, OPERATION AND DESCRIPTION.

1-6. SHOCK STRUT. The main landing gear shock strut absorbs the energy from ground loads during landing and taxiing. This is attained by a telescoping piston and cylinder assembly that is pressurized with air and oil in the extended position. Impact loads during landing are metered by oil being forced through an orifice during the compression stroke. The taxi loads have less orifice effect and receive support from the compressed air column. On the extension stroke, a recoil valve meters oil exit between the piston and cylinder to dampen rebound loads. The shock strut cylinder also incorporates a fixed side brace to support side loads between the strut and inboard trunnion attach point. The air oil shock strut is closed system. A hydraulic interface exists with the brake pressure lines at the upper swivel manifold and lower torque arm pin. An electrical interface exists on the piston for the anti-skid lines.

1-7. The strut also has the capability of being retracted with the wheel and piston being swiveled for stowage clearance when acted upon by the retraction system. This swiveling action is accomplished by sequencing the rotary movement of the piston to the cylinder collar by torque links. The collar, in turn, is rotated by a simple link mechanism actuated by the geometry of the retract movement. In the gear down position the collar, and thereby the wheel, is locked in the forward position by a lock finger extending from the lower drag brace into a slot in both the cylinder and the collar. The initial retract motion removes the lock finger for the swivel action to rotate the wheel into the stowed position. Towing and tie down provisions are on the cylinder collar.

1-8. The shock strut assembly has an extended length of approximately 51 inches from the trunnion to the axle centerline with a compression stroke of 9 inches. It is serviced with nitrogen and hydraulic oil with the attach points being lubricated with grease.

1-9. The piston is fabricated from high-strength steel and is protected by chromium on the wear surfaces and with low-embrittlement cadmium and paint on the nonfunctional surfaces. The piston provides an axle for the wheel, brake, and anti-skid installation, and is the inner telescoping member of the shock strut. Jack pad attachment provisions are at the bottom of the piston. The left and right main gear pistons are not interchangeable.

1-10. The cylinder is fabricated from high-strength steel and is protected primarily by low embrittlement cadmium plating and paint. It is the outer fixed member of the shock strut and provides a trunnion and socket for pin attachment to the aircraft. It also incorporates an integral side brace between the inboard trunnion area and the lower end of the cylinder. The cylinder has bushed lugs for the drag and jury brace attachment, and provisions for the collar assembly. A port on the lower end of the cylinder provides for an alternate charging point as well as a drain port. Another port provides for a proximity switch to detect full extension. The left and right main gear cylinders are not interchangeable.

1-11. The orifice support tube is an anodized aluminum member that supports the hydraulic loads imposed on the orifice plate. The support tube protrudes through the top of the cylinder where it incorporates the charging port. This part is interchangeable between the left and right main gears.

1-12. The metering pin is an anodized aluminum tapered pin that meters the oil flow through the orifice and thereby controls the load stroke relationship. This pin installs against an ID bulkhead in the piston and is retained by spring-loaded pins.

1-13. The torque arm assembly consists of two high-strength steel links fastened together to maintain alignment between the cylinder, piston, and wheel. The torque arms are interchangeable between themselves and between both main gears. The torque arms also provide for the passage of brake hydraulic fluid from the hydraulic swivel at the cylinder attach point to the manifold at the piston attach point.

1-14. The torque collar mounts on the lower end of the cylinder and positions the wheel in the gear stowed and gear down position. The collar position is controlled through the swivel linkage and, in turn, positions the wheel through the torque arms that attach the collar to the piston. The collar is fabricated from high-strength steel.

1-15. Internal parts consist of seals, scraper rings, upper and lower bearings that are interchangeable between main gears. External parts consist primarily of attaching bolts and nuts fabricated from steel; they are interchangeable between main gears. There is also a hydraulic swivel that transmits the brake lines from the cylinder to the upper torque arm in order to accommodate relative rotation between the cylinder and piston during retraction.

1-16. DRAG BRACE. The drag brace supports the main gear drag loads, provides a downlock, a swivel collar forward position lock, and provides for gear retraction by folding. The interfaces with the drag brace are mechanical and consist of airframe, shock strut cylinder, swivel collar, and retract actuator attachments. The two jury links provide an overcenter downlock between the shock strut and the drag brace apex, thus preventing retraction in the extended position. Retract actuator lugs on the upper jury link provide for the energy path to unlock the jury links and retract the gear. The jury brace provides for the mounting of the ground lock pin and the downlock switch is mounted on the trunnion collar.

1-17. The upper drag brace is fabricated from titanium. The lower drag link material is high strength steel protected by cadmium. Both the upper and lower drag braces are interchangeable between the left and right main gears.

1-18. The upper jury brace is fabricated from cadmium plated, high strength steel and is not interchangeable between left and right main gears because of the actuator attachment. The lower jury brace

material is anodized aluminum and is interchangeable between left and right main gears.

1-19. LEADING PARTICULARS.

1-20. Table 1-1 lists main features and leading particulars on the main landing gear assembly.

Table 1-1. Leading Particulars

Length	
Extended.....	51.73 to 51.87 inches
Fully Compressed.....	42.73 to 42.79 inches
Stroke	9.00 to 9.08 inches
Weight (approximate)	
(each gear).....	155 pounds
Charging Medium	
Hydraulic Oil	MIL-H-5606 or MIL-H-6083
Nitrogen	BB-N-411, Type I, Class I, Grade B
Pressure Rating (fully extended)	
Low Pressure Chamber..	29 to 500 psi
High Pressure Chamber..	673 to 1100 psi

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.M.)

BILL OF MATERIALS

26338A

STL-STEEL
AL-ALUMINUM
MAG-MAGNESIUM
TITA-TITANIUM
SS-S STL
SYN-SYNTHETIC
LD-LEAD

ROUTED LEVEL	ITEMS	CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	QTY	UNIT	YIELD	SCRAP	PART	INTIC	REV	EFFECTIVITY	TECH	ORD	PENDING	103	252	PENDING	AFTO	22	
0			168A10501-2011		76301	F-15 MAIN STRUT ASSY (L.H., H.H.M.)	1	EA															
1	1		1K410501-10J3	1620011671000	30400	..KIT, PARTS (C)	1	EA															
2	2		1S77K288-12Z1	1620011753303	76301	..PACKING ASSEMBLY (T-RING) (KIT)	18	EA															
2	2		1712ZFR160-5708	5330010442339	72902	..PACKING ASSEMBLY (T-RING)	18	EA															
2	2		1712ZFR160T	5330010196394	72902	..PACKING ASSEMBLY (T-RING)	18	EA															
2	2		1S77K254-115E1	5330010071644	76301	..PACKING ASSEMBLY (T-RING) (KIT)	112	EA															
2	2		17115PR160-5708	5330010071644	72902	..PACKING ASSEMBLY (T-RING)	112	EA															
2	2		17115PR160T	5330005443259	72902	..PACKING ASSEMBLY (T-RING)	112	EA															
2	2		1S77K254-1.3E2	5330012541395	76301	..PACKING ASSEMBLY (T-RING) (KIT)	18	EA															
2	2		17113NS160-5708	5330012541395	72902	..PACKING ASSEMBLY (T-RING)	18	EA															
2	2		17113NS160T	5330005338134	72902	..PACKING ASSEMBLY (T-RING)	18	EA															
2	2		1S77K254-1.9E1	5330010962186	76301	..PACKING ASSEMBLY (T-RING) (KIT)	18	EA															
2	2		17119PR160-5708	N.S.L.	72902	..PACKING ASSEMBLY (T-RING)	18	EA															
2	2		17119PR160T	5330005338137	72902	..PACKING ASSEMBLY (T-RING)	18	EA															
2	2		168B418015-101	5330010808078	76301	..PACKING ASSEMBLY (T-RING) (KIT)	11	EA															
2	2		168B418015-105	5330010799153	76301	..PACKING ASSEMBLY (T-RING) (KIT)	11	EA															
2	2		168B418015-107	5330010804829	76301	..PACKING ASSEMBLY (T-RING) (KIT)	11	EA															
2	2		168B418015-103	5330010804830	76301	..PACKING ASSEMBLY (T-RING)	11	EA															
2	2		168B418015-109	5330012445287	76301	..PACKING ASSEMBLY (T-RING) (KIT)	11	EA															
2	2		N.P.L.	N.S.L.		..PACKING & RETAINER ASSY (PBELJO)	11	EA															
3	3		1N6227-5	5330001965339	88044	..PACKING (O-RING)	11	EA															
3	3		1N628774-427	5330007296143	96906	..RETAINER (BACKUP RING)	11	EA															
2	2		168B418015-221	5330010800040	76301	..PACKING (T-RING) (KIT)	11	EA															
2	2		168B418015-219	5330010800039	76301	..PACKING (T-RING)	11	EA															
2	2		168B418015-207	5330010800039	76301	..PACKING (T-RING)	11	EA															
2	2		1N628775-332	5330006411481	96906	..PACKING (O-RING) (KIT)	11	EA															
2	2		1N6227-35	5330001943715	88044	..PACKING (O-RING)	11	EA															
2	2		1N628774-332	5330005420920	96906	..RETAINER (BACKUP RING) (KIT)	11	EA															
2	2		1N628775-340	5330005822136	96906	..PACKING (O-RING) (KIT)	11	EA															
2	2		1N6227-43	5330001943730	88044	..PACKING (O-RING)	11	EA															
2	2		1N628774-340	5330005821533	96906	..RETAINER (BACKUP RING) (KIT)	11	EA															
2	2		1N628775-008	5330005793158	96906	..PACKING (O-RING) (KIT)	11	EA															
2	2		1N628778-3	5330008357485	96906	..PACKING (O-RING) (KIT)	11	EA															
2	2		1N628778-4	5330008952956	96906	..PACKING (O-RING) (KIT)	11	EA															
2	2		1N628778-10	5330002859842	96906	..PACKING (O-RING) (KIT)	11	EA															
1	1		1N624655-151	5315008151405	96656	..PIN, CUTTER	13	EA															
1	1		1E10080-5	5310002735870	72962	..NUT, CASTLE	11	EA															
1	1		1S13M00K5	5310002735870	92592	..NUT, CASTLE	11	EA															
1	1		174640C3	5310002735870	150392	..NUT, CASTLE	11	EA															
1	1		1N656C316	5310001670803	180044	..WASHER, FLAT	11	EA															
1	1		168B410457-2001	5320003337312	76301	..BUSHING, SLEEVE (BUNGEE)	11	EA															
1	1		1N656C316L	5310001670814	180044	..WASHER, FLAT	13	EA															
1	1		1N515795-811	5310005805977	96906	..WASHER, FLAT	11	EA															
1	1		168B410057-1003	14730010376583	76301	..BOLT, FLUID (BUNGEE)	11	EA															

F-15 MAIN STRUT ASSEMBLY (L.H., R.H.W.)

BILL OF MATERIALS

26338A

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

ROUTED ITEMS	FLOW LEVEL	CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PER OF ASSY	DATE	CONTROL NUMBER	REV	LEVEL	PENDING ACTION	PENDING ACTION	PENDING ACTION
			17464016	531000323371	150392	..NUT, CASTLE	12	EA							
			169410641	531000183455	188044	..WASHER, FLAT	12	EA							
STL			1689410643-2001	13120003387498	176301	..BUSHING, SLEEVE (BUNGEE)	11	EA							
STL			1688410566-1001	14730003650777	176301	..BOLT, FLUID (BUNGEE)	11	EA							
			1684410661-1001	11620003337134	176301	..BUNGEE ASSEMBLY	11	EA							
			1684410659-1001	116200010790495	176301	..CYLINDER SUBASSEMBLY	11	EA							
			15T4M130-08002	13120005284353	176301	..BUSHING (BRACKET ATTACH)	12	EA							
			17829418-47	13120010731960	198747	..BUSHING (BRACKET ATTACH (O.S.))	12	AR/EA							
				M.S.L.	176301	..CYLINDER	11	EA							
			1684410659-2001	M.S.L.	176301	..ROD SUBASSEMBLY	11	EA							
			1684410664-1001	M.S.L.	176301	..NUT, HEXAGON	11	EA							
			1M5509-7	15310002083747	180205	..NUT, LOCKING	11	EA							
			1M631193K7CP	15340011045436	180205	..LOCKING DEVICE (2 PCS)	11	EA							
			1684410659-2001	15310003453774	176301	..NUT, EXTENSION (ROD)	11	EA							
			1184965A	15310005285893	123650	..DISC SPRING	125	EA							
			1684410659-2001	15310003649593	176301	..SPACER	11	EA							
			1M528775-028	15330005805056	196906	..PACKING (O-RING)	11	EA							
			1M528775-015	15330006185361	196906	..PACKING (O-RING)	11	EA							
			1684410662-2001	11620010783217	176301	..CAP (BUNGEE)	11	EA							
			1684410665-2001	11620010777386	176301	..ROD (BUNGEE)	11	EA							
			1M5630316H	15304005299715	180205	..BOLT, SHEAR	11	EA							
			1M7600C10	15310001670801	188044	..WASHER, FLAT	11	EA							
			1M5679C3M	15310006809306	180205	..NUT, LOCKING	11	EA							
AL			1684410616-2003	11620003337132	176301	..PLATE, LOCKING	11	EA							
AL			1684410616-2001	11620003337132	176301	..PLATE, LOCKING	11	EA							
			1E10080-4	15310002735869	172962	..NUT, CASTLE	12	EA							
			1S13M401C4	15310002735869	172975	..NUT, CASTLE	12	EA							
			17464002	15310002735869	150392	..NUT, CASTLE	12	EA							
			1M7600C16L	15310005157449	188044	..WASHER, FLAT	11	EA							
STL			1684410607-2001	15304004154856	176301	..BOLT, ECCENTRIC	11	EA							
			1E10080-7	15310003106955	172962	..NUT, CASTLE	11	EA							
			1S13M40M17	15310003106955	172975	..NUT, CASTLE	11	EA							
			17464002	15310003106955	150392	..NUT, CASTLE	11	EA							
STL			1684410612-2001	15310003768660	16301	..WASHER, KEY	11	EA							
STL			1684410615-2001	15365005403721	176301	..WASHER, LAMINATED (SHIM)	11	EA							
			1684410615-2001	15365005403721	176301	..WASHER, LAMINATED (SHIM)	11	EA							
			1M5516-1A	11620003337133	176301	..SPINDLE ASSEMBLY	11	EA							
			1M5516-1A	14730002774780	180205	..FITTING, BRASS	11	EA							
			M.S.L.	M.S.L.	176301	..SPINDLE SUBASSY	11	EA							
			15T4M130-06003	13120005185104	176301	..BUSHING (LINK ATTACH)	12	EA							
			17829424-65	13120010731971	198747	..BUSHING (LINK ATTACH) (O.S.)	12	AR/EA							
			M.P.L.	M.S.L.	176301	..SPINDLE	11	EA							
STL			1684410615-2003	15365005403722	176301	..WASHER, LAMINATED (SHIM)	11	EA							
STL			15T4M130-0-0035	13120003167998	176301	..BUSHING, SLEEVE (BELL CRANK)	12	EA							
STL			1684410615-2001	15304003859192	176301	..BOLT, HEX	11	EA							
			1684410611-1001	13040003291054	176301	..CONNECTING LINK ASSEMBLY	11	EA							
			1334610	14730003495338	154311	..FITTING BRASS	11	EA							

BILL OF MATERIALS

26338A

ROUTED ITEMS	LDG LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	IR,D,C	REV	TECH ORG	CONTROL	PENDING	PENDING	PENDING
								NUMBER	DATE	ACTION	ACTION	ACTION
1.000.4	168A10777-2003	13120003409530	176301	BUSHING (SPINDLE ATTACH)							
1.000.3	IN.P.L.			BUSHING SET (O.S.) (PSEUDO)							
1.000.4	1782942-63	13120010731970	198747	BUSHING (SPINDLE ATTACH) (O.S.)							
1.000.3	168916-23V	13120005299840	115860	BEARING (SPHERICAL)							
1.000.3	18896-20706A	13120005299840	181376	BEARING (SPHERICAL)							
1.000.3	1K5916-17	13120005299840	197613	BEARING (SPHERICAL)							
1.000.3	1688121L29A	13120005299840	121335	BEARING (SPHERICAL)							
1.000.3	155927-1A01	13120005299840	109455	BEARING (SPHERICAL)							
1.000.3	IN.P.L.			CONNECTING LINK							
1.000.3	168A10406-1003	11620003394277	176301		..CRANK ASSEMBLY							
1.000.3	168A10401-1001	11620003394277	176301		..BELL CRANK ASSEMBLY							
1.000.3	168A10442-2001	13120003387493	176301	BUSHING (BOLT ASSY BOSS)							
1.000.3	1782942-61	13120010731969	198747	BUSHING (BOLT ASSY. BOSS) (O.S.)							
1.000.3	1782941E-03	13120010731968	198747	BUSHING (LINK ATTACH) (REPAIR)							
1.000.3	IN.P.L.			BELL CRANK							
1.000.2	16865307U33D	15306005300005	180205		..BOLT, SHEAR							
1.000.2	1687600716	15310001670805	188044		..WASHER, FLAT							
1.000.2	1E10080-7	15310003105955	172962		..NUT, CASTLE							
1.000.2	15134404C7	15310003105955	192595		..NUT, CASTLE							
1.000.2	17464007	15310003105955	150392		..NUT, CASTLE							
1.000.2	1682465-300	15315002341863	196906		..PIN, COTTER							
1.000.2	168A10777-1001	11620003394277	176301		..BOLT ASSY. BUSHING							
1.000.3	1514131-08002	13120005284353	176301	BUSHING (BUNGEE ATTACH)							
1.000.3	1782942-67	13120010731941	198747	BUSHING (BUNGEE ATTACH) (O.S.)							
1.000.3	IN.P.L.			BOLT (CRANK)							
1.000.1	168A10408-1001	11620003394294	176301		..INSERT, LUBRICATION (PLASTIC)							
1.000.1	16815002-1	14730001720010	196906		..FITTING, GREASE							
1.000.1	1682877-018	153300046180799	196906		..PACKING (O-RING)							
1.000.1	1682877-023	153300046180799	196906		..PACKING (O-RING)							
1.000.1	168A10777-1001	11620003394277	176301		..PIN ASSEMBLY (LUBRICATION ATTACH)							
1.000.2	1685516-1A	14730002771780	180205		..FITTING, GREASE							
1.000.2	IN.P.L.				..PIN (JURY LINK ATTACH)							
1.000.1	16863940328	15306005285032	180205		..BOLT, SHEAR							
1.000.1	16863940328	15310011215534	188044		..WASHER, FLAT							
1.000.1	1E10080-10	15310003105979	172962		..NUT, CASTLE							
1.000.1	15134404C10	15310003105979	192595		..NUT, CASTLE							
1.000.1	174640C10	15310003105979	150392		..NUT, CASTLE							
1.000.1	1682465-302	15315002341864	196906		..PIN, COTTER							
1.000.1	16863940328	15310002826907	188044		..WASHER, FLAT							
1.000.1	16863940328	15310010990546	176301		..WASHER, FLAT (SPECIAL)							
1.000.1	16863940328	15310005955607	188044		..WASHER, FLAT							
1.000.1	168A10777-1001	11620003394277	176301		..BUSHING, SLEEVE (BOLT)							
1.000.1	168A10777-1001	11620003394277	176301		..BOLT ASSEMBLY (RETRACT)							
1.000.1	1685516-1A	14730002771780	180205		..FITTING, GREASE							

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.M.)

BILL OF MATERIALS

263309

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

ROUTED ITEMS	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	YIELD	SCRAP	PART	IMIC	REV	EFFECTIVITY	TECH	ORD	PENDING	PENDING	PENDING	PENDING		
	3	MSS1601A	14730002774780	180205	...FITTING, GREASE	12														
	3	IN.P.L.	IN.S.L.		...BRACE SUBASSY, LOWER DRAG	11														
	4	IN.P.L.	IN.S.L.		...BUSHING SET (PSEUDO)	11														
	5	174M130-22005	13120005284362	176301	...BUSHING (LINK ATTACH)	12														
	5	174M130-22003	13120005284774	176301	...BUSHING (LINK ATTACH)	12														
	4	IN.P.L.	IN.S.L.		...BUSHING, SET (O.S.) (PSEUDO)	11														
	5	7829421-55	13120010740292	198747	...BUSHING (LINK ATTACH) (O.S.)	12														
	5	7829424-53	13120010731946	198747	...BUSHING (LINK ATTACH) (O.S.)	12														
	4	174M130-22004	13120005185630	176301	...BUSHING (DRANK BOLT BOSS)	12														
	4	782942-57	13120010731967	198747	...BUSHING (DRANK BOLT BOSS) (O.S.)	12														
	4	168410687-2001	11620003337135	176301	...SLEEVE (DRAG BRACE LOCK)	11														
	4	16841197-5-20	15320005262959	180205	...RIVET	11														
	4	IN.P.L.	IN.S.L.		...BRACE (LOWER DRAG)	11														
	2	1652466F-153	15315002341854	196906	...PIN, COTTER	17														
	2	174394-3M	IN.S.L.		...NUT, CASTLE	12														
	2	168410779-2001	11620003480778	176301	...ADAPTER (LOWER LINK)	12														
	2	168410780-2001	15307003900753	176301	...STUD (LOWER LINK)	11														
	2	168410755-2005	11620003337139	176301	...PIN, APEX	11														
	2	1E10080-5	15310002735870	172962	...NUT, CASTLE	12														
	2	15139404CS	15310002735870	192595	...NUT, CASTLE	12														
	2	174640CS	15310002735870	150392	...NUT, CASTLE	12														
	2	168410791-2001	15310001670814	188044	...WASHER, FLAT	14														
	2	168410791-2001	13120005461885	176301	...BUSHING (SPRING ATTACH)	12														
	2	15174M167PS-0095	13120005515139	176301	...BEARING (INNER BLEEVE)	12														
	2	14K35-02087	IN.S.L.	176301	...WASHER, FLAT (SPECIAL)	12														
	2	168410791-2001	15306006151385	180205	...BOLT, SHEAR	12														
	2	1E10080-4	15310002735869	172962	...NUT, CASTLE	12														
	2	15139404CA	15310002735869	192595	...NUT, CASTLE	12														
	2	174640CA	15310002735869	150392	...NUT, CASTLE	12														
	2	14K35-021084	IN.S.L.	176301	...WASHER, FLAT (SPECIAL)	12														
	2	168410782-2003	11620005389940	176301	...SPOOL (LINK/BAE SPACER)	12														
	2	168410780-2003	153150053976141	176301	...STUD (UPPER LINK)	11														
	2	168410725-1005	11620012249329	176301	...SPRING ASSY, DOWNLOCK (L.H.)	11														
	2	168410725-1005	13120012106190	181349	...BUSHING, FERRID	11														
	3	1681934/1-070018	IN.S.L.	181349	...BUSHING, FERRID	11														
	3	IN.P.L.	IN.S.L.		...SPRING, DOWNLOCK (L.H.)	11														
	2	168410725-1003	IN.S.L.	176301	...SPRING ASSY, DOWNLOCK (L.H.)	11														
	3	1681934/1-070018	13120012106190	181349	...BUSHING, FERRID	11														
	3	IN.P.L.	IN.S.L.	181349	...BUSHING, FERRID	11														
	2	168410725-1003	11620001323253	176301	...SPRING ASSY, DOWNLOCK (L.H.)	11														
	3	1681934/1-070018	13120012106190	181349	...BUSHING, FERRID	11														
	3	IN.P.L.	IN.S.L.	181349	...BUSHING, FERRID	11														

STL-STEEL
AL-ALUMINUM
MAG-MAGNESIUM
TITA-TITANIUM
SS-S STL
SYN-SYNTHETIC
LD-LEAD

ROUTED ITEMS	ITEMS	QTY	LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PER ASSY	YIELD	SCRAP	PART	INTC	REV	EFFE	TECH	ORD	PENDING	PENDING	PENDING	AFTO	ACTION	ACTION
	..2			68A10725-1004	1620001323209	76301	...SPRINGS ASSY, DOWNLOCK (R.H.)	EA	11														
	..3			181934/1-080016	13120012106190	181349	...BUSHING, FABROID	EA	11														
	..3			181934/1-070018	IN.S.L.	181349	...BUSHING, FABROID	EA	11														
	..3			IN.P.L.	IN.S.L.		...SPRING, DOWNLOCK (R.H.)	EA	11														
	..2			68A10725-1002	1620001323209	76301	...SPRING ASSY, DOWNLOCK (R.H.)	EA	11														
	..3			181934/1-080016	13120012106190	181349	...BUSHING, FABROID	EA	11														
	..3			181934/1-070018	IN.S.L.	181349	...BUSHING, FABROID	EA	11														
	..3			IN.P.L.	IN.S.L.		...SPRING, DOWNLOCK (R.H.)	EA	11														
ISTL	..2			68A10771-2001	15310005570517	104274	...NUT, APEX (SPECIAL)	EA	11														
ISTL	..2			68A10770-1001	14730005497352	76301	...BOLT ASSY, APEX (JURY LINK)	EA	11														
	..3			INSS16-1A	14730002774780	180205	...FITTING, GREASE	EA	11														
	..3			IN.P.L.	IN.S.L.		...BOLT, APEX (JURY LINK)	EA	11														
ISTL	..2			68A10764-2001	15315005546340	176301	...PIN, APEX (JURY LINK)	EA	11														
	..3			INSS16-1A	1620010360283	76301	...LINK-ASSEMBLY-(LOWER JURY)	EA	11														
	..3			IN.P.L.	14730002774780	180205	...FITTING, GREASE	EA	11														
	..3			IN.P.L.	IN.S.L.		...LINK SUBASSY, (LOWER JURY)	EA	11														
	..4			1ST4H130-10006	13120005260517	176301	...BUSHING (APEX BOSS)	EA	12														
	..4			17829424-51	13120010731963	198747	...BUSHING (APEX BOSS) (O.S.)	EA	12														
	..4			168A10778-2001	13120005063232	176301	...BUSHING (DRAG BRACE ATTACH)	EA	11														
	..4			17829419-01	13120010746917	198747	...BUSHING (DRAG BRACE ATTACH) (O.S.)	EA	11														
	..4			17829423-27	13120010731964	198747	...BUSHING (GROUND BOSS) (REPAIR)	EA	12														
	..4			IN.P.L.	IN.S.L.		...LINK (LOWER JURY)	EA	11														
	..3			INSS16-1A	11620010400381	176301	...LINK ASSEMBLY (UPPER JURY)	EA	11														
	..3			IN.P.L.	14730002774780	180205	...FITTING, GREASE	EA	11														
	..3			IN.P.L.	IN.S.L.		...LINK SUBASSY (UPPER JURY)	EA	11														
	..4			181936-1-12	13120010388753	181349	...BEARING, SPHERICAL	EA	11														
	..4			1ST4H130-10006	13120005260517	176301	...BUSHING (APEX BOSS)	EA	12														
	..4			17829424-51	13120010731963	198747	...BUSHING (APEX BOSS) (O.S.)	EA	12														
	..4			17829423-23	13120010731961	198747	...BUSHING (UPPER JURY)	EA	11														
	..4			IN.P.L.	IN.S.L.		...LINK (UPPER JURY)	EA	11														
	..1			68A10770-1007	IN.S.L.	6301	...SHOCK ABSORBER ASSY (L.H.,H.H.W.)	EA	11														
	..2			18E2A398-4	15345008651403	196906	...PLUG, MACHINE	EA	11														
	..2			18E2A391110L	15345009000972	196906	...PLUG, MACHINE	EA	11														
	..2			18E2B889-2	148200053536483	196906	...VALVE ASSEMBLY (CHARGING)	EA	13														
	..2			18E2A391113	15345000068202	196906	...PLUG, MACH	EA	11														
	..2			68A10770-2001	IN.S.L.	176301	...NUT, SPECIAL (FICE TUBE)	EA	11														
ISTL	..2			68A10770-2003	15310010668861	176301	...NUT, SPECIAL (DRIFICE TUBE)	EA	11														
ISTL	..2			68A10770-2003	IN.S.L.	176301	...RETAINER (GRIFICE TUBE)	EA	11														
ISTL	..2			68A10770-2001	15330004068996	176301	...RETAINER (GRIFICE TUBE)	EA	11														
ISTL	..2			68A10674-2001	11620003386551	176301	...TAB, LOCKING (SLAND NUT)	EA	11														
	..2			18E2A39416	15304002837462	180205	...BOLT, SHEAR	EA	14														
	..2			18E2A39416	15310009520309	180205	...WASHER, FLAT	EA	14														
	..2			18E2A39416	15310007207644	180205	...NUT, LOCKING	EA	16														
	..2			168690030-2001	IN.S.L.	176301	...PLATE, IDENTIFICATION	EA	11														

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

STL-STEEL
AL-ALUMINUM
AW-WASHER
TIT-TITANIUM
SS-S STL
SYM-SYNTHETIC
LD-LEAD

ROUTED ITEM	ITEM CODE	LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	QTY	UNIT	YIELD	SCRAP	IPART	INIC	REV	EFFECTIVITY	TECH	ORD	PENDING	PENDING	AFTO	22
											TYPE	LEVEL	DATE	NUMBER						
ISL	1.2	1813404C		15310002735869	192595	...NUT, CASTLE	12	EA												
ISL	1.2	174640C		15310002735869	150392	...NUT, CASTLE	12	EA												
ISL	1.2	182240F-151		15315008151405	196906	...PIN, COTTER	14	EA												
ISL	1.2	1810080-3		15310002735870	172962	...NUT, CASTLE	12	EA												
ISL	1.2	1813404CS		15310002735870	192595	...NUT, CASTLE	12	EA												
ISL	1.2	174640CS		15310002735870	150392	...NUT, CASTLE	12	EA												
ISL	1.2	168410422-2001		15310003453822	176301	...WASHER, SPECIAL (SWIVEL)	12	EA												
ISL	1.2	168410419-1001		11620003394341	176301	...SHAFT ASSEMBLY (HYDRAULIC SWIVEL)	11	EA												
ISL	1.3	1815551-602		15315008487829	196906	...PIN, SPRING (ROLL)	11	EA												
ISL	1.3	18F5004-13		14730002706240	183324	...ADAPTER, FLUID	11	EA												
ISL	1.3	1828775-010		15330005840266	196906	...PACKING (O-RING)	11	EA												
ISL	1.3	18F5006-13		14730002706241	183324	...ADAPTER, FLUID	11	EA												
ISL	1.3	1828775-012		15330005840265	196906	...PACKING (O-RING)	11	EA												
ISL	1.3	IN.P.L.		IN.S.L.		...SHAFT (HYDRAULIC SWIVEL)	11													
ISL	1.2	168410414-1003		11620003394338	176301	...LINK (HYDRAULIC TRANSFER)	11	EA												
ISL	1.2	1865630411H		15304005084173	180205	...BOLT, SHEAR	11	EA												
ISL	1.2	168410453-2001		15310003572449	176301	...WASHER, SPECIAL (SWIVEL)	11	EA												
ISL	1.2	168410421-1005		11620003394377	176301	...CRANK ASSEMBLY (HYD TRANSFER)	11	EA												
ISL	1.3	1815556-602		15315011027480	196906	...PIN, SPRING (ROLL)	12	EA												
ISL	1.3	IN.P.L.		IN.S.L.		...CRANK (HYD TRANSFER)	11													
ISL	1.2	1681410410-1001		11620003394300	176301	...BOLT & WASHER ASSY (PSEUDO)	12	EA												
ISL	1.3	IN.P.L.		IN.S.L.		...BOLT, SHEAR	11													
ISL	1.3	1865630414		15306004925584	180205	...BOLT, SHEAR	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	18617019-4-4X		15306010442963	186524	...BOLT & WASHER ASSY (PSEUDO)	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	12	ARI												
ISL	1.3	IN.P.L.		IN.S.L.		...BOLT, SHEAR (1ST O.S.)	11													
ISL	1.3	18656-4-1		15306010442963	173197	...BOLT & WASHER ASSY (PSEUDO)	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	18671254-4-4		127624	127624	...BOLT, SHEAR (1ST O.S.)	11													
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	12	ARI												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT, SHEAR (1ST O.S.)	11													
ISL	1.3	1511-1061-4-4		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	12	ARI												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT, SHEAR (1ST O.S.)	11													
ISL	1.3	1867600416		15306010442963	106710	...BOLT & WASHER ASSY (PSEUDO)	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT, SHEAR (1ST O.S.)	11													
ISL	1.3	1867600416		15306010442963	188044	...WASHER, FLAT	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT	11	EA												
ISL	1.2	IN.P.L.		IN.S.L.		...BOLT & WASHER ASSY (PSEUDO)	12	ARI												
ISL	1.3	1867600416		15310005319515	188044	...WASHER, FLAT														

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26339A

ROUTED ITEM CODE	FLW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS PER ASSY	YIELD	SCRAP	PART NO.	REV	EFFECTIVE DATE	CONTROL NUMBER	PENDING ACTION	PENDING ACTION	PENDING ACTION
1.2	IN.P.L.	1889-4	5306010452871	73197	BOLT & WASHER ASSY (PSEUDO)	12	ARI								
1.3	IN.P.L.	1890-4	5306010452871	73197	BOLT, SHEAR (2ND O.S.)	11	IEA								
1.3	IN.P.L.	1891-4	5310001670803	88044	WASHER, FLAT	11	IEA								
1.2	IN.P.L.	1811-1162-4-4	57928	88044	BOLT & WASHER ASSY (PSEUDO)	12	ARI								
1.3	IN.S.L.	1892-4	5310001670803	88044	BOLT, SHEAR (2ND O.S.)	11	IEA								
1.2	IN.P.L.	1893-4	5310001670803	88044	WASHER, FLAT	11	IEA								
1.3	IN.S.L.	1894-4	5306010452871	06710	BOLT & WASHER ASSY (PSEUDO)	12	ARI								
1.3	IN.S.L.	1895-4	5310001670803	88044	BOLT, SHEAR (2ND O.S.)	11	IEA								
1.2	IN.P.L.	1896-4	5310001670803	88044	WASHER, FLAT	11	IEA								
1.3	IN.S.L.	1897-4	5306010452871	97215	BOLT & WASHER ASSY (PSEUDO)	12	ARI								
1.3	IN.S.L.	1898-4	5310001670803	88044	BOLT, SHEAR (2ND O.S.)	11	IEA								
1.2	IN.P.L.	109451-4-4	03680	03680	BOLT & WASHER ASSY (PSEUDO)	12	ARI								
1.3	IN.S.L.	1899-4	5310001670803	88044	BOLT, SHEAR (2ND O.S.)	11	IEA								
1.2	IN.P.L.	168411020-2003	1620004881770	76301	MANIFOLD (UPPER)	11	IEA								
1.2	IN.P.L.	1684110451-1001	1620003394301	76301	MANIFOLD ASSY (LOWER)	11	IEA								
1.3	IN.P.L.	18528775-012	4730002706241	98324	ADAPTER, FLUID	11	IEA								
1.3	IN.P.L.	18528775-012	5330005840265	96906	PACKING (O-RING)	11	IEA								
1.3	IN.P.L.	18528775-012	4730002706240	98324	ADAPTER, FLUID	11	IEA								
1.3	IN.P.L.	18528775-010	5330005840266	96906	PACKING (O-RING)	11	IEA								
1.2	IN.P.L.	18528775-010	5315000590491	96906	MANIFOLD (LOWER)	11	IEA								
1.2	IN.P.L.	18528775-010	5315000590491	96906	PIN, COTTER	11	IEA								
1.2	IN.P.L.	18528775-010	5310003952927	76301	NUT, SPECIAL (APEX)	11	IEA								
1.2	IN.P.L.	18528775-010	5310003440072	76301	WASHER, KEY (APEX)	11	IEA								
1.2	IN.P.L.	18528775-010	5310003956622	76301	WASHER, SPACER (APEX)	14	IEA								
1.2	IN.P.L.	18528775-010	11620003480794	76301	BOLT, SPECIAL (APEX)	11	IEA								
1.2	IN.P.L.	18528775-010	11620003383306	76301	APRT, TORQUE	12	IEA								
1.2	IN.P.L.	18528775-010	5310003444690	76301	NUT, ROUND (TORQUE COLLAR)	11	IEA								
1.2	IN.P.L.	18528775-010	11620003440615	76301	WASHER, KEYING (COLLAR NUT)	11	IEA								
1.2	IN.P.L.	18528775-010	11620003440616	76301	COLLAR ASSEMBLY (TORQUE)	11	IEA								
1.3	IN.P.L.	18528775-010	1473002774780	180205	FITTING, GREASE	14	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	COLLAR SUBASSY (TORQUE)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING SET (PSEUDO)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (COLLAR BOTTOM)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (COLLAR TOP)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING SET (O.S.) (PSEUDO)	11	ARI								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (COLLAR BOTTOM) (O.S.)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (COLLAR TOP) (O.S.)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING SET (PSEUDO)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (SPINDLE LUG, BOTTOM)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (SPINDLE LUG, TOP)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING SET (O.S.) (PSEUDO)	11	ARI								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (SPINDLE LUG, BIT) (O.S.)	11	IEA								
1.3	IN.P.L.	18528775-010	5315000590491	96906	BUSHING (SPINDLE LUG, BIT) (O.S.)	11	IEA								

R-15 MAIN STRUT ASSEMBLY (L.H., H.H.N.)

BILL OF MATERIALS

26338A

STL-STEEL
AL-ALUMINUM
MAG-MAGNESIUM
TITA-TITANIUM
SS-S STL
SYN-SYNTHETIC
LD-LEAD

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS	PER	REV	TECH	CONTROL	PENDING	PENDING	PENDING	PENDING
							OF	DATE	NO	NO	NO	NO	NO	NO
AL	...	168752148-488A	11620010749060	76301	CABLE ASSEMBLY (ELECTRICAL)	11	EA							
	...	1627472110F39	5975005039701	96906	CONNECTOR, RECP	11	EA							
	...	163902874-20-20	5999001468592	81349	PIN	15	EA							
	...	1627473110F55	5935005588284	96906	CONNECTOR, PLUS	11	EA							
	...	163902975-20-20	5999001728253	81349	SOCKET	15	EA							
	...	1684890017-3274	9905010820574	76301	BAND, MARKER	11	EA							
	...	1684890017-3275	N.S.L.	76301	BAND, MARKER	11	EA							
	...	168760-CA	5310011416672	88044	WASHER, FLAT	14	EA							
	...	16851957-121	5305004006531	96906	SCREW, MACHINE	14	EA							
	...	1685679204W	5310004034663	80205	NUT, SELF LOCK	14	EA							
	...	1684411740-1001	1620003486494	76301	ADAPTER, LANDING	11	EA							
	...	1682750510-2	5935005519501	96906	CABLE, CLAMP	11	EA							
	...	16841308F10-1	5935005409540	76301	CABLE, CLAMP	11	EA							
	...	168341228-20S2U0	N.S.L.	76301	CABLE, SPECIAL (TWO FEET)	12	EA							
	...	16845001014898	6145001014898	81349	CABLE, SPECIAL (TWO FEET)	12	EA							
	...	1688410461-1001	3110003481526	76301	CAM FOLLOWER ASSEMBLY	11	EA							
	...	1685516-1A	4730002774780	80205	FITTING, GREASE	11	EA							
	...	N.P.L.	N.S.L.		CAM, FOLLOWER	11	EA							
	...	16824665-300	5315002341863	96906	PIN, COTTER	11	EA							
	...	1610080-8	172962	172962	NUT, CASTLE	11	EA							
	...	1683400C8	N.S.L.	92595	NUT, CASTLE	11	EA							
	...	174640021	N.S.L.	50392	NUT, CASTLE	11	EA							
	...	1687600316	5310001670806	88044	WASHER, FLAT	13	EA							
	...	168382816L	5365007280923	76301	WASHER, LAMINATED (SHIM)	12	EA							
	...	1684410784-2003	5315001245344	76301	PIN, HEADED STRAIGHT	12	EA							
	...	1684410704-1011	116200108030404	76301	PISTON ASSEMBLY	11	EA							
	...	168516-1A	1730002774780	80205	FITTING, GREASE	12	EA							
	...	N.P.L.	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							
	...	1684410636-2001	3120003481527	76301	BUSHING (TORQUE ARM)	12	EA							
	...	16829421-01	3120010731972	98747	BUSHING (TORQUE ARM) (O.S.)	12	EA							
	...	1684410704-2009	N.S.L.	76301	PISTON	11	EA							
	...	1684410704-2009	1620003959764	09455	HEAD (UPPER BEARING)	11	EA							
	...	1684410704-2017	N.S.L.		PISTON SUBASSEMBLY	11	EA							
	...	1684130-08005	3120005185629	76301	BUSHING (CAM FOLLOWER)	12	EA							
	...	16829424-71	3120010731973	98747	BUSHING (CAM FOLLOWER) (O.S.)	12	EA							

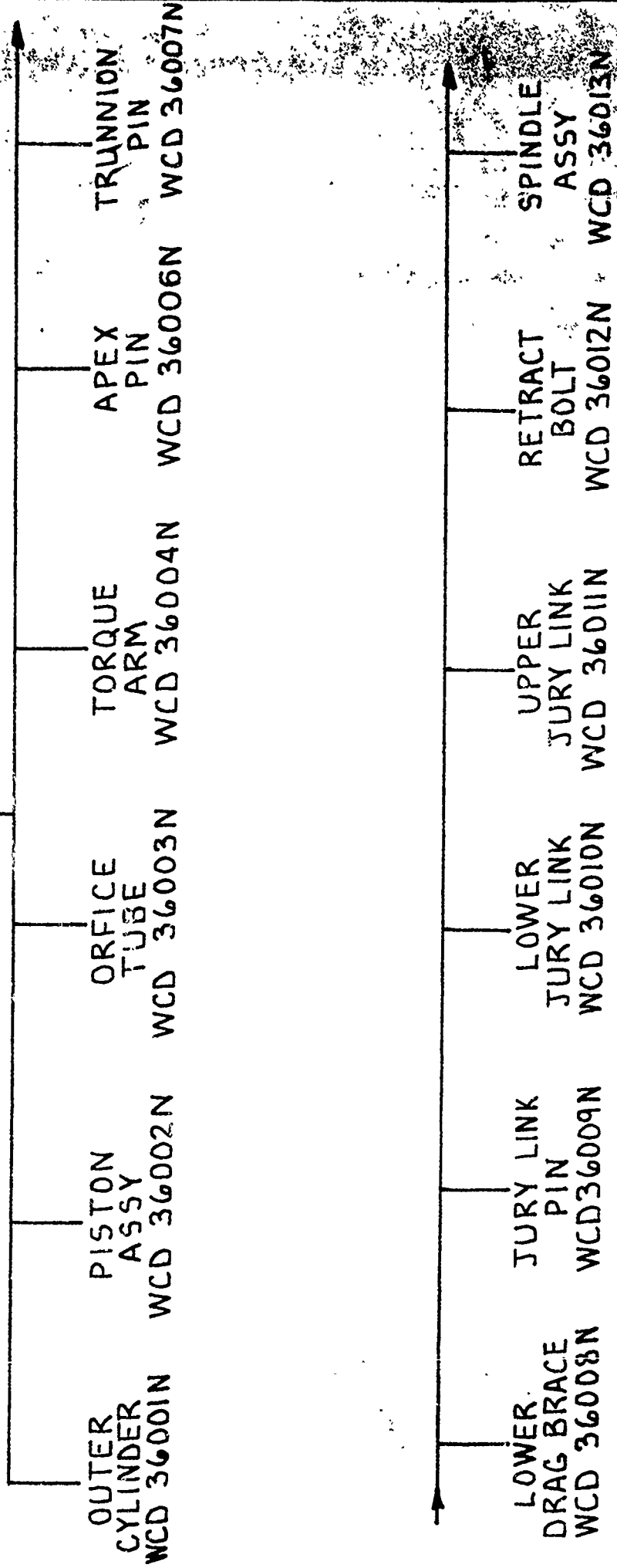
BILL OF MATERIALS

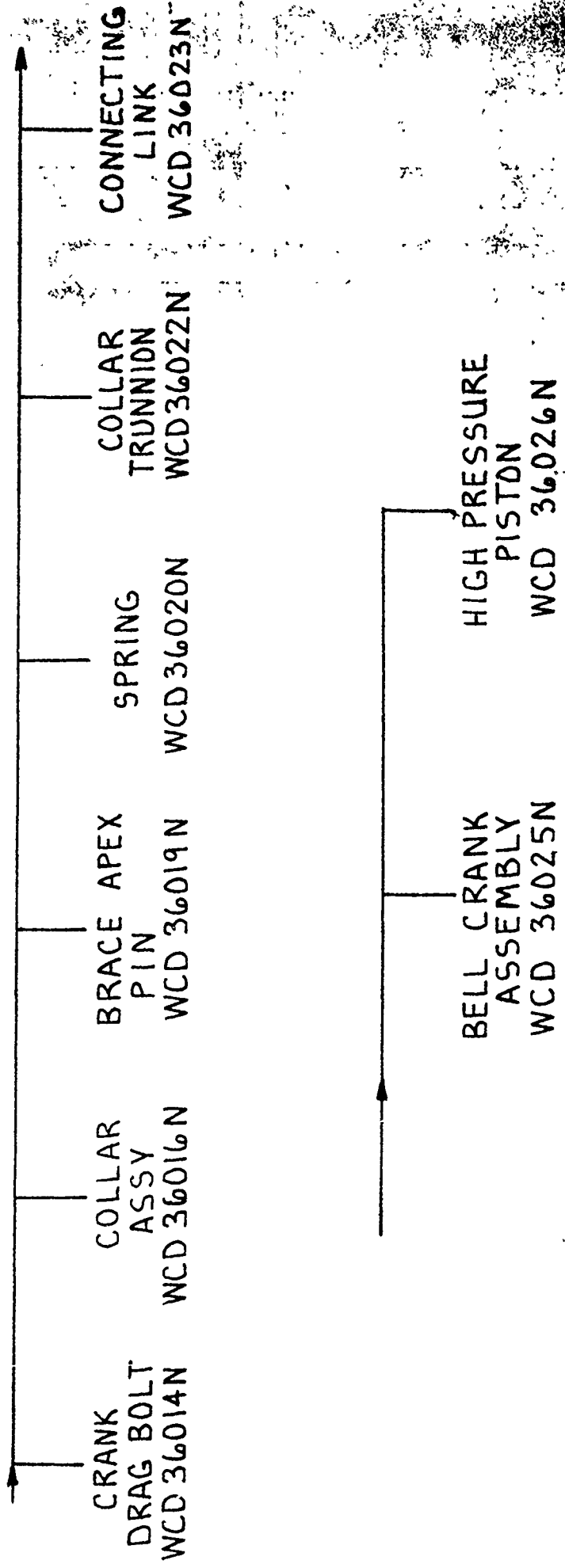
26338A

STL-STEEL
AL-ALUMINUM
MAG-MAGNESIUM
TITAN-TITANIUM
SS-S STL
SYN-SYNTHETIC
LD-LEAD

ROUTED	ITEMS	ILUM LEVEL	CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS	PER OF ASSY	REV	TECH	ORD	PENDING	PENDING	PENDING	PENDING	PENDING	PENDING	PENDING	
STL		1..2		168A10727-2001	11620003959754	176301	...RING, PISTON	1	1											
AL		1..2		168A10723-1001	14730003547633	176301	...RESTRICTOR, FLOW	1	1											
AL		1..2		168A10631-2001	11620005006802	176301	...TAB, LOCKING	1	1											
		1..2		MAGS1351C3M	53050003726315	180205	...SCREW, MACHINE	2	1											
AL		1..2		168A10713-2003	11620010667227	176301	...PIN, METERING	1	1											
		1..2		IRRT165DP-119	5365011232480	180756	...RING, RETAINING	1	1											
AL		1..2		168A10742-2001	11620010703436	176301	...CAP (METERING PIN)	1	1											
		1..2		IRST193D-119	5365010986662	180756	...RING, RETAINING	1	1											
		1..2		IRST193S-119	N.S.L.		...RING, RETAINING	1	1											
AL		1..2		168A10740-2001	11620010703435	176301	...LOCK ADAPTER (METERING PIN)	1	1											
STL		1..2		168A10741-2001	5360010768450	176301	...SPRING, COMPRESSION	1	1											
BRASS		1..2		168A10428-2003	5315011963425	176301	...PIN, LOCKING (METERING PIN)	3	1											
BRASS		1..2		168A10428-2001	53150003770964	176301	...PIN, LOCKING (METERING PIN)	3	1											
		1..2		168A10788-2003	53150005389262	176301	...PIN, LOCKING (POSITION RING)	1	1											
STL		1..2		168A10798-2003	11620005357468	176301	...RETAINER (SNUBBER STOP)	1	1											
STL		1..2		168A10797-2001	53650005264500	176301	...RING, POSITIONING (SNUBBER STOP)	1	1											
STL		1..2		168A10796-2001	11620005233927	176301	...STOP, SNUBBER	1	1											
STL		1..2		168A10705-1005	N.S.L.		...DAMPENER, REBOUND (PRESSURE)	1	1											
STL		1..2		168A10705-1007	N.S.L.		...DAMPENER, REBOUND (PRESSURE)	1	1											
AL		1..2		168A10641-2001	53300003900259	176301	...RETAINER, SEAL	1	1											
AL		1..2		179288	3120004168900	109455	...BEARING, LOWER	1	1											
BRASS		1..2		MAG287762-41	11650005168336	198906	...RING, SCRAPER	1	1											
AL		1..2		168A10618-2001	14730003650242	176301	...NUT, BLAND (PACKING)	1	1											
		1..1		MAG5817-1	5340006822113	180205	...CAP, PROTECTIVE	1	1											
		1..1		MAG5817-1	5340006822115	180205	...CAP, PROTECTIVE	1	1											

F-15
MAIN LANDING GEAR ASSY
(L.H. H.W.)
PCN 26338A
WCD 36000N





FAMILY 1

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER.	6019 FROM DAYS
COOP	POLL	25918A		T-38 MLG	STRUT ASSY	1620-01-014-1984	7531234-20	4S1-75-13	45
DELE		25976A		F-15 MLG	WHEEL INBOARD HALF	1630-01-144-0625	17 OCT 88	4W3-0-23	16
DELE		25977A		F-15 MLG	WHEEL OUTBOARD HALF	1630-01-142-7474	01/11/88	4W3-0-23	
DELE		25985A		C-130	WHEEL HALF OUTBOARD	1630-01-155-6299	10 DECEMBER 86	4W3-4-363	
DELE		25986A		C-130	WHEEL HALF INBOARD	1630-01-161-9753	01/11/88	4W3-4-363	
JENS	PRIC	25987A		C-130	WHEEL HALF OUTBOARD	1630-01-030-5437	9542379	4W1-4-393	20
DELE		25988A		C-130	WHEEL HALF INBOARD	1630-01-030-5436	01/11/88	4W1-4-393	
MART	SHEL	25992A		A-10	CARD CIRCUIT GAU-B	1005-01-182-6383	176C2885	11W1-27-7-3	4
MART	SHEL	25993A		B-52	BOOSTER MOTOR	1005-00-604-0260	ABA400ADZ	11F-46-16-4	4
DELE		26012A		F-16 MLG	BRAKE ASSY	1630-01-186-2492	15 OCT 88	4B1-2-1162	30
JENS	RIGB	26029A		C-130	BRAKE PRESSURE PLATE	1630-01-005-4188JT	5002564	4B1-2-1003	16
DELE		26030A		C-130	BRAKE ASSY	1630-00-825-4794JT	10 OCT 88	4B1-2-1003	27
MART	SHEL	26038A		F-4	BOMB RACK MAU-12BB	1095-01-107-9207	64J13210-5	11B29-3-25-2	19
JENS	RIGB	26049A		C-130	BRAKE TORQUE TUBE	1630-00-102-4365	9550151	4B1-2-1003	16
COVI	SHEL	26062A		F-111	INERTIA REEL	1377-00-411-7061	0103157-54	11P9-11-3	8
CRAG	SHEL	26093A		A-10	ELECTRICAL ASSY	5999-00-572-3201AY	201F167	11W1-27-7-3/4	16
COOP	COOP	26108A	-J	F-16 MLG	STRUT ASSY	1620-01-162-7518	2006600-155	4S2-00-3	60
COOP	COOP	26109A		F-16 MLG	DRAG BRACE	1620-01-182-6348	2006000-125	4SA6-32-3	25
COOP	COOP	26110A		F-16 MLG	STEEL PISTON (INNER)	1620-01-200-5320	2006161-103	4S1-100-3	25
COOP	COOP	26111A		F-16 MLG	ALUMINUM PISTON (OUTER)	1620-01-200-7131	2006106-105	4S1-100-3	41
JENS	PRIC	26112A		C-141 MLG	WHEEL HALF INBOARD	1630-01-142-8298	5000295-3	4W1-7-1123	20
JENS	PRIC	26113A		C-141	MLG WHEEL HALF OUTBOARD	1630-01-147-8300	5000296-2	4W1-7-1123	20
MART	SHEL	26146A	-G	T-33	REEL INERTIA	1600-00-138-5515LS	0103170-4A	13AA-17-3	13
MART	SHEL	26176A			M16 RIFLE	1005-00-856-6885	8448600	11W3-5-5-1	0
JENS	PRIC	26177A		F-5 MLG	WHEEL E/W	1630-01-041-6012	5001114-4	4W1-0-63	20
JENS	RIGB	26182A		F-15 MLG	BRAKE TORQUE TUBE C/D	1630-01-068-8013	2606021	4B1-2-1173	16
JENS	PRIC	26183A		F-15 MLG	WHEEL A/B	1630-01-137-5742	5000064-10LC	4W1-0-73	5
DELE		26200A		B-52 MLG	WHEEL HALF INBOARD	1630-01-112-3934	17 OCT 88	4W1-7-1193	30
COOP	COOP	26244A		F-15 MLG	LINK ASSY	1620-00-305-1782	68AA50758-1001	4S2-73-3	20
DELE		26248A		F-4	ECM POD ADAPTER	1560-00-350-7820BF	27 OCT 87	1FA-1479	
MART	SHEL	26284A		A-37	BOMB SHACKLE RACK	1095-00-055-6035	4BAAD2	11B40-2-7-2	10
BENT	POLL	26290A		T-38 MLG	ACT BRACE ASSY	1620-00-105-8933	6-41650-505	4SA6-17-3	30
MART	SHEL	26311A			BATTERY BOX	6140-00-052-3895	66F6230	11W1-31-3-2	5
MART	SHEL	26322A			FAIRING	1005-00-948-8402	11699902	11W1-31-5-2	8
COOP	COOP	26337A		F-15 MLG	STRUT ASSY R/H H/W	1620-01-167-0999	68AA10501-2012	4A4-22-3	30
COOP	COOP	26338A		F-15 MLG	STRUT ASSY L/H H/W	1620-01-167-1000	68AA10501-2011	4A4-22-3	30
DELE		26356A		F-16 MLG	STRUT ASSY	1620-01-124-9135	20 FEB 87	4S2-00-3	
MART	SHEL	26357A		M61-A1	ROTOR BODY	1005-00-344-1550	A7790762	11W1-12-4-4-33	61
JENS	RIGB	26363A		E-3A/B/C	HOUSING	1630-01-030-8276	9542025-1	4B1-2-1153	20
MART	SHEL	26404A		MULTIPLE	LAU-100 R/H AIM 9	1440-01-059-6278AB	14-82003-502	11L1-2-11-11	14
MART	SHEL	26405A		B-52	BOX END	1005-00-545-0009	571542-405	11F8-3-7-3	
MART	SHEL	26406A		20MM	M61 FEEDER	1005-00-473-6054	5910555	11W1-7-9-2	11
COOP	TOLM	26409A		F-111 MLG	BELLCRANK	1620-00-199-8482	917617-103	4A4-14-3	20
JENS	RIGB	26410A		F-16 MLG	BRAKE PRESSURE FLT A/B/C	1630-01-186-2484	5007754	4B1-2-1164	16
JENS	RIGB	26411A		F-16 MLG	BRAKE STATIONARY DSK ABC	1630-01-084-4227	5004554	4B1-2-1164	16
JENS	RIGB	26412A		F-16 MLG	BRAKE END PLATE A/B/C/D	1630-01-106-9701	5004557	4B1-2-1164	16
JENS	RIGB	26413A		F-16 MLG	BRAKE ROTATING DISK ABCD	1630-01-106-9702	5004553	4B1-2-1164	16
JENS	RIGB	26461A	-J	F-15 MLG	BRAKE HEAT STACK C/D	1630-01-186-2469	2607431	4B1-2-1173	
JENS	RIGB	26462A	-J	F-15 MLG	BRAKE HEAT STACK A/B	1630-01-146-7682	5000001	4B1-2-1123	
MART	SHEL	26480A		0A037B	LOADER	1005-00-868-3077	66F12270	11W1-7-10-3	10

PROD NoR	RCC	OPER NoR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
26338	MNPC3	HR010	N	H3	7	4.70	1.00	4.70
		LF999	N	H3	7	.21	1.00	.21
FAMILY I								4.91
F-15 MLG								
	MNPGP	00010	N	H3	5	11.60	1.00	11.60
		PP000	N	3S	5	1.16	1.00	1.16
*								12.76
	MNPGW	PM000	E	DJ	5	.91	1.00	.91
		PM002	N	DJ	5	.20	1.00	.20
		PM003	N	DJ	5	.01	1.00	.01
		WC001	E	KI	5	1.93	1.00	1.93
		WD001	E	H3	5	2.32	1.00	2.32
		WE001	E	DI	5	.96	1.00	.96
		WE002	E	DI	5	.96	1.00	.96
		WE003	N	DI	5	.63	1.00	.63
		WE004	N	DI	5	.37	1.00	.37
		WE006	N	DI	5	.16	1.00	.16
		WE007	N	DI	5	.17	1.00	.17
		WE008	N	DI	5	.21	1.00	.21
		WE009	N	DI	5	.26	1.00	.26
		WE010	N	DI	5	.17	1.00	.17
		WE011	N	DI	5	.25	1.00	.25
		WE012	N	DI	5	.16	1.00	.16
		WE013	N	DI	5	.16	1.00	.16
		WE014	N	DI	5	.16	1.00	.16
		WE016	N	DI	5	.25	1.00	.25
		WE019	N	DI	5	.16	1.00	.16
		WE020	N	DI	5	1.02	2.00	2.04
		WE022	N	DI	5	.17	1.00	.17
		WE023	N	DI	5	.17	1.00	.17
		WE025	N	DI	5	.17	1.00	.17
		WE026	N	DI	5	.46	1.00	.46
		XNPGW	X	H3	5	5.56	1.00	5.56
*								19.02
	MNPNA	NA001	E	DB	2	.41	1.00	.41
		NA002	E	DB	2	.61	1.00	.61
		NA003	E	DB	2	.33	.61	.20
		NA004	E	DB	2	.23	2.00	.46
		NA006	E	DB	2	.04	1.00	.04
		NA007	E	DB	2	.07	1.00	.07
		NA008	E	DB	2	.10	.05	.05
		NA009	E	DB	2	.02	1.00	.02
		NA010	E	DB	2	.07	.96	.06
		NA011	E	DB	2	.15	1.00	.15
		NA012	E	DB	2	.04	1.00	.04
		NA013	E	DB	2	.02	1.00	.02
		NA014	E	DB	2	.07	1.00	.07
		NA016	E	DB	2	.03	1.00	.03



PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	FACTORED	
							OCC FAC	STAND HOURS
26338A	MNPNA	NA019	E	DB	2	.04	1.00	4
		NA020	E	DB	2	.10	2.00	20
		NA022	E	DB	2	.04	1.00	4
		NA026	E	DB	2	.61	1.00	.61
		XNPNA	X	DB	2	5.90	1.00	5.90
								8.97
*								
MNPRA		RA001	E	JA	1	6.99	.41	2.86
		RA002	E	JA	1	1.32	1.00	1.32
		RA003	N	JA	1	1.94	.89	1.72
		RA004	E	JA	1	.13	.05	
		RA007	E	JA	1	.04	1.00	4
		RA008	E	JA	1	2.39	.05	11
		RA009	E	JA	1	.04	1.00	4
		RA010	E	JA	1	1.43	.07	10
		RA011	E	JA	1	2.08	.70	1.45
		RA013	E	JA	1	1.11	1.00	1.11
		RA014	E	JA	1	.79	.57	45
		RA016	E	JA	1	2.36	.26	61
		RA020	E	JA	1	.20	.75	15
		RA022	E	JA	1	4.02	.10	40
		RA023	E	JA	1	1.31	1.00	1.31
RA025	E	JA	1	2.24	1.00	2.24		
								13.91
*								
MNPRA		R8001	E	JA	3	3.24	.56	1.81
		R8002	E	JA	3	6.42	.44	2.82
		R8004	E	JA	3	2.59	.05	12
		R8006	N	JA	3	1.41	.05	7
		R8007	E	JA	3	2.36	.11	25
		R8009	E	JA	3	2.25	.05	11
		R8011	E	JA	3	1.01	.05	5
		R8012	N	JA	3	1.41	.10	14
		R8013	E	JA	3	1.81	.05	9
		R8014	E	JA	3	1.13	.05	5
		R8019	E	JA	3	2.28	.10	22
		R8022	N	JA	3	3.62	.10	36
R8026	E	JA	3	4.16	.33	1.37		
								7.46
*								
MNPRA		RC001	N	UP	8	3.05	.74	2.25
		RC002	N	UP	8	12.62	.96	12.11
		RC003	E	UP	8	1.74	.61	1.06
		RC004	E	UP	8	.78	.13	10
		RC006	E	UP	8	.74	.07	5
		RC007	N	UP	8	1.25	.33	41
		RC008	E	UP	8	.62	.26	16
		RC009	E	UP	8	.74	.07	5
		RC010	E	UP	8	.36	.10	3
		RC011	E	UP	8	.81	.31	65

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
26338A	MNPRC	RC012	N	UP	3	2.68	.05	13
		RC013	E	UP	8	.62	.15	9
		RC014	E	UP	6	.77	.48	36
		RC016	E	UP	3	.54	.63	34
		RC019	E	UP	3	.61	.07	4
		RC020	E	UP	8	.92	.82	75
		RC022	E	UP	8	.96	.56	53
		RC026	N	UP	3	5.57	.05	27
		XNPRC	X	UP	3	3.45	1.00	3.45

								22.83

	MNPSE	XNPSE	X	SA	2	.50	1.00	50

								50

36000 WORK CONTROL DOCUMENT (MEDS)

DATE: 09/11/80 PAGE: 02 OF 02 PAGES

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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN STRUT ASSY	26337A
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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		NSN C/N			

68A410501-20108	/H 1620010799928	26337A H	/	W	
68A410501-20111	/H 1620011671000	[REDACTED]	/	W	
68A410501-20125	/H 1620011670999	26337A H	/	W	
68A410501-20091	/H 1620010572791	26338A H	/	W	

GOVERNING DIRECTIVES: APLOR 66-51
MANDI 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 PARTS 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 (IF NEEDED) FOR STORAGE AND HANDLING.

*****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
DISPATCH	FUNCTIONAL CODE	A	C	36000N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-348-18

36000N WORK CONTROL DOCUMENT (MEDS)

DATE

PAGE 01 PAGE

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"
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	68A410501-2009 68A410501-2010 68A410501-2011 68A410501-2012							
	REQD	MATCH-UP *****ROUTED COMPONENTS***** NEW REWORKED NO SERVICEABLE 958 REWORK						001 68A410501	
		CUTTER CYL. / / 36001N PISTON / / 36002N							
		ORIFICE TUBE / / 36003N TORQUE ARM / / 36004N							
		APEX PIN J.L. / / 36006N TRUN. PIN / / 36007N							
		UPPER JURY LINK / / 36008N LOWER JURY LINK / / 36009N							
		LOWER JURY LINK / / 36010N UP. JURY LINK / / 36011N							
		RETRACT BOLT / / 36012N SPINDLE ASSY / / 36013N							
		SWIVEL CRANK D.B. / / 36014N COLLAR ASSY / / (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36000N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1968-0-346-148

36000N WORK CONTROL DOCUMENT (MEDS)

DATE: _____ 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 STRUT ASSY
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		36016N JURY BR. APEX PIN/ 36019N SPRING / /			
		36020N COLLAR TRUN. / / 36022N CONN. LINK ASSY / /			
		36023N BELL CRANK ASSY / / 36025N HIGH PRESS. PISTON /			
		36026N MISC. (STEEL) / / 36015N MISC. (ALUM) / /			
		36027N MISC. (STAINLESS STEEL) /			
		36028N			
		36029N			
		36030N			
		36031N			
		36032N			
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		36097N			
		36098N			
		36099N			
		36100N			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36000N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-545-78

WORK CONTROL DOCUMENT

8. JOB ORDER NO		9. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COM	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
18. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
[REDACTED]	[REDACTED]	MASK, PRIME AND PAINT					001 MNP GP		
	REQD	*C/P MOVE					002 09		
	[REDACTED]	DECALS					001 MNP GP		
	REQD	*C/P MOVE					002 09		
	[REDACTED]	FINAL ACCEPTANCE OF WCD PACKAGE FOR COMPLETNESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP		
	REQD	*C/P MOVE					002 09		
	[REDACTED]	FINAL PRODUCT VISUAL INSPECTION					001 MNP GP		
	REQD	*C/P MOVE					002 09		
							003 WB03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36000N			
		B		D					

* U.S. GOVERNMENT PRINTING OFFICE: 1969 O-358-12

36001N WORK CONTROL DOCUMENT (MDS)

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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO
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10. MODEL-DESIGN-SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN OUTER CYLINDER	21837A
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N	NSN	C/N			
68A410702-1006	RH 1620010753562	26337A R / H L / H	H /		

***** UNIT COST: \$10,796.46 *****

GOVERNING DIRECTIVES: AFLDR 66-51
MANOI 66-3

BLAST IAW MIL-STD-1504

FMP IAW MIL-STD-1949
P/O NO1263

GRIP IAW MIL-STD-871

GRIND IAW MIL-STD-866

TEMPER RICH IAW MIL-STD-867

SHOT PEEN IAW MIL-S-13165

COAT IAW MIL-STD-370

COAT IAW MIL-C-9837

CHROME PLATE IAW MIL-STD-1501
P/O NS1691

DRAKE IAW 4S-1-182
PART 4-11

IVD ALUM PLATE IAW MIL-C-33480A

ALUMINE IAW MIL-C-5541
HEAT TREAT 290,000/300,000 PSI

ALL WORK SPECIFIED IN THIS DOCUMENT
HAVE BEEN THOROUGHLY TRAINED AND ARE
FAMILIAR WITH ALL THE SAFETY
PRECAUTIONS AND PROCEDURES PERTAINING TO

THE USE OF FEDERAL ORDER (F.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

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	248

* U.S. GOVERNMENT PRINTING OFFICE: 1980-500-10

36001 WORK CONTROL DOCUMENT (MEDI)

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"	
		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	68A410702-1005 68A410702-1006							
		DISASSEMBLE		*C/P MOVE			001 MNF5W		
	REQD						002 02		
							003 L602		
							005 187A5199		
		CHEM CLEAN		*C/P MOVE			001 MNF6W		
	REQD						002 03		
							003 SL01		
		WASH CLEAN ONLY		*C/P MOVE			001 MNF0L		
	REQD						002 03		
							003 BL01		
		DATE IN		DATE OUT			001 MNF6W		
	REQD						002 03		
							003 BK03		
				*C/P MOVE					
	REQD					M	001 MNFRA		
							002 05		
							003 MLC4		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C	B	D				
								36001N	

* U.S. GOVERNMENT PRINTING OFFICE: 1969-04-16 *

3. JOB ORDER NO.		6. QUANTITY		4. PRODUCTION SEC/RCS		5. DATE SCHED		7. DATE COMPLETED	
9. PART NUMBER			8. TECH DATA			10. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION		16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"
			E & I INSPECTION					001 MHPGW	
		REQD	STRUT CYLINDER (AT TRUNNION COLLAR) O.D. I/R CYL. 68A410702-1001,-1002 2.6350/2.6400/2.6300					002 04	
			CYL. 68A410702-1003,-1004 2.6950/2.7000/2.6900						
			CYL. 68A410702-1005,-1006 2.7450/2.7600/2.7500						
			UPPER BORE ID 4.9375/4.9405/4.9430						
			LOWER BORE ID 5.2240/5.2260/5.2280						
			OUTBOARD JURY LINK BUSHING I.D. 1.0000/1.0010/1.0040						
			UPPER DRAG BRACE BUSHING I.D. 1.408/1.439/1.441						
			INBOARD JURY LINK BUSHING I.D. 1.2500/1.2510/1.254						
			DOOR SPRING ATTACH BUSHINGS 1.0125/1.015/1.0160						
			STRUT AREA OD 5.6220/5.6240/5.6200						
			TRUNNION PIN BUSHING I.D. 2.0965/2.0975/2.1000						
			OUTBOARD TRUNNION BOSS O.D. 1.5612/1.5600						
			ORIFICE TUBE HOLE 2.746/2.7476/2.749						
			CROSS PIN HOLE .380/.395 (CONTINUED)						
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36001N			
		B		D					

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* U.S. GOVERNMENT PRINTING OFFICE: 1980-500-100

WORK CONTROL DOCUMENT (MDS)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETE
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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. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
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		*C/P MOVE			
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26	021	REMOVE BUSHINGS THAT STATION 84 CAN NOT REMOVE *C/P MOVE			
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26	022	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
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26	023	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
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26	024	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
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26	025	HONE LOWER BORE MAX ID 5.228 *C/P MOVE		001 MNPRB 002 01 003 HV02 005 X8745245	
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26	026	HONE UPPER BORE MAX ID 4.9430 *C/P MOVE		001 MNPRB 002 01 003 HV02 005 X8745245	
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26	040	NICK AND BURR IAW PAGE 5-3 PARAGRAPH 5-3 *C/P MOVE		001 MNPRA 002 03 003 BE01	
----	-----	--	--	---------------------------------	--

26	045	O/S ORIFICE TUBE BUSHING REPAIR IAW DRAWING LE-110 *C/P MOVE*		001 MNPRA 002 03 003 MH04 005 X7831914	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-00-00-00

WORK CONTROL DOCUMENT (MEDS)

DATE 89041

8. JOB ORDER NO	9. 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	

18. DISPATCH STATION	16. PERFORM RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
✓ 26	050	O/S DRAG BRACE BOSS MAX I.D. 1.6263 REF. #31 FIG. 8-2 *C/P MOVE		001 MNPRA 002 03 003 BE01	
✓ 26	060	O/S TRUNNION SOCKET MAX I.D. 2.2029 REF. #32 FIG. 8-2 *L/P MOVE		001 MNPRA 002 03 003 MHO4 005 X7831914	
✓ 26	070	O/S INBOARD JURY BOSS MAX I.D. 1.4401 REF. #33 FIG. 8-2 *C/P MOVE		001 MNPRA 002 03 003 BE01	
✓ 26	080	O/S OUTBOARD TRUNNION BOSS MAX I.D. 1.3241 REF. #34 FIG. 8-2 *L/P MOVE		001 MNPRA 002 03 003 BE01	
✓ 26	090	O/S DOOR DRIVE BOSS MAX I.D. 1.4391 REF. #35 FIG. 8-2 *C/P MOVE		001 MNPRA 002 03 003 BE01	
✓ 26	095	O/S CROSS PIN HOLE I.D. TO CLEAN UP NOT TO EXCEED .395 MAX.		001 MNPRA 002 03 003 BE01	
✓ 26	098	WAPOR RELEASE *C/P MOVE		001 MNPRA 002 03 003 BE01	
✓ 26	100	STRIP BLINDING TRUNNION O.D. ONLY *C/P MOVE		001 MNPRA 002 02 003 SC02	
✓ 26	110	STRIP STEERING COLLAR AREA OD ONLY *C/P MOVE		001 MNPRA 002 02 003 SC02	
✓ 26	113	STRIP CHROME LOWER BORE I.D. *C/P MOVE		001 MNPRA 002 02 003 SC02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
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U.S. GOVERNMENT PRINTING OFFICE: 1980-00-00-10

WORK CONTROL DOCUMENT (MDS)

DATE 10/20/01

PAGE 01 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. EM 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"
✓	115	FIRST GRIND BORE ONLY NOT TO EXCEED 5.2440 *C/P MOVE		001 MNFRB 002 02 003 GIO5 005 X7831949	
✓	120	FIRST GRIND OUTER DIAMENSION BOSS O.D. 1.543 MIN *C/P MOVE		001 MNFRB 002 03 003 G001 005 X7831950	
✓	130	FIRST GRIND COLLAR AREA MIN. O.D. 5.602 *C/P MOVE		001 MNFRB 002 03 003 G001	
		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNFRB 002 06 003 TEC3	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
26B ✓	150	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH TIME OUT _____ DATE OUT _____		001 MNFRB 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNFRB 002 06 003 MLC4	
26 ✓	165	VAPOR DEGREASE *C/P MOVE		001 MNFRB 002 03 003 IGO1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-04-24

WORK CONTROL

1. JOB ORDER NO		2. 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						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	170	SHOT PEEN REWORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE					001 MNPRC 002 01 003 SP02		
26 ✓	175	PREPARE COLLAR O.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC *C/P MOVE					001 MNPRC 002 02 003 BE01 005 X7831914		
26 ✓	178	PREPARE COLLAR O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	190	CHROME PLATE COLLAR O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 5.6240/5.622					001 MNPRC 002 02 003 CP01 005 X7831914		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE					008 C0010		
268 ✓	180	BARE 4 HRS @ 350-400F AFTER CHROME DATE & TIME IN _____ DATE & TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
268 ✓	190	FINISH GRIND COLLAR O.D. 5.6220/5.6240 32 A2 *C/P MOVE					001 MNPRC 002 03 003 BK01		
268 ✓	191	BARE 4 HRS @ 350-400F AFTER CHROME DATE & TIME IN _____ DATE & TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26 ✓	192	PREPARE LOWER BORE FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26 ✓	194	PREPARE LOWER BORE FOR CHROME PLATE CLASS III TYPE I OR II MASK/FIXTURE/ETC (CONTINUED)					001 MNPRC 002 02 003 BE01 005 X7881949		
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36001N			
		B		D					

* U.S. GOVERNMENT PRINTING OFFICE: 1965-08-16

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WORK CONTROL DOCUMENT (MFGS)

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						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MECHANIC SIGN OFF REQUIRED							
26	195	CHROME PLATE LOWER BORE CLASS III TYPE I OR II SUFFICIENT TO GRIND BACK TO 5.224/5.226					001 MNPRC 002 02 003 CP01 005 X7881949 008 C1010		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26B	200	BAKE 4 HRS AT 350-400F AFTER CHROME PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	202	PREPARE OUTBOARD TRUNNION BOSS O.D. FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC *C/P MOVE					001 MNPRC 002 02 003 BE01 005 X7831914		
		REQ. SIGN OFF PERM. REQ. _____							
26	204	PREPARE (O.D.) TRUNNION BOSS FOR CHROME PLATE, BRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	206	CHROME PLATE OUTBOARD TRUNNION BOSS O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 1.5612/1.560					001 MNPRC 002 02 003 CP01 005 X7831914 008 C0020		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36001N			
		B		D					

* U.S. GOVERNMENT PRINTING OFFICE: 1969-0-345-142

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36001N WORK CONTROL DOCUMENT (MEDS)

DATE: 89041

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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	

18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26B ✓	207	BAKE 4 HRS @ 350-400F AFTER CHROME. DATE & TIME IN _____ DATE & TIME OUT _____ *C/P MOVE		001 MNPFC 002 02 003 BK01	
		210 FINISH GRIND OUTBOARD TRUNNION BOSS O.D. 1.5412/1.560 32RMS *C/P MOVE		001 MNPFB 002 03 003 GG01 005 X7831950	
		215 FINISH GRIND LOWER BORE 5.224/5.226 32 RMS *C/P MOVE		001 MNPFB 002 02 003 GI05 005 X7831949	
26B ✓	225	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPFC 002 02 003 BK01	
		227 MOVE ***** NOTE ***** IF LAST NBI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNPNA 002 06 003 MLC4	
26 ✓	235	VAPOR DECREASE *C/P MOVE		001 MNPFC 002 03 003 DG01	
		237 MOVE ***** NOTE ***** (CONTINUED)	M	001 MNPNA 002 06 003 ZSC1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
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* U.S. GOVERNMENT PRINTING OFFICE: 1980-00-000

CONTROL DOCUMENT (CD)

DATE

1. JOB ORDER		2. 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						
18. 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	300	PRIOR TO CAD, VAC CAD OR IVD ALUM PLATE, GRIT BLAST ALL AREAS TO BE PLATED *C/P MOVE					001 MNPRC 002 01 003 BLC2		
26	370	CAD PLATE TYPE II CLASS II 12.5 SQ FT AT 625 - 875 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
260	380	BAKE 25 M/S AT 350-400F PRIOR TO FINAL PLATING DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26	385	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE					001 MNPRC 002 02 003 IR01		
26	390	VACUUM CAD PLATE OPTIONAL -- IF BUSHING HAVE NOT BEEN REMOVED TYPE I CLASS III *C/P MOVE					001 MNPRC 002 02 003 VCC1		
26	395	HOT WATER RINSE & CLEAN *C/P MOVE*					001 MNPRC 002 02 003 IR01		
26	397	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 380 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)					001 MNPRC 002 03 003 IVD1		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		36001N			
		B		D					

* U.S. GOVERNMENT PRINTING OFFICE: 1969-488-782

36001N WORK CONTROL DOCUMENT (MEDS)

DATE 89041

PAGE 1 OF 1 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 OUTER CYLINDER						
18. 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	398	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE						001 MNFRC 002 03 003 TAO1	
	.65	*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****				M		001 MNFNA 002 06 003 MLC4	
69	405	O/S ORIFICE TUBE BUSHING REPAIR IAW DRAWING LE-110 *C/P MOVE P/N LE110-3						001 MNFRA 002 03 003 BE01	
69	409	MACHINE UPPER DRAG BUSH 872 *C/P MOVE P/N 8148157-1 202						001 MNFRA 002 03 003 LE02	
69	410	UPPER DRAG BUSH INSTALLATION STD P/N STANDARD-12002 (78) 1.4280/1.4390 SHRINK FIT AT .001/.003 INSIDE FACE TO FACE 1.8284/1.8368 OUTSIDE FACE TO FACE 3.7342/3.7416 MIN 3.7196 FLANGE THICKNESS .0393/.0403 *C/P MOVE						001 MNFRA 002 03 003 BE01	
		*C/P MOVE P/N 7829424-75						001 MNFRA 002 03 003 BE02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36001N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1989-508-10

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3601N WORK CONTROL DOCUMENT (MDS)

1. DATE 12-12-78
2. OF 12

8. JOB ORDER NO		9. 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						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
✓	420	UPPER JURY LINK BUSHING ON P/N 7829424-75 REF #31 FIG 8-2 1.438/1.439 SHRINK FIT AT .001/.003 INSIDE FACE TO FACE 1.8284/1.8368 OUTSIDE FACE TO FACE 3.7342/3.7416 MIN 3.7196 FLANGE THICKNESS .0393 TO .0403 *C/P MOVE						001 MNPRA	
✓	429	MACHINE UPPER JURY LINK BUSH STD O/S *C/P MOVE P/NST4M130-16001						001 MNPRA	
✓	430	UPPER JURY LINK BUSH INSTALLATION OUTBOARD STD P/N ST4M130-16001 1.000/1.001/1.004 FACE TO FACE 6.6294/6.6374/6.656 FLANGE THICKNESS .0593/.0603 *C/P MOVE						001 MNPRA	
✓	439	MACHINE O/S UPPER JURY LINK BUSHING #34 OUTBOARD *C/P MOVE P/N 7829424-77						001 MNPRA	
✓	440	O/S UPPER JURY LINK BUSH INSTALL. OUTBOARD P/N 7829424-77 REF #34 FIG 8-2 1.000/1.001/1.004 FACE TO FACE 6.2947/6.3027/6.3206 FLANGE THICKNESS .0593/.0603 *C/P MOVE						001 MNPRA	
✓		UPPER JURY LINK BUSHING INBOARD *C/P MOVE P/N ST4M130-20001						001 MNPRA	
✓		UPPER JURY LINK BUSHING INBOARD STD P/N ST4M130-20001 ID 1.250/1.251 FLANGE THICKNESS (CONTINUED)						001 MNPRA	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36001N	
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U.S. GOVERNMENT PRINTING OFFICE: 1978-0-280-000

WORK CONTROL DOCUMENT (MIL-STD-168)

DATE

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8. JOB ORDER NO		9. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			6. 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"	
		.0593/.0603 *C/P MOVE							
✓ 459		MACHINE O/S UPPER JURY LINN BUSH INBOARD #33 *C/P MOVE P/N7829424-01					001 MNFRA 002 03 003 LEO2		
✓ 460		O/S UPPER JURY LINN BUSH INSTALL. INBOARD P/N 7829424-77 REF #33 FIG 8-2 1.250/1.251/1.254 FLANGE THICKNESS .0593/.0603 *C/P MOVE					001 MNFRA 002 03 003 BE01		
✓ 469		MACHINE STD DOOR DRIVE BUSH *C/P MOVE P/N68A410670-2001					001 MNFRA 002 03 003 LEO2		
✓ 470		STD DOOR DRIVE BUSH INSTALLATION P/N 68A410670-2001 ID #31257.3135 FLANGE THICKNESS .027/.030 MIN .019 6 PLACES FACE TO FACE .300/.320/.284 MIN SHRINK FIT AT .0001/.0021 *C/P MOVE					001 MNFRA 002 03 003 BE01		
✓ 479		MACHINE O/S DOOR DRIVE BOSS BUSH #33 *C/P MOVE P/N7829424-87					001 MNFRA 002 03 003 LEO2		
✓		O/S DOOR DRIVE BOSS BUSH INSTALLATION P/N 7829424-87 REF #35 FIG 8-2 .3125/.3135/.3160 FLANGE THICKNESS .027/.030 MIN .019 6 PLACES FACE TO FACE .300/.320/.284 MIN SHRINK FIT AT .0001/.0021 *C/P MOVE					001 MNFRA 002 03 003 BE01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36001N	
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U.S. GOVERNMENT PRINTING OFFICE: 1980-0-288-000

36001N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

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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	489	MACHINE STD TRUNNION BUSH *C/P MOVE P/N68A410720-2001					001 MNRKA 002 03 003 LEO2		
69	490	STD TRUNNION BUSH INSTALLATION 68A410720-2001 ID 2.0945/2.0975 SHRINK FIT AT .001/.003 *C/P MOVE					001 MNRKA 002 03 003 BEA1		
69	499	MACHINE O/S TRUNNION SOCKET BUSH #32 *C/P MOVE P/N 7829417-01					001 MNRKA 002 03 003 LEO2		
69	500	O/S TRUNNION SOCKET BUSH INSTALL. P/N 7829417-01 REF #32 FIG 8-2 2.0945/2.0975/2.100 SHRINK FIT AT .001/.003 *C/P MOVE					001 MNRKA 002 03 003 BEO1		
	503	MASK, PRIME, AND PAINT *C/P MOVE					001 MNRUP 002 09 003 WBO3		
	507	DETAILS *C/P MOVE					001 MNRUP 002 09 003 WBO3		
	510	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL ELECTRICAL MEASUREMENTS					001 MNRUP 002 09 003 WBO2		
	520	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNRUP 002 09 003 WBO3		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-040-780

1. PART NO.		2. QUANTITY		3. PRODUCTION SEC/RCS MNP GP		4. DATE SCHED		5. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 4A4-22-3 4S-1-182				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES F 15 MAIN			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PISTON ASSY			26378A			
15. DISPATCH STATION P/N		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED NSN C/N					
58A410704-1012		7H 1520010803407		26337A H		/	W		
68A410704-1005		7H 1620010803401		26337A H		/	W		
68A410704-1006		7H 1620010818799		26338A H		/	W		
		***** UNIT COST: \$6089.00 *****							
		GOVERNING DIRECTIVES:		AFLCR 66-51					
				MANDI 66-3					
		BLAST		IAW MIL-STD-150A					
		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					
		FPI		IAW MIL-STD-6866					
		C&O		IAW MIL-SID-870					
		VAC CAD		IAW MIL-C-8837					
		CHROME PLATE		IAW MIL-STD-1501					
				P/O N41891					
		BAKE		IAW 4S-1-182					
				MADI 74-12					
		1VD ALUM PLATE		IAW MIL-C-83488A					
		ALODINE		IAW MIL-C-5541					
		***** 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. THE		APPLICABLE T.O.'S AND SUPPLEMENTS					
		WILL ALWAYS BE USED IN CONJUNCTION		WITH THIS DOCUMENT.					
		(CONTINUED)							
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
DISPATCH		FUNCTIONAL CODE	A		C		36002N		
			B		D				

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* U.S. GOVERNMENT PRINTING OFFICE: 1978-240-448

36002N WORK CONTROL DOCUMENT (WEDS)

PAGE 1

3. 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 ASSY						
18. DISPATCH STATION	19. PERM RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*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	68A410704-1005 68A410704-1006 68A410704-1011 68A410704-1012							
		DISASSEMBLE *C/P MOVE						001 MNPBW 002 03 003 BLQ1	
	REQD								
		CHEM CLEAN *C/P MOVE						001 MNPBW 002 03 003 BLQ1	
	REQD								
		BLAST CLEAN ONLY *C/P MOVE						001 MNPBW 002 03 003 BLQ1	
	REQD								
		BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____						001 MNPBW 002 03 003 BK03	
	REQD								

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

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U.S. GOVERNMENT PRINTING OFFICE: 1980-000-000

36002N WORK CONTROL DOCUMENT (MEDS)

DATE 1901

8. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
9. PART NUMBER				8. TECH DATA				6. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PISTON ASSY						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
	REDD	*C/P MOVE				M		001 MNP NA 002 05 003 MLO4	
	REQD	E & I INSPECTION IAW T.O. 4A4-22-3 TABLE 8-1						001 MNP GW 002 04 003 EIC1	
		PISTON O.D. LOWER AREA 4.495/4.497/4.492							
		PISTON O.D HEAD AREA 4.385/4.383							
		PISTON ID METERING PIN SEAL AREA 3.7430/3.7430/3.7470							
		PISTON ID ABOVE METERING PIN SEAL AREA 3.820/3.822							
		PISTON HEAD AREA ID 4.060							
		LARGE AREA I.D. 2.960/2.250 MAX. TOLERANCE IS 0.000 FOR LIGHT AND HEAVY METAL 0.010-0.015.							
		SMALL AREA I.D. 2.960/2.010 MAX. TOLERANCE IS 0.020 HEAVY METAL ONLY							
		PISTON HEAD PIN ID .500/.501							
		FLANGE BUSHING BASE METAL I.D. .625/.626							
		FLANGE BUSHING ID .501/.502							
		TORQUE ARM BUSHING FACE TO FACE 3.625/3.624 (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1969-0-340-940

36002N WORK CONTROL DOCUMENT (MEDS)

DATE 29 OCT 80

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 ASSY						
18. DISPATCH STATION	16. PERF HCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		TORQUE ARM BUSHING ID 1.118/1.119							
		TORQUE ARM BUSHING BASE METAL AFTER PLATE 1.219/1.220							
		INNER AXLE JOURNAL 2.9322/2.9345/2.9296							
		OUTER AXLE JOURNAL 2.9117/2.914/2.9091							
		BRAKE FLANGE HOLE I.D. .749 MIN. .776 MAX. DIA.							
		NOTE. IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.							
		*C/P MOVE							
26	024	VAPOR DECREASE		*C/P MOVE			001 MNHRC	002 03	003 D601
26	026	SLIP PAD		*C/P MOVE			001 MNHRC	002 03	003 0001
26	028	R K...		*C/P MOVE			001 MNHRC	002 03	003 L502
		NICK B BURR *C/P MOVE*					001 MNHRA	002 03	003 BE01
		CLEAN UP AS NECESSARY NOT TO EXCEED 2.300 MAX. DIA. HEAVY WT./LIGHT WT. (CONTINUED)					001 MNHRA	002 03	003 BE01
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A	C		36002N				
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 198-0-00-00

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WORK CONTROL DOCUMENT (METS)

DATE

WORK CONTROL DOCUMENT

8. JOB ORDER NO		9. 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 ASSY						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		C/P MOVE							
✓	040	POLISH UP HONE SMALL LEAK TO CLEAN UP AS NECESSARY NOT TO EXCEED 2.070 MAX. DIA. HEAVY WEIGHT ONLY *C/P MOVE*					001 MNFRA 002 03 003 BE01		
✓	042	O/S TORQUE ARM BOSS MAX ID 1.2935 *C/P MOVE					001 MNFRA 002 03 003 BE01		
✓	045	O/S UPLOCK BOSS MAX ID 1.2992 *C/P MOVE					001 MNFRA 002 03 003 BE01		
✓	048	POLISH BRAKE FLANGE HOLES TO REMOVE CORR. NOT TO EXCEED .776 MAX. DIA. *C/P MOVE					001 MNFRA 002 03 003 BE01		
✓	049	CAMER DEGREASE *C/P MOVE					001 MNFRC 002 03 003 IG01		
✓	050	STRIP CHAMFER FROM PISTON OD *C/P MOVE					001 MNFRC 002 02 003 SC02		
✓	060	STRIP CHAMFER FROM PISTON ID *C/P MOVE					001 MNFRC 002 02 003 SC02		
✓	062	STRIP INNER AXLE JOURNAL *C/P MOVE					001 MNFRC 002 02 003 SC02		
✓	065	STRIP OUTER AXLE JOURNAL *C/P MOVE					001 MNFRC 002 02 003 SC02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36002N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1958-0-560-40

3. JOB ORDER NO	4. QUANTITY	5. PRODUCTION SEC/RCC	6. DATE SCHED	7. DATE COMPLETED
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8. PART NUMBER	9. TECH DATA	10. DRAWING NO
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11. MODEL-DESIGN-SERIES	12. STOCK NUMBER	13. OPTIONAL
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14. SERIAL NUMBER	15. NOUN PISTON ASSY
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16. DISPATCH STATION	17. PERF RCC/OP NO	18. WORK TO BE ACCOMPLISHED	19. MECHANIC	20. "P"	21. "Q"
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[REDACTED]	070	FIRST GRIND PISTON I.D. MIN O.D. 4.4750 *C/P MOVE		001 MNFRB 002 03 003 GG01 005 X7831945	
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[REDACTED]	080	FIRST GRIND PISTON I.D. METERING PIN SEAL AREA MAX I.D. 3.763 *C/P MOVE		001 MNFRB 002 02 003 SI01 005 X7831945	
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[REDACTED]	082	1ST GRIND INNER AXLE JOURNAL MIN O.D. 2.9250 *C/P MOVE		001 MNFRB 002 03 003 0501 005 X7831948	
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[REDACTED]	085	1ST GRIND OUTER AXLE JOURNAL MIN O.D. 2.9051 *C/P MOVE		001 MNFRB 002 03 003 GG01 005 X7831948	
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[REDACTED]		TIME OUT _____ DATE OUT _____ ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * ***** *C/P MOVE	M	001 MNFNA 002 06 003 TEC3	
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26B	100	SAFE < HRS WITHIN 8 HRS OF ETCH DATE TO _____ TIME IN _____		001 MNFRB 002 02 003 GG01	
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[REDACTED]		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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[REDACTED]		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * ***** *C/P MOVE	M	001 MNFNA 002 06 003 MLC4	
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22. FINAL DESTINATION		23. COORDINATION/INITIATING RCC SIGNATURE/DATE		24. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

1. ORDER NO.		2. 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 ASSY						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓	115	VAPOR DEGREASE *C/P MOVE					001 MNPFC	002 03 003 DG01	
26 ✓	120	SHOT PEEN ALL REWORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE					001 MNPFC	002 01 003 SP02	
26 ✓	125	PREPARE PISTON I.D. FOR CHROME PLATE, GRIT BLAST. *C/P MOVE					001 MNPFC	002 01 003 BL02	
26 ✓	127	PREPARE FOR CHROME PLATE PISTON I.D. SEAL FIXTURE/MASK/ETC. IAW MIL-STD-1501 & P/O N61891					001 MNPFC	002 02 003 BE01 005 X7831923	
		MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26 ✓	130	CHROME PLATE PISTON I.D. SEAL TYPE II CLASS III SUFFICIENT TO BRIND BACK TO 3.743 TIME OUT _____ DATE OUT _____					001 MNPFC	002 02 003 CP01 005 X7831923 008 C1010	
		MECHANIC SIGNOFF REQUIRED *C/P MOVE							
26B ✓	135	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____					001 MNPFC	002 02 003 BK01	
		*C/P MOVE							
26 ✓	136	PREPARE FOR CHROME PLATE PISTON O.D. FIXTURE/MASK/ETC. IAW MIL-STD-1501 & P/O N61891 (CONTINUED)					001 MNPFC	002 02 003 BE01 005 X7831921	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

26B

1. JOB ORDER NO		2. QUANTITY		3. PRODUCTION SEC/RCC		4. DATE ORDERED		5. DATE SHIPPED	
7. PART NUMBER				8. TECH DATA				9. ITEM DESCRIPTION	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PISTON ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MECHANIC SIGN OFF REQUIRED *C/P MOVE							
26	139	PREPAPE PISTON O.D. FOR CHROME PLATE, GRIT BLAST. *C/P MOVE						001 MNPRC	002 01
								003 BL02	
26	140	CHROME PLATE PISTON O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 4.497 TIME OUT DATE OUT						001 MNPRC	002 02
								003 CP01	005 X7831921
		*MECHANIC SIGNOFF REQUIRED----- *C/P MOVE						008 C0010	
26B	150	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN TIME IN DATE OUT TIME OUT *C/P MOVE						001 MNPRC	002 02
								003 BK01	
26	152	PREPARE FOR CHROME PLATE AXLE JOURNALS FIXTURE/MASK/ETC. IAW MIL-STD-1501 & P/O N50073						001 MNPRC	002 02
		MECHANIC SIGN OFF REQUIRED *C/P MOVE						003 1501	
26	154	PREPARE AXLE JOURNALS FOR CHROME PLATE, GRIT BLAST. *C/P MOVE						001 MNPRC	002 01
								003 BL02	
26	156	CHROME PLATE INNER AXLE JOURNAL TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 2.9345 (CONTINUED)						001 MNPRC	002 02
								003 CP01	008 C0020
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/IN			
DISPATCH	FUNCTIONAL CODE	A	C			36002N			
		B	D						

U.S. GOVERNMENT PRINTING OFFICE: 1969-00-70

36002N WORK CONTROL DOCUMENT (NRDS)

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 ASSY
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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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		TIME OUT _____ DATE OUT _____ *MECHANIC SIGNOFF REQUIRED----- *C/P MOVE			
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25 ✓	157	CHROME PLATE OUTER AXLE JOURNAL TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 2.9140. TIME OUT _____ DATE OUT _____ *MECHANIC SIGNOFF REQUIRED----- * P MOVE		001 MNPRC 002 02 003 CP01 008 C0030	
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		BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
--	--	---	--	---------------------------------	--

26B ✓	158	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
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		FINISH GRIND PISTON O.D. 4.4250/4.4275 ±.0005 *C/P MOVE		001 MNPRC 002 03 003 6G01 005 X7831945	
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8 ✓	170	FINISH GRIND PISTON ID, METERING PIN SEAL AREA 3.743/3.745 ±.0005 *C/P MOVE		001 MNPRC 002 02 003 6101 005 X7131945	
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80 ✓	175	FINISH GRIND INNER AXLE JOURNAL 2.9022/2.9345 *C/P MOVE		001 MNPRC 002 03 003 6G01 005 X7831948	
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		FINISH GRIND OUTER AXLE JOURNAL 2.9117/2.9140 *C/P MOVE		001 MNPRC 002 03 003 6G01 005 X7831948	
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26B ✓	180	BAKE 4 HRS 350-400F AFTER FINISH GRIND 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/IN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN	
DISPATCH	FUNCTIONAL CODE	A	C	36002N	
		B	D		

1. JOB ORDER NO	2. 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 ASSY	

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			
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNRNA 002 06 003 MLC4	
		***** NOTE ***** *C/P MOVE			
26	195	VAPOR DEGREASE *C/P MOVE		001 MNRRC 002 03 003 DGO1	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNRNA 002 06 003 ZSO1	
		***** NOTE ***** *C/P MOVE			
26	205	PRIOR TO CAB/VAC CAB/IVB, BRIT BLAST ALL AREAS TO BE CAB/ VAC CAB/ IVB PLATED. *C/P MOVE		001 MNRRC 002 01 003 BLC2	
26	210	CAB PLATE TYPE II CLASS II 2.53 SW FT AT 141 - 197 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNRRC 002 03 003 CA01	
26B	220	BAKE 23 HRS WITHIN 4 HRS OF CAB PLATE DATE IN _____ TIME IN _____		001 MNRRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-00-00

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DOCUMENT (METS)

DATE

1. CASE 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 PISTON ASSY						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
26	225	VACUUM CAD PLATE TYPE I CLASS I OPTIONAL IF BUSHINGS NOT REMOVED NOTE OPERATION 220 MUST BE ACCOMPLISHED PRIOR TO VAC CAD *C/P MOVE						001 MNARC 002 02 003 VCC1	
26	227	HOT WATER RINSE & CLEAN *C/P MOVE*						001 MNARC 002 02 003 IRC1	
26	230	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE						001 MNARC 002 02 003 IRC1	
26	233	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 220 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION. *C/P MOVE						001 MNARC 002 03 003 IV01	
26	234	ALOXIN- III ALUM PLATE CLASS 1A *C/P MOVE						001 MNARC 002 03 003 TA01	
	.65	ONLY IF TANK CAD ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * ***** *C/P MOVE					M	001 MNARC 002 06 003 MLC4	
		***** *C/P MOVE ***** P/N 68A410636-2001						001 MNARC 002 03 003 LFC1	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT#			
DISPATCH	FUNCTIONAL CODE	A		C		36002N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1969-0-349-480

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 PISTON ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
✓		TORQUE ARM BUSH INSTALLATION P/N 88H410636-2001 ID 1.118/1.119 FIT .001/.0025 FLANGE INBOARD .061/.068/.053						001 MNPRA	
		FLANGE AXEL SIDE .056/.065/.048 FACE TO FACE OUTSIDE 3.624/3.625/3.608 MIN *C/P MOVE						002 03	
		FLANGE INBOARD .061/.068/.053						003 BE01	
✓	244	MACHINE O/S TORQUE ARM BUSHING *C/P MOVE P/N 7829421-01						001 MNPRA	
								002 03	
								003 LE02	
✓	245	O/S TORQUE ARM BUSH INSTALLATION P/N 7829421-01 ID 1.118/1.119 INSTALL SAME AS STD *C/P MOVE						001 MNPRA	
								002 03	
								003 BE01	
✓	249	MACHINE CAM FOLLOWER BUSHING *C/P MOVE P/N ST4M130-08005						001 MNPRA	
								002 03	
								003 LE02	
✓	250	CAM FOLLOWER BUSH INSTALLATION P/N ST4M130-08005 ID .501/.502 FIT .0005/.0015 FLANGE .056/ .061/.048 FACE 1.087/1.117/1.071 *C/P MOVE						001 MNPRA	
								002 03	
								003 BE01	
✓	254	MACHINE O/S CAM FOLLOWER BUSHING *C/P MOVE P/N 7829424-71						001 MNPRA	
								002 03	
								003 LE02	
✓		CAM BUSH INSTALLATION P/N 7829424-71 ID .501/.502 INSTALL SAME AS STD *C/P MOVE						001 MNPRA	
								002 03	
								003 BE01	
34A	257	MATCH-UP PISTON HEAD (9) AND PISTON (55). IF PISTON HEAD WITH SAME SERIAL # AS PISTON CANNOT BE FOUND (CONTINUED)						001 MNPRA	
								002 06	
								003 MLC01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/IN			
DISPATCH	FUNCTIONAL CODE	A	C	E	G	I	K	M	O
									36002N

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

7. PART NUMBER 8. TECH DATA 9. PART SERIAL NO.
4A4-22-3
4S-1-182

10. MODEL DESIGN-SERIES 11. STOCK NUMBER 12. OPTIONAL
F15-MLG

13. SERIAL NUMBER 14. NOUN
ORIFICE TUBE

26338A

15. DISPATCH STATION 16. PERF RCC/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECHANIC 19. "P" 20. "Q"

P/N 6BA410726-1001
NSN [REDACTED] C/N 26338A L / H
26337A R / H

GOVERNING DIRECTIVES: AF LCR 66-51
MANO 66-3
***** UNIT COST: \$1121.67 *****
FPI IAW MIL-STD-6866
ANODIZE IAW MIL-A-8625
HARD ANODIZE IAW MIL-A-8625
BLAST IAW MIL-STD-1504
ALDOLINE IAW MIL-C-5541
STRIP IAW MIL-STD-871

*****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 AF LCR FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.
COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (IF NEEDED) 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
(CONTINUED)

21. FINAL DESTINATION 22. COORDINATION/INITIATING RCC SIGNATURE/DATE 23. DOCUMENT/BN
DISPATCH FUNCTIONAL CODE A C
B D
36003N
275

U.S. GOVERNMENT PRINTING OFFICE: 1969-0-348-448

CONTROL DOCUMENT (MFGS)

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 ORIFICE TUBE							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"	
		PRECLUDE INJURIES.								
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.								
	001	68A410726-1001								
		DISASSEMBLE *C/P MOVE							001 MNP GW	
	REQD								002 02	
									003 LG02	
									005 XB745199	
		DEGREASE ONLY *C/P MOVE							001 MNP GW	
	REQD	***** NOTE *****							002 02	
		PROTECT HARD ANODIZE AREA *							003 DG02	

		BLAST CLEAN *C/P MOVE							001 MNP GW	
	REQD								002 03	
									003 BLO7	
									001 MNP NA	
	REQD						M		002 05	
									003 ZY05	
		E AND I							001 MNP GW	
	REQD	OD 2.988 2.997/2.991							002 04	
									003 E101	
		AREA 3 OF FIG 8-7 PAGE 8-19 FROM BEARING TOWARD ORIFICE TIP FIRST 5 INCHES MIN OD 2.988 8 RMS NO DEFECTS ALLOWED IN SEALING AREA								
		AREA 2 BALANCE OF HARD ANODIZED AREA .030 DEEP DEFECTS 2.935 MIN OD MAX 63 RMS LOCAL REWORK PERMITTED (CONTINUED)								
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/IN				
DISPATCH	FUNCTIONAL CODE	A	C	E	G	I	K	M	O	Q
										36403N

U.S. GOVERNMENT PRINTING OFFICE: 1988-000-000

276

36003N WORK CONTROL DOCUMENT

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 III	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			
	025	POLISH HARD ANODIZED AREA IF AREA DOES NOT CLEAN UP AS SPECIFIED IN T.O., ROUTE TO STRIP *C/P MOVE		001 MNFRA 002 03 003 LE02	
	027	DISASSEMBLE AS REQUIRED REMOVE STRIP ANODIZE. NOTE: REMOVE RIVETS AND STEEL COMPONENTS. *C/P MOVE		001 MNFRA 002 03 003 BE01	
26	030	STRIP ANODIZE *C/P MOVE		001 MNFRC 002 03 003 AN04	
		*C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****	M	001 MNFNA 002 06 003 ZA02	
26	050	ANODIZE TYPE II CLASS I *C/P MOVE		001 MNFRC 002 03 003 ASC3	
69	055	POLISH TUBE TO 6-8 RMS MAX IN SEALING AREA AS DEFINED IN E & I SECTION 63 RMS MAX REST OF TUBE MIN OD 2.995 *C/P MOVE		001 MNFRA 002 03 003 LE02	
26	060	HARD ANODIZE TYPE III SUFFICIENT TO BUILD TO MAX OF 2.997 *C/P MOVE		001 MNFRC 002 03 003 AH01 005 ADD10	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36003N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980-50-510

36004N WORK CONTROL DOCUMENT (MEDS)

DATE 89041

PAGE 1 OF 1 PAGES

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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN TORQUE ARM	36004N
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18. DISPATCH STATION	16. PERFORM NO	17. WORK TO BE ACCOMPLISHED	19. MECHANIC	20. "P"	21. "Q"
P/N 68A410	46-2005	NSN ██████████ 26336A L / H 26337A R / H 50431A			

***** UNIT COST: \$1542.30 *****
 GOVERNING DIRECTIVES: APLCR 66-51
 PART I 66-3
 LAST IAW MIL-STD-1504
 FMPI IAW MIL-STD-1949
 P/O N01561
 CAD IAW MIL-STD-870
 BAKE IAW 4S-1-182
 CHROME PLATE IAW MIL-STD-1501
 & P/O N61891
 TEMPER ETCH IAW MIL-STD-867
 STRIP CHROME IAW MIL-STD-871
 IVD ALUM PLATE IAW MIL-STD-8843CA
 ALUETNE IAW MIL-STD-541
 ***** STEEL COOK P/*****

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDOUS MATERIALS IN THE BASIC TECHNICAL MANUAL (T.O.) AND U.S. SUPPLIES REPAIR MANUALS. ALL WORK SHALL BE DONE IN ACCORDANCE 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/IN
DISPATCH	FUNCTIONAL CODE	A	C	36004N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041

PAGE 2 OF 2 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 TORQUE ARM
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15. DISPATCH STATION	16. PERP 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	68A410646-2005			
		DISASSEMBLE *C/P MOVE		001 MNR SW 002 02 003 LG02 005 X8745199	
	REQD				
		CHEM CLEAN *C/P MOVE		001 MNR SW 002 03 003 SL01	
	REQD				
		BLAST CLEAN ONLY *C/P MOVE		001 MNR SW 002 03 003 BL07	
	REQD				
		PAUSE 4 HRS AT 350-400F		001 MNR SW 002 03 003 BK03	
	REQD	DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
		*C/P MOVE	M	001 MNR SW 002 05 003 MSC3	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SW
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-340-101

36004N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041

PAGE 3 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 TORQUE ARM	

18. DISPATCH STATION	19. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		E & I INSPECTION		001 MNHGW 002 04 003 EIC1	
	REQD	APEX PIN I.D. .738/.7385/.741			
		TORQUE ARM PIN I. D. 1.118/1.119 1.122 APEX BOSS THICKNESS .998/1.00 T.A. BOSS THICKNESS .933/.943			
		APEX FACE TO FACE ID 1.250/1.252 TORQUE ARM BASE FACE TO FACE 3.626/3.628			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE			
69 ✓	025	REMOVE TORQUE ARM PIN *C/P MOVE*		001 MNHRA 002 03 003 BEC1	
69 ✓	030	O/S LOCK PIN 205 REQUIRES O/S BOLT *C/P MOVE		001 MNHRA 002 03 003 BEC1	
26 ✓	034	VALVE DECREASE *C/P MOVE		001 MNHRC 002 03 003 DSC1	
26 ✓	036	STRIP CAD *C/P MOVE		001 MNHRC 002 02 003 CSC1	
26 ✓	038	STRIP RUST *C/P MOVE		001 MNHRC 002 02 003 CSC2	
26 ✓	040	STRIP CHROME BASE FACE TO FACE *C/P MOVE		001 MNHRC 002 02 003 BEC2	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36004N

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U.S. GOVERNMENT PRINTING OFFICE: 1980-440-782

WORK CONTROL DOCUMENT (MEDS)

DATE 89041

PAGE 4 OF 4 PAGES

1. JOB ORDER NO	2. 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 TORQUE ARM
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15. DISPATCH STATION	16. PERP/RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	050	STRIP CHROME BASE BOSS I.D. *C/P MOVE		001 MNHRA 002 01 003 BE01	
26	060	STRIP CHROME APEX FACE TO FACE *C/P MOVE		001 MNHRC 002 02 003 SC02	
26	070	STRIP CHROME APEX BOSS I.D. *C/P MOVE		001 MNHRC 002 02 003 SC02	
	080	FIRST GRIND BASE LUG FACES TO CLEAN UP NOT TO EXCEED 3.646 *C/P MOVE		001 MNHRC 002 01 003 SJ01	
	090	FIRST GRIND APEX LUG FACES NOT TO EXCEED .982" NOTE: APEX LUGS FACE TO FACE NOT TO EXCEED 1.2750 *C/P MOVE		001 MNHRC 002 01 003 GJ01	
	100	FIRST GRIND BASE BOSS I.D. NOT TO EXCEED 1.138 *C/P MOVE		001 MNHRC 002 01 003 GJ01 005 X857942	
8	110	FIRST GRIND APEX LUG BOSS I.D. NOT TO EXCEED .752 *C/P MOVE		001 MNHRC 002 01 003 SJ02 005 X857942	
		DATE OUT _____ TIME OUT _____ *C/P MOVE	H	001 MNHRA 002 06 003 TE03	
		*****NOTE***** IF LAST NDI OPERATION IS COMPLETED * HERE, TAKE PRODUCTION COUNT. * *****			
26B	130	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH. DATE IN _____ TIME IN _____ (CONTINUED)		001 MNHRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	36004N

WORK CONTROL DOCUMENT (MEDS)

1. DATE

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 TORQUE ARM
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15. DISPATCH STATION	16. PERP 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 NCI OPERATION IS COMPLETED PLEASE TAKE PRODUCTION COUNT. *****	M	001 MNFNA 002 06 003 MLO4	
--	--	--	---	---------------------------------	--

26	145	VAPOR DECREASE *C/P MOVE		001 MNFRC 002 03 003 DGO1	
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26	150	PREPARE BASE/APEX LUGS FOR CHROME PLATE, BRIT BLAST *C/P MOVE		001 MNFRC 002 01 003 BLO4	
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26	155	PREPARE FOR CHROME PLATE OF BASE/ APEX LUGS, FIXTURE/ MASK/ETC IAW MIL-STD-1501 & P/O N61891 *MECHANIC SIGNOFF REQUIRED		001 MNFRC 002 02 003 BE01 005 X7929107	
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26	160	CHROME PLATE BASE LUGS FACE TO FACE TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 3.25/3.25 TIME OUT DATE OUT *MECHANIC SIGNOFF REQUIRED *C/P MOVE		001 MNFRC 002 02 003 CP01 005 X7929107 008 C0010	
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26	170	CHROME PLATE APEX LUGS FACE TO FACE TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 1.250/1.252 TIME OUT DATE OUT *MECHANIC SIGNOFF REQUIRED *C/P MOVE		001 MNFRC 002 02 003 CP01 005 X7929107 008 C0020	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	35004N
		B	D	

36004N WORK CONTROL DOCUMENT (MEDS)

DATE: 11/10/50

PAGE 1 OF 2 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 TORQUE ARM
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	13. MECHANIC	19. "P"	20. "Q"
26 ✓	173	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME TIME IN _____ DATE IN _____		001 MNPRC 002 02 003 BK01	

		TIME OUT _____ DATE OUT _____ *C/P MOVE			
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26 ✓	175	PREPARE BASE/APEX BOSS FOR CHROME PLATE. GRIT BAST *C/P MOVE		001 MNPRC 002 01 003 BLO4	
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26 ✓	177	PREPARE FOR CHROME PLATE OF BASE/APEX BOSS ID, FIXTURE/MASK/ETC IAW MIL-STD-1501 & P/D N61891 *MECHANIC SIGNOFF REQUIRED-----		001 MNPRC 002 02 003 BE01	
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		*C/P MOVE			
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26 ✓	180	CHROME PLATE BASE BOSS I.D. TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 1.118/1.119		001 MNPRC 002 02 003 CP01 008 CIO10	
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		TIME OUT _____ DATE OUT _____ *MECHANIC SIGNOFF REQUIRED----- *C/P MOVE			
--	--	---	--	--	--

26 ✓	190	CHROME PLATE APEX BOSS I.D. TYPE II CLASS II SUFFICIENT TO GRIND BACK TO .7380/.7385		001 MNPRC 002 02 003 CP01 008 CIO20	
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		TIME OUT _____ DATE OUT _____ *MECHANIC SIGNOFF REQUIRED----- *C/P MOVE			
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26B ✓	200	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME 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/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1949-0-245-10

36004N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

PAGE 7 OF 7 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 TURBINE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
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DATE OUT _____ TIME OUT _____
*C/P MOVE

8 ✓	210	FINISH GRIND BASE LUG FACE TO FACE TO 3.626/3.628 *C/P MOVE		001 MNFRB 002 01 003 GJ01	
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8 /	220	FINISH GRIND APEX FACE TO FACE TO 1.000/1.002/.998 - FACE TO FACE BETWEEN LUGS 1.252/1.250 *C/P MOVE		001 MNFRB 002 01 003 GJ01	
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8 /	230	FINISH GRIND BASE BOSS I.D. 1.118/1.117 *C/P MOVE		001 MNFRB 002 01 003 GJ01 005 X857942	
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8 /	240	FINISH GRIND APEX BOSS I.D. .7380/.7385 *C/P MOVE		001 MNFRB 002 01 003 GJ01 005 X857942	
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26B ✓	250	BAKE 4 HRG @ 350-400 TIME IN _____ DATE IN _____ TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNFRB 002 02 003 BK01	
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		<p>***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCT TO COURT. *****</p>	M	001 MNFRB 002 06 003 HLC4	
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26 ✓	265	VAPOR DEGLAZE *C/P MOVE		001 MNFRB 002 03 003 DG01	
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		<p>***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED (CONTINUED)</p>	M	001 MNFRB 002 06 003 ZS01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1980-00-10

36004N WORK CONTROL DOCUMENT (MEDS)

1. DATE: [REDACTED] PAGE: [REDACTED]

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 TORQUE ARM						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		HERE, TAKE PRODUCTION COUNT. *****							
26	✓ 275	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED						001 MNPRC 002 01 003 BL02	
26	✓ 200	CAD PLATE TYPE II CLASS II .25 SQ FT AT 12.5 - 17.5 AMPS TIME OUT OF TANK *C/P MOVE						001 MNPRC 002 03 003 CAD1	
26B	✓ 290	BAKE 23 HRS WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____						001 MNPRC 002 02 003 BX01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	✓ 300	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE						001 MNPRC 002 02 003 IRC1	
	265	*C/P MOVE ***** NOTE ***** IF LAST NUI OPERATION IS COMPLETED				M		001 MNPRC 002 06 003 MLC4	
		HERE, TAKE PRODUCTION COUNT. *****							
26	✓ 313	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	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36004N	

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* U.S. GOVERNMENT PRINTING OFFICE: 1980-048-148

36004N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

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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 TORQUE ARM
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	317	ALDINE IVD ALUM PLATE CLASS IA *C/P MOVE		001 MNRRC 002 03 003 TAO1	
	318	PAINT, FINAL, DECAL *C/P MOVE		001 MNRGP 002 09 003 WBO3	
	320	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS Y58 *REQ*		001 MNRGP 002 09 003 WBO3	
	330	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQ*		001 MNRGP 002 09 003 WBO3	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980-287-10

36006N WORK CONTROL DOCUMENT (MDS)

8904

PAGE 1 OF 1 PAGE

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	

APEX PIN - JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		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	68A410764-2001			
		DISASSEMBLE *C/P MOVE		001 MNRGW	
	*REQD)			002 02	
				003 LG02	
		DEGREASE ONLY *C/P MOVE		005 X8745199	
	REQD			001 MNRGW	
				002 02	
				003 DG02	
		BLAST CLEAN ONLY *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	
				003 BK03	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
	REQD			001 MNRNA	
				002 05	
				003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/ON
DISPATCH	FUNCTIONAL CODE	A	C	36006N

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U.S. GOVERNMENT PRINTING OFFICE: 1980-000-289

WORK CONTROL DOCUMENT (MEDS)

36006N

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. NOUN APEX PIN - JURY LINK						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECT					001 MNRGW		
	REQD	PIN OD .6860/.6870/.6840					002 04		
26	025	VAPOR DEGREASE		*C/P MOVE			001 MNRRC		
26	030	STRIP CAD		*C/P MOVE			002 03		
26	035	STRIP RUST		*C/P MOVE			003 IG01		
26	040	STRIP CHROME FROM PIN		*C/P MOVE			001 MNRRC		
8	050	FIRST GRIND PIN OD .6860		*C/P MOVE			002 02		
				*C/P MOVE		M	003 SC02		
		TIME OUT _____		DATE OUT _____			001 MNRFB		
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
26B	070	BAKE 4 HRS WITHIN 4 HRS OF ETCH					002 01		
		DATE IN _____		TIME IN _____			003 BK01		
		DATE OUT _____		TIME OUT _____					
		*C/P MOVE							

* U.S. GOVERNMENT PRINTING OFFICE: 1967-50-70

31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36006N	
		B	D		

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36006N

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	

APEX PIN - JURY LINK

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****	M	001 MNRNA 002 06 003 MLO4	
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26 ✓	085	VAPOR DEGREASE *C/P MOVE		001 MNRFC 002 03 003 DGO1	
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26 ✓	090	SHOT PEEN PIN OD .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNRFC 002 01 003 SP02	
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26 ✓	093	PREPARE FOR CHROME PLATE OF PIN O.D. FIXTURE/MASK/ETC IAW MIL-STD-1501		001 MNRFC 002 02 003 BE01	
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		*MECHANIC SIGNOFF REQUIRED----- *C/P MOVE			
--	--	--	--	--	--

26 ✓	097	PREPARE PIN O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNRFC 002 01 003 BLO4	
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26 ✓	100	CHROME PLATE PIN O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO .687.		001 MNRFC 002 02 003 CP01	
------	-----	---	--	---------------------------------	--

		TIME OUT _____ DATE OUT _____ *MECHANIC SIGNOFF REQUIRED----- *C/P MOVE		008 CDO10	
--	--	---	--	-----------	--

26B ✓	110	BAKE 4 HRS WITHIN IN 4 HRS OF CHROME DATE IN _____ TIME IN _____		001 MNRFC 002 02 003 BK01	
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31. FINAL DESTINATION		32. COORDINATION/INITIATING RCC SIGNATURE/DATE		33. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36006N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1980-540-103

36006N

WORK CONTROL DOCUMENT (MEDS)

DATE 89041

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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 APEX PIN - JURY LINK
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT _____ TIME OUT _____			

8 ✓	120	*C/P MOVE FINISH GRIND PIN OD .6860/.6870 *C/P MOVE		001 MNFRB 002 01 003 GEOO	
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26B ✓	130	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNFRC 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

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

26 ✓	145	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DGO1	
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		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MNFNA 002 06 003 ZS01	
--	--	--	---	---------------------------------	--

26 ✓	155	PRIOR TO CAD/IVD, GRIT BLAST ALL AREASE TO BE CAD/IVD PLATED *C/P MOVE		001 MNFRC 002 01 003 BLO4	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/ON	
DISPATCH	FUNCTIONAL CODE	A	B	36003N	

U.S. GOVERNMENT PRINTING OFFICE: 1980-50-50-10

36006N

WORK CONTROL DOCUMENT (MEDS)

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
13. SERIAL NUMBER	14. NOUN	
APEX PIN - JURY LINK		

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	160	CAD PLATE TYPE II CLASS II .03 SQ FT AT 1.5 - 2:1 AMPS *C/P MOVE		001 MNFRC 002 03 003 CAD1	
26B ✓	170	TIME OUT _____ DATE OUT _____ BAKE 23 HRS WITHIN 4 HRS OF CAD 3.4 SQ FT AT 170-238 AMPS DATE IN _____ TIME IN _____		001 MNFRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26 ✓	175	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNFRC 002 02 003 IR01	
		*C/P MOVE		001 MNFNA 002 06 003 MLO4	
		***** NOTE ***** *REQD* IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M		
26 ✓	185	VAC. I.V.D. ALUM. PLATE CLASS 2 TYPE II NOTE: OPERATION--170 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MNFRC 002 03 003 IV01	
26 ✓	190	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNFRC 002 03 003 TA01	
	200	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNFGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	B	36006N
		C	D	

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36007N WORK CONTROL DOCUMENT (MEDS)

DATE 89041

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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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN TRUNNION PIN	26338A
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18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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P/N 68A4107	35-2001	NEN C/N 26338A L / H 26337A R / H			
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***** UNIT COST: \$344.76 *****

GOVERNING DIRECTIVES: AFLDR 66-51
MANDI 6-3

ALG57 IAW MIL-STD-1514

FMPI IAW MIL-STD-1949
P/O N01561

STRIP IAW MIL-STD-871

GRIND IAW MIL-STD-844

TEMPER ETCH IAW MIL-STD-857

SHOT PEEN IAW MIL-S-13125

STEEL ABOVE 240,000 PSI

CAD IAW MIL-STD-870

CHROME PLATE IAW MIL-STD-1571

P/O N61891

BAKE IAW 4S-1-182

MARI 74-17

IVD ALUM PLATE IAW MIL-C-83428A

ALODINE IAW MIL-C-5541

HEAT TREAT 290,000/300,000 PSI

***** STEEL 300P *****

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PROCEDURES AND PRACTICES AND SPECIAL INSTRUCTIONS IN THE BASIC ELEMENTAL 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
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N

* U.S. GOVERNMENT PRINTING OFFICE: 1980-340-700

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 PIN
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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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		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFETY ARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			

	001	68A410785-2001			
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		DISASSEMBLE *C/P MOVE		001 MNFGW	
	REQD			002 02	
				003 LE02	
				005 X8745199	

		DEGREASE ONLY *C/P MOVE		001 MNFGW	
	REQD			002 02	
				003 IG02	

		BLAST CLEAN ONLY *C/P MOVE		001 MNFGW	
	REQD			002 03	
				003 EL07	

		BASE 4 H&S AT 100-400F		001 MNFGW	
	REQD	DATE IN _____ TIME IN _____		002 03	
				003 BK03	

		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			

		*C/P MOVE		001 MNFGW	
	REQD			002 03	
				003 NS02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN	
DISPATCH	FUNCTIONAL CODE	A	C	36007N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1980-549-101

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						
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E & I INSPECTION					001 MNRGW		
	REQD	LARGE O.D. 2.0940/2.0955/2.0900 MIN					002 04		
		SMALL O.D. 1.4978/1.4988 /1.4950 MIN					003 EI01		
		CROSS PIN HOLE .350/.385 /1.5-5 (MAX)							
		NOTE: IF NO FURTHER REMOVING IS REQUIRED AN ADDITIONAL FMP1 MUST BE PERFORMED.							
		*C/P MOVE							
26 ✓	030	POLISH CROSS PIN HOLE .395 MAX					001 MNRRA		
		*C/P MOVE					002 03		
							003 BE01		
26 ✓	034	VAPOR DEGREASE				*C/P MOVE	001 MNRRC		
							002 03		
							003 BE01		
26 ✓	036	STRIP OAD				*C/P MOVE	001 MNRRC		
							002 02		
							003 CS01		
26 ✓	038	STRIP RUST				*C/P MOVE	001 MNRRC		
							002 02		
							003 BE01		
26 ✓	040	STRIP CHROME FROM LABEL CL				*C/P MOVE	001 MNRRC		
							002 02		
							003 SC02		
26 ✓	050	STRIP CHROME FROM SMALL OD				*C/P MOVE	001 MNRRC		
							002 02		
							003 SC02		
		[REDACTED] 0770					001 MNRKB		
		*C/P MOVE					002 02		
							003 GE02		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36007N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1989-048-12

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 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"
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8	070	FIRST GRIND SMALL O.D. TO .0005 *C/P MOVE		001 MNHRC 002 02 003 GE02	
---	-----	--	--	---------------------------------	--

		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNHNA 002 06 003 TE03	
--	--	--	---	---------------------------------	--

		***** NOTE ***** IF LAST NDI OPERAITON IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
--	--	--	--	--	--

26B	090	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____		001 MNHRC 002 02 003 BK01	
-----	-----	--	--	---------------------------------	--

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

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERAITON IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNHNA 002 06 003 ML04	
--	--	---	---	---------------------------------	--

25	105	VAPOR DEGREASE TO/IN MOVE		001 MNHRC 002 03 003 DG01	
----	-----	---------------------------	--	---------------------------------	--

26	110	SHOT PEEN REMORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNHRC 002 01 003 SP02	
----	-----	---	--	---------------------------------	--

26	113	PREPARE O.D. FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC (CONTINUED)		001 MNHRC 002 02 003 BE01	
----	-----	---	--	---------------------------------	--

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
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DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-540-100

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"
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		MECHANIC SIGN OFF REQUIRED *C/P MOVE			
--	--	---	--	--	--

26 ✓	117	PREPARE O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BLO4	
------	-----	--	--	---------------------------------	--

26 ✓	120	CHROME PLATE LARGE O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 2.0955		001 MNPRC 002 02 003 CPO1 008 CDO10	
------	-----	--	--	--	--

		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE			
--	--	--	--	--	--

26 - ✓	130	CHROME PLATE SMALL O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 1.4908		001 MNPRC 002 02 003 CPO1 004 CDO20	
--------	-----	--	--	--	--

		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE			
--	--	--	--	--	--

26B ✓	135	BARE 4 HRS AT 350 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			
--	--	--	--	--	--

B ✓	150	FINISH BRIND LARGE O.D. 2.0940/2.0955 OD *C/P MOVE		001 MNPRC 002 02 003 GE02	
-----	-----	---	--	---------------------------------	--

B ✓	150	FINISH BRIND SMALL O.D. 1.4978/1.4988 O.D. (CONTINUED)		001 MNPRC 002 02 003 GE02	
-----	-----	---	--	---------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36007N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1989-568-70

36007N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041

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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 IRUNNION PIN
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18. 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			
--	--	------------	--	--	--

26B ✓	170	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *CP MOVE			
--	--	---	--	--	--

		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPRC 002 06 003 MLO4	
--	--	--	---	---------------------------------	--

		HERE, TAKE PRODUCTION COUNT. * *****			
--	--	---	--	--	--

26 ✓	185	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 BGO1	
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		[REDACTED] PRODUCTION COUNT AN070 *C/P MOVE ***** NOTE *****	M	001 MNPRC 002 06 003 ZSO1	
--	--	---	---	---------------------------------	--

		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****			
--	--	--	--	--	--

26 ✓	191	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BLO4	
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26 ✓	192	CAD PLATE TYPE II CLASS II .115 SQ FT AT 5.75 - 8. AMPS *C/P MOVE		001 MNPRC 002 03 003 CAD1	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36007N	

U.S. GOVERNMENT PRINTING OFFICE: 1989-0-60-100

36007N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

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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	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26D ✓	196	BAKE 28 HRS WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
26 ✓	197	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNPRC 002 02 003 IR01	
	065	*C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 MNFNA 002 06 003 MLO4	
26 ✓	201	VAL IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 196 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVO1	
26 ✓	203	ALODINE IVD ALUM PLATE CLASS 2A *C/P MOVE		001 MNPRC 002 03 003 IAO1	
	205	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*		001 MNPRGP 002 04 003 SA03	
	210	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPRGP 002 06 003 SA03	

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
SIGNATURE: FUNCTIONAL CODE	A	C

36008N WORK CONTROL DOCUMENT (MEDS)

DATE B9041

PAGE 1 OF 1 PAGES

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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN LOWER DRAG BRACE	26738A
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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 68A4107	92-1001	NSN 51620003654004 26338A L / H 26337A R / H			
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***** UNIT COST: \$1710.59 *****

GOVERNING DIRECTIVES: AFLER 66-51
MANOI 66-3

PLANT IAW MIL-STD-1504

FNPI IAW MIL-STD-1949

P/O NO1561

RIVET IAW 1F-15A-3

CAD IAW MIL-810-970

VAD CAD IAW MIL-C-8837

BAKE IAW 4S-1-182

IAW MAOI 74-12

ALUMINE IAW MIL-C-5541

100 ALUM PLATE IAW MIL-C-82488A

HEAT TREAT 200,000/300,000 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

WILL ALWAYS BE HELD IN CONJUNCTION WITH THE

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

WARNING

MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS (CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36008N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-340-10

36008N WORK CONTROL DOCUMENT (MDS)

DATE 704

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/ACC		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 DRAG BRACE						
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 (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	68A410792-1001							
		DISASSEMBLE *C/P MOVE						001 MNFGW 002 02 003 LG02 005 XE745199	
	REQD								
		CHEM CLEAN *C/P MOVE						001 MNFGW 002 03 003 BLD1	
	REQD								
		LAST CLEAN ONLY *C/P MOVE						001 MNFGW 002 03 003 BLD1	
	REQD								
		SPECIAL 4 HRS 100% COMPLIANCE REQUIRED						001 MNFGW 002 03 003 BK03	
	REQD	DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
								001 MNFGW 002 05 003 MS03	
	REQD					M			
		E AND I INSPECT BUSHING (7) ID 1.4380/1.439 WEAR 1.441						001 MNFGW 002 04 003 EIC1	
	REQD								

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36008N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1969-568-102

3600BN WORK CONTROL DOCUMENT (MDS)

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 LOWER DRAG BRACE	

18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BASE METAL 1.500/1.5015 AFTER PLATE FLANGE .0393/.0403/.032 BUSHING (6) ID 1.373/1.376/1.378 BASE METAL 1.531/1.5325 AFTER PLATE			
		FLANGE .039/.040/.032 BUSHING (8) ID 1.4380/1.439/1.441 BUSHING BASE METAL 1.562/1.5625 AFTER PLATE			
		BUSHING 6&7 INSIDE FACE .9577/.9497/ .9354 OUTSIDE DEMENTION OVERALL OF BUSHING 6&7 3.2580/3.2708/3.2464 6&7 3.2580/3.2464 WITH BUSHING			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE			
26 ✓	030	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DGO	
26 ✓	035	STRIP CAN *C/P MOVE		001 MNPRC 002 02 003 CS01	
26 ✓	037	STRIP RCT *C/P MOVE		001 MNPRC 002 02 003 CS02	
26 ✓	040	LOCK SLEEVE REPLACE IN CRACK EXCESSIVE WEAR FROM CONTACT STRUT CYL. SLOT EXIST ? DRILL OUT RIVET USING 5/32 DRILL DO NOT DRILL INTO BASE METAL ARBER PRESS DRAG BRACE FINGER OUT OF LOCK SLEEVE		001 MNPRC 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	3600BN
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-00-10

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 DRAG BRACE						
18. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26 ✓		INDEX 51 FIG 1-3 INDEX 53 FIG 1-3 *C/P MOVE						001 MNFRA 002 03 003 MVO1	
26 ✓		INDEX 55 FIG 1-3 INDEX 55 FIG 1-3 *C/P MOVE						001 MNFRA 002 03 003 MVO1	
26 ✓	046	O/S CYL ATTACH BOSS 1.6271 MAX 7829424 INDEX 57 FIG 1-3 *C/P MOVE						001 MNFRA 002 03 003 MVO1	
26 ✓	050	VPAOR DECREASE *C/P MOVE						001 MNFRC 002 03 003 DSO1	
26 ✓	055	PRIOR TO CAD/IVD, ORT. BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE						001 MNFRC 002 01 003 BLO2	
26 ✓	060	CAD PLATE TYPE II CLASS II 11.26 SQ FT AT 560 - 795.2 AMPS TIME OUT DATE OUT *C/P MOVE						001 MNFRC 002 03 003 CA01	
26B ✓	070	BAKE 25 MBS WITHIN 4 MBS OF CAD DATE IN ----- TIME IN----- DATE OUT ----- TIME OUT----- *C/P MOVE						001 MNFRC 002 02 003 BK01	
26 ✓	080	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE						001 MNFRC 002 02 003 IRC1	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		36008N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1968-0-340-242

3600BN WORD CONTROL DOCUMENT (MIL)

PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SECAGE	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 DRAG BRACE
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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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26 ✓	090	VAC CAD PLATE IF BUSHING OR SLEEVE HAVE NOT BEEN REMOVED *C/P MOVE		001 MNHRC 002 02 003 VC01	
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26 ✓	092	HOT WATER RINSE AFTER VAC CAD *C/P MOVE		001 MNHRC 002 02 003 IRC1	
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26 ✓	094	VAC. I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION --070 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MNHRC 002 03 003 IV01	
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26 ✓	096	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNHRC 002 03 003 TA01	
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26 ✓	065	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****	M	001 MNHNA 002 06 003 ML04	
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69 ✓	100	MACHINE NEW LOCK SLEEVE *C/P MOVE P/N 68A410689-2001		001 MNHRA 002 03 003 MV01	
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69 ✓	101	INSTALL NEW LOCK SLEEVE 68A410689-2001 USING HEAT SHRINK METHOD *C/P MOVE		001 MNHRA 002 03 003 BE01	
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69 ✓	102	INSTALL RIVET T/D 4A4-22-3 FIG 5-1. RIVET HEAD SHOULD BE LOCATED OPPOSITE SIDE OF (CONTINUED)		001 MNHSA 002 08 003 HB01	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	3600BN	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1980-040-20

36008N WORK CONTROL DOCUMENT (MEDS)

DATE 89041

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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 DRAG BRACE						
18. DISPATCH STATION	16. PERFORM NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		FINGER ENGAGEMENT. *C/P MOVE P/N NAS1199-5-20							
69 ✓	108	MACHINE SLEEVE AS PER TO 4A4-22-3 FIG 5-1 *C/P MOVE						001 MNR RA	
69 ✓	109	MACHINE APEX #8 INBOARD BUSHING *C/P MOVE P/N ST4M130-22004						001 MNR RA	
69 ✓	110	INSTALL APEX INBOARD BUSHING (8) P/N ST4M130-22004 I.D. 1.438/1.439 *C/P MOVE						001 MNR RA	
69 ✓	114	MACHINE O/S APEX INBOARD BOSS *C/P MOVE P/N 7828424-53						001 MNR RA	
69 ✓	115	INSTALL O/S APEX INBOARD BOSS 1.375/1.575 P/N 7828424-53 INBOARD - OUTBOARD FACE TO FACE: 3.298/3.270S/3.2464 FLANGE .0397/.0407/.032 *C/P MOVE						001 MNR RA	
69 ✓	119	MACHINE APEX OUTBOARD BUSH #7 *C/P MOVE P/N ST4M130-22005						001 MNR RA	
69 ✓	120	INSTALL APEX OUTBOARD BUSHING (7) P/N ST4M130-22005 I.D. 1.4380/1.4390 *C/P MOVE						001 MNR RA	
69 ✓	124	MACHINE O/S OUTBOARD APEX BOSS *C/P MOVE P/N 7829424-55						001 MNR RA	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36008N	
		B	D		

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U.S. GOVERNMENT PRINTING OFFICE: 1980-540-102

WORK CONTROL DOCUMENT (MEDS)

DATE 89041

PAGE 07 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 LOWER DRAG BRACE
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69 ✓	125	INSTALL O/S OUTBOARD APEX BOSS, 1.438/1.439 P/N 7829424-55 FLANGE .039/.040/.032 *C/P MOVE		001 MNR RA 002 03 003 BE01	
69 ✓	129	MACHINE CYL LUG BUSHING #3 *C/P MOVE P/N ST4M130-22003		001 MNR RA 002 03 003 LE02	
69 ✓	130	INSTALL CYLINDER LUG BUSHING (6) P/N ST4M130-22003 ID 1.375/1.376 *C/P MOVE		001 MNR RA 002 03 003 BE01	
69 ✓	134	MACHINE O/S CYL ATTACH BOSS *C/P MOVE P/N 7829424-57		001 MNR RA 002 03 003 LE02	
69 ✓	135	INSTALL O/S CYL ATTACH BOSS 1.438/1.439 P/N 7829424-57 FLANGE .0393/.0403/.032 CURSIDE FACE TO FACE 1.9056/1.8132/1.7912 *C/P MOVE		001 MNR RA 002 03 003 BE01	
	140	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL RECORDING OPERATIONS THIS YEAR		001 MNR RA 002 06 003 1303	
	150	FINAL PROJECT VISION EXPRESSION *REQD*		001 MNR RA 002 06 003 SA03	

U.S. GOVERNMENT PRINTING OFFICE: 1988-00-10

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36008N
		B	D	

WORK CONTROL DOCUMENT (MEDS)

PAGE 07 OF 08

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA 4A4-22-3 4S-1-182		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN JURY LINK PIN	

15. DISPATCH STATION P/N	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED NEW EXN	18. MECHANIC	19. "P"	20. "Q"
68A4107	56-1001	1620003386530 26335A L / H 26337A R / H			
		GOVERNING DIRECTIVES BLAST FPI STRIP GRIND TEMPER ETCH SHOT PEEN FPI CHROME PLATE VAC CAD PLATE CAD PLATE BAKE IVD ALUM PLATE ALODINE **** STEEL ROOM 280/280 1 11 **** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERSONNEL SAFETY PRACTICES AND PROCEDURES. THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN 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/BN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

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U.S. GOVERNMENT PRINTING OFFICE: 1980-000-100

36009N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 8904

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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 JURY LINK PIN
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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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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 224410753-1001

[REDACTED]

DISASSEMBLE *C/P MOVE

001 MNSW
002 02
003 LE02
005 X8745199

REQD

[REDACTED]

DECREASE ONLY *C/P MOVE

001 MNSW
002 02
003 0602

REQD

[REDACTED]

BLAST CLEAN ONLY *C/P MOVE

001 MNSW
002 03
003 BLC7

REQD

[REDACTED]

DATE IN _____ TIME IN _____

001 MNSW
002 03
003 BK02

REQD

DATE OUT _____ TIME OUT _____

*C/P MOVE

[REDACTED]

*C/P MOVE

001 MNSW
002 05
003 MS03

REQD

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-540-100

36009N

WORK CONTROL DOCUMENT (MEDS)

DATE 9041

PAGE 1 OF 1 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 JURY LINK PIN
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15. DISPATCH STATION	16. PERFORM RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MNR OR "Q"	20. "Q"
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		REQD PIN OD SMALL END .9980/.9990/.9960		001 MNR OR 002 04 003 EIC1	
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		LARDE G.D. 1.874/1.8725 CROSS BOLT HOLE .252/.254/.254 MAX. NCTS: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FINI MUST BE PERFORMED. *C/P MOVE			
--	--	---	--	--	--

✓	001	WATER RESISTANCE	*C/P MOVE	001 MNR OR 002 03 003 DG01	
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✓	002	STRIP CAB	*C/P MOVE	001 MNR OR 002 02 003 CS01	
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✓	002	STRIP CAB	*C/P MOVE	001 MNR OR 002 02 003 CS02	
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✓	000	MACHINE CROSS BOLT HOLE .244	*C/P MOVE	001 MNR OR 002 03 003 SC01	
---	-----	---------------------------------	-----------	----------------------------------	--

✓	002	STRIP CAB	*C/P MOVE	001 MNR OR 002 02 003 SC02	
---	-----	-----------	-----------	----------------------------------	--

		FIRST BRIND PIN SMALL G.D. MIN .8725	*C/P MOVE	001 MNR OR 002 01 003 GE00	
--	--	--------------------------------------	-----------	----------------------------------	--

		SA 2161A (EXCHANGE) 1.2475 MIN	*C/P MOVE	001 MNR OR 002 01 003 GE00	
--	--	--------------------------------	-----------	----------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-040-282

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 JURY LINK PIN
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15. DISPATCH STATION	16. PERFORM RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" INITIALS	20. "Q" INITIALS
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		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	002 06 003 TEC3	
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		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *			
--	--	---	--	--	--

005	070	PREPARE FOR DISPATCH WITHIN 2 HRS OF ETCH DATE IN _____ TIME IN _____		002 02 003 BK01	
-----	-----	---	--	--------------------	--

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

		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *	M	002 06 003 MLO4	
--	--	---	---	--------------------	--

--	--	--	--	--	--

006	066	PREPARE FOR DISPATCH WITHIN 2 HRS OF ETCH DATE IN _____ TIME IN _____		002 03 003 BK01	
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007	070	PREPARE FOR DISPATCH WITHIN 2 HRS OF ETCH DATE IN _____ TIME IN _____		002 01 003 SP02	
-----	-----	---	--	--------------------	--

008	070	PREPARE FOR CHROME PLATE OF PIN O.D. FIGURE/MASK/ETC. *MECHANIC SIGNOFF REQUIRED		001 MNRC 002 02 003 BE01	
-----	-----	--	--	--------------------------------	--

009	077	PREPARE PIN S.D. FOR CHROME PLATE GRIT BLAST		001 MNRC 002 01 003 BLO4	
-----	-----	---	--	--------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-08-10

WORK CONTROL DOCUMENT (MEDS)

11 DATE 89041

PAGE 1 OF 1 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 JURY LINK PIN
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
20	100	GRIND PLATE LARGE O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO .9990. TIME OUT _____ DATE OUT _____		001 MNPRC "O" 002 02 003 CP01 008 C0010	
		*MECHANIC SIGNOFF REQUIRED *C/P MOVE			
20	100	GRIND PLATE LARGE O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 1.374. TIME OUT _____ DATE OUT _____		001 MNPRC 002 02 003 CP01 008 C0020	
		*MECHANIC SIGNOFF REQUIRED *C/P MOVE			
20	110	BAKE 20HR2 WITHIN 4 HRS OF CHROME OF CHROME DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
20	120	FINISH GRIND PIN .9950/.9990 *C/P MOVE		001 MNPRC 002 01 003 9500	
20	125	FINISH GRIND LARGE O.D. TYPE II *C/P MOVE		001 MNPRC 002 01 003 9500	
20	130	BAKE 4 HR2 AT 200-400F 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/IN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-540-70

WORK CONTROL DOCUMENT (MDS)

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 JURY LINK PIN	

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26	175	CHROMATE CONVERSION FOR TYPE II CAD AND TYPE II VAC CAD *C/P MOVE		001 MNR RC 002 02 003 IR01	
		*C/P MOVE		001 MNR CA	
	.65	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 MLC4	
27	187	VAC. 1 *D. ALIN. PLATE CLASS 2 TYPE II NOTE: OPERATION --170 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE MOVE DURING I.V.B. OPTION. *C/P MOVE		001 MNR RC 002 03 003 IV01	
28	187	ALIN. 1 *D. ALIN. PLATE CLASS 1A *C/P MOVE		001 MNR RC 002 03 003 TA01	
	170	FINAL INSPECTION OF WORK CONTROL DOCUMENT FOR COMPLETION & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNR RC 002 06 003 SA03	
	200	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNR RC 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-04-10

WORK CONTROL DOCUMENT (HEAD)

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 LOWER JURY LINK						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "Q"
		REWORK (CONVERTER REWORK) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	SMA-10775-1003							
	[REDACTED]	DISASSEMBLE							001 MNRGW
	REQD								002 G2
	[REDACTED]	CHECK CLEAN							003 L602
	REQD								005 Y3745199
	[REDACTED]	NEARLY CLEAN ONLY							001 MNRGW
	REQD								002 03
	[REDACTED]								003 AC32
	[REDACTED]								001 MNRGW
	REQD						M		002 03
	[REDACTED]	INSPECT							003 ZY05
	REQD								001 MNRGW
	[REDACTED]	FLANGED BUSHING 10 .6875/.6825/.6910							002 04
	[REDACTED]	SERIES ATTACH HOLES .312/.292 .537max							003 E101
	[REDACTED]	SERIES BUSHING 1.0							
	[REDACTED]	1.3750/1.3760/1.3780							
	[REDACTED]	NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FPI MUST BE PERFORMED.							
	[REDACTED]								*C/P MOVE
26	000	STRIP ANODIZE							001 MNRGW
		*C/P MOVE							002 03
									003 AN04

* U.S. GOVERNMENT PRINTING OFFICE: 1969-0-340-70

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36010N	
		B	D		

36010N WORK CONTROL DOCUMENT (MDS)

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 JURY LINK						
18. DISPATCH STATION	16. PERP RCC/OP	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19.	20.
		* * * * * N O T E * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *						001 MNENA "Q"	
								002 06	
								003 ZA02	
57 ✓	042	POLISH SPRING ATTACH HOLE .927 MAX. *C/P MOVE*						001 MNENA	
								002 03	
								003 BE01	
57 ✓	044	O/S APEX LUG BOSS MAX I.D. .0765 *C/P MOVE						001 MNENA	
								002 03	
								003 BE02	
57 ✓	046	O/S GROUND LUG BOSS MAX I.D. .5800 *C/P MOVE						001 MNENA	
								002 03	
								003 BE01	
57 ✓	048	O/S BRAG BRACE LUG BOSS MAX I.D. 1.5315 *C/P MOVE						001 MNENA	
								002 03	
								003 BE01	
57 ✓	050	ANGLE II TYPE II CLASS I *C/P MOVE						001 MNENA	
								002 03	
								003 AS03	
57 ✓	051	MACHINE STL APEX FLANGED BUSH P/N 874190-10000 *C/P MOVE						002 03	
								002 LE02	
57 ✓	060	MACHINE STL APEX FLANGED BUSH P/N 874190-10000 *C/P MOVE						001 MNENA	
								002 03	
								003 BE01	
57 ✓	061	MACHINE STL APEX FLANGED BUSH P/N 7829424-51 *C/P MOVE						001 MNENA	
								002 03	
								003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	36010N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1980-040-280

36010 WORK CONTROL DOCUMENT (METS)

DATE

DATE COMPLETED

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 JURY LINK
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" "Q"	20.
07	065	INSTALL 0/5 APEX FLANGE BUSH P/N 7829424-51 I.D. .76875/.6885 FACE TO FACE .9644/.9714/.986 FLANGE .0393/.0403/.032 FIT AT .0003/.0015 *C/P MOVE		001 MNERA 002 OS 003 BE01	
07	067	INSTALL STD DRAG BRACE BOSS BUSH *C/P MOVE P/N 68A410778-2001		001 MNERA 002 OS 003 BE01	
07	070	HONE STD DRAG BRACE BOSS BUSH P/N 68A410778-2001 ID 1.3750/1.3760 *C/P MOVE		001 MNERA 002 OS 003 MFG	
07	072	MACH 0/5 DRAG BRACE BUSHINGS *C/P MOVE P/N 7829419-01		001 MNERA 002 OS 003 LE02	
07	075	INSTALL 0/5 DRAG BRACE BUSH P/N 68A410778-2001 *C/P MOVE		001 MNERA 002 OS 003 BE00	
07	077	HONE 0/5 DRAG BRACE BOSS BUSH P/N 7829419-01 I.D. 1.3750/1.3760 FIT AT .001/.003 *C/P MOVE		001 MNERA 002 OS 003 BE01	
07	078	INSTALL 0/5 DRAG BRACE BOSS BUSH P/N 7829423-27 I.D. .520/.5215 FIT AT .0005/.001 *C/P MOVE		001 MNERA 002 OS 003 LE02	
	080	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS, ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNERA 002 OS 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36010N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1969-00-10

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNPGB	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN UPPER JURY LINK	26337A
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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6BA410	94-1006	/H 1620010403580 26337A R / H			
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~~6BA410 94-1006~~

COVERING LINES: AFSC 66 51
MANGI 66-3
BLAST IAW MIL-STD-1504
F... IAW MIL-SIC-154V

STRIP IAW MIL-STD-971
GRIND IAW MIL-STD-866
TEMPER ETCH IAW MIL-STD-867

SMI FEEN IAW MIL-S 15165
FPI IAW MIL-STD-6866
CAD IAW MIL-STD-870
UAC CAD IAW MIL-C-8837

GRIND PLATE IAW MIL-SIC-1501
P/Q No 1891
BAKE IAW 4S-1-182
MAGI 74-12

VAL 171 ALUM PLATE IAW MIL-S 83400
ALODINE IAW MIL-C-5541
*****STEEL 300*****
*****UNIT COST \$2927.07*****

OPERATORS 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. THESE 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
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980-285-70

3601IN

WORK CONTROL DOCUMENT (MEDS)

DATE 89041

PAGE 01 OF 01 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 UPPER JURY LINK
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
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PARTY OF THE FOLLOWING RETAIN 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 6SA410774-1005
6SA410774-1006

[REDACTED]

[REDACTED] *C/P MOVE

REQD

001 MNRSM
002 02
003 L802
005 X8745199

[REDACTED]

[REDACTED] *C/P MOVE

REQD

001 MNRSM
002 03
003 SL01

[REDACTED]

[REDACTED] *C/P MOVE

REQD

001 MNRSM
002 03
003 SL01

[REDACTED]

[REDACTED] *C/P MOVE

REQD

DATE IN _____ TIME IN _____

001 MNRSM
002 03
003 BK03

DATE OUT _____ TIME OUT _____

*C/P MOVE

[REDACTED]

[REDACTED] *C/P MOVE

REQD

M

001 MNRSM
002 05
003 MSC3

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	3601IN
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1985-505-20

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 JURY LINK

15. DISPATCH	16. PERFORM RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" "Q"	20.
		E AND I INSPECT		001 M... 002 04 003 EIC1	
	REQD	SPRING ATTACH HOLE .312/.3195 .327 MAX			
		LINK OD 1.248/1.247/1.245			
		BEARING ID .7495/.7500/.7520			
		CYL RPLX SOCKET ID 1.075/1.076/1.070			
		FLANGED BUSHING ID .6895/.6885/.6910			
		CRANE BOSS SLOT .600 .600 MAX			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
67	021	REMOVE PIN FROM JURY LINK *C/P MOVE*		001 MNERA 002 03 003 BE01	
67	022	REMOVE BUSHINGS *C/P MOVE		001 MNERA 002 03 003 BE01	
67	023	POLISH ATTACH HOLE .327 MAX. *C/P MOVE*		001 MNERA 002 03 003 BE01	
67	025	B/O CYL SOCKET *C/P MOVE		001 MNERA 002 03 003 LE02 005 X8433614	
67		USING CARE NOT TO CUT INTO METAL. PRESS BEARING OUT IAW. (CONTINUED)		001 MNERA 002 03 003 MV00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1988-00-10

WORK CONTROL DOCUMENT (MEDS)

1 DATE 9041

PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE ORDERED	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 JURY LINK	

15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		WORK TO BE ACCOMPLISHED *C/P MOVE			
✓	033	075 BPEX BOSS ID 1.0760 *C/P MOVE		001 MNDRA 002 03 003 BE01	
✓	038	REWORK GROUND BOSS SLOT 1.19 MAXI *C/P MOVE*		001 MNDRA 002 03 003 BE01	
✓	040	VAPER DECREASE *C/P MOVE		001 MNDRA 002 02 003 BE01	
✓	042	STRIP CAL *C/P MOVE		001 MNDRA 002 02 003 CS01	
✓	043	STRIP RUB *C/P MOVE		001 MNDRA 002 02 003 CS02	
✓	045	STRIP CHANGE FROM LINK 20 *C/P MOVE		001 MNDRA 002 02 003 BE02	
✓	050	FIRST GRIND LINK 20 MIN OD 1.2280 *C/P MOVE		001 MNDRA 002 02 003 BE04	
		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNDRA 002 06 003 TE03	
<p>***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *</p>					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	C	3601IN
		B	D	

224

WORK CONTROL DOCUMENT (MEDS)

1. DATE

2. TIME

7. JOB ORDER NO	8. QUANTITY	4. PRODUCTION SECT/RS	5. DATE DESIG	6. DATE REWORK
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9. PART NUMBER	10. TECH DATA	11. ITEM SERIAL NO.
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12. MODEL DESIGN SERIES	13. STOCK NUMBER	14. OPTIONAL
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15. SERIAL NUMBER	16. NOUN UPPER JURY LINK
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17. DISPATCH STATION	18. PERM REC/OP NO	19. WORK TO BE ACCOMPLISHED	20. MECHANIC	21. "A"	22. "B"
✓	070	MAKE 4 HRS WITHIN 6 HRS OF ETEL DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNRRC 002 02 003 BK01	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****	M	001 MNRNA 002 06 003 MLO4	
✓	085	VAPER DECREASE *C/P MOVE		001 MNRRC 002 03 003 DG01	
✓	076	SHOT WREN LINK 3D .008/.012 52 100% COVERAGE *L/P MOVE		001 MNRRC 002 01 003 SPO2	
✓	075	PREPARE LINK 88 FOR CHROME PLATE TYPE 1 CLASS 3. MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 MNRRC 002 02 003 BE01	
✓	077	PREPARE LINK 88 FOR CHROME PLATE, GRIT BLAST. *C/P MOVE		001 MNRRC 002 01 003 BLO4	

23. FINAL DESTINATION DISPATCH	24. COORDINATION/INITIATING REC SIGNATURE/DATE FUNCTIONAL CODE	25. DOCUMENT/IN 3601IN
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25

WORK CONTROL DOCUMENT (MDS)

DATE 90-41

PAGE 07 OF 08 PAGES

1. JOB ORDER NO	2. QUANTITY	3. PRODUCTION REQUIRED	4. DATE ORDERED	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. SYCCR NUMBER	11. OPTIONAL
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12. SERIAL NUMBER	13. NOUN UPPER JURY LINK
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14. DISPATCH STATION	15. PERF RCC/OP NO	16. WORK TO BE ACCOMPLISHED	17. MECHANIC	18. DISPATCH NO	19. DATE
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✓	100	CHARGE PLAIN LINK CLASS III SUFFICIENT TO GRIND BACK TO 1.249		002 02 003 CP01 008 C0010	
---	-----	--	--	---------------------------------	--

		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE			
--	--	--	--	--	--

✓	110	TAKE 4 HRS WITHIN 4 HRS OF CURVE		001 MNRFC 002 02 003 BK01	
---	-----	----------------------------------	--	---------------------------------	--

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

✓	120	FINISH GRIND LINK BB 1.248/1.249 *C/P MOVE		001 MNRFC 002 02 003 GE04	
---	-----	--	--	---------------------------------	--

✓	130	TAKE 4 HRS AT 350-400F		001 MNRFC 002 02 003 BK01	
---	-----	------------------------	--	---------------------------------	--

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

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

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****		001 MNRFC 002 06 003 ML04	
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✓	145	VAPOR DECREASE *C/P MOVE		001 MNRFC 002 03 003 BK01	
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		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____			
--	--	--	--	--	--

20. FINAL DESTINATION		21. COORDINATION/INITIATING RCC SIGNATURE/DATE		22. DOCUMENT#
DISPATCH	FUNCTIONAL CODE	A	C	36011N

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WORK CONTROL DOCUMENT (MDS)

PAGE 1 OF 1

1. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCE	5. DATE SERIES	6. DATE EMPLOYED
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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. NSUN UPPER JURY LINK
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15. DISPATCH	16. PERF. ACC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. MND/NA	20. "G"
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MND/NA 002 06 003 ZS01	
✓	150	✓ PRIOR TO CAB/VAC CAD/IVD, GRIT BLAS ALL AREAS TO BE CAD/VAC CAD/IVD PLAYED. *C/P MOVE		001 MND/NA 002 01 003 BL04	
✓	160	✓ CAB PLATE TYPE II CLASS II .055 SQ FT AT 2.75 - 3.85 AMPS *C/P MOVE TIME OUT _____ DATE OUT _____		001 MND/NA 002 03 003 CA01	
✓	162	✓ OPTICAL VACUUM CAB PLATE TYPE II CLASS I IF BUSHINGS ARE NOT REMOVED		001 MND/NA 002 02 003 VC02	
✓	165	✓ SAME 25 HRS WITHIN 4 HRS OF CAB *C/P MOVE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MND/NA 002 02 003 BK01	
✓	170	✓ IRIBITE *C/P MOVE		001 MND/NA 002 02 003 IR01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MND/NA 002 06 003 MLC4	

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SH
DISPATCH	A	3601LN
FUNCTIONAL CODE	C	
	B	
	D	

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/REG	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 JURY LINK
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15. DISPATCH STATION	16. PERF ACC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
✓	175	IVD PLATE (INITIATED BY PLATING) *NOTE* OPERATION 165 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION. C/P MOVE		001 MNR RC "G" 002 03 003 IVO1	
✓	177	BLOODLINE IVD AREAS (INITIATED BY PLATING) C/P MOVE		001 MNR RC 002 03 003 TAO1	
✓	200	INSTALL BEARING IAW 4A4 22-3 *C/P MOVE P/N M81936-1-12			
✓	201	MACHINE 8/9 CYL SOCKET BUSHING *C/P MOVE PRESS FIT .001/.003 P/N 7829423-23		001 MNR RA 002 02 003 LEO2	
✓	203	INSTALL 8/9 CYL SOCKET BUSHING P/N 7829423-23 *C/P MOVE		001 MNR RA 002 02 003 BE01	
✓	205	MACHINE FINISH SOCKET BUSHING I.D. 1.3750/1.3765 *C/P MOVE		001 MNR RA 002 02 003 LEO2 005 XB693614	
✓	206	MACHINE STD APEX BUSHING PRESS FIT .0005/.0015 *C/P MOVE P/N 5T4M130-10006		001 MNR RA 002 02 003 LEO2	
✓	208	INSTALL STD APEX BUSHING P/N 5T4M130-10006 *C/P MOVE		002 02 003 BE01	
		MACHINE 8T APEX FLANGED BUSHING P/N 5T4M130-10006 I.D. .6875/.6885 *C/P MOVE		001 MNR RA 002 02 003 HH00	
		MACHINE 8T APEX FLANGED BUSHING PRESS FIT .0005/.0015 *C/P MOVE		001 MNR RA 002 02 003 LEO2	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING REG SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	B	36011N
		B	B	

36011N WORK CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO	2. QUANTITY	4. PRODUCTION SEQ/ISS	3. DATE ORDERED	5. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	6. 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 UPPER JURY LINK
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15. DISPATCH STATION	16. PERP/RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		17. W/N 7827424 51			
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215	INSTALL O/S APEX BUSHINGS *O/P MOVE FIT .0005/.0015 *O/P MOVE	001 MNR RA 002 02 003 BEC1
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217	REMOVE O/S APEX BUSHINGS I.D. .6875/.6885 *O/P MOVE	001 MNR RA 002 02 003 MHCC
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220	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958	001 MNR CP 002 06 003 SA03
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220	FINAL PRODUCT VISUAL INSPECTION *O/P MOVE	001 MNR CP 002 06 003 SA03
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	C	36011N

36012N WORK CONTROL DOCUMENT (MEDS)

DATE 308

1. JOB ORDER NO.	2. QUANTITY	4. PRODUCTION SERIES MNP GP	5. DATE ORDERED	6. DATE SHIPPED
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7. PART NUMBER	8. TECH DATA 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN RETRACT BOLT	26338N
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15. DISPATCH STATION	16. PERFORMANCE NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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68A410	68-1001	XXXXXXXXXXXX 26338A L / H 26337A R / H			
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UNIT COST: \$127.05

GOVERNING DIRECTIVES:

- AFLOM 66-51
- MANO1 66-3
- BLAST IAW MIL-STD-1504
- FPI IAW MIL-STD-1749
- 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
- FPI IAW MIL-STD-6866
- CAD IAW MIL-STD-870
- CHROME PLATE IAW MIL-STD-1501
- P/O N61891
- BAKE IAW 4S-1-182
- MANO1 74-12
- COV ROOM PLATE IAW MIL-C-65403A
- ALODINE IAW MIL-C-5541

*****STEEL 300M*****

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
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36012N

WORK CONTROL DOCUMENT (MDS)

1. JOB ORDER NO.	2. QUANTITY	3. PRODUCTION METHOD	4. DATE ORDER	5. 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. NAME RETRACT BOLT

15. DISPATCH STATION	16. PERP ACC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		<p>NOTE: 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.</p> <p>*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO JELIA STAMP.</p>			
	001	004720700-1001			
		ASSEMBLE			001 MNDN
	REQD				002 02
					003 L502
					005 XB745199
		REMOVE ONLY			001 MNDN
	REQD				002 02
					003 D602
		CLEAN ONLY			001 MNDN
	REQD				002 03
					003 3L07
		DATE IN _____ TIME IN _____			002 03
	REQD				003 BK03
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
					001 MNDN
	REQD		M		002 05
					003 M803

21. FINAL DESTINATION		22. COORDINATION/INITIATING REC SIGNATURE/DATE		23. DOCUMENT/ID
DISPATCH	FUNCTIONAL CODE	A	B	36012N

1. PART NUMBER	2. QUANTITY	3. PRODUCTION ORDER	4. DATE ORDERED	5. DATE RECEIVED
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6. PART NUMBER	7. TEST DATA	8. TEST SERIAL NO.
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9. MODEL DESIGN SERIES	10. STOCK NUMBER	11. OPTIONAL
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12. SERIAL NUMBER	13. noun RETRACT BOLT
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14. DISPATCH	15. REPAIR REQ/OP	16. WORK TO BE ACCOMPLISHED	17. MECHANIC	18. "P" NUMBER "O"
	*REQDN	BOLT SMALL OD .7480/.7490/.7460 *C/P MOVE		001 MNRFC 002 04 003 EIC1
030 ✓		VAPOR DECREASE *C/P MOVE		001 MNRFC 002 03 003 DGC1
035 ✓		STRIP OAE *C/P MOVE		001 MNRFC 002 02 003 CSC1
045 ✓		STRIP RUST *C/P MOVE		001 MNRFC 002 02 003 CSC2
050 ✓		STRIP CHROME SMALL O.B. *C/P MOVE		001 MNRFC 002 02 003 SCC2
070 ✓		FIRST GRIND SMALL OD MIN OD .7280 *C/P MOVE		001 MNRFC 002 01 003 BE90
		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNRFC 002 06 003 TEC3
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****		
090 ✓		TAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____ (CONTINUED)		001 MNRFC 002 02 003 BK01

19. FINAL DESTINATION	20. COORDINATION/INITIATING RCG SIGNATURE/DATE	21. DOCUMENT/NO.
DISPATCH FUNCTIONAL CODE	A	36012N

7. JOB ORDER NO	8. QUANTITY	9. PRODUCTION SEC/RCC	10. DATE SCHED	11. DATE COMPLETED
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12. PART NUMBER	13. TECH DATA	14. ITEM SERIAL NO
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15. MODEL DESIGN SERIES	16. STOCK NUMBER	17. OPTIONAL
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18. SERIAL NUMBER	19. NOUN RETRACT BOLT
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20. DISPATCH STATION	21. PERFORM RCC/OP NO	22. WORK TO BE ACCOMPLISHED	23. MECHANIC	24. "P"	25. "Q"
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DATE OUT _____ TIME OUT _____
 *C/P MOVE

***** NOTE *****
 IF LAST NDI OPERATION IS COMPLETED
 HERE, TAKE PRODUCTION COUNT *

DATE OUT _____ TIME OUT _____
 *C/P MOVE

100 VAPOR DECREASE *C/P MOVE
 001 MNR/BA
 002 02
 003 DG01

110 CHST BEEN REMOVED AREAS
 .608/.012 A2 100% COVERAGE
 *C/P MOVE
 001 MNR/BA
 002 01
 003 SPC2

120 PREPARE SMALL O.D. FOR CHROME
 PLATE TYPE 2 CLASS 3
 MASK/FIXTURE/ETC *C/P MOVE
 MECHANIC SIGN OFF REQUIRED
 001 MNR/BA
 002 02
 003 PE01

125 PREPARE SMALL O.D. FOR CHROME PLATE
 GRIT BLAST *C/P MOVE
 001 MNR/BA
 002 01
 003 BLO4

130 CHROME PLATE SMALL O.D. TYPE 2
 CLASS 3 SUFFICIENT TO BRING BACK TO
 .7490
 001 MNR/BA
 002 02
 003 CP01
 008 CDD10

DATE OUT _____ TIME OUT _____
 MECHANIC SIGN OFF REQUIRED
 *C/P MOVE

140 BAKE 4 HRS WITHIN 4 HRS OF CHROME
 DATE IN _____ TIME IN _____
 (CONTINUED)
 001 MNR/BA
 002 02
 003 BK01

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	36012N

1. JOB ORDER NO.	2. QUANTITY	3. PRODUCTION SOURCE	4. DATE BEG	5. DATE COMPLET
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. WORK RETRACT BOLT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C"
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DATE OUT _____ TIME OUT _____
 #C/P MOVE

160. ~~***** NOTE *****~~
~~IF LAST NDL OPERATION IS COMPLETED*~~
~~HERE, TAKE PRODUCTION COUNT~~

170. MAKE 4 NRS. AT 050 400F
 DATE IN _____ TIME IN _____

DATE OUT _____ TIME OUT _____
 #C/P MOVE

***** NOTE *****
 IF LAST NDL OPERATION IS COMPLETED*
 HERE, TAKE PRODUCTION COUNT

185. VAPOR DECREASE #C/P MOVE

***** NOTE *****
 IF LAST NDL OPERATION IS COMPLETED*
 TAKE PRODUCTION COUNT

195. PRIOR TO CAD/IVD, COIT PLACT ALL
 AREAS TOBE CAD/IVD PLATED
 #C/P MOVE

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCS SIGNATURE/DATE		23. DOCUMENT/N
DISPATCH	FUNCTIONAL CODE	A	C	36012N

1. JOB ORDER NO	2. QUANTITY	3. PRODUCTION SEQUENCE	4. DATE ORDERED	5. 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. BYCEN NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. MOUNT RETRACT BOLT	

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" KNIFE	20. "C"
20	200	CRA PLATE TYPE II CLASS 11 0.05 SQ FT AT 2.5 - 3.5 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MN/RC 002 03 003 CAC1	

21	210	MAKE 20 HRD WITHIN 4 HRD OF CAR DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MN/RC 002 02 003 BK01	
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22	210	CHROMATE CONVERSION FOR TANK CAS *C/P MOVE		001 MN/RC 002 02 003 IR01	
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	65	*** NOTE *** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MN/RC 002 06 003 MLC4	
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23	223	VAC. I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION--210 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MN/RC 002 03 003 IV01	
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24	227	ALBINE IVE ALUM PLATE CLASS 1A *C/P MOVE		001 MN/RC 002 03 003 TAG1	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/N
DISPATCH	FUNCTIONAL CODE	A	B	36012N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/AGE MNPGR	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4A4-22-3 4S-1-182	9. ITEM SERIAL NO
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10. MODEL DESIGN SERIES F 15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN SPINDLE ASSY	26337A
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15. DISPATCH STATION P/R	16. PERFORM RCC/OP NO 24-1001	17. WORK TO BE ACCOMPLISHED 162000 26338A L / H 26337A R / H	18. MECHANIC	19. "P"	20. "Q"
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UNIT COST: \$241.00				
GOVERNING DIRECTIVES:		AFLCR 66-51		
		MANDI 66-3		
BLAST	IAW	MIL-STD-1504		
	IAW	MIL-STD-1742		
		P/O NO1561		
STRIP	IAW	MIL-STD-871		
GRIND	IAW	MIL-STD-846		
TEMPER ETCH	IAW	MIL-STD-867		
SHOT PEEN	IAW	MIL-9-13165		
FPI	IAW	MIL-STD-6866		
CHROME PLATE	IAW	MIL-STD-1501		
		P/O N41091		
BAKE	IAW	4S-1-182		
		MAOI 74-12		
VAC OAD	IAW	MIL-C-9873A		
NO PLATE	IAW	MIL-STD-870		
IVB ALUM PLATE	IAW	MIL-C-83488A		
ALODINE	IAW	MIL-C-5541		
*****STEEL 300M*****				

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/BN
DISPATCH	FUNCTIONAL CODE	A	E	36013N
		B	D	

36013M

WORK CONTROL DOCUMENT (MEDS)

1 DATE 9041

PAGE 2 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCS	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
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13. SERIAL NUMBER	14. NOUN SPINDLE ASSY
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15. DISPATCH STATION	16. PERP. NO /OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "G"
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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 PREVENT INJURIES.

REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA

DATE 11/24/84

[REDACTED] *REQD* [REDACTED] *C/P MOVE

001 MNRGN
002 02
003 LG02
005 XB745199

[REDACTED] *REQD* [REDACTED] *C/P MOVE

001 MNRGN
002 03
003 SL01

[REDACTED] *REQD* [REDACTED] *C/P MOVE

001 MNRGN
002 03
003 BL07

[REDACTED] TAKE 4 HRS AT 350-400F

001 MNRGN
002 03
003 BK03

REQD DATE IN _____ TIME IN _____

DATE OUT _____ TIME OUT _____

*C/P MOVE

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCS SIGNATURE/DATE		23. DOCUMENT/EN
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DISPATCH	FUNCTIONAL CODE	A	B	36013M
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36013N WORK CONTROL DOCUMENT (MEDS)

11 34739041

3 PAGE 1 OF 3 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/ACC	5. DATE SCHED	6. DATE COMPLETES
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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 SPINDLE ASSY
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15. DISPATCH	16. PERM. ACC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. MND/NA	20.
	REQD	WORK TO BE ACCOMPLISHED	M	001 MND/NA	
		PREL. INSPECTION		002 05	
	REQD	LARGE OD .6230/.6240/.6210		003 MSC3	
		CHALL OD .4580/.4590/.4550		001 MND/NA	
		BUSHINGS ID .3750/.3760/.3790		002 04	
		*C/P MOVE		003 EIC1	
26	024	WAFER BECKLE		001 MND/NA	
				002 03	
				003 BEC1	
26	026	STRIP CAB		001 MND/NA	
				002 02	
				003 CSC1	
26	028	STRIP RUST		001 MND/NA	
				002 02	
				003 CSC2	
26	030	O/S BUSH EGGS MAX ID .5611		001 MND/NA	
		*C/P MOVE		002 03	
				003 BEC1	
26	040	STRIP LARGE OD		001 MND/NA	
		*C/P MOVE		002 02	
				003 SC02	
26	050	STRIP SMALL OD		001 MND/NA	
		*C/P MOVE		002 02	
				003 SC02	
				001 MND/NA	
				002 01	
				003 GE00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	C	36013N

WORK CONTROL DOCUMENT (MEDS)

1. DATE: 10/11/60

2. PART NAME

3. JOB ORDER NO.	4. QUANTITY	5. PRODUCTION SECTOR	6. DATE SCHED.	7. DATE COMPLETED
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8. PART NUMBER	9. TECH DATA	10. ITEM SERIAL NO.
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11. MODEL DESIGN SERIES	12. STOCK NUMBER	13. OPTIONAL
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14. SERIAL NUMBER	15. NGUN SPINDLE ASSY
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16. DISPATCH STATION	17. PERP RCC/OP NO.	18. WORK TO BE ACCOMPLISHED	19. MECHANIC	20. "P" NUMBER	21. "G"
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✓	070	FIRST DRIND SHALL BE FIN. OP. 10/11/60 *C/P MOVE		001 MNRRC	002 01	003 GECO
		*C/P MOVE	M	001 MNRRC	002 06	003 TEC3
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****				

✓	090	MAKE * HRS WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____		001 MNRRC	002 02	003 BK01
---	-----	--	--	-----------	--------	----------

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

		*C/P MOVE	M	001 MNRRC	002 06	003 MLC4
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****				

✓	100	VMPOR DEGREASE *C/P MOVE		001 MNRRC	002 03	003 DG01
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✓	110	SHOT PEEN REMORKEB AREAS .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNRRC	002 01	003 SPC2
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✓	110	PREPARE DE FOR CHROME PLATE TYPE II CLASS III, MASK/FIXTURE/ETC. *C/P MOVE (CONTINUED)		001 MNRRC	002 02	003 BE01
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	E	36013N	

WORK CONTROL DOCUMENT (MILC)

1. JOB ORDER NO		2. QUANTITY		3. PRODUCTION SEC/OPS		4. DATE SERIES		5. DATE DESCRIPTION	
7. PART NUMBER				8. TECH DATA			9. ITEM SERIAL NO.		
10. MODEL DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SPINDLE ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19.	20.	
251	170	TAKE 4 HRS AT 550 RPM						001 MAK RC	00
		DATE IN _____ TIME IN _____						002 02	
		DATE OUT _____ TIME OUT _____						003 BK01	
		*C/P MOVE							
		***** NOTE *****						001 MAK NA	
		IF LAST NDI OPERATION IS COMPLETED*				M		002 06	
		HERE, TAKE PRODUCTION COUNT.						003 ML04	

25	177	VAPOR DEGREASE						001 MNPRC	
		*C/P MOVE						002 03	
		DATE IN _____ TIME IN _____						003 BS01	
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		***** NOTE *****				M		001 MAK NA	
		IF LAST NDI OPERATION IS COMPLETED*						002 06	
		HERE, TAKE PRODUCTION COUNT.						003 ZS01	

25	181	PRIOR TO GRABING BAG/PLATE, TEST PLATE						001 MNPRC	
		ALL AREAS TO BE GRAB/VAS BAG/PLATE						002 01	
		PLATED. *C/P MOVE						003 BL04	
26	183	VAS GRAB PLATE IF BUSH WERE NOT REMOVED. *C/P MOVE						001 MNPRC	
		DATE IN _____ TIME IN _____						002 02	
		DATE OUT _____ TIME OUT _____						003 VC01	
26	185	GRAB PLATE 0.033 SQ FT AT 1.6 - 2.3 AMPS						001 MNPRC	
		DATE OUT _____ TIME OUT _____						002 03	
		(CONTINUED)						003 CA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/NO
DISPATCH	FUNCTIONAL CODE	A	C	36013N

36013N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 99041

7

PAGE 07 OF 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. SYSCR NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN SPINDLE ASSY
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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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		WORK TO BE ACCOMPLISHED	MECHANIC	"P"	"Q"
202 C ✓	187	BAKE 2CHRS AT 350 400F WITHIN 4HRS OF CAD PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNERC 002 02 003 BK01	

		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNERC 002 06 003 MLO4	
--	--	---	---	---------------------------------	--

20 C ✓	191	IRIDITE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *		001 MNERC 002 02 003 IRC1	
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20 C ✓	195	VAC IVD ALUM PLATE CLASS 2 1/2 CAL CL NOTE: OPERATION 187 MUST BE ACCOMPLISHED IF PRIOR PLATING WORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNERC 002 03 003 1V01	
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20 C ✓	196	ALIGNING IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNERC 002 03 003 TAO1	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36013N	
		B	D		

WORK CONTROL DOCUMENT (MESH)

DATE: 11/1/68

PAGE 07 OF 08 PAGES

1. JOB ORDER NO.		2. QUANTITY		3. PRODUCTION SEC/RCS		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 SPINDLE ASSY						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P" MAN/RA	20. "Q"	
✓	127	MACHINE 073 SUPPLING P/N ST4M130-06003					001	MAN/RA	002
							003	LL	
✓	200	MACHINE 073 SUPPLING ID .375/.3760 *C/P MOVE					001	MAN/RA	002 03
							003	BE01	
✓	204	MACHINE 073 SUPPLING P/N 7829424-65					001	MAN/RA	002 03
							003	LE02	
✓	205	INSTALL 075 BUSH ID .375/.3760 FIT .00057.001 *C/P MOVE					001	MAN/RA	002 03
							003	BE01	
	207	PRINT & TAG *C/P MOVE					001	MAN/OP	002 09
							003	WB03	
	210	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001	MAN/OP	002 06
		REQD					003	SAC3	
	220	FINAL REVIEW VISUAL INSPECTION *C/P MOVE					001	MAN/OP	002 06
		REQD					003	SAC3	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN	
DISPATCH	FUNCTIONAL CODE	A	C	36013N	
		B	D		

7. JOB ORDER NO.	8. QUANTITY	4. PRODUCTION DESIGN MNPGP	9. DATE CODES	6. DATE CODES	
7. PART NUMBER		5. TECH DATA 464-22-3 48-1-182	9. ITEM DESIGN		

10. MODEL DESIGN SERIES F15 MAIN	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN SWIVEL CRANK DRAG BOLT	

2637A

18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	1041	26336A L / H 26337A R / H			
		UNIT COST			
		GOVERNING DIRECTIVES: AFJCR 66-51 MADCI 66-3			
		BLAS. IAW MIL-STD-1504			
		FWPL IAW MIL-STD-1947			
		970 NC1561			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-887			
		FPI IAW MIL-STD-8866			
		CAD IAW MIL-STD-870			
		CHROME PLATE IAW MIL-STD-1501			
		970 NC1071			
		BAKE IAW 48-1-182 MADCI 74-12			
		HEAT TREAT 280,000/300,000 PSI			
		1/8" PLATE IAW MIL-C-89430A			
		ALUMINE IAW MIL-C-5541			
		*****STEEL 300M*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND PROCEDURES 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/BN
DISPATCH	FUNCTIONAL CODE	A	C	36014N
		B	D	

WORK CONTROL DOCUMENT

1. JOB ORDER NO.	2. QUANTITY	4. PRODUCTION QUANTITY	3. DATE ORDERED	5. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	6. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NSUN SWIVEL CRANK DRAG BOLT
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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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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	00A410607 1001				
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[REDACTED]	DISASSEMBLE	*C/P MOVE			
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REQD
001 MNEGW
002 02
003 LG02
005 X8745199

[REDACTED]	ITEM CLEAN	*C/P MOVE			
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REQD
001 MNEGW
002 03
003 SLC1

[REDACTED]	BLAST CLEAN ONLY	*C/P MOVE			
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REQD
001 MNEGW
002 03
003 BLC7

[REDACTED]	BAKE 4 HRS AT 350 100F				
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REQD
001 MNEGW
002 03
003 BK03

	DATE IN _____ TIME IN _____				
--	-----------------------------	--	--	--	--

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

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36014N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 904

1. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCS		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO		
10. MODEL DESIGN SERIES			11. SYDOR NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SWIVEL CRANK DRAG BOLT						
15. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19.	20.
	REQU	[REDACTED] *C/P MOVE					M	001 MNRNA	00
	REQU	[REDACTED] AND 1 INSPECT						002 05	
	REQU	BOLT OD 1.4355/1.4365/1.4330						003 MSC3	
		PLANET MOUNTING 1.5007/1.5017/1.502						001 MNRBU	
		*C/P MOVE						002 04	
								003 EI01	
28	024	VAPOR DEGREASE *C/P MOVE						001 MNRRC	
								002 03	
								003 DGC1	
28	016	STRIP CAB *C/P MOVE						001 MNRRC	
								002 02	
								003 CS01	
28	020	STRIP RUST *C/P MOVE						001 MNRRC	
								002 02	
								003 CS02	
28	090	O/S BUNGEE BOSS MAX TB *C/P MOVE						001 MNRRA	
								002 03	
								003 BE01	
28	060	STRIP BUNGEE BOSS MAX TB *C/P MOVE						001 MNRRC	
								002 02	
								003 SC02	
		REBENTER *C/P MOVE						001 MNRRA	
								002 03	
								003 LE02	
		STRIP BUNGEE BOSS MAX TB *C/P MOVE						001 MNRRC	
		1.4160 MIN OD						002 02	
								003 GE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT#	
DISPATCH	FUNCTIONAL CODE	A	C	36014N	
		B	D		

WORK CONTROL DOCUMENT

1. JOB ORDER NO		2. QUANTITY		3. PRODUCTION SOURCE		4. DATE ORDERED		5. DATE RECEIVED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER		14. NAME SWIVEL CRANK DRAG BOLT							
15. DISPATCH	16. PERP. ACCPT.	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. C/P	20. M/N/A
		[REDACTED]					M	002 06	003 TEC3
		TIME OUT _____ DATE OUT _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****							
26R	070	BAKE 4 HRS WITHIN 6 HRS OF ETCH						001 MNRRC	002 02
		DATE IN _____ TIME IN _____						003 BKC1	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED]						001 MNRNA	
		*C/P MOVE					M	002 06	003 MLC4
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *****							
28	000	VAPOR DECREASE						001 MNRRC	002 03
		[REDACTED]						003 BKC1	
29	070	SHOT PEEN PIN 02 .006/.010 AZ 100% COVERAGE						002 01	003 SPC2
		*C/P MOVE							
29	079	PREPARE PIN FOR CHROME PLATE TYPE II CLASS III. MASK/FIXTURE/ETC						001 MNRRC	002 02
		*C/P MOVE						003 BEC1	
29	077	MECHANIC SIGN OFF REQUIRED PREPARE PIN O.B. FOR CHROME PLATE, GRIT BLAST.						001 MNRRC	002 01
		*C/P MOVE						003 BLC4	
21. FINAL DESTINATION		22. COORDINATION/INITIATING REC SIGNATURE/DATE				23. DOCUMENTATION			
DISPATCH	FUNCTIONAL CODE	A				36014N			

1. JOB ORDER NO.		2. QUANTITY		3. PRODUCTION SEQUENCE		4. DATE ORDERED		5. DATE SHIPPED	
7. PART NUMBER			8. TECH DATA			9. TIME REQUIRED			
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. SPECIAL			
13. SERIAL NUMBER			14. NOUN SWIVEL CRANK DRAG BOLT						
15. DISPATCH STATION	16. PERFORM NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. MNR RC	20. "B"	
20	100	GRIND CRANK PIN TO 1.4365 III SUFFICIENT TO GRIND BACK TO 1.4365					001 MNR RC	002 02	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED MCP/ MOVE						003 CP01	
								008 CD010	
20R	110	DATE 4 HRS WITHIN 4 HRS OF GRIND DATE IN _____ TIME IN _____					001 MNR RC	002 02	
		DATE OUT _____ TIME OUT _____ MCP/ MOVE						003 BK01	
	120	FINISH GRIND PIN OD 1.4355/1.4355 MCP/ MOVE					001 MNR RC	002 02	
								003 GE01	
20R	130	DATE 4 HRS DATE IN _____ TIME IN _____					001 MNR RC	002 02	
		DATE OUT _____ TIME OUT _____ MCP/ MOVE						003 BK01	
		MCP/ MOVE ***** NOT C ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION START* *****				M	002 06	003 ML04	
20	145	VAPOR DECREASE MCP/ MOVE					001 MNR RC	002 09	
								003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/ON				
DISPATCH	FUNCTIONAL CODE	A	C		36014N				
		B	D						

CONTROL DOCUMENT (MDS)

DATE 9041

PAGE 01 OF 01 PAGES

1. JOB ORDER NO.	2. QUANTITY	4. PRODUCTION SIZE/NO.	5. DATE CODE	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 SWIVEL CRANK DRAG BOLT
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15. DISPATCH REGION	16. PERF RCC/PP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. M/N/RC	20. M/N/RC
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MOVE
 ***** NOTE *****
 IF LAST NDI OPERATION IS COMPLETED*
 HERE, TAKE PRODUCTION COUNT.

150
 PRIOR TO CAD/IVD, BRIT BLAST ALL
 AREAS TO BE CAD/IVD PLATED.
 *C/P MOVE
 001 M/N/RC
 002 01
 003 BLOC

150
 CAD PLATE TYPE I CLASS II
 .15 SQ FT AT 7.5 - 10.5 AMPS
 TIME OUT _____ DATE OUT _____
 *C/P MOVE
 001 M/N/RC
 002 03
 003 CAD

170
 SAME AS WRD WITHIN 4 HRS OF DAB
 DATE IN _____ TIME IN _____
 DATE OUT _____ TIME OUT _____
 *C/P MOVE
 001 M/N/RC
 002 02
 003 BK01

MOVE
 ***** NOTE *****
 IF LAST NDI OPERATION IS COMPLETED*
 HERE, TAKE PRODUCTION COUNT.

165
 HAS IVD ALUM PLATE CLASS 2 TYPE II
 NOTE: OPERATION 170 MUST BE
 ACCOMPLISHED IF PRIOR PLATING REWORK
 (CONTINUED)
 001 M/N/RC
 002 03
 003 IVC1

21. FINAL DESTINATION DISPATCH	21. FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	22. B	23. DOCUMENT/BN 36014N
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21. DISPATCH	21. FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	22. B	23. DOCUMENT/BN 36014N
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WORK CONTROL DOCUMENT (WCD)

1. DATE: 04-11-77

2. PAGE 07 OF 08

3. JOB ORDER NO		5. QUANTITY		4. PRODUCTION STORAGE		6. DATE SCHED		7. DATE COMPLETED	
9. PART NUMBER				8. TECH DATA				10. P/N SERIAL NO.	
10. MODEL DESIGN/SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SWIVEL CRANK DRAG BOLT						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19.	20.
		15 DONE, BEFORE USING IVE OPTION.							
✓ 26	187	ALOGINE IVE ALUM PLATE CLASS 1A *C/P MOVE							001 MNRBC 002 03 003 TA01
✓ 27	187	MACHINE FLANGED [REDACTED] *C/P MOVE P/N ST4M130-08002							001 MNRRA 002 03 003 LE02
✓ 27	190	INSTALL FLANGED [REDACTED] ST4M130-08002 ID .5007.501 *C/P MOVE							001 MNRRA 002 03 003 BE01
✓ 27	174	MACHINE 6/8 BUNGEE [REDACTED] *C/P MOVE P/N 7829424-67							001 MNRRA 002 03 003 LE02
✓ 27	175	INSTALL 6/8 BUNGEE [REDACTED] P/N 7829424-67 ID .5007.501 FIT .0005/.0015 *C/P MOVE							001 MNRRA 002 03 003 BE01
[REDACTED]	200	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958							001 MNRBC 002 06 003 SA03
[REDACTED]	210	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*							001 MNRBC 002 06 003 SA03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION	
DISPATCH	FUNCTIONAL CODE	A	B	36014N	

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNPBP	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA 4A4-22-3 4S-1-182		9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES F15 MAIN	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN COLLAR ASSY	26378A

15. DISPATCH STATION PZN	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED RSM GAN	18. MECHANIC	19. "P"	20. "Q"
<p>68A410733-10027H 1620003386559 26378A R / H</p>					

UNIT COST: \$2750.00					
GOVERNING DIRECTIVES:					
		AFLCR 66-51			
		MANCI 66-3			
	BLAST	IAW MIL-STD-1534			
	PIPI	IAW MIL-STD-1799			
		P/O NO1581			
	BAKE	IAW 4S-1-182			
		MADI 74-12			
	GRIND	IAW MIL-STD-866			
	CAD	IAW MIL-STD-870			
	IVD ALUM PLATE	IAW MIL-C-83498A			
	ALODINE	IAW MIL-C-5541			
	VAC CAD	IAW MIL-C-8837			
	TEMPER ETCH	IAW MIL-STD-867			
	SHOT PEEN	IAW MIL-S-13165			

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 THE 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
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN	
DISPATCH	FUNCTIONAL CODE	A	E	36016N	

CONTROL DOCUMENT

FORM 904

Rev. 5-1-60

1. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/PCS		5. DATE BEG		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 COLLAR ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. 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 18 IS EQUIVALENT TO DELTA STAMP.				18. MECHANIC	19. "P"	20. "Q"	
	001	68A410733-1001 68A410733-1002							
		DISASSEMBLE *G/P MOVE						001 MMSCH 002 02 003 LG02 005 X8745199	
		REQD							
		GREN CLEAN *G/P MOVE						001 MMSCH 002 03 003 SL01	
		REQD							
		BLAST CLEAN ONLY *G/P MOVE						001 MMSCH 002 03 003 BL01	
		REQD							
		BAKE 4 HRS AT 350-400F						001 MMSCH 002 03 003 BK03	
		REQD DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		REQD							
		*G/P MOVE						001 MMSCH 002 05 003 MSC3	
		REQD							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN	
DISPATCH	FUNCTIONAL CODE	A	E	36016N	

U.S. GOVERNMENT PRINTING OFFICE: 1959-540-102

343

1. JOB ORDER NO		2. 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 COLLAR ASSY							
15. DISPATCH		16. PERP RCC/OP		17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. 20.	
				E & I 118 9 9					001 "MNERC" "Q"	
		REQD		BUSHING ID #17 & 18 5.6265/5.6275/5.6301 BASE METAL 3.705/3.7064 FACE TO FACE 2.620/2.625/2.604 FLANGE TYPICAL .039/.040/.031					002 04 003 EIC1	
				TORQUE ARM LUG BUSHINGS #17 I.D. 1.118/1.1185/1.121 BASE METAL 1.219/1.2204 FACE TO FACE 3.624/3.625/3.603 FLANGE .0617/.0667/.058 .056/.065/.048						
				COLLAR SPINDEL BUSHINGS #15 TOP FACE M .625/.626/.627 FLANGE H .893/.0903/.0813 #16 BOTTOM FACE N .500/.501/.504 FLANGE (N) .0593/.0603/.0513 BASE METAL TOP .750/.7515 BOTTOM .625/.6265 FACE TO FACE 2.1392/2.1616 *C/P MOVE						
26		024		VIBROR SECREASE				*C/P MOVE	001 MNERC 002 03 003 EIC1	
26		025		PART 025				*C/P MOVE	002 02 003 EIC1	
26		028		STRIP RUST				*C/P MOVE	001 MNERC 002 02 003 EIC2	
				NOT TO EXCEED 5.7671 MAX *C/P MOVE					001 MNERC 002 03 003 LE02 005 XB433615	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/EN	
DISPATCH	FUNCTIONAL CODE	A	E		36016N	

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 COLLAR ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19.	20.
07 ✓	040	NONE FOR BUE. AREA 1.002 AS REQUIRED NOT TO EXCEED 1.284 MAX *C/P MOVE						001 MNFRA "G"	
07 ✓	030	MACHINE SPINDLE LOG UPPER W/5 AC REQUIRED NOT TO EXCEED 0.15 *C/P MOVE						001 MNFRA	002 03 003 BE01
07 ✓	060	MACHINE SPINDLE LOG LOWER #10 REQUIRED NOT TO EXCEED 0.6901 *C/P MOVE						001 MNFRA	002 03 003 BE01
[REDACTED]		DATE OUT [REDACTED] TIME OUT [REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****					M	001 MNFRA	002 06 003 TE03
22 ✓	000	ETCH DATE IN [REDACTED] TIME IN [REDACTED] DATE OUT [REDACTED] TIME OUT [REDACTED]						001 MNFRA	002 02 003 BK01
[REDACTED]		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * *****					M	001 MNFRA	002 06 003 HLU4
26 ✓	095	HARBOR DECREASE *C/P MOVE						001 MNFRC	002 03 003 DG01

U.S. GOVERNMENT PRINTING OFFICE: 1969-50-702

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36016N

WORK CONTROL DOCUMENT (MEDS)

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 COLLAR ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" NUMBER	20. "Q" NUMBER
20 ✓	100	CHLT PEEN .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNERC 002 01 003 SPO2	
20 ✓	100	PRIOR TO CAD/VAC CAD/IVB, BRIT BLAST ALL AREAS TO BE CAD/VAC CAD/IVD. *C/P MOVE		001 MNERC 002 01 003 BLO2	
20 ✓	110	CAD PLATE TYPE 2 CLASS 2 TYPE 20 AT 37.5 - 52.5 AMPS *C/P MOVE		001 MNERC 002 02 003 CA01	
20 ✓	120	VAC CAD TYPE 2 CLASS 1 IF BUSHINGS ARE NOT REMOVED *C/P MOVE		001 MNERC 002 02 003 7001	
20 ✓	130	TAKE 20 HRS WITHIN 4 HRS OF TANK CLE DATE IN _____ TIME IN _____ *C/P MOVE		001 MNERC 002 02 003 BLO1	
20 ✓	135	GREENITE CONVERSION COATING FOR 2 CAD PLATE *C/P MOVE		001 MNERC 002 02 003 TR01	
		<p>165</p> <p>***** NOTE *****</p> <p>IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT.</p> <p>*****</p>		001 MNERC 002 04 003 BLO4	
20 ✓	137	VAC IVB ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 130 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)		001 MNERC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	B	36016N

U.S. GOVERNMENT PRINTING OFFICE: 1989-000-000

36016N WORK CONTROL DOCUMENT (MEDS)

1 DATE 39041

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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 COLLAR ASSY
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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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TO DONE, BEFORE USING IVD OPTION.
*C/P MOVE

26 ✓ 138 ALIGNED IVD ALUM PLATE CLASS 1A
*C/P MOVE

139 INSTALL COLLAR BUSHING STD
*C/P MOVE

P/N 68A410645-2003
P/N 68A410644-2001

140 ✓ MACHINE COLLAR BUSHING STD P/N
TOP 68A410645-2003
BOTTOM 68A410644-2001

.0001/.0025 FIT - FACE TO FACE
2.620/2.625 FLANGE .037/.040

INLINE TO 5.6265/5.6275 I.D.
*C/P MOVE

148 ✓ MACHINE COLLAR BUSHING STD
P/N 7926302-01
P/N 7829424-89

149 ✓ INSTALL COLLAR BUSHING STD
*C/P MOVE

P/N 7926302-01
P/N 7829424-89

150 ✓ MACHINE COLLAR BUSHING STD
TOP 7926302-01
BOTTOM 7829424-89

.0001/.0025 FIT - FACE TO FACE
2.620/2.625 FLANGE .037/.040

INLINE TO 5.6265/5.6275 I.D.
*C/P MOVE

TOP P/N 7926302-01 FACE TO FACE
2.1392/2.1616 ID .625/.626 FLANGE

(CONTINUED)

001 MNR RA
002 03
003 BE01

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
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DISPATCH	FUNCTIONAL CODE	A	C	36016N
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DISPATCH	FUNCTIONAL CODE	A	C	36016N
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U.S. GOVERNMENT PRINTING OFFICE: 1980-000-100

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 COLLAR ASSY
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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	-	WORK TO BE ACCOMPLISHED			
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169		MACHINE SPINDLE BUSHING #15 P/N 7829424-85		001 MNRBA 002 03 003 LE02	
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170		INSTALL SPINDLE BUSHING 00 #15 TOP P/N 7829424-85 FACE TO FACE 2.1392/2.1616 ID .625/.626 FLANGE (N) .0592/.0903		001 MNRBA 002 03 003 BE01	
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180		INSTALL SPINDLE LUG BUSHING 01# #16 BOTTOM P/N 684410636-09003 FACE TO FACE 2.1392/2.1616 ID .500/.501 FLANGE (N) .0592/.0603		001 MNRBA 002 03 003 BE01	
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189		MACHINE SPINDLE LUG BUSH 07# #16 P/N 7829414-82		001 MNRBA 002 03 003 LE02	
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190		INSTALL SPINDLE LUG BUSHING 08 #16 BOTTOM P/N 7829424-83 FACE TO FACE 2.1392/2.1616 ID .500/.501 FLANGE (N) .0592/.0603		001 MNRBA 002 03 003 BE01	
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199		MACHINE SPINDLE LUG BUSHING 09 #16 P/N 68A410636-2002		001 MNRBA 002 03 003 LE02	
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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	36016N
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DISPATCH	FUNCTIONAL CODE	A	C	36016N
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U.S. GOVERNMENT PRINTING OFFICE: 1980-00-00

0138 WORK CONTROL DOCUMENT (MEDS)

DATE 9041

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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 COLLAR ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
✓ 01	200	INSTALL TORQUE ARM LUG BUSHING Q/C #19 P/N 38A410836-2001 FACE TO FACE 3.6241/3.625 ID 1.118/1.1185 INCLINE FLANGE VIEWED FROM TOP LEFT (J) .0517/.068 RIGHT (K) .056/.065 *C/P MOVE		001 MAN RA "Q"	
✓ 07	209	MACHINE TORQUE ARM LUG BUSH Q/C #1 P/N 7829421-01 *C/P MOVE		002 03 003 BE01	
✓ 07	210	INSTALL TORQUE ARM LUG BUSHING Q/C #19 P/N 7829421-01 FACE TO FACE 3.6241/3.625 ID 1.118/1.119 INCLINE FLANGE VIEWED FROM TOP LEFT (J) .0517/.068 RIGHT (K) .056/.065 *C/P MOVE		002 03 003 BE01	
		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		002 06 003 SA03	
		FINAL PROJECT MECHANICAL DRAWING *C/P MOVE		002 02 003 1103	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36016N

U.S. GOVERNMENT PRINTING OFFICE: 1985-50-100

WORK CONTROL DOCUMENT (MEDS)

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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN JURY BRACE APEX PIN	26337A
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15. DISPATCH STATION TZN	16. PERF RCC/OP NO 55-2005	17. WORK TO BE ACCOMPLISHED NON	18. MECHANIC	19. "P"	20. "Q"
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68A4107	55-2005	[REDACTED] / H 26337A R / H			
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GOVERNING DIRECTIVES:		AFLCR 66-51			
		MANDI 66-3			
GLASS	IAW	MIL-STD-1944			
RED LAD	IAW	MIL-STD-1940			
VAL GND	IAW	MIL-STD-1940			
AMP	IAW	MIL-STD-1949			
		P/O NO1561			
STRIP	IAW	MIL-STD-271			
		MIL-STD-200			
TEMPER ETCH	IAW	MIL-STD-867			
DRILL PLATE	IAW	MIL-S-13165			
RPI	IAW	MIL-STD-6366			
CRACK PLATE		IAW	MIL-STD-1551		
		P/O R61971			
SABL	IAW	4S-1-182			
		MAOI 74-12			
DRILL PLATE		IAW	MIL-STD-1551		
ALUMINUM		IAW	MIL-C-5841		
*****STEEL 300m*****					
** UNIT COST \$331.56**					
PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND APP FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND PROCEDURES.					
THE ABOVE TECHNICAL DRAWING AND THE 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 AND PROTECTED (O/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	36019N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980-449-702

WORK CONTROL DOCUMENT (MEDS)

DATE

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1. JOB ORDER NO	2. 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 JURY BRACE APEX PIN	

15. DISPATCH STATION	16. PERFORMANCE 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 PREVENT INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	28A410755 2005			
		DISASSEMBLE *C/P MOVE		001 MNRGW	
	REQD			002 02	
				003 LG02	
				005 XB745199	
		CHOP TUBING *C/P MOVE		001 MNRGW	
	REQD			002 03	
				003 SLO1	
				002 03	
	REQD			003 BLO7	
		PAKE 4HRS AT 350-400F		001 MNRGW	
	REQD	DATE IN _____ TIME IN _____		002 03	
				003 BK03	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	B	36019N

U.S. GOVERNMENT PRINTING OFFICE: 1980-340-100

36019N

WORK CONTROL DOCUMENT (MEDS)

DATE 9041

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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 JURY BRACE APEX PIN
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15. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MNR/NA	20. "Q"
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	REQD		M	001 MNRNA	
				002 05	
				003 MS03	

		& I PIN O.D.		001 MNRGW	
	REQD	LARGE END 1.436/1.437		002 04	
		WEAR 1.424		003 EI01	

		SMALL END 1.373/1.374			
		WEAR 1.371			
		*C/P MOVE			

24 ✓	024	VAPOR DEBRASS	*C/P MOVE	001 MNRRC	
				002 03	
				003 DG01	

25 ✓	025	STRIP EAB	*C/P MOVE	001 MNRRC	
				002 02	
				003 CS01	

26 ✓	026	STRIP RUST	*C/P MOVE	001 MNRRC	
				002 02	
				003 CS02	

27 ✓	027	STRIP CHROME	*C/P MOVE	001 MNRRC	
				002 02	
				003 SE02	

28 ✓	028	FIRST GRIND LARGE O.D. 1.421 MIN	*C/P MOVE	001 MNRRC	
				002 01	
				003 SE00	

29 ✓				001 MNRRC	
				002 01	
				003 SE00	

30 ✓				001 MNRNA	
				002 03	
				003 TE03	

DATE OUT _____ TIME OUT _____
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	G	36019N

U.S. GOVERNMENT PRINTING OFFICE: 1983-549-748

WORK CONTROL DOCUMENT (MEDS)

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 JURY BRACE APEX PIN
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18. 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 ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
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202 ✓	070	BAKE AIDS AT 350-400F WITHIN 60S OF ETCH DATE IN _____ TIME IN _____		001 MNR10 002 02 003 3K01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

		 *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNR10 002 06 003 MLC4	
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20 ✓	085	WAFPS. DECREASE *C/P MOVE		001 MNRRC 002 03 003 BGC1	
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20 ✓	090	PREPARE FOR CHROME PLATE, MASK/ .005/.012 A2 100% COVERAGE *C/P MOVE		001 MNRRC 002 01 003 SP02	
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20 ✓	093	PREPARE FOR CHROME PLATE, MASK/ FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED		001 MNRRC 002 02 003 BE01	
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20 ✓	097	PREPARE O.D. FOR CHROME PLATE, GRET BLAST. *C/P MOVE		001 MNRRC 002 01 003 BLC4	
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N

U.S. GOVERNMENT PRINTING OFFICE: 1959-040-100

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 JURY GRADE APEX PIN
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18. DISPATCH STATION	19. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "C/P" MOVE	20. "Q"
✓	100	CHROME PLATE LARGE O.D. SUFFICIENT TO GRIND TO 1.437 DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE		002 02 003 CP01 009 00010	
✓	100	CHROME PLATE SMALL O.D. SUFFICIENT TO GRIND TO 1.374 DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE		001 00010 002 02 003 CP01 008 00020	
✓	110	BAKE AIRS AT 350-400F WITHIN 4HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 00010 002 02 003 BK01	
✓	120	FINISH GRIND O.D. LARGE O.D. 1.436/1.427 *C/P MOVE		001 00010 002 01 003 0E00	
✓	125	FINISH GRIND O.D. SMALL O.D. 1.373/1.374 *C/P MOVE		001 00010 002 01 003 0E00	
✓	130	BAKE AIRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 00010 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1960-040-710

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 JURY BRACE APEX PIN
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15. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" "M" "A" "Q"	20.
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		*C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 002 06 003 MLO4	
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20 ✓	145	VAPOR RELEASE *C/P MOVE		001 MNRRC 002 03 003 DBO1	
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		*C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * *****	M	001 002 06 003 ZSO1	
--	--	---	---	---------------------------	--

20 ✓	172	PRIOR TO CAD/VAC CAD/IVD, BRIT BLAS ALL AREAS TO BE CAD/VAC CAD/IVD PLATED. *C/P MOVE		001 MNRRC 002 01 003 BLO4	
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20 ✓	172	VAC CAD *C/P MOVE		001 MNRRC 002 02 003 VCO1	
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20 ✓	177	LOAD RATE TO BE IN RANGE .0Y 50 ST AT 4.5 - 6.3 AMPS DATE OUT _____ TIME OUT _____ *C/P MOVE		001 002 03 003 LAC1	
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20 ✓	170	BAKE 20HRS AT 250-400F WITHIN 4HRS OF CAD PLATE DATE IN _____ TIME IN _____ (CONTINUED)		001 MNRRC 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	36019N	
		B	D		

U.S. GOVERNMENT PRINTING OFFICE: 1980-040-102

36019N WORK CONTROL DOCUMENT (MEDS)

1 DATE 9041

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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 JURY BRACE APEX PIN
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18. DISPATCH STATION	19. 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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24 ✓	175	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNRG 002 02 003 IR01	
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		[REDACTED]		001 MNRG 002 06 003 MLO4	
--	--	------------	--	--------------------------------	--

	.65	*C/P MOVE *** NOTE *** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. ***	M		
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24 ✓	188	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 170 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION.		001 MNRG 002 03 003 IVO1	
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25 ✓	187	ALUMINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNRG 002 03 003 TAO1	
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	190	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 95		001 MNRG 002 06 003 SA05	
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	200	FINAL REQUEST VISUAL INSPECTION *REQD* *C/P MOVE		001 MNRG 002 06 003 SA03	
--	-----	---	--	--------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/ID
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DISPATCH	FUNCTIONAL CODE	A	C	36019N
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36020N

WORK CONTROL DOCUMENT (MEDS)

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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 4A4-22-4 4S-1-1B2	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN SPRING	26338A
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15. DISPATCH STATION PZR	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED NPN OPN	18. MECHANIC	19. "P"	20. "Q"
68A4107	25-1001	1620001323209 26338A L / H 26338A L / H			
68A4107	25-1002	1620001323209 26337A R / H 26337A R / H			
		GOVERNING DIRECTIVES: AFSCR 66-51 MANDI 66-9 BLAST IAW MIL-STD-1504 CAD PLATE IAW MIL-STD-870 VAC CAD PLATE IAW MIL-C-8897 FMPI IAW MIL-STD-1949 P/O NO1561 IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 *****UNIT COST \$26.14***** *****TELE*****			
		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 IN BLOCK 8 OF THIS WLC FORM. AVAILABLE 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 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36020N

U.S. GOVERNMENT PRINTING OFFICE: 1980-000-10

WORK CONTROL DOCUMENT (MEDS)

1 DATE 9041

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCS	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 SPRING
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15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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PROCEEDURES 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 15 IS EQUIVALENT TO DELTA STAMP.

001 68A410725-1001
68A410725-1002

[REDACTED]	[REDACTED]	DISASSEMBLE *C/P MOVE		001 MNEGM	
	REQD			002 02	
				003 LG02	
				005 X8745199	

[REDACTED]	[REDACTED]	DECREASE ONLY *C/P MOVE		001 MNEGM	
	REQD			002 02	
				003 DG02	

[REDACTED]	[REDACTED]	BLAST CLEAN ONLY (NOTE: PROTECT BUSHINGS) *C/P MOVE		001 MNEGM	
	REQD			002 03	
				003 PL07	

[REDACTED]	[REDACTED]	*C/P MOVE*		001 MNEGM	
	REQD			002 05	
				003 MEO3	

[REDACTED]	[REDACTED]	INSPECT VISUALLY FOR DISTORTION ROUTE 100X FOR SPRING TEST, CAD/IVD ALUM PLATE *C/P MOVE		001 MNEGM	
	REQD			002 04	
				003 EIC1	

[REDACTED]	[REDACTED]	TEST DOWN LOCK SPRING FOR LEAD AND DEFLECTION AND SERIALIZE PER DWG# 68A410725 (CONTINUED)		001 MNEGM	
	REQD			002 04	
				003 EIC1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	36020N

WORK CONTROL DOCUMENT (MED)

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLET	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SPRING						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		HIGH READING LOW READING *C/P MOVE*							
27	040	REMOVE BUSHINGS *C/P MOVE*						001 MNFRA	
								002 03	
								003 BE01	
28	050	VAPOR DECREASE *C/P MOVE						001 MNFRC	
								002 03	
								003 DG01	
28	060	STRIP VAC CAB *C/P MOVE						001 MNFRC	
								002 02	
								003 CS01	
28	070	STRIP RUST *C/P MOVE						001 MNFRC	
								002 02	
								003 CS02	
28	080	PRIOR TO VAC VAD/IVB, BRIT BLAST ALL AREAS TO BE VAC CAD/IVD PLATED. *C/P MOVE						001 MNFRC	
								002 01	
								003 BLO4	
28	090	VAC CAB PLATE SPRING COMPLETE *C/P MOVE						001 MNFRC	
								002 02	
								003 VCO1	
28	100	HOT WATER RINSE VAC CAB *C/P MOVE						001 MNFRC	
								002 02	
								003 IRC1	
28	110	VAC I.V.B. ALUM PLATE CLASS 2 TYPE II *C/P MOVE						001 MNFRC	
								002 03	
								003 IVO1	
28	120	ALODINE IVB ALUM PLATE CLASS 1A *C/P MOVE						001 MNFRC	
								002 03	
								003 FAC1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	B	36020N	

U.S. GOVERNMENT PRINTING OFFICE: 1959-500-10

36020N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041

4 4

PAGE ___ OF ___ 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 SPRING
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
	?	<p>*** NOTE ***</p> <p>IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *</p> <p>*C/P MOVE</p>	M	002 03 003 ML04	

140		<p>INSTALL BUSHING IN PROPER LOG HOLES</p> <p>"NOTE" DO NOT REAM</p> <p>*C/P MOVE</p> <p>P/N M81934/1-03C-016</p> <p>P/N M81934/1-07C-018</p>		002 03 003 8E01	
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150		<p>FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958</p> <p>*REQD*</p> <p>*C/P MOVE</p>		001 ML 03 002 06 003 SA03	
150		<p>FINAL PRODUCT VISUAL INSPECTION</p> <p>*REQD*</p> <p>*C/P MOVE</p>		001 ML 03 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36020N

WORK CONTROL DOCUMENT (MEDS)

DATE

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCT (MFG/REC/RCC)	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4A4-22-3 48-1-182	9. ITEM SERIAL NO.
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10. MODEL PREFIX-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. BOL/LAR TRUNNION
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
68A410638-1009	LH 1620010753563	36309A L / H			
68A410638-1009	LH 1620010753563	36309A L / H			
68A410638-1010	RH 1620010753564	36319A R / H			
68A410638-1010	RH 1620010753564	36337A R / H			

GOVERNING DIRECTIVES: AFLCR 66-51

MANDI 66-3

BLAST IAW MIL-STD-150

FMPI IAW MIL-STD-1949

P/O NO 561

CAD IAW MIL-STD-870

BAK IAW 48-1-182

MAI 7-12

&/OR P/O N61891

IVD ALUM PLATE IAW MIL-C-83488A

ALDINE IAW MIL-C-5541

*****S T E E L*****

*****250-300 KSI 300 M*****

*****UNIT COST \$983.65 *****

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"*****

(CONTINUED)

81. FINAL DESTINATION		82. COORDINATION/INITIATING RCC SIGNATURE/DATE		83. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	36022N

U.S. GOVERNMENT PRINTING OFFICE: 1969-00-00-00

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. SCHLAR TRUNNION
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE DONE/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	18. MECHANIC	19. "P"	20. "O"
	001	6E410638-1009 68A410638-1010			
34D	005	DISASSEMBLE *C/P MOVE		001 MNP GW	
	REQD			002 02	
				003 LG02	
34C	007	CHEM CLEAN *C/P MOVE		005 XE745199	
	REQD			001 MNP GW	
				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 @ 350-400F		001 MNP GW	
	REQD	DATE & TIME IN _____		002 03	
		DATE & TIME OUT _____		003 BK03	
		*C/P MOVE			
34H	013	F.M.P.I. *C/P MOVE		001 MNPNA	
	REQD		H	002 03	
				003 ME03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT#
DISPATCH	FUNCTIONAL CODE	A	C	36022N
		B	D	

WORK CONTROL DOCUMENT (MEDS)

1. DATE

PAGE 3 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
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13. SERIAL NUMBER	14. COLLAR TRUNNION
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15. DISPATCH STATION	16. PERCENTAGE OF (MED)	17. DESCRIPTION	18. MECHANIC	19. CODE	20. QUANTITY
		E AND I FLANGE BUSHING 0.375/0.375		001 MNPGR	
		BUNGEE ATTACH BOSS .500/.5015		002 04	
	REQD	CYLINDER ATTACH BOSS 2.742/2.744		003 EI01	
		C/P MOVE			
		***** NOTE *****			
		ROUTE UPPER COLLAR HALF AND LOWER COLLAR HALF AS MATCHED SET			

26	030	VAPOR DECREASE		001 MNPRC	
		C/P MOVE		002 03	
				003 DG01	
26	040	STRIP CAD		001 MNPRC	
		C/P MOVE		002 03	
				003 CS01	
26	050	STRIP RUST		001 MNPRC	
		C/P MOVE		002 02	
				003 CS02	
69	070	O/S BUNGEE ATTACH BOSS NOT TO EXCEED 0.5651		001 MNPRA	
		C/P MOVE		002 03	
				003 BE01	
69	080	O/S FLANGE BUSHING BOSS NOT TO EXCEED 0.5651		001 MNPRA	
		C/P MOVE		002 03	
				003 BE01	
69	090	MODIFY LIGHT WEIGHT COLLARS INTO HEAVYWEIGHT IAW DRWG 6BA410638		001 MNPRA	
		*C/P MOVE		002 03	
				003 LE02	
				005 X8633621	
69	095	REIDENTIFY COLLARS AFTER MOD.		001 MNPRA	
		R/H - 6BA410638-2020		002 03	
		L/H - 6BA410638-2019		003 BE01	
		*C/P MOVE			
26	110	TEMPER ETCH REWORKED AREAS		001 MNPRA	
		TIME OUT _____ DATE OUT _____		002 04	
		C/P MOVE		003 TE03	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	C	36022N

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. COLLAR TRUNNION						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. * * * * * WORK TO BE COMPLETED * * * * *				18. MECHANIC	19. "P"	20. "Q"	
26B	120	IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * * BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE AND TIME IN _____ DATE AND TIME OUT _____ *C/P MOVE*					001 MNPRC		
8A	130	F.M.P.I *C/P MOVE* * * * * * NOTE * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * *					001 MNPNA 002 02 003 ML04		
26	140	VAPOR DECREASE *C/P MOVE*					001 MNPRC 002 03 003 DG01		
26	150	SHOTPEEN COLLAR I.D. .012 A2 100% COVERAGE *C/P MOVE*					001 MNPRC 002 01 003 SF02		
26	160	SHOTPEEN REWORKED AREAS .012 A2 100% COVERAGE *C/P MOVE*					001 MNPRC 002 01 003 SF02		
26	260	GRIT BLAST ALL AREAS TO BE CAD/IVD *C/P MOVE					001 MNPRC 002 01 003 BL04		
26	270	CAD PLATE E II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE*					001 MNPRC 002 03 003 CA01		
26B	280	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE & TIME IN _____ DATE & TIME OUT _____ (CONTINUED)					001 MNPRC 002 02 003 BK01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36022N	
		B	D		

WORK CONTROL DOCUMENT (MEDS)

1 DATE

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. SIMILAR TRUNNION						
18. DISPATCH STATION	19. PERP. RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				*C/P MOVE	15. MECHANIC	16. "P"	20. "Q"
26	290	IRIDITE				*C/P MOVE*		001 MNPRC	
								002 02	
								003 IR01	
26	330	VAC, IVD ALUM PLATE CLASS 2 TYPE I						001 MNPRC	
		NOTE: OPERATION 140 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION.						002 03	
						*C/P MOVE		003 IV01	
26	340	ALODINE IVD ALUM PLATE CLASS 1A						001 MNPRC	
						C/P MOVE		002 03	
								003 TA01	
69	350	MACHINE BUNGEE ATTACH BUSHING						001 MNPRA	
		P/N 7829423-33				*C/P MOVE*		002 03	
								003 LB02	
69	360	INSTALL BUSHING IN BUNGEE ATTACH						001 MNPRA	
		BOSS REAM TO .500/.5015				*C/P MOVE*		002 03	
		P/N 7829423-33 (1) EA						003 BE01	
69	370	MACHINE FLANGED BUSHING						001 MNPRA	
						C/P MOVE		002 03	
		P/N ST4M139C6-23						003 LB02	
69	380	INSTALL FLANGED BUSHING REAM .375/						001 MNPRA	
		.376				*C/P MOVE*		002 03	
		P/N ST4M139C6-23 (1) EA						003 BE01	
34A	400	FINAL ACCEPTANCE OF WORK CONTROL						001 MNPGW	
		DOCUMENT OF COMPLETENESS & ACCURACY						002 02	
		REQD OF ALL PRECEDING OPERATIONS THIS 958						003 ML01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN	
DISPATCH	FUNCTIONAL CODE	A	C	36022N	
		B	D		

WORK CONTROL DOCUMENT (MEDS)

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. NOMENCLATURE
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18. DISPATCH STATION	19. PERCENTAGE OF WORK COMPLETED	17. FINAL PRODUCT VISUAL INSPECTION	18. MECHANIC	19. MNP	20. PGW
		FINAL PRODUCT VISUAL INSPECTION		001 MNP	001 PGW
		C/P MOVE		002 04	
	REQD			003 ML	001
34A	420	ASSEMBLE		001 MNP	PGP
				002 03	
				003 SA	003
34P	430	PAINTE		001 MNP	PGP
		1. CLEAN		002 09	
		2. MASK		003 SP	003
		3. PRIME			
		4. PAINT 1ST COAT			
		5. PAINT 2ND COAT			
		C/P MOVE			
34P	440	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP	PGP
				002 09	
	REQD			003 SP	003
34P	450	FINAL PRODUCT VISUAL INSPECTION		001 MNP	PGP
				002 09	
	REQD			003 SP	003

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36022N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-04-01

36023N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89072

PAGE 1 OF 1 PAGES

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 4A4-22-3 48-1-182	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN CONNECTING LINK ASSY	26378A
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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68A410	11-1001	26338A L / H 26337A R / H			
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GOVERNING DIRECTIVES: AFLOR 66-51
MANDI 66-3
IAW MIL-STD-1504
IAW MIL-STD-883B

UNIT COST \$ 233.23 ***
***** I T A N I U *****

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PROCEDURES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND I.O. SUPPLEMENTS REFERENCED IN BLOCK 6 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 ABOVE) FOR STORAGE 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
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36023N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1989-08-18

36023N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 9072

2

PAGE OF 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 CONNECTING LINK ASSY
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15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		START			
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	001	03A110011 1001			
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		INSPECTION	*C/P MOVE	001 MNP SW	
	REQD			002 02	
				003 LG02	
				005 X8745199	

		CHEM CLEAN	*C/P MOVE	001 MNP SW	
	REQD			002 03	
				003 ACC2	

		BLAST CLEAN ONLY	*C/P MOVE	001 MNP SW	
	REQD			002 03	
				003 BLC7	

			*C/P MOVE	001 MNP SW	
	REQD			002 05	
				003 ZY05	

		8 I IMPRESSION (AS PER FIG 2-5)		001 MNP SW	
	REQD	BUSHING #23 .425/.428		002 04	
		BUSHING #24 .325/.328		003 E101	
		SPHERICAL BEARING I.D. .3745/.3770			
		CHECK BEARING FOR EXCESSIVE PLAY OR			
		LOOSENESS BETWEEN RACE AND LINK			
		*C/P MOVE			

		STAKE METAL STAKE AS PER T.O.		001 MNP SW	
		*C/P MOVE		002 03	
				003 BE01	

		STAKE AS PER T.O.		001 MNP SW	
		C/P MOVE		002 03	
		(CONTINUED)		003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/N
DISPATCH	FUNCTIONAL CODE	A	E	36023N
		B	F	

36023N WORK CONTROL DOCUMENT (MEDS)

DATE 9072

PAGE 3 OF 3 PAGES

1. JOB ORDER NO	2. 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 CONNECTING LINK ASSY
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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 68A410777-2001			
009		MACHINE BUSHING *C/P MOVE P/N 68A410777-2001		001 MNR RA 002 03 003 LEO2	
050		INSTALL BUSHING P/N 68A410777-2001 MACHINE I.D. .425/.426 *C/P MOVE		001 MNR RA 002 03 003 BE01	
064		MACHINE BUSHING *C/P MOVE P/N 68A410777-2003		001 MNR RA 002 03 003 LEO2	
063		INSTALL BUSHING P/N 68A410777-2003 MACHINE I.D. .325/.326		001 MNR RA 002 03 003 BE01	
		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNR RA 002 03 003 SA03	
		FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNR RA 002 03 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	36023N

36025N

WORK CONTROL DOCUMENT (MEDS)

DATE 87041

PAGE 1 OF 1 PAGES

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 4A4-22-3 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL DESIGN-SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN BELL CRANK ASSEMBLY	15. 26338A
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18. DISPATCH STATION P7M	16. PERF RCC/OP NO 001-1001	17. WORK TO BE ACCOMPLISHED N.S.L. 26338A L / H 26337A R / H	18. MECHANIC	19. "P"	20. "Q"
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GOVERNING DIRECTIVES: AFLOR 66-51 MANDI 66-3 IAW MIL-STD-1504 IAW MIL-STD-6866					
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***** ***** I T A N I U M ***** *****					
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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 AFLO FORM 950. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
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EQUIPMENT WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
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<p style="text-align: center;">W A R N I N G</p> 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.					
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REQD (MANDATORY REQUIREMENT) IN (CONTINUED)					
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36025N	
		B	D		

CONTROL DOCUMENT (MIL-STD-1316)

FORM 9041

PAGE 1 OF 2 PAGES

7. ORDER NO.		8. QUANTITY		9. PRODUCTION SEC/ACC		10. DATE ORDERED		11. DATE COMPLETED					
12. PART NUMBER				13. TECH DATA				14. ITEM SERIAL NO.					
15. MODEL DESIGN SERIES			16. STOCK NUMBER			17. OPTIONAL							
18. SERIAL NUMBER			19. NOUN BELL CRANK ASSEMBLY										
20. DISPATCH STATION		21. PERF RCC/OP NO		22. WORK TO BE ACCOMPLISHED				23. MECHANIC		24. "P"		25. "Q"	
		001		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.									
		001		DISASSEMBLE				*C/P MOVE		001 MNFCW		002 02	
		REQD								003 LG02		005 X8745199	
		001		DEGREASE ONLY				*C/P MOVE		001 MNFCW		002 02	
		REQD								003 DG02			
		001		CLEAN CLEAN ONLY				*C/P MOVE		001 MNFCW		002 03	
		REQD								003 BLC7			
		001						*C/P MOVE		001 MNFCW		002 05	
		REQD								003 ZY05			
		001		#1 INSPECTION (AS PER FIG 0 2, REF #18 & 19.)						001 MNFCW		002 04	
		REQD		LINK HOLE $- .5000 + .0015 - .0000$						003 E101			
		001		CYLINDER HOLE $1.496 + .0010 - .0000$									
		REQD		PIN HOLE $1.4375 + .0020 - .0000$									
		001		BUSHING I.D. $1.4367/1.4372/1.4390$									
		REQD		*C/P MOVE									
		001		LINK HOLE TO $1.5597/1.560$						001 MNFCW		002 03	
		REQD		*C/P MOVE								003 BE01	
		001		P/N 7829424-61				*C/P MOVE		001 MNFCW		002 03	
		REQD										003 LE02	

26. FINAL DESTINATION		27. COORDINATION/INITIATING RCC SIGNATURE/DATE				28. DOCUMENT/BN	
DISPATCH		FUNCTIONAL CODE		A		C	
						36025N	

36025N WORK CONTROL DOCUMENT (MEDS)

1 34789041

3 3

PAGE 07 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/ACC		5. DATE SERIES		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 BELL CRANK ASSEMBLY							
15. DISPATCH STATION		16. PERF RCC/OP NO		17.				18. MECHANIC	19.	20.
040		040		INSTALL OVERSIZED [REDACTED] P/N 7829424-61, [REDACTED] 1.496/1.497 64 RMS FINISH PRESS FIT -.0010/.0030 *C/P MOVE				001 MNDRA "Q"	002 03	003 HH00
049		049		DRILL #10 DIA THRU 2 HOLES IN LINE *C/P MOVE				001 MNDRA	002 03	003 DP02
050		050		AFTER CYL BUSHING [REDACTED] REAM MACHINE HOLES [REDACTED] .0020 0.0000 *C/P MOVE				001 MNDRA	002 03	003 BE01
060		060		MACHINE LINK [REDACTED] TO .5630 .5649 *C/P MOVE				001 MNDRA	002 03	003 BE01
069		069		MACHINE B/S LINK [REDACTED] .5674 VALUE P/N 7829418-03				001 MNDRA	002 03	003 LE02
070		070		INSTALL OVERSIZED [REDACTED] P/N 7829418-03 [REDACTED] TO .5000/.5015 64 RMS FINISH PRESS FIT -.0010/.0030 *C/P MOVE				001 MNDRA	002 03	003 BE01
070		070		*REQD* PLEASE ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS AND ACCURACY OF ALL PRECEDING OPERATIONS THIS 950				001 MNDRA	002 03	003 SA03
070		070		*REQD* FINE PRODUCT VISUAL [REDACTED] *C/P MOVE				001 MNDRA	002 03	003 SA03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SH	
DISPATCH	FUNCTIONAL CODE	A	C	36025N	

36026N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 9041

1

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/CC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4A4-22-3-4 4S-1-182	9. ITEM SERIAL NO.
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10. MODEL DESIGN SERIES F-15 MAIN LAND NG GEAR	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN HIGH PRESSURE PISTON	26337A
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18. DISPATCH STATION P7R	19. PERF RCC/OP NO 70-2001	17. WORK TO BE ACCOMPLISHED NON E7R	18. MECHANIC	19. "P"	20. "Q"
68A410	70-2001	<p>UNIT 888T 4783.00</p> <p>GOVERNING DIRECTIVES: AFLDR 66-51 MANOI 66-3 BLAST IAW MIL-STD-1504 BRAKE IAW 4S-1-182 MADI 74-12 FPI IAW MIL-STD-6864 FMPI IAW MIL-STD-1949</p> <p>F70 N01561</p> <p>CAD PLATE IAW MIL-STD 870 STIMP IAW MIL-STD-871 TEMPER ETCH IAW MIL-STD-847 SAUTPEEN IAW MIL-STD-1503 CHROME PLATE IAW MIL-STD-868 NICKEL PLATE IAW MIL-STD-868 IVD ALUM PLATE IAW MIL-C-83488A ALUMINE IAW MIL-STD-8641</p> <p>*****STEEL 300M 280/300 KSI*****</p> <p>ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDOUS MATERIALS IN THE BASIC OPERATIONAL ORDER AND T.C. PROCEDURES. ALL TOOLS AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.</p> <p>*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.</p> <p>*****W A R N I N G*****</p> <p>MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)</p>			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	36026N

36026N

WORK CONTROL DOCUMENT (MEDS)

DATE 9041

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PAGE 01 OF 01 PAGES

1. JOB ORDER NO	2. 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 HIGH PRESSURE PISTON	

15. DISPATCH STATION	16. PERP 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 BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	JWI	089410790-2001			
	[REDACTED]	[REDACTED] *C/P MOVE		001 XNFGW	
	REQD			002 02	
	[REDACTED]	[REDACTED] *C/P MOVE		003 LG02	
	REQD			005 XB745199	
	[REDACTED]	[REDACTED] *C/P MOVE		001 XNFGW	
	REQD			002 02	
	[REDACTED]	[REDACTED] *C/P MOVE		003 DG02	
	REQD			001 XNFGW	
	[REDACTED]	[REDACTED] *C/P MOVE		002 03	
	REQD	DATE IN _____ TIME IN _____		003 BK03	
	[REDACTED]	[REDACTED] *C/P MOVE			
	[REDACTED]	[REDACTED] *C/P MOVE		001 XNFGW	
	REQD		M	002 05	
	[REDACTED]	[REDACTED] *C/P MOVE		003 MS03	
	[REDACTED]	[REDACTED] *C/P MOVE		001 XNFGW	
	REQD	PISTON LANDS O.D 4.9325/4.9345 WEAR 4.9285 (CONTINUED)		002 04	
	[REDACTED]	[REDACTED] *C/P MOVE		003 BX01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	B	36026N

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/CSG	5. DATE ISSUED	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 HIGH PRESSURE PISTON
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PISTON LANDS I.D. 3.0060/3.0020 WEAR 3.0060 GROOVE O.D. 4.4575/4.4605 WEAR 4.4555 GROOVE I.D. 3.369/3.371 WEAR 3.373 *C/P MOVE			
26	024	VAPOR BEDREASE *C/P MOVE		001 MNERC 002 03 003 2001	
26	025	STRIP CAD *C/P MOVE		001 MNERC 002 02 003 CS01	
26	028	STRIP RUST *C/P MOVE		001 MNERC 002 02 003 CS02	
26	030	STRIP CHROME PISTON LANDS O.D. *C/P MOVE		001 MNERC 002 02 003 SC02	
26	040	STRIP CHROME PISTON LANDS I.D. *C/P MOVE		001 MNERC 002 02 003 SC02	
26	045	STRIP CHROME PISTON I.D. *C/P MOVE		002 02 003 SC02	
26	050	STRIP NICKEL PISTON GROOVE O.D. *C/P MOVE		001 MNERC 002 03 003 SN01	
26	060	STRIP NICKEL PISTON GROOVE I.D. *C/P MOVE		001 MNERC 002 03 003 SN01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/N
DISPATCH	FUNCTIONAL CODE	A	B	36026N

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34026N WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE ORDERED	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 HIGH PRESSURE PISTON	

15. DISPATCH STATION	16. PERF RCC/OP NO	17.	18. MECHANIC	19.	20.
5	070	FIRST GRIND PISTON MIN. DIA. 4.9125 *C/P MOVE		001 MNEBY "G"	002 02 003 GEC1
5	080	FIRST GRIND PISTON MAX. DIA. 3.022 *C/P MOVE		001 MNEBY	002 02 003 G103 005 X8745175
5	090	FIRST GRIND PISTON MIN. DIA. 4.4395 *C/P MOVE		001 MNEBY	002 02 003 GEC1
5	100	FIRST GRIND PISTON MAX. DIA. 3.389 *C/P MOVE		001 MNEBY	002 02 003 G103 005 X8745175

DATE OUT	TIME OUT	DATE OUT	M	001 MNEBY	002 06 003 TEC3
* * * * * N O T E * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * *					

122	122	TAKE 4 HRS WITHIN 8 HRS OF ETCN		001 MNEBY	002 02 003 BK02
DATE IN	TIME IN	DATE OUT	TIME OUT	*C/P MOVE	001 MNEBY

* * * * * N O T E * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * *					
			M	001 MNEBY	002 06 003 MLC4

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	36026N	

WORK CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO		2. QUANTITY		4. PRODUCTION SEC/CS		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 HIGH PRESSURE PISTON						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19.	20.
25 ✓	133	VAPOR DECREASE *C/P MOVE						001 MNRFC	002 03
								003 DGO1	
26 ✓	140	SHOTPEEN REWORKED AREA'S INTENSITY OF .008/.012A *C/P MOVE						001 MNRFC	002 01
								003 SPD2	
26 ✓	143	PREPARE PISTON LANDS O.B. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC MECHANIC SIGN OFF REQD						001 MNRFC	002 02
								003 BE01	005 X8412386
26 ✓	147	PREPARE PISTON LANDS O.B. FOR CHROME PLATE GRIT BLAST *C/P MOVE						001 MNRFC	002 01
								003 BLO4	
26 ✓	150	CHROME PLATE PISTON LANDS O.B. CLASS III TYPE II SUFF. TO GRIND TO 4.9325/4.9345						001 MNRFC	002 02
								003 CPO1	005 X8412386
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQD *C/P MOVE						006 0010	
268 ✓	153	BAKE 4 HRS AT 350 °C WITHIN 1 HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNRFC	002 02
								002 BK01	
26 ✓	157	PREPARE PISTON LANDS I.E. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE ETC MECHANIC SIGN OFF REQD						001 MNRFC	002 02
								003 BE01	005 X8412386
26 ✓	156	PREPARE PISTON LANDS I.E. FOR CHROME PLATE, GRIT BLAST *C/P MOVE						001 MNRFC	002 01
								003 BLO4	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/NO
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

1. JOB ORDER NO	2. QUANTITY	3. PRODUCTION SEC/PCS	4. DATE SCHED	5. 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 HIGH PRESSURE PISTON
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" NUMBER	20. "Q" NUMBER
20	180	CHROME PLATE PISTON LANDS I.D. CLASS III TYPE II SUFF. TO GRIND TO 3.000/3.002 DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQD *C/P MOVE		001 MNRRC 002 02 003 CPC1 005 XB412386 008 GI410	
20B	170	BAKE 4 HRS AT 350 400 F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNRRC 002 02 003 BK01	
20	180	FINISH GRIND PISTON LANDS O.D. 4.9325/4.9345 32 RMS *C/P MOVE		001 MNRRC 002 02 003 BE01	
20	190	FINISH GRIND PISTON LAND I.D. 3.000/3.002 32 RMS *C/P MOVE		001 MNRRC 002 02 003 GI03 005 XB412386	
20B	200	BAKE 4 HRS AT 350 400 F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNRRC 002 02 003 BK01	
20B	200	PREPARE PISTON GROOVE O.D. FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNRRC 002 03 003 BE01 005 XB412386	
20	207	PREPARE PISTON GROOVE O.D. FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNRRC 002 01 003 BL04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/IN
DISPATCH	FUNCTIONAL CODE	A	C	36026N

U.S. GOVERNMENT PRINTING OFFICE: 1969-00-00-00

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 HIGH PRESSURE PISTON
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" NUMBER	20. "Q" NUMBER
✓	210	NICKEL PLATE PISTON GROOVE I.D. SUFF. TO GRIND TO 4.4575/4.4605 DATE OUT-----TIME OUT----- *C/P MOVE		001 MNFRG 002 03 003 NP01 005 XB412386 006 NP01	
✓	217	BAKE 24 HRS AT 350 400F WITHIN 4 HRS OF NICKEL PLATE DATE IN-----TIME IN----- DATE OUT-----TIME OUT----- *C/P MOVE		001 MNFRG 002 02 003 BK01	
✓	218	PREPARE PISTON GROOVE I.D. FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNFRG 002 03 003 BE01 005 XB412386	
✓	218	PREPARE PISTON GROOVE I.D. FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNFRG 002 01 003 BL04	
✓	220	NICKEL PLATE PISTON GROOVE I.D. SUFF. TO GRIND TO 2.3677/2.371 DATE OUT-----TIME OUT----- *C/P MOVE		001 MNFRG 002 03 003 NP01 005 XB412386 006 NP01	
✓	230	BAKE 24 HRS AT 350 400F WITHIN 4 HRS OF NICKEL PLATE DATE IN-----TIME IN----- DATE OUT-----TIME OUT----- *C/P MOVE		001 MNFRG 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1965-0-565-782

WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/ACC	5. DATE BEGINS	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 HIGH PRESSURE PISTON
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MM HRS	20. "G"
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8	240	FINISH GRIND PISTON GROOVE 0.13 4.4575/4.4605 32 RMS *C/P MOVE		001 MM HRS 002 02 003 GE01	
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9	200	FINISH GRIND PISTON GROOVE 1.18 3.969/3.971 32 RMS *C/P MOVE		001 MM HRS 002 02 003 GI03 005 AS745175	
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200	200	BAKE 7 HRS AT 300-400 F		002 02 003 BK01	
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		DATE IN-----TIME IN-----			
		DATE OUT-----TIME OUT-----			
		*C/P MOVE			

		*C/P MOVE		001 MM HRS	
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		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 05 003 ML04	
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		*C/P MOVE		001 MM HRS	
--	--	-----------	--	------------	--

	265	VAPOR DECREASE		002 03 003 DS01	
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		*C/P MOVE		001 MM HRS	
--	--	-----------	--	------------	--

		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ZS01	
--	--	--	---	--------------------	--

		*C/P MOVE		001 MM HRS	
--	--	-----------	--	------------	--

26	275	PRIOR TO CAD/IVD, CRIT BLAST ALL AREASE TO BE CAD/IVD PLATED *C/P MOVE		002 01 003 BL04	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
DISPATCH FUNCTIONAL CODE	A C	36026N

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36026N

WORK CONTROL DOCUMENT (WCD)

DATE 9041

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1. JOB ORDER NO	2. QUANTITY	3. PRODUCTION SECTORS	4. DATE SCHED	5. DATE COMPLETED
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6. PART NUMBER	7. TECH DATA	8. 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 HIGH PRESSURE PISTON
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15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
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25	280	CAD PLATE ID ONLY TYPE II CLASS I *C/P MOVE		001 MNFR 002 03 003 CA01	
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26B	290	BAKE 25 HRS AT 350/400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____		001 MNFR 002 02 003 BK01	
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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26	295	IRIDITE C/P MOVE		001 MNFR 002 02 003 IR01	
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	-65	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNFR 002 06 003 ML04	
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26	303	VAD IVD ALUM PLATE ID ONLY CLASS 2 TYPE II NOTE: OPERATION--290 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USE.		001 MNFR 002 03 003 1001	
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26	307	ALBINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNFR 002 03 003 TA01	
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	310	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNFR 002 06 003 SA03	
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	
		36026N

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

F-15 MLG

RA001	STEP	DATE	DESCRIPTION	FACT	STANDARD	DESCRIPTION	BASE HOURS	PRD TIME	STD HOURS	A BLY PCT C
0001	JA 01	00	PERCENT ENGR 89.2	.41	F-15 MAIN OUTER CYLINDER PART NUMBER/NSN	7.04	.000	.000	2.88	0
0010			68A410702-1003		1620010667226					
0020			68A410702-1004		1620010667225					
0030			68A410702-1005		1620010760547					
0040			68A410702-1006		1620040753562					
0050			68A410702-1001		1620003592094					
0060			68A410702-1002		1620003486499					
0030	JA 01	15	REMOVE BUSHING WITH PRESS	.75	PRORATE OVER 4 PARTS	.089	.010	.075		1
0010 E			RDM-SU-01	.25	S/U FOR BENCH WCRK GENERAL	.27525		.079		
0020 E			RLG-RS-K1	1.00	REN BUSHING (1ST OR SINGLE)	.01099		.012		
0030 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0040	JA 01	15	NICK & BURR --40--	.05	PRORATED OVER 4 PARTS	.351	.003	.020		0
0010 E			RDM-SU-01	.25	S/U FOR BENCH WCRK GENERAL	.27525		.079		
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078		
0030 E			RLG-HP-V1	4.00	TURN OBJ 190° IN STRAP VISE REPOSITION 4 TIMES	.00612		.028		
0040 E			GCL-CD-AS130	130.00	CLN SPT/SD IN W/DRILL & BRSH45 SQ IN X 2 ROUGH & FINISH	.00138		.206		
0050 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0045	JA 01	15	O/S HOLE ON MILL/SMALL PART	1.00	PRORATE OVER 4 PARTS	.911	.137	1.048		15
0010 E			KMH-SU-V1	.25	S/U VERT MILL BORE SHAL FTRPRORATE 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-BD-CC	1.00	BORE HOLE 2 X 1 1/2 GROUP 4 USE PROPER ELEMENT/TABLE	.48456		.559		
0060 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0050	JA 01	15	OVERSIZE HOLE WITH REAMER	.05	PRORATE OVER 4 PARTS	.353	.003	.020		0
0010 E			RDM-BU-S1	.25	SET UP TO REMUSH BOSSES	.18669		.053		
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078		
0030 E			RDM-BU-R2	3.00	REAM WITH LEPCO REAMER 3 PASSES	.07337		.253		
0040 E			RDM-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.009		
0050 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0070	JA 01	15	OVERSIZE HOLE WITH REAMER	.05	PRORATE OVER 4 PARTS	.353	.003	.020		0
0010 E			RDM-BU-S1	.25	SET UP TO REMUSH BOSSES	.18669		.053		
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078		
0030 E			RDM-BU-R2	3.00	REAM WITH LEPCO REAMER 3 PASSES	.07337		.253		
0040 E			RDM-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.009		
0050 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0060	JA 01	15	O/S HOLE ON MILL/SMALL PART	.05	PRORATE OVER 4 PARTS	.760	.006	.044		1
0010 E			KMH-SU-V1	.25	S/U VERT MILL BORE SHAL FTRPRORATE 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-BD-DA	1.00	BORE HOLE 2.5 X 1 1/2 GROUP 4 USE PROPER ELEMENT/TABLE	.33548		.385		
0060 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0070	JA 01	15	OVERSIZE HOLE WITH REAMER	.05	PRORATE OVER 4 PARTS	.353	.003	.020		0
0010 E			RDM-BU-S1	.25	SET UP TO REMUSH BOSSES	.18669		.053		
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078		
0030 E			RDM-BU-R2	3.00	REAM WITH LEPCO REAMER 3 PASSES	.07337		.253		
0040 E			RDM-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.009		
0050 E			RJP-PU-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011		
0080	JA 01	15	OVERSIZE HOLE WITH REAMER	.05	PRORATE OVER 4 PARTS	.353	.003	.020		0
0010 E			RDM-BU-S1	.25	SET UP TO REMUSH BOSSES	.18669		.053		
0020 E			RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078		
0030 E			RDM-BU-R2	3.00	REAM WITH LEPCO REAMER 3 PASSES	.07337		.253		

0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009	
0050 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
	JA 01	15	.05	OVERSIZE HOLE WITH REAMER		.353	.000	.020	0
0010 E		RBW-BU-S1	.25	SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.04831		.078	
0030 E		RBW-BU-R2	3.00	REAM WITH LEHPCO REAMER	3 PASSES	.07337		.253	
0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009	
0050 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0095	JA 01	15	.05	OVERSIZE HOLE WITH REAMER		.353	.000	.020	0
0010 E		RBW-BU-S1	.25	SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.04831		.078	
0030 E		RBW-BU-R2	3.00	REAM WITH LEHPCO REAMER	3 PASSES	.07337		.253	
0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009	
0050 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0405	JA 01	15	1.00	HAND HONE BUSHING		.275	.001	.317	4
0010 E		RBW-BU-S1	.25	SET UP TO REMUSH 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	
0080 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0409	JA 01	15	.91	TURN BUSHING GROUP 1/BRONZE		.443	.040	.444	7
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.046	
0030 E		KML-TA-EC	4.00	DIA 1.50-2.00 REN .033-.250		.06699		.308	
0040 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0410	JA 01	15	.91	INST/REAM SET FLANGED BUSH		1.010	.138	1.057	15
0010 E		RBW-BU-S1	.25	SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	4.00	REMUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		1.096	
0030 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0419	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE		.443	.003	.025	0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.046	
0030 E		KML-TA-EC	4.00	DIA 1.50-2.00 REN .033-.250		.06699		.308	
0040 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0420	JA 01	15	.05	INST/REAM SET FLANGED BUSH		1.010	.000	.058	1
0010 E		RBW-BU-S1	.25	SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	4.00	REMUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		1.096	
0030 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0429	JA 01	15	.91	TURN BUSHING GROUP 1/BRONZE		.211	.029	.222	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-CC	1.00	DIA .501-1.00 REN .033-.250		.06699		.077	
0040 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0430	JA 01	15	.91	HAND HONE BUSHING		.275	.000	.280	4
0010 E		RBW-BU-S1	.25	SET UP TO REMUSH 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	
0080 E		RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011	
0439	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE		.211	.000	.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	KNL-TA-CC	1.00 DIA .501-1.00 REN .033-.250	.06699	.077	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
JA 01	15	.05 HAND HONE BUSHING	.275	.002	.016
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	
0080 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0449	JA 01	15 .91 TURN BUSHING GROUP 1/BRONZE	.211	.029	.222
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	KNL-TA-CC	1.00 DIA .501-1.00 REN .033-.250	.06699	.077	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0450	JA 01	15 .91 HAND HONE BUSHING	.275	.038	.288
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	.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	
0080 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0459	JA 01	15 .05 TURN BUSHING GROUP 1/BRONZE	.211	.002	.012
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	KNL-TA-CC	1.00 DIA .501-1.00 REN .033-.250	.06699	.077	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
JA 01	15	.05 HAND HONE BUSHING	.275	.002	.016
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	.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	
0080 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0469	JA 01	15 .82 TURN BUSHING GROUP 4/STEEL	.849	.104	.801
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	6.00 1ST PART IN-OUT SCROLL CHUCK	.01006	.069	
0030 E	KNL-TD-CC	6.00 DIA .501-1.00 REN .033-.250	.10898	.751	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0470	JA 01	15 .82 INST/REAM SET FLANGED BUSH	.771	.095	.728
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	3.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835	.822	
0030 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0479	JA 01	15 .05 TURN BUSHING GROUP 4/STEEL	.849	.006	.049
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	6.00 1ST PART IN-OUT SCROLL CHUCK	.01006	.069	
0030 E	KNL-TD-CC	6.00 DIA .501-1.00 REN .033-.250	.10898	.751	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0480	JA 01	15 .05 INST/REAM SET FLANGED BUSH	.771	.006	.044
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	3.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835	.822	
0030 E	RJP-PW-R1	1.00 REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
JA 01	15	.82 TURN BUSHING GROUP 1/BRONZE	.297	.037	.280
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-FC	2.00	DIA 2.00-3.00 REM .033-.250		.07104		.163	
40 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
JA 01	15	.82	HAND HONE BUSHING		.399	.049	.377	5
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-AA	2.00	INSTALL ONE STRAIGHT BUSHING		.02062		.047	
0030 E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 N		2.00	HONE PART NAME		.10000		.230	
0060 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0070 E	RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D		.00333		.007	
0080 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0499	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.297	.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-FC	2.00	DIA 2.00-3.00 REM .033-.250		.07104		.163	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0500			XXXXXXXXXXXXXX					
0500	JA 01	15	1.00	HAND HONE BUSHING	.399	.060	.459	7
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-AA	2.00	INSTALL ONE STRAIGHT BUSHING		.02062		.047	
0030 E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 N		2.00	HONE PART NAME		.10000		.230	
0060 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0070 E	RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D		.00333		.007	
0080 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			07SEP83 REVIEW & CHG OCC. FACTORS	0.86				
0011			14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <	1.21				
716			19HAR85 DOWN GRADED NOT MARKET BASKET					
.900			J.CALDWELL TECH MANEAM					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

<---X---X--->

1234567890123456 ELSE PUT IN END

OPER	TECH	S	W	F	P	A/R	REV												
SUB	T	K	SR	A	FA	SUPPORT	OCC	←	DESCRIPTION	→	BASE	PFD	STD						A
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C				
	S	E	JA	EA	1	K	88183	.41	PERCENT ENGR 89.2	F-15 MAIN OUTER CYLINDER	6.98		2.86						
			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000						0
0030									68A410702-1005	1620010760547									
0040									68A410702-1006	1620040753562									
0030		JA	01		15			.73	REMOVE BUSHING WITH PRESS		.089	.010	.075						1
0010	E					RBW-SU-01		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079						
0020	E					RLG-RS-K1		1.00	REM BUSHING (1ST OR SINGLE)		.01099		.012						
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011						
0040		JA	01		15			.05	NICK & BURR --40--		.351	.003	.020						0
0010	E					RBW-SU-01		.25	S/U FOR BENCH WORK GENERAL	PRORATED OVER 4 PARTS	.27525		.079						
0020	E					RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078						
0030	E					RLG-HP-V1		4.00	TURN OBJ 190° IN STRAP VISE REPOSITION 4 TIMES		.00612		.028						
0040	E					GCL-CD-A5130		3.00	CLN SPT/SQ IN W/DRILL & BRSH65 SQ IN X 2 ROUGH & FINISH		.00138		.206						
0050	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011						
0045		JA	01		15			1.00	O/S HOLE ON MILL/SMALL PART		.911	.137	1.048						15
0010	E					KHM-SU-V1		.25	S/U VERT MILL BORE SHAL FTRPRORATE OVER 4 PARTS		.50518		.145						
0020	E					RHL-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098						
0030	E					RHL-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146						
0040	E					RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087						
0050	E					RHL-BD-CC		1.00	BORE HOLE 2 X 1 1/2 GROUP 4 USE PROPER ELEMENT/TABLE		.48656		.559						
0060	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011						
0050		JA	01		15			.05	OVERSIZE HOLE WITH REAMER		.353	.003	.020						0
0010	E					RDW-BU-S1		.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053						
0020	E					RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078						
0030	E					RDW-BU-R2		3.00	REAM WITH LENPCD REAMER 3 PASSES		.07337		.253						
0040	E					RDW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009						
0050	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011						
0070		JA	01		15			.05	OVERSIZE HOLE WITH REAMER		.353	.003	.020						0
0010	E					RDW-BU-S1		.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053						
0020	E					RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078						
0030	E					RDW-BU-R2		3.00	REAM WITH LENPCD REAMER 3 PASSES		.07337		.253						
0040	E					RDW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009						
0050	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011						
0060		JA	01		15			.05	OVERSIZE HOLE WITH REAMER		.353	.003	.020						0
0010	E					RDW-BU-S1		.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053						
0020	E					RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078						
0030	E					RDW-BU-R2		3.00	REAM WITH LENPCD REAMER 3 PASSES		.07337		.253						
0040	E					RDW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009						
0050	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011						
0090		JA	01		15			.05	OVERSIZE HOLE WITH REAMER		.353	.003	.020						0
0010	E					RDW-BU-S1		.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053						
0020	E					RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078						

0030 E	RDM-BU-R2	3.00	REAM WITH LEHPCO REAMER	3 PASSES	.07337		.253	
0040 E	RDM-DB-A1	2.00	BEAM HOLE/CUTOUT BOTH SIDES		.00423		.009	
0050 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0095	JA 01	15	.05	OVERSIZE HOLE WITH REAMER	.353	.003	.020	0
0010 E	RDM-BU-S1	.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RLB-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.04831		.078	
0030 E	RDM-BU-R2	3.00	REAM WITH LEHPCO REAMER	3 PASSES	.07337		.253	
0040 E	RDM-DB-A1	2.00	BEAM HOLE/CUTOUT BOTH SIDES		.00423		.009	
0050 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0405	JA 01	15	1.00	HAND HONE BUSHING	.265	.040	.305	4
0010 E	RDM-BU-S1	.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDM-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RDM-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 E		1.00		HONE PART NAME	.10000		.115	
0060 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0070 E	RDM-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0080 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0409	JA 01	15	.91	TURN BUSHING GROUP 1/BRONZE	.443	.060	.464	7
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.046	
0030 E	KHL-TA-EC	4.00	BIA 1.50-2.00 REN .033-.250		.06699		.308	
0040 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0410	JA 01	15	.91	INST/REAM SET FLANGED BUSH	1.010	.138	1.057	15
0010 E	RDM-BU-S1	.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDM-BU-B1	4.00	REHON A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		1.096	
0030 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0419	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.443	.003	.025	0
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.046	
0030 E	KHL-TA-EC	4.00	BIA 1.50-2.00 REN .033-.250		.06699		.308	
0040 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
	JA 01	15	.05	INST/REAM SET FLANGED BUSH	1.010	.008	.058	1
0010 E	RDM-BU-S1	.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDM-BU-B1	4.00	REHON A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		1.096	
0030 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0429	JA 01	15	.91	TURN BUSHING GROUP 1/BRONZE	.211	.029	.222	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	KHL-TA-CC	1.00	BIA .501-1.00 REN .033-.250		.06699		.077	
0040 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0430	JA 01	15	.91	HAND HONE BUSHING	.265	.036	.278	4
0010 E	RDM-BU-S1	.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDM-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RDM-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 E		1.00		HONE PART NAME	.10000		.115	
0060 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0070 E	RDM-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0080 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0439	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	KHL-TA-CC	1.00	BIA .501-1.00 REN .033-.250		.06699		.077	
0040 E	RJP-PV-R1	1.00	REN NPL PAPERMARK SIGN OFF DOC		.01001		.011	
0440	JA 01	15	.05	HAND HONE BUSHING	.265	.002	.015	0
0010 E	RDM-BU-S1	.25	SET UP TO REDUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDM-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	

0030 E	RBW-SU-01	.25 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 M		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 1 D		.00333		.003	
0080 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0450 JA 01	15	.91	TURN BUSHING GROUP 1/BRONZE	.211	.029	.222	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-CC	1.00 DIA .501-1.00 REN .033-.250		.06699		.077	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0450 JA 01	15	.91	HAND HONE BUSHING	.265	.036	.278	4
0010 E	RBW-BU-S1	.25 SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RBW-SU-01	.25 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 M		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 1 D		.00333		.003	
0080 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0459 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 REN .033-.250		.06699		.077	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0460 JA 01	15	.05	HAND HONE BUSHING	.265	.002	.015	0
0010 E	RBW-BU-S1	.25 SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RBW-SU-01	.25 S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0040 M		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 1 D		.00333		.003	
0080 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0460 JA 01	15	.82	TURN BUSHING GROUP 4/STEEL	.849	.104	.801	11
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	6.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.069	
0030 E	KML-TD-CC	6.00 DIA .501-1.00 REN .033-.250		.10898		.751	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0470 JA 01	15	.82	INST/REAM SET FLANGED BUSH	.771	.095	.728	10
0010 E	RBW-BU-S1	.25 SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-D1	3.00 REMUSH A-SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.822	
0030 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0479 JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	.849	.006	.049	1
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	6.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.069	
0030 E	KML-TD-CC	6.00 DIA .501-1.00 REN .033-.250		.10898		.751	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0480 JA 01	15	.05	INST/REAM SET FLANGED BUSH	.771	.006	.044	1
0010 E	RBW-BU-S1	.25 SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-D1	3.00 REMUSH A-SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.822	
0030 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0489 JA 01	15	.82	TURN BUSHING GROUP 1/BRONZE	.297	.037	.280	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-FC	2.00 DIA 2.00-3.00 REN .033-.250		.07104		.163	
0040 E	RJP-PW-R1	1.00 REN RPL PAPRMRK SIGN OFF DOC		.01001		.011	
0490 JA 01	15	.82	HAND HONE BUSHING	.389	.048	.367	5
0010 E	RBW-BU-S1	.25 SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	

0020 E	RDW-BU-M	2.00	INSTALL ONE STRAIGHT BUSHING	.02062	.047			
0030 E	RDW-SU-B1	.25	S/U FOR BENCH WORK GENERAL	.27525	.079			
0040 N		2.00	HONE PART NAME	.10000	.230			
0040 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.018			
0070 E	RDW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333	.007			
0080 E	RJP-PW-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC	.01001	.011			
	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.297	.002	.017	0
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962	.143			
0020 E	RLA-IP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01004	.023			
0030 E	KHL-TA-FC	2.00	DIA 2.00-3.00 REN .033-.250	.07104	.163			
0040 E	RJP-PW-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC	.01001	.011			
0500			XXXXXXXXXXXXX					
0500	JA 01	15	1.00	HAND HONE BUSHING	.389	.058	.448	6
0010 E	RDW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053			
0020 E	RDW-BU-M	2.00	INSTALL ONE STRAIGHT BUSHING	.02062	.047			
0030 E	RDW-SU-B1	.25	S/U FOR BENCH WORK GENERAL	.27525	.079			
0040 N		2.00	HONE PART NAME	.10000	.230			
0040 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.018			
0070 E	RDW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333	.007			
0080 E	RJP-PW-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC	.01001	.011			
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			07SEP83 REVIEW & CHG OCC. FACTORS		0.86			
0011			14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <		1.21			
0016			19MAR85 DOWN GRADED NOT MARKET BASKET					
0900			J.CALDWELL TECH MANEAM					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC. PRD NROP NR

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/890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

11/21/88

A-E0448-MH1-BY-H45 PAGE 0001

26338A F15 M/G L/H HW

RCC M/P/RA

444-22-3

86224

OPER	TECH	S	S	M	F	P	A/R	REV	SUB	T	K	HR	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PTD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C						
RA002	S	E	JA	EA	1	K 88203	1.00	PERCENT ENGR 99.1	MACHINE PISTON ASBY. F15 M.	1.32		1.32									
0001			JA	01	00		.00		PART NUMBER/STOCK NUMBER	.000	.000	.000		0							
								68A410704-1011	1620010003404												
								68A410704-1012	1620010003401												
								68A410704-1005	1620010003401												
								68A410704-1006	1620010018799												
0030			JA	01	15		.24		NICK AND BURR MEDIUM PART	.077	.003	.021		2							
								RLG-RS-W3	1.00 NICK & BURR MED STRUT PART	.06711		.077									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0035			JA	01	15		.05		HAND HONE BUSHING	.178	.001	.010		1							
								ROW-SU-81	.25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27325		.079									
									HONE PART NAME	.10000		.115									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0040			JA	01	15		.05		HAND HONE BUSHING	.178	.001	.010		1							
								ROW-SU-81	.25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27325		.079									
									HONE PART NAME	.10000		.115									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0042			JA	01	15		.05		REMOVE ZEA 5° BUSH IN LINE	.093	.001	.005		0							
								ROW-SU-81	.25 S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27325		.079									
								RLG-RS-KF	1.00 K/O TYPE 3 BUSH 3-5 IN DIA	.01471		.016									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
									REMOVE ZEA 5° BUSH IN LINE	.093	.001	.005		0							
								ROW-SU-81	.25 S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27325		.079									
								RLG-RS-KF	1.00 K/O TYPE 3 BUSH 3-5 IN DIA	.01471		.016									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0048			JA	01	15		1.00		POLISH I.D.	.029	.004	.034		3							
								RSB-JP-05	1.00 PREP HAND DRILL CHANGE 1 BIT	.01603		.018									
								ROW-BU-P1	1.00 B.J. TERFLY POLISH BUSHING I.D.	.00333		.003									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0239			JA	01	15		.76		TURN BUSHING GROUP 1/BRONZE	.289	.033	.253		19							
								RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143									
								RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023									
								KHL-TA-CC	2.00 DIA .501-1.00 REN .033-.250 2 BUSHINGS	.06699		.154									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0240			JA	01	15		.76		INST/REAM SET FLANGED BUSH	.295	.034	.258		19							
								ROW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053									
								ROW-BU-S1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0244			JA	01	15		.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017		1							
								RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143									
								RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023									
								KHL-TA-CC	2.00 DIA .501-1.00 REN .033-.250 2 BUSHINGS	.06699		.154									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
0245			JA	01	15		.05		INST/REAM SET FLANGED BUSH	.295	.002	.017		1							
								ROW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053									
								ROW-BU-S1	1.00 REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274									
								RJP-PU-R1	1.00 REN RPL PAPERK SIGN OFF DOC	.01001		.011									
									TURN BUSHING GROUP 1/BRONZE	.289	.037	.286		22							
								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-CC	2.00	DIA .501-1.00 REN .033-.250 2 BUSHINGS	.06699		.154	
0040 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011	
0250	JA 01	15	.84 INST/REAM SET FLANGED BUSH	.295	.038	.292	22
0010 E	RDW-BU-S1	.25	SET UP TO REDUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDW-BU-B1	1.00	REDUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011	
0254	JA 01	15	.05 TURN BUSHING GROUP 1/"BRONZE	.289	.002	.017	1
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-EC	2.00	DIA 1.50-2.00 REN .033-.250	.06699		.154	
0040 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011	
0255	JA 01	15	.05 INST/REAM SET FLANGED BUSH	.295	.002	.017	1
0010 E	RDW-BU-S1	.25	SET UP TO REDUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RDW-BU-B1	1.00	REDUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.274	
0030 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011	
0259	JA 01	15	.05 DRILL PISTON HEAD TO PISTON	1.404	.011	.081	6
0010 E	RML-SU-V1	1.00	S/U VERT MILL BORE SHAL FIXR,	.75732		.870	
0020 E	RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP,	.18155		.208	
0030 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS,	.07261		.083	
0040 E	RML-SU-C1	1.00	INSTALL & REMOVE CLAMP,	.02404		.027	
0050 E	RML-BA-AA	2.00	BORE HOLE 1 X 1/2 GROUP 1 2 EA HOLES	.17936		.412	
0060 E	RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC,	.01001		.011	
9000	JA 01	15	.01 LABOR STANDARD HISTORY	.000	.000	.000	0
0010			06SEP83 REVIEW AND CHG OCC. FACTORS			1.37	
0011			14NOV84 2-YR REVIEW W/OCC CHANGE > OLD STD <			1.19	
0021			18MAR85 DOWN GRADED HOT MARKET BASKET				
0022			20NOV85 ADDED TIME TO HOME AXLE ID OLD STD			1.66	
0023			29SEPT86 ADDED SUBOP 0257 OLD STD			1.68	
0900			J CALDWELL TECH MANEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD:NR0P NR

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26338A F15 MLG L/H NM		M F PF A/R REV		T K NR A FA SUPPORT		DCC		DESCRIPTION		DATE	PFD	STD	A
STEP	B L	K C	DC	ELEMENT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C
RA003	S N	JA EA	1	K 00187	.89	PERCENT ENGR 55.5	F-15 MLG ORIFICE TUBE	1.93		1.72			
0001		JA 01	00		.00		PART NUMBER/NSN	.000	.000	.000		0	
	0010					68M10726-1001	1620003486485						
0025		JA 01	15		.31		POLISH HARD ANODIZE	.361	.017	.129		7	
	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			KHL-TA-FC	1.00	DIA 2.00-3.00 REN .033-.250		.07104		.081			
	0040 E			KHL-TA-FB	11.00	DIA 3.0 REN .250 ADD INCH		.01228		.155			
	0050 E			RJP-PU-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC		.01001		.011			
0027		JA 01	15		1.00		DISASSEMBLE	.189	.028	.218		11	
	0010 E			KHL-CD-P1	1.00	CENTER DRILL		.01519		.017			
	0020 E			RSB-JP-03	1.00	PREP HAND DRILL FOR USE		.00861		.009			
	0030 E			RLA-DR-CA	4.00	DRILL HOLE 1/8-1/4 DIA (1/2		.03903		.179			
	0040 E			RJP-PU-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC		.01001		.011			
0055		JA 01	15		1.00		POLISH TUBE, 6-8 RMS	.567	.085	.653		34	
	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			RTL-MM-M1	2.00	MIKE ID OR 2 FLAT SURFACES		.07104		.163			
	0040 N				1.00		POLISH O.D.	.25000		.287			
	0050 E			ZIT-VI-B1	1.00	VISUAL INSP SMALL CYL I.D.		.02036		.023			
	0060 E			RJP-PU-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC		.01001		.011			
0070		JA 01	15		1.00		POLISH TUBE, 6-8 RMS	.817	.123	.940		48	
	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			RTL-MM-M1	2.00	MIKE ID OR 2 FLAT SURFACES		.07104		.163			
	0040 N				1.00		POLISH O.D.	.50000		.575			
	0050 E			ZIT-VI-B1	1.00	VISUAL INSP SMALL CYL I.D.		.02036		.023			
	0060 E			RJP-PU-R1	1.00	REN RPL PAPERWORK SIGN OFF DOC		.01001		.011			
9000		JA 01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000		0	
	0010					5 JUL 88	INITIAL INPUT						
	0900					KIN VINCENT, HANEL, 73932							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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Q	26338A	F15 MLG L/H HW					07/28/88	A-E0468-MM1-DY-M45		PAGE 0001
SUB	T K	#R A FA SUPPORT	OCC	DESCRIPTION			BASE	PTD	STD	A
STEP D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL			HOURS	TIME	HOURS	DLY PCT C
RA004	S E JA EA 1	J 88187	.05	PERCENT ENGR 99.9	F-15 TORQUE ARM		.13		.00	
0001	JA 01 00		.00		PART NUMBER/NSN		.000	.000	.000	0
0010				68A410646-2005	1620001386306					
0025	JA 01 15		1.00		REMOVE TOR ARM PIN		.086	.013	.100	75
0010 E	RBW-SU-61		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS		.27525		.079	
0020 E	RLG-RS-KA		1.00	K/O SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER		.00780		.008	
0030 E	RJP-PW-R1		1.00	REN RPL PAPERWK SIGN OFF DOC			.01001		.011	
0030	JA 01 15		1.00		O/S LOCK PIN		.029	.004	.034	25
0010 E	RSG-JP-05		1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0020 E	RBW-BU-P1		1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003	
0030 E	RJP-PW-R1		1.00	REN RPL PAPERWK SIGN OFF DOC			.01001		.011	
9000	JA 01 00		.00		LABOR STANDARD HISTORY		.000	.000	.000	0
0001				5 JULY 88	INITIAL INPUT					
0900				KIM VINCENT, MANEL 73255						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
A007	S	E	JA	EA	1	K 88190	1.00	PERCENT ENGR 99.9	F-15 MAIN TRUNNION PIN	.03		.03	
0001			JA	01	15		.00		PART NUMBER/ NSM	.000	.000	.000	0
0010								68A410735-2001	1620003386529				
0030			JA	01	15		1.00			.030	.005	.035	100
0010	E					RSG-JP-03	.25	PREP HAND DRILL FOR USE	PRORATED OVER 4 PARTS	.00861		.002	
0020	E					GTL-DD-A4	2.00	DRILL HOLE W/PORTABLE DRILL	DRILL CROSS BOLT HOLE 2 HOLE	.00924		.021	
0030	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	00		.00		LABOR STANDRD HISTORY	.000	.000	.000	0
0900								8 APR. 1988	RICHARD G. MARTIN				
									HAMEL-73357-MRPII				

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

RA008	S	E	JA	EA	1	J	88188	.05	PERCENT ENGR 99.9	F-15M LOWER DRAG BRACE	2.38		.11		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
									68A410792-1001	1620003654004					
0040			JA	01	15			1.00		LOCATE & DRILL 1 HOLE	.072	.011	.084		4
0010	E							1.00	KML-CD-P1	CENTER DRILL	.01519		.017		
0020	E							1.00	RSG-JP-03	PREP HAND DRILL FOR USE	.00861		.009		
0030	E							1.00	RLA-DR-CA	DRILL HOLE 1/8-1/4 DIA (1/2	.03903		.044		
0040	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0042			JA	01	15			.05		O/S HOLE ON MILL/SMALL PART	.781	.006	.045		2
0010	E							.25	KHM-SU-V1	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS	.50518		.145		
0020	E							1.00	RML-HP-CA	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098		
0030	E							1.00	RML-AL-AB	ALIGN VERTICAL AXIS ROD	.12699		.146		
0040	E							1.00	RML-AL-AC	ALIGN HOLE TO SPINDLE ROD	.07609		.087		
0050	E							1.00	RML-BD-BB	BORE HOLE 1.5 X 1 GROUP 4 USE PROPER ELEMENT/TABLE	.35729		.410		
0060	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0044			JA	01	15			.05		O/S HOLE ON MILL/SMALL PART	.781	.006	.045		2
0010	E							.25	KHM-SU-V1	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS	.50518		.145		
0020	E							1.00	RML-HP-CA	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098		
0030	E							1.00	RML-AL-AB	ALIGN VERTICAL AXIS ROD	.12699		.146		
0040	E							1.00	RML-AL-AC	ALIGN HOLE TO SPINDLE ROD	.07609		.087		
0050	E							1.00	RML-BD-BB	BORE HOLE 1.5 X 1 GROUP 4 USE PROPER ELEMENT/TABLE	.35729		.410		
0060	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
16			JA	01	15			.05		O/S HOLE ON MILL/SMALL PART	.911	.007	.052		2
0010	E							.25	KHM-SU-V1	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS	.50518		.145		
0020	E							1.00	RML-HP-CA	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098		
0030	E							1.00	RML-AL-AB	ALIGN VERTICAL AXIS ROD	.12699		.146		
0040	E							1.00	RML-AL-AC	ALIGN HOLE TO SPINDLE ROD	.07609		.087		
0050	E							1.00	RML-BD-BD	BORE HOLE 1.5 X 2 GROUP 4 USE PROPER ELEMENT/TABLE	.48689		.559		
0060	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0100			JA	01	15			.05		O/S HOLE ON MILL/SMALL PART	.640	.005	.037		2
0010	E							.25	KHM-SU-V1	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS	.50518		.145		
0020	E							1.00	RML-HP-CA	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098		
0030	E							1.00	RML-AL-AB	ALIGN VERTICAL AXIS ROD	.12699		.146		
0040	E							1.00	RML-AL-AC	ALIGN HOLE TO SPINDLE ROD	.07609		.087		
0050	E							1.00	RML-BA-CD	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21626		.248		
0060	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0101			JA	01	15			.05		INST STRAIGHT BUSH NO POLISH	.077	.001	.004		0
0010	E							.25	RBW-BU-S1	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053		
0020	E							1.00	RBW-BU-A4	INSTALL ONE STRAIGHT BUSHING	.02062		.023		
0030	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0105			JA	01	15			.05		NICK AND BURR SMALL PART	.055	.000	.003		0
0010	E							1.00	RLG-RS-N4	NICK & BURR SMALL STRUT PART	.04595		.052		
0030	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0109			JA	01	15			1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		14
0010	E							.25	RLA-SU-S3	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143		
0020	E							2.00	RLA-HP-C1	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023		
0030	E							2.00	KML-TA-EC	DIA 1.50-2.00 REM .033-.250	.06699		.154		
0040	E							1.00	RJP-PW-R1	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
J			JA	01	15			1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339		14

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		
JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	1
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-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699	.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001	.011		
0115	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	1
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		
0119	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	14
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-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699	.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001	.011		
0120	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.295	.044	.339	14
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		
0124	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	1
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-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699	.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001	.011		
0125	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	1
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		
0129	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	14
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-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699	.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001	.011		
0130	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.295	.044	.339	14
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		
0134	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	1
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-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699	.154		
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001	.011		
0135	JA 01	15	.05	INST/REAM SET FLANGED BUSH	.295	.002	.017	1
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		
9000	JA 01	00	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			7 JUL 98	INITIAL INPUT				
0900			KIM VINCENT, MANEL, 73255					

ROGATE LABOR STANDARDS, INPUT

U	TECH S S	W F PF A/R REV	OCC		DESCRIPTION	BASE	PFD	STD	A
SUB	T K	IR A FA SUP/PORT	FACT	STO	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
STEP	D L	K C DC ELEMENT	FACT	STO	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
RA009	S E JA EA 1	J 88194	1.00	PERCENT ENGR 99.9	F-15 M JURY LINK PIN	.03		.03	
0001	JA 01 00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010				58A410756-1001	1620003386530				
0030	JA 01 15		1.00		MACH. CROSS BOLT HOLES	.030	.005	.035	100
0010 E		RSG-JP-03	.25	PREP HAND DRILL FOR USE	PRORATED OVER 4 PARTS	.00861		.002	
0020 E		GTL-DD-A4	2.00	DRILL HOLE W/PORTABLE DRILL	DRILL CROSS BOLT HOLE 2 HOLE	.00924		.021	
0030 E		RJP-PW-R1	1.00	REM RFL PAPWRK SIGN OFF DDC		.01001		.011	
9000	JA 01 00		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010				12 JUL 88	INITIAL INPUT				
0900				KIM VINCENT, HANEL, 73952					

TO INTERROGATE LABOR STANDARDS, INPUT

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

09/16/88

A-E046B-MH1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW

RCC MNPRA

4A4-22-3

86224

SUB	TECH S S	T K	W F PF A/R REV	R A FA SUPPORT	OCC	←	DESCRIPTION	→	BASE HOURS	PFD TIME	STD HOURS	A	
												DLY	PCT C
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL						
RA010	S E	JA EA	1	K 88189	.07	PERCENT ENGR 83.9	F-15 MAIN LOWER JURY LINK		1.43		.10		
0001		JA 01	00		.00		PART NUMBER/MSN		.000	.000	.000		0
0010						68A410795-1003	1620010360263						
0042		JA 01	15		.05		POLISH I.D.		.029	.000	.002		0
0010 E				RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018		
0020 E				RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003		
0030 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011		
0044		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 LENPCD 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		
0046		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 LENPCD 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		
0048		JA 01	15		.05		O/S HOLE ON MILL/SMALL PART		.630	.005	.036		3
0010 E				KMM-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-BD	1.00	BORE HOLE 1.5 X 2 GROUP 1	USE PROPER ELEMENT/TABLE		.20600		.236		
0060 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011		
0059		JA 01	15		1.00		TURN BUSHING GROUP 1/BRONZE		.443	.066	.510		36
0010 E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E				RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.046		
0030 E				KML-TA-CC	4.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS		.06699		.308		
0040 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011		
0060		JA 01	15		1.00		INST/REAM SET FLANGED BUSH		.295	.044	.339		24
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 PAPWRK SIGN OFF DOC			.01001		.011		
0064		JA 01	15		.05		TURN BUSHING GROUP 1/BRONZE		.443	.003	.025		2
0010 E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E				RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.046		
0030 E				KML-TA-CC	4.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS		.06699		.308		
0040 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011		
0065		JA 01	15		.05		INST/REAM SET FLANGED BUSH		.295	.002	.017		1
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 PAPWRK SIGN OFF DOC			.01001		.011		
0069		JA 01	15		.50		INST STRAIGHT BUSH NO POLISH		.077	.006	.044		3
0010 E				RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
0020 E				RBW-BU-AA	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011		
0070		JA 01	15		1.00		HONE BUSHING/SUNNEN STROKER		.163	.025	.188		13

0010 E	ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061	
0020 N		1.00		HONE BUSHING	.10000		.115	
30 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0072	JA 01	15		MACH O/S DRAG BRACE	.289	.002	.017	1
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-CC	2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS		.06699		.154	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0074	JA 01	15		INSTALL O/S DRAG BRACE	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.19669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0075	JA 01	15		HONE BUSHING/SUNNEN STROKER	.163	.025	.188	13
0010 E	ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061	
0020 N		1.00		HONE BUSHING	.10000		.115	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0077	JA 01	15		MACH O/S GROUND BOSS	.289	.002	.017	1
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-CC	2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS		.06699		.154	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0078	JA 01	15		INSTALL O/S GROUND BOSS	.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-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	24		LABOR STANDARD HISTORY	.000	.000	.000	0
0010			13SEP83 NEW INPUT-NO OCC FACTOR HISTORY					
0011			14NOV84 2 YR REVIEW W/NO CHANGE					
0012			18MAR85 DOWN GRADED NOT MARKET BASKET					
0013			25NOV85 CHANGED SUBOPS TO MATCH 958 OLD STD .29					
0900			J.CALDWELL TECH MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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26338A F15 MLG L/H HW

CH S S W F PF A/R REV

T K AR A FA SUPPORT

DCC

DESCRIPTION

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT

C

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A
RA011	S	E	JA	EA	1	K 88195	.70	PERCENT ENGR 94.8	F-15M UPPER JURY LINK		2.08		1.45		
0001			JA	01		00	.00		PART NUMBER/NSN		.000	.000	.000		0
		0010						68A410794-1006	1620010403580						
		0020						68A410794-1005	1620010483581						
0021			JA	01		15	.26		REMOVE BUSHING/1" DIA		.086	.003	.026		1
		0010	E				.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS		.27525		.079		
		0020	E				1.00	K/D SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER		.00780		.008		
		0030	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0022			JA	01		15	1.00		REMOVE BUSHING/1" DIA		.102	.015	.118		6
		0010	E				.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS		.27525		.079		
		0020	E				3.00	K/D SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER		.00780		.026		
		0030	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0023			JA	01		15	.95		POLISH I.D.		.029	.004	.032		2
		0010	E				1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018		
		0020	E				1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003		
		0030	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0025			JA	01		15	1.00		TURN BUSHING GROUP 4/STEEL		.317	.048	.365		18
		0010	E				.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
		0020	E				1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
		0030	E				1.00	DIA 1.50-2.00 REM .033-.250			.17225		.198		
		0040	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0026			JA	01		15	.05		O/S HOLE ON HILL/SMALL PART		.640	.005	.037		2
		0010	E				.25	S/U VERT HILL BORE SMAL FTR	PRORATE OVER 4 PARTS		.50518		.145		
		0020	E				1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
		0030	E				1.00	ALIGN VERTICAL AXIS ROD			.12699		.146		
		0040	E				1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087		
		0050	E				1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE		.21626		.248		
		0060	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0035			JA	01		15	.26		OVERSIZE HOLE WITH REAMER		.349	.014	.104		5
		0010	E				.25	SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
		0020	E				1.00	OBJ IN/OUT STP VISE-HST HAND			.06831		.078		
		0030	E				3.00	REAM WITH LEMPCO REAMER	3 PASSES		.07337		.253		
		0040	E				1.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004		
		0050	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0038			JA	01		15	1.00		NICK AND BURR SMALL PART		.055	.008	.064		3
		0010	E				1.00	NICK & BURR SMALL STRUT PART			.04595		.052		
		0030	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0200			JA	01		15	.26		INSTALL BEARING		.089	.004	.027		1
		0010	E				.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS		.27525		.079		
		0020	E				1.00	REM BUSHING (1ST OR SINGLE)			.01099		.012		
		0030	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0201			JA	01		15	1.00		TURN BUSHING GROUP 1/BRONZE		.240	.036	.276		13
		0010	E				.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
		0020	E				1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
		0030	E				1.00	DIA .501-1.00 REM .033-.250			.06699		.077		
		0040	E				3.00	DIA 1.0 REMOVE .250 ADD INCH			.00947		.032		
		0050	E				1.00	REM RPL PAPERMARK SIGN OFF DOC			.01001		.011		
0207			JA	01		15	1.00		INST STRAIGHT BUSH NO POLISH		.077	.012	.089		4
		10	E				.25	SET UP TO REMUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		

0020 E	RBW-BU-A4	1.00	ONE STRAIGHT BUSHING	.02062		.023		
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0205	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.259	.039	.299	14
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.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	KML-TA-CD	3.00	DIA 1.0 REMOVE .250 ADD INCH	.00947		.032		
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 PAPWRK SIGN OFF DOC	.01001		.011		
0206	JA 01	15	.89	TURN BUSHING GROUP 1/BRONZE	.307	.041	.315	15
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143		
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023		
0030 E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154		
0040 E	KML-TA-CD	2.00	DIA 1.0 REMOVE .250 ADD INCH	.00947		.021		
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0208	JA 01	15	.89	INST SET FLANGED BUSHINGS	.108	.014	.111	5
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053		
0020 E	RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133		.059		
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0210	JA 01	15	.89	HONE BUSHING/SUNNEN STROKER	.183	.024	.187	9
0010 E	ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	.21517		.061		
0020 N		1.00	HONE BUSHING	.10000		.115		
0030 E	RSG-JP-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		
0212	JA 01	15	.05	TURN BUSHING GROUP 1/BRONZE	.307	.002	.018	1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143		
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023		
0030 E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	.06699		.154		
0040 E	KML-TA-CD	2.00	DIA 1.0 REMOVE .250 ADD INCH	.00947		.021		
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0215	JA 01	15	.05	INST SET FLANGED BUSHINGS	.108	.001	.006	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053		
0020 E	RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133		.059		
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0217	JA 01	15	.05	HONE BUSHING/SUNNEN STROKER	.183	.001	.011	1
0010 E	ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	.21517		.061		
0020 N		1.00	HONE BUSHING	.10000		.115		
0030 E	RSG-JP-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		
9000	JA 01	00	.00	LABOR STANDRD HISTORY	.000	.000	.000	0
0900				8 APR. 1988 RICHARD G. MARTIN MANEL-73357-NRPII				

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC HNPRA

07/28/88
4A4-22-3

A-E046B-NM1-DY-M45 PAGE 0001
86224

26338A F15 MLG L/H HW		TECH S S W F PF A/R REV		SUB T K #R A FA SUPPORT		OCC <----->		DESCRIPTION <----->		BASE	FPD	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C
RA013	S E	JA EA	1	J 88197	1.00	PERCENT ENGR 99.9	F-15M SPINDLE ASSY	1.10		1.10			
0001		JA 01	00		.00		PART NUMBER/NSN	.000	.000	.000			0
0010						68A410624-1001	1620003337133						
0030		JA 01	15		1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402			36
0010 E				RRW-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 WISE-HST HAND		.06831		.078			
0030 E				RRW-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 PAPRWRK SIGN OFF DOC		.01001		.011			
0197		JA 01	15		1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332			30
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-CC	2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154			
0040 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0200		JA 01	15		1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339			31
0010 E				RRW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020 E				RRW-BU-R1	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			2
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-CC	2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154			
0040 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0205		JA 01	15		.05		INST/REAM SET FLANGED BUSH	.295	.002	.017			2
0010 E				RRW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020 E				RRW-BU-R1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23935		.274			
0030 E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
9000		JA 01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000			0
0010						15 JUL 88	INITIAL INPUT						
0900						KIM VINCENT, HANEL, 73255							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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RA016	S E JA EA 1	J 88196	.26	PERCENT ENGR 99.7	F-15 M COLLAR ASSY	2.35		.61		
0001	JA 01	00	.00		PART NUMBER/NSN	.000	.000	.000		0
0010				68A10733-1001	1620003440616					
0020				68A10733-1002	1620003386559					
0030	JA 01	15	.05		TURN BUSHING GROUP 4/STEEL	2.073	.016	.119		5
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-TD-JC	3.00	DIA 5.00-6.00 REM .033-.250		.40208		1.387		
0040 E		KML-TD-JD	3.00	DIA 6.00 REM .250 ADD INCH		.24071		.830		
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0040	JA 01	15	.05		HAND HONE BUSHING	.178	.001	.010		0
0010 E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079		
0020 N			1.00		HONE PART NAME	.10000		.115		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0050	JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.739	.006	.042		2
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXT	PRORATE 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-BD-AB	1.00	BORE HOLE 1 X 1 GROUP 4	USE PROPER ELEMENT/TABLE	.31431		.361		
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070	JA 01	15	.09		O/S HOLE ON MILL/SMALL PART	.739	.010	.076		3
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXT	PRORATE 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-BD-AB	1.00	BORE HOLE 1 X 1 GROUP 4	USE PROPER ELEMENT/TABLE	.31431		.361		
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0139	JA 01	15	.86		INST STRAIGHT BUSH NO POLISH	.097	.013	.097		4
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	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0140	JA 01	15	.86		TURN BUSHING GROUP 4/STEEL	.373	.048	.369		16
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-TD-CC	2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0148	JA 01	15	.14		TURN BUSHING GROUP 4/STEEL	.373	.008	.060		3
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-TD-CC	2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0149	JA 01	15	.14		INST STRAIGHT BUSH NO POLISH	.077	.002	.012		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		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0150	JA 01	15	.14		TURN BUSHING GROUP 4/STEEL	.373	.008	.060		3
010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		

0030 E	KML-TD-CC	2.00 DIA .501-1.00 REM .033-.250	.10873	.250		
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
JA 01	15	.57	INST/REAM SET FLANGED BUSH	.175	.015	.115 5
.010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835	.137	
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0169	JA 01	15	.09	TURN BUSHING GROUP 1/BRONZE	.221	.003 .023 1
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	KML-TA-CD	1.00 DIA 1.0 REMOVE .250 ADD INCH	.00947	.010		
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0170	JA 01	15	.09	INST/REAM SET FLANGED BUSH	.175	.002 .018 1
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835	.137	
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0180	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.175	.026 .202 9
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835	.137	
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0189	JA 01	15	.29	TURN BUSHING GROUP 1/BRONZE	.221	.010 .074 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-CC	1.00 DIA .501-1.00 REM .033-.250	.06699	.077		
0040 E	KML-TA-CD	1.00 DIA 1.0 REMOVE .250 ADD INCH	.00947	.010		
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0190	JA 01	15	.29	INST/REAM SET FLANGED BUSH	.175	.008 .059 2
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835	.137	
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0199	JA 01	15	.57	TURN BUSHING GROUP 1/BRONZE	.289	.025 .189 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 2 BUSHINGS		.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 PAPWRK SIGN OFF DOC	.01001	.011		
0200	JA 01	15	.57	INST STRAIGHT BUSH NO POLISH	.097	.008 .064 3
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	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0209	JA 01	15	.09	TURN BUSHING GROUP 1/BRONZE	.289	.004 .030 1
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-EC	2.00 DIA 1.50-2.00 REM .033-.250	.06699	.154		
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
0210	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	.640	.096 .737 31
0010 E	KMM-SU-V1	.25 S/U VERT MILL BORE SHAL FXT	PRORATE 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-CD	1.00 BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626	.248	
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011		
9000	JA 01	00	.00	LABOR STANDARD HISTORY	.000	.000 .000 0
0010		14 JUL 88	INITIAL INPUT			
0900		KIM VINCENT, HANEL, 73255				

STEP	D	L	K	C	DC	ELEMENT	FACT	STO	DESCRIPTION	BASE	PFD	STD	A
							OCC	STO	DESCRIPTION	HOURS	TIME	HOURS	DLY PCT C
							FACT	STO	DESCRIPTION	HOURS	TIME	HOURS	DLY PCT C
RA020	S	E	JA	EA	1	J 88196	.75	PERCENT ENGR 99.9	F-15 MAIN SPRING	.20		.15	
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
						0010		68A410725-1001	1620001323253				
						0020		68A410725-1002	1620001323209				
0040			JA	01	15		1.00		REMOVE BUSHING	.094	.014	.109	54
						0010 E		RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27525		.079	
						0020 E		RLG-RS-KA	2.00 K/D SINGLE BUSH 1/4-1 IN DIA REMOVE BUSHING WITH KNOCKER	.00780		.017	
						0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0140			JA	01	15		1.00		INSTALL BUSHING	.079	.012	.092	46
						0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
						0020 E		RBW-BU-A2	1.00 INSTALL SET STRAIGHT BUSHING NO POLISH	.02299		.026	
						0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000			JA	01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
						0010		14 JUL 88	INITIAL INPUT				
						0900		KIM VINCENT, MANEL, 73255					

TO INTERROGATE LABOR STANDARDS, INPUT

SCC PRD NRQP NR
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 1 /890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

05/26/89

A-50465-XM1-DY-445 PAGE 0001

2633GA F15 MLG L/H HW

RCC MNPRA

4A4-22-3

36224

OPER	TECH	S	S	W	F	FF	A/R	REV	SUB	T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	DESCRIPTION	HOURS	TIME	HOURS	DLY	PCT	C						
3A022	S	E	JA	EA	1	J	88292	1.00	PERCENT ENGR 79.9								MACH COLLAR TRUNNION F15M	4.11			4.11
0001			JA	01	00			.00									PART NUMBER/NGN	.000	.000	.000	0
									68A410638-1009								1620010753563				
									68A410638-1005								1620010395815				
0070			JA	01	15			1.00	OVERSIZE HOLE WITH REAMER	.349	.052	.402									10
								.25	SET UP TO REBUSH BOSSES	.18669		.053					PRORATE OVER 4 PARTS				
0010 E								1.00	OBJ IN/OUT STP VISE-HST HAND	.06831		.078									
0020 E								3.00	REAM WITH LEMPCO REAMER 3 PASSES	.07337		.253									
0030 E								1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004									
0040 E								1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011									
0050 E								1.00	OVERSIZE HOLE WITH REAMER	.798	.120	.918									22
0080			JA	01	15			1.00	OVERSIZE HOLE WITH REAMER	.18669		.053									
								.25	SET UP TO REBUSH BOSSES	.06831		.078									
0010 E								1.00	OBJ IN/OUT STP VISE-HST HAND	.07337		.259									
0020 E								9.00	REAM WITH LEMPCO REAMER 3 PASSES	.00423		.014									
0030 E								3.00	DEBUR HOLE/CUTOUT BOTH SIDES	.01001		.011									
0040 E								1.00	REM RPL PAPERWK SIGN OFF DOC	.705	.106	.812									20
0050 E								1.00	TURN BUSHING GROUP 4/STEEL	.49962		.143									
0090			JA	01	15			1.00	TURN BUSHING GROUP 4/STEEL	.01006		.023									
								.25	SET UP SMALL MEDIUM LATHE	.27540		.533									
0010 E								2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01001		.011									
0020 E								2.00	DIA 3.00-4.00 REM .033-.250	.062	.012	.095									2
0030 E								1.00	REIDENTIFY / METAL STAMP	.27525		.079									
0040 E								1.00	STAMP WITH METAL STAMP	.00342		.003									
0095			JA	01	15			1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011									
								.25	S/U FOR BENCH WORK GENERAL	.492	.074	.566									14
0010 E								1.00	TURN BUSHING GROUP 4/STEEL	.49962		.143									
0020 E								3.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.034									
0030 E								3.00	DIA .501-1.00 REM .033-.250	.10876		.375									
0040 E								1.00	REM RPL PAPERWK SIGN OFF DOC	.01001		.011									
0350			JA	01	15			1.00	INST/REAM SET STRAIGHT BUSH	.723	.109	.832									20
								.25	SET UP TO REBUSH BOSSES	.18669		.053									
0010 E								3.00	REBUSH A SET OF 2 BOSSES	.22231		.766									
0020 E								1.00	INCLUDES REAM & POLISH	.01001		.011									
0030 E								1.00	REM RPL PAPERWK SIGN OFF DOC	.253	.038	.292									7
0370			JA	01	15			1.00	TURN BUSHING GROUP 4/STEEL	.49962		.143									
								.25	SET UP SMALL MEDIUM LATHE	.01006		.011									
0010 E								1.00	1ST PART IN-OUT SCROLL CHUCK	.10876		.375									
0020 E								1.00	DIA .501-1.00 REM .033-.250	.01001		.011									
0030 E								1.00	REM RPL PAPERWK SIGN OFF DOC	.170	.026	.196									5
0040 E								1.00	INST/REAM SET FLANGED BUSH	.18669		.053									
0390			JA	01	15			1.00	REBUSH A SET OF 2 BOSSES	.23835		.137									
								.50	REBUSH A SET OF 2 BOSSES	.01001		.005									
0010 E								1.00	INCLUDES REAM & POLISH												
0020 E								.50	REM RPL PAPERWK SIGN OFF DOC												
0030 E								1.00	LABOR STANDARD HISTORY	.300	.000	.300									0
9000			JA	01	00			1.00	LABOR STANDARD HISTORY												
									2 AUGUST 88 INITIAL INPUT/NEW WORKLOAD												
0001									KERRY COOP MANEL 7-3357												
0010									22 MAR 89 INITIAL INPUT 4RP II												
0000									ALBERT HARRWOOD MANEL 7-3723												
0900																					

26338A F15 MLG L/H HW

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

RA023	S	E	JA	EA	1	J	88189	1.00	PERCENT ENGR 99.9	F-15 MAIN CONNECTING LINK	1.31		1.31		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
	0010								68A410611-1001	3040003291054					
0050			JA	01	15			1.00		REMOVE BUSHING 3" DIA	.087	.013	.100		8
	0010	E				RBW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
	0020	E				RLG-RS-KB		1.00	K/O SINGLE BUSH 1-3 IN DIA	REMOVE 3" DIA BUSH/KNOCKER	.00836		.009		
	0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0055			JA	01	15			1.00		INST STRAIGHT BUSH NO POLISH	.077	.012	.089		7
	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				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0059			JA	01	15			1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		25
	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-CC		2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS		.06699		.154		
	0040	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	15			1.00		INST/REAM SET FLANGED BUSH	.175	.026	.202		15
	0010	E				RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
	0020	E				RBW-BU-B1		.50	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.137		
	0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0064			JA	01	15			1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		25
	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-CC		2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS		.06699		.154		
	0040	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0065			JA	01	15			1.00		TURN BUSHING GROUP 1/BRONZE	.224	.034	.259		20
	0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
	0020	E				RLA-HP-C1		.50	1ST PART IN-OUT SCROLL CHUCK		.01006		.005		
	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 PAPWRK SIGN OFF DOC		.01001		.011		
7000			JA	01	00			.00		LABOR STANDRD HISTORY	.000	.000	.000		0
0900										8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII					

TO INTERROGATE LABOR STANDARDS, INPUT

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

26338A F15 MLG L/H HW

J H S S W F P F 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

RA025	S	E	JA	EA	1	J	88189	1.00	PERCENT ENGR 96.6	F-15 MAIN BELL CRANK ASSY	3.38		3.38		
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
									68A410601-1001	NSL					
0030			JA	01		15		1.00		REMOVE BUSHING WITH PRESS	.089	.013	.103		3
			0010	E			RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
			0020	E			RLG-RS-K1	1.00	REN BUSHING (1ST OR SINGLE)		.01099		.012		
			0030	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0034			JA	01		15		1.00		MACHINE STD BUSHING	.289	.043	.332		10
			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-EC	2.00	DIA 1.50-2.00 REN .033-.250		.06699		.154		
			0040	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0035			JA	01		15		1.00		INSTALL STD BUSHING	.077	.012	.089		3
			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			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0037			JA	01		15		1.00		MACHINE CYL HOLE O/S	.622	.093	.716		21
			0010	E			KMH-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		
			050	E			KMH-BA-BD	1.00	BORE HOLE 1.5 X 2 GROUP 1		.19789		.227		
			060	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0039			JA	01		15		1.00		MACHINE O/S BUSHING	.317	.048	.365		11
			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-TD-EC	1.00	DIA 1.50-2.00 REN .033-.250		.17225		.198		
			0040	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0040			JA	01		15		1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188		6
			0010	E			ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061		
			0020	N				1.00		HONE BUSHING	.10000		.115		
			0030	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0049			JA	01		15		1.00		DRILL CROSS BOLT HOLE	.030	.005	.035		1
			0010	E			RSG-JF-03	.25	PREP HAND DRILL FOR USE	PROPATED OVER 4 PARTS	.00861		.002		
			0020	E			6TL-DD-A4	2.00	DRILL HOLE W/PORTABLE DRILL	DRILL CROSS BOLT HOLE 2 HOLE	.00924		.021		
			0030	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0050			JA	01		15		1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402		12
			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	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
0060			JA	01		15		1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402		12
			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		
			050	E			RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC		.01001		.011		
			JA	01		15		1.00		MACHINE O/S LINK BUSHING	.373	.056	.429		10

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	KHL-TD-CC	2.00 DIA .501-1.00 REM .033-.250		.10898		.250		
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
00/0	JA 01	15	1.00	INST/REAM SET STRAIGHT BUSH	.278	.042	.321	9
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E	RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.255		
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
9000	JA 01	00	.00	LABOR STANDRD HISTORY	.000	.000	.000	0
0900				8 APR. 1988 RICHARD G. MARTIN HANEL-73357-MRPII				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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26338A F15 MLG L/H HW

RCC MNPRB

4A4-22-3

86224

OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	A
SUB	T	K	#R	A	FA	SUPPORT					HOURS	TIME	HOURS	DLY PCT C
STEP	D	L	K	C	DC	ELEMENT	FACT		STORED	SUPPLEMENTAL				
RB001	S	E	JA	EA	3	K 88183	.56		PERCENT ENGR 99.9	GRIND REPAIR OUTER CYLINDER	3.24		1.81	
0001			JA	01	00		.00			PART NUMBER/NSN	.000	.000	.000	0
									68A410702-1005	1620010760547				
									68A410702-1006	1620040753562				
0025			JA	01	15		.33			HONE LOWER BORE I.D.	.306	.015	.116	4
										HONE LOWER BORE TO MAINT				
										SIZE & FINISH REQ NO SUPPORT ELEMENTS AT THIS TIME				
0020	E					RTL-SU-G1	1.00		SET UP A DIAL BORE GAGE		.08248		.094	
0030	E					RGR-HM-C2	1.00		HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0040	E					RLG-IT-V4	6.00		VIS INSP INTERIOR SURFACE	BORESCOPE BEFORE & AFTER HON	.02219		.153	
										1 OCC PER INCH				
0050	E					RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0026			JA	01	15		.27			HONE UPPER BORE I.D.	.306	.012	.095	3
										HONE UPPER BORE TO MAINT				
										SIZE & FINISH REQ NO SUPPORT ELEMENTS AT THIS TIME				
0020	E					RTL-SU-G1	1.00		SET UP A DIAL BORE GAGE		.08248		.094	
0030	E					RGR-HM-C2	1.00		HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0040	E					RLG-IT-V4	6.00		VIS INSP INTERIOR SURFACE	BORESCOPE BEFORE & AFTER HON	.02219		.153	
										1 OCC PER INCH				
0050	E					RJP-PW-R1	1.00		REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01	15		.53			1ST GRIND LOWER BORE	1.595	.127	.973	30
0010	E					RGR-SU-I2	.20		SET UP LRG INTERNAL GRINDER	PRORATE 5 PARTS	1.53372		.352	
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					KMG-ID-ME	1.00		GRIND OUT .010 & 0 ID X 3.0		.71847		.826	
0050	E					KMG-DW-ID	2.00		DRESS INTERNAL WHEEL	DRESS WHEEL AS NEEDED	.02458		.056	
0060	E					RTL-SU-G1	.50		SET UP A DIAL BORE GAGE	PRORATE 2 PARTS	.08248		.047	
0070	E					RGR-HM-C2	1.00		HANDLE & MEAS LENGTH 1 TO 5	CHECK I.D. 3 TIMES 3 PLACES	.08102		.093	
0120			JA	01	15		.05			1ST GRIND OUTBOARD TRUN-120-	.936	.007	.054	2
										PRORATE 4 PARTS	1.05938		.304	
0010	E					RGR-SU-G1	.25		SET UP A GAP GRINDER					
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					KMG-OD-ED	1.00		GRIND .010 2 OD X 2 1/2		.14517		.166	
0050	E					KMG-DW-OD	2.00		DRESS EXTERNAL WHEEL	1 TO SQ WHEEL 1 FOR FINISH	.02308		.053	
0060	E					RGR-HM-C2	1.00		HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0130			JA	01	15		.06			1ST GRIND POSITION COLL-130-	1.396	.013	.096	3
										PRORATE 5 PARTS	.78266		.180	
0010	E					RGR-SU-A1	.20		SET UP INTERNAL ATT GAP GRND	PRORATE 5 PARTS				
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	DIAL IN AXLE	.09095		.104	
0040	E					KMG-OD-LE	1.00		GRIND .010 FROM 5 IN OD X 3		.42668		.490	
										.015 TO .020 STOCK REMOVAL				
0050	E					RGR-WD-G2	4.00		WHEEL DRESS GAP GRINDER	DRESS WHEEL AS NEEDED	.08334		.383	
0060	E					RGR-HM-C2	1.00		HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0190			JA	01	15		.06			FINISH GRIND COLLAR OD--190-	1.498	.013	.103	3
										PRORATE 4 PARTS	1.05938		.304	
0010	E					RGR-SU-G1	.25		SET UP A GAP GRINDER					
0020	E					RGR-HP-L4	1.00		LOAD LARGE PART GAP GR FIXTR		.30830		.354	
0030	E					KHM-SU-A2	1.00		DIAL AXIS VERTICAL		.13083		.150	
0040	E					KMG-OD-MJ	1.00		GRIND .040 -5 1/2 OD X 2 1/2		.64451		.741	
0050	E					KMG-DW-OD	3.00		DRESS EXTERNAL WHEEL	DRESS WHEEL AS NEEDED	.02308		.079	

0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093		
JA 01	15	.05	FINISH GRIND OUTB TRUN--210-	9.285	.070	.534		16
0010 E	RGR-SU-A1	.20	SET UP INTERNAL ATT GAP GRNDPRORATE 5 PARTS	.78266		.180		
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	KMG-ID-KK	8.00	GRIND OUT .040 4 1/2 ID X 3 24 INCH BORE	1.03946		9.563		
0050 E	RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER DRESS WHEEL AS NEEDED	.08334		.383		
0060 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093		
0215	JA 01	15	.53 FINISH GRIND LOWER BORE	2.083	.166	1.270		39
0010 E	RGR-SU-I2	.20	SET UP LRG INTERNAL GRINDER PRORATE 5 PARTS	1.53372		.352		
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	KMG-ID-LK	1.00	GRIND OUT .040 5 ID X 3 GRIND	1.15712		1.330		
0050 E	KMG-DW-ID	4.00	DRESS INTERNAL WHEEL DRESS WHEEL AS NEEDED	.02458		.113		
0060 E	RTL-SU-G1	.50	SET UP A DIAL BORE GAGE PRORATE 2 PARTS	.08248		.047		
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 CHECK I.D. 3 TIMES 3 PLACES	.08102		.093		
0215			FINISH GRIND LOWER BORE					
9000	JA 01	15	.01 LABOR STANDARD HISTORY	.000	.000	.000		0
0010			07SEP83 REVIEW & CHG OCC. FACTORS 0.86					
0011			14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD < 1.21					
0016			19MAR85 DOWN GRADED NOT MARKET BASKET					
0900			J.CALDWELL TECH MANEAM					

TO INTERROGATE LABOR STANDARDS, INPUT

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26338A F15 HL6 L/H HM

RCC HNRB

4A4-22-3

86224

OPER	TECH	S	W	F	P	A/R	REV	OCC	DESCRIPTION	BASE	PFD	STD	A
SUB	T	K	R	A	FA	SUPPORT		FACT	STOR	HOURS	TIME	HOURS	DLY PCT C
STEP	D	L	K	C	DC	ELEMENT			SUPPLEMENTAL				
RB002	S	E	JA	EA	3	K	88207	.44	PERCENT ENGR 93.4	6.42		2.82	
0001			JA	01		00		.00	GRIND PISTON ASSY F-15 HL6 PART NUMBER/NSN	.000	.000	.000	0
0030									68A410704-1011 1620018033404				
0040									68A410704-1012 1620018033407				
0050									68A410704-1005 1620018033401				
0060									68A410704-1006 1620018188799				
0070			JA	01		15		.33	1ST GRIND PISTON O.D.	3.090	.153	1.173	18
0010	N							1.00	S/U GRINDER >RGRSUG1<	1.10683		1.272	
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 DIAL IN AXIS	.09095		.104	
0040	E						RGR-GE-S2112.00	GR STEEL OD (OCC FACT L X D)5.2 X 21.5	.01093			1.407	
0050	E						RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5 INCH DIA	.01014		.058	
0060	E						RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER EXTRA WHEEL DRESS AS NEEDED	.08334		.191	
0070	E						RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0080	E						RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.011	
0090	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0080			JA	01		15		.42	1ST GRIND M/PIN SEAL ID	1.067	.067	.515	8
0010	E						RBW-BU-P1	.20	BUTTERFLY POLISH BUSHING I DPRORATE 5 PARTS	.00333		.000	
0020	E						RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR	.30830		.354	
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER DIAL IN AXIS	.02632		.030	
0040	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION	.06761		.077	
0050	E						KMG-ID-JE	1.00	GRIND OUT .010-4 IN ID X 3 DRESS WHEEL AS NEEDED	.48265		.535	
0060	E						KMG-DW-ID	1.00	DRESS INTERNAL WHEEL PRORATE 2,PARTS	.02458		.028	
0070	E						RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)CHECK I.D. 3 TIMES 3 PLACES	.01014		.011	
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		.	
0100	E						RJP-PW-R1	1.00	REN RPL PAPERWK SIGN OFF DOC	.01001		.	
0082			JA	01		15		.58	1ST GRIND INNER AXLE JRNL	1.197	.104	.798	12
0010	E						RGR-SU-G1	.50	SET UP A GAP GRINDER PRORATE W/SUB OP 0027	1.05938		.609	
0020	E						RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTRPRORATE W/SUB OP 0027	.30830		.177	
0030	E						RLA-HP-C3	.50	CHUCK SYNET PART IN 4 JAW PRORATE W/SUB OP 0027	.09095		.052	
0040	E						KMG-OD-GE	1.00	GRIND .010 3 OD X 3	.25700		.295	
0050	E						RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)	.01014		.011	
0060	E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER	.08334		.095	
0070	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0080	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	
0085			JA	01		15		.58	1ST GRIND OUTER AXLE JRNL	1.197	.104	.798	12
0010	E						RGR-SU-G1	.50	SET UP A GAP GRINDER PRORATE W/SUB OP 0025	1.05938		.609	
0020	E						RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTRPRORATE W/SUB OP 0025	.30830		.177	
0030	E						RLA-HP-C3	.50	CHUCK SYNET PART IN 4 JAW PRORATE W/SUB OP 0025	.09095		.052	
0040	E						KMG-OD-GE	1.00	GRIND .010 3 OD X 3	.25700		.295	
0050	E						RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)	.01014		.011	
0060	E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER	.08334		.095	
0070	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	.02632		.030	
0080	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	
J			JA	01		15		.17	FINISH GRIND PISTON O.D	4.408	.112	.862	13
0010	E						RGR-SU-G1	1.00	SET UP A GAP GRINDER	1.05938		1.218	

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-C21	12.00	GR CHROM OD (OCC FACT L X D) 5.2 X 21.5		.02189		2.819	
0050 E	RGR-GE-D3	5.20	DWELL (GAP GRINDER CHROM OD) 5.2 INCH DIA		.02029		.121	
0060 E	RGR-WD-G2	3.00	WHEEL DRESS GAP GRINDER DRESS WHEEL AS NEEDED		.08334		.287	
0070 E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0080 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011	
0090 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0170	JA 01	15	.17	FINISH GRIND M/PIN SEAL	1.801	.046	.352	5
0010 E	RGR-SU-I2	.20	SET UP LRG INTERNAL GRINDER PRORATE 5 PARTS		1.53372		.352	
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-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL DRESS WHEEL AS NEEDED		.02458		.028	
0060 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION PRORATE 2 PARTS		.06761		.077	
0070 E	KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3 CHECK I.D. 3 TIMES 3 PLACES		.80697		.928	
0080 E	RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023	
0090 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.073	
0100 E	ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064	
0110 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0120 E	RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011	
0175	JA 01	15	.58	GRIND CHROME	1.788	.156	1.193	19
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER PRORATE OVER 4 PARTS		1.05938		1.218	
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-GK	1.00	GRIND .040 3 OD X 3		.41367		.475	
0070 E	RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD) OCCURRANCED FOR DIA		.02029		.070	
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 PAPWRK SIGN OFF DOC		.01001		.011	
0177	JA 01	15	.64	GRIND CHROME	.994	.095	.732	11
0010 E	RGR-SU-G1	.25	SET UP A GAP GRINDER PRORATE OVER 4 PARTS		1.05938		.304	
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-GK	1.00	GRIND .040 3 OD X 3		.41367		.475	
0070 E	RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD) OCCURRANCED FOR DIA		.02029		.070	
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 PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				13SEP83 NEW INPUT-NO OCC FACTOR ON SUB OP'S 0025 &				
0020				0027, 0050 & 0060 <OLD STD> .58				
0021				14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD < .72				
0026				18MAR85 DOWN GRADED NOT MARKET BASKET				
0900				J.CALDWELL TECH MANEAA				

TO INTERROGATE LABOR STANDARDS. INPUV

MRQP NR
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 1234567890123456 ELSE PUT IN END

24338A F15 MLG L/H HW

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

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RB004	S	E	JA	EA	3	J 88187	.05	PERCENT ENGR 99.9	GRIND TORQUE ARM	2.59		.12	
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
								68A410646-2005	1620001386306				
C080			JA	01	15		.25		JIG GRINDER LABOR	1.151	.043	.331	13
0010 E						RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020 E						KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
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-OD	3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084	
0060 E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070 E						KMG-OD-HE	1.00	GRIND .010 3 1/2 OD X 3		.30050		.345	
0080 E						RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090 E						RTL-MM-M3	1.00	MIC O D FIRST MEASUREMENT		.00616		.007	
0100 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0090			JA	01	15		.25		JIG GRINDER LABOR	.878	.033	.253	10
0010 E						RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020 E						KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
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-OD	3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02308		.079	
0060 E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070 E						KMG-OD-CA	1.00	GRIND .010 1 OD X 1		.03200		.036	
0080 E						RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090 E						RTL-MM-M3	1.00	MIC O D FIRST MEASUREMENT		.00616		.007	
0100 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100			JA	01	15		.25		JIG GRINDER LABOR	.993	.037	.286	11
0010 E						RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020 E						KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
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		.084	
0060 E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070 E						KMG-ID-EB	1.00	GRIND OUT .010 2.00 ID X 1.0		.09266		.106	
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						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0110			JA	01	15		.25		JIG GRINDER LABOR	.993	.037	.286	11
0010 E						RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020 E						KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
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		.084	
0060 E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070 E						KMG-ID-EB	1.00	GRIND OUT .010 2.00 ID X 1.0		.09266		.106	
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						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01	15		.25		JIG GRINDER LABOR	1.777	.067	.511	20
J010 E						RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	

0020 E	KHM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
0030 E	RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP	.11975		.137		
40 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087		
.50 E	KMG-DW-OD	3.00	DRESS EXTERNAL WHEEL	.02308	3 DRESSES REQUIRED	.079		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3	.80697		.928		
0080 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093		
0090 E	KMG-OD-FF	1.00	GRIND .040 2 1/2 OD X 1	.13000		.149		
0100 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0220	JA 01	15	.25	JIG GRINDER LABOR	.898	.034	.258	10
0010 E	RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217		
0020 E	KHM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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-OD	3.00	DRESS EXTERNAL WHEEL	.02308	3 DRESSES REQUIRED	.079		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-OD-CF	1.00	GRIND .040 1 OD X 1	.05200		.059		
0080 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093		
0090 E	RTL-MM-M3	1.00	MIC O D FIRST MEASUREMENT	.00616		.007		
0100 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0230	JA 01	15	.25	JIG GRINDER LABOR	1.091	.041	.314	12
0010 E	RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217		
0020 E	KHM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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	.02458	3 DRESSES REQUIRED	.084		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-ID-EG	1.00	GRIND OUT .040 2 ID X 1	.19049		.219		
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	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011		
0240	JA 01	15	.25	JIG GRINDER LABOR	1.241	.047	.357	14
0010 E	RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217		
0020 E	KHM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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	.02458	3 DRESSES REQUIRED	.084		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-ID-EJ	1.00	GRIND OUT .040 2 ID X 2	.34082		.391		
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	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			21NOV85 INITAL INPUT NEW REPAIR					
0900			J.C.LDWELL TECH MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

07/28/88

A-E0462-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW

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SUB	TECH	S	S	W	F	PF	A/R	REV	TR	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PRD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C			
33006	S	N	JA	EA	3	J 88188	.05	PERCENT ENGR 75.9	GRIND APEX PIN-JURY LINK	1.40		.07						
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0				
								68A410764-2001	5315005546340									
0050			JA	01	15		1.00		1ST GRIND O.D.	.588	.085	.677		48				
0010	E					RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335						
0020	E					RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028						
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-BD	1.00	GRIND .010 3/40 X 2 1/2 L		.05417		.062						
0070	E					RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011						
0080	E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093						
0090	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011						
0120			JA	01	15		1.00		FINISH GRIND O.D.	.635	.095	.731		52				
0010	N						1.00		S/U GRINDER > RGRSUC2 <	.29500		.339						
0020	E					RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028						
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-BJ	1.00	GRIND .040 3/4 OD X 2 1/2		.08734		.100						
0070	E					RGR-GF-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023						
0080	E					RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093						
0090	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011						
9000			JA	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0				
0010									13SEP83 NEW INPUT-NO OCC FACTOR HISTORY									
0011									14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD < .13									
0016									18MAR85 DOWN GRADED NOT MARKET BASKET									
0900									J.CALDWELL TECH MANEAA									

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MNPR NR

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OPER	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	STOR	DESCRIPTION	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C					
RS007	S	E	JA	EA	3	K	88190	.11	PERCENT ENGR	99.9	GRIND TRUNNION PIN	2.35		.25							
0001			JA	01	15		.00		PART NUMBER/ NSN		.000	.000	.000		0						
	0010							68M10735-2001	1620003386529												
0060			JA	01	15		1.00		1ST GRIND O.D.		.489	.073	.563		24						
	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	2.00		DRESS EXTERNAL WHEEL		.02308		.053								
	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		DWELL (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		REN RPL PAPWRK SIGN OFF DOC		.01001		.111								
0070			JA	01	15		1.00		1ST GRIND O.D.		.455	.068	.523		22						
	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	2.00		DRESS EXTERNAL WHEEL		.02308		.053								
	0050	E				KMG-GW-LK	1.00		LOCATE WHEEL TO POSITION		.06761		.077								
	0060	E				KMG-OD-DC	1.00		GRIND .010 1 1/2 OD X 2		.08884		.102								
	0070	E				RGR-GE-D2	1.50		DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.017								
	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 PAPWRK SIGN OFF DOC		.01001		.011								
0150			JA	01	15		1.00		GRIND CHROME		.582	.087	.670		28						
	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	2.00		DRESS EXTERNAL WHEEL		.02308		.053								
	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		.19084		.219								
	0070	E				RGR-GE-D3	2.00		DWELL (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		REN RPL PAPWRK SIGN OFF DOC		.01001		.011								
0160			JA	01	15		1.00		CHROME GRIND O.D.		.524	.079	.603		26						
	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	2.00		DRESS EXTERNAL WHEEL		.02308		.053								
	0050	E				KMG-GW-LK	1.00		LOCATE WHEEL TO POSITION		.06761		.077								
	0060	E				KMG-OD-DH	1.00		GRIND .040 1 1/2 OD X 2		.14334		.164								
	0070	E				RGR-GE-D3	1.50		DWELL (GAP GRINDER CHROM OD)	OCCURRANCED 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		REN RPL PAPWRK SIGN OFF DOC		.01001		.011								
9000			JA	01	15		.01		LABOR STANDARD HISTORY		.000	.000	.000		0						
	0010								07SEP83 REVIEW & CHG OCC. FACTORS				0.19								
	0011								14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <				.10								
	0016								18MAR85 DOWN GRADED NOT MARKET BASKET												
	.900								J.CALDWELL TECH MANEAM												

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 DIAL IN CYL O.D.		.09095		.104	
0040 E	RGR-GE-C2	12.00	GR CHROM OD (OCC FACT L X D) 5.2 X 21.5		.02189		2.819	
0050 E	RGR-GE-D3	5.20	DWELL (GAP GRINDER CHROM OD) 5.2 INCH DIA		.02029		.121	
0060 E	RGR-WD-62	3.00	WHEEL DRESS GAP GRINDER DRESS WHEEL AS NEEDED		.08334		.287	
0070 E	RGR-HH-C4	1.00	HANDLE & NEAS LENGTH 12 - 24		.10674		.122	
0080 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0090 E	RGR-HH-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0170	JA 01	15	.17	FINISH GRIND H/PIN SEAL	1.801	.046	.352	5
0010 E	RGR-SU-I2	.20	SET UP LRG INTERNAL GRINDER PRORATE 5 PARTS		1.53372		.352	
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-HH-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0050 E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL DRESS WHEEL AS NEEDED		.02458		.028	
0060 E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION PRORATE 2 PARTS		.06761		.077	
0070 E	KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3 CHECK I.D. 3 TIMES 3 PLACES		.80697		.928	
0080 E	RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023	
0090 E	RGR-HH-C2	1.00	HANDLE & NEAS LENGTH 1 TO 5		.08102		.093	
0100 E	ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064	
0110 E	RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0120 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0175	JA 01	15	.58	GRIND CHROME	1.788	.156	1.193	19
0010 E	RGR-SU-G1	1.00	SET UP A GAP GRINDER PRORATE OVER 4 PARTS		1.05938		1.218	
0020 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E	RGR-HH-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-GK	1.00	GRIND .040 3 OD X 3		.41367		.475	
0070 E	RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD) OCCURRANCED FOR DIA		.02029		.070	
0080 E	RTL-MM-M3	6.00	NIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0177	JA 01	15	.64	GRIND CHROME	.994	.095	.732	11
0010 E	RGR-SU-G1	.25	SET UP A GAP GRINDER PRORATE OVER 4 PARTS		1.05938		.304	
0020 E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E	RGR-HH-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-GK	1.00	GRIND .040 3 OD X 3		.41367		.475	
0070 E	RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD) OCCURRANCED FOR DIA		.02029		.070	
0080 E	RTL-MM-M3	6.00	NIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				13SEP83 NEW INPUT-WD OCC FACTOR ON SUB OP'S 0025 &				
0020				0027, 0050 & 0060 <OLD STD>			.58	
0021				14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <			.72	
0026				18MAR85 DOWN GRADED NOT MARKET BASKET				
0900				J.CALDWELL TECH NAMEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

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26338A F15 HLG L/H HW

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				
RB004	S E	JA EA	3	J	88187	.05 PERCENT ENGR 99.9	GRIND TORQUE ARM	2.59		.12	
0001		JA 01		00		.00	PART NUMBER/NSN	.000	.000	.000	0
						68A410646-2005	1620001386306				
0080		JA 01		15		.25	JIG GRINDER LABOR	1.151	.043	.331	13
0010 E		RGR-SU-J1				.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217	
0020 E		KMH-HP-CB				1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105	
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-OD				3.00	DRESS EXTERNAL WHEEL 3 DRESSES REQUIRED	.02458		.084	
0060 E		KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION LOCATE AFTER EACH DRESS	.06761		.233	
0070 E		KMG-OD-HE				1.00	GRIND .010 3 1/2 OD X 3	.30050		.345	
0080 E		RGR-HH-C2				1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090 E		RTL-MM-M3				1.00	MIC O D FIRST MEASUREMENT	.00616		.007	
0100 E		RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0090		JA 01		15		.25	JIG GRINDER LABOR	.878	.033	.253	10
0010 E		RGR-SU-J1				.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217	
0020 E		KMH-HP-CB				1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105	
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-OD				3.00	DRESS EXTERNAL WHEEL 3 DRESSES REQUIRED	.02308		.079	
0060 E		KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION LOCATE AFTER EACH DRESS	.06761		.233	
0070 E		KMG-OD-CA				1.00	GRIND .010 1 OD X 1	.03200		.036	
0080 E		RGR-HH-C2				1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090 E		RTL-MM-M3				1.00	MIC O D FIRST MEASUREMENT	.00616		.007	
0100 E		RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0100		JA 01		15		.25	JIG GRINDER LABOR	.993	.037	.286	11
0010 E		RGR-SU-J1				.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217	
0020 E		KMH-HP-CB				1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105	
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		.084	
0060 E		KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION LOCATE AFTER EACH DRESS	.06761		.233	
0070 E		KMG-ID-EB				1.00	GRIND OUT .010 2.00 ID X 1.0	.09266		.106	
0080 E		RGR-HH-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		RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0110		JA 01		15		.25	JIG GRINDER LABOR	.993	.037	.286	11
0010 E		RGR-SU-J1				.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217	
0020 E		KMH-HP-CB				1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105	
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		.084	
0060 E		KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION LOCATE AFTER EACH DRESS	.06761		.233	
0070 E		KMG-ID-EB				1.00	GRIND OUT .010 2.00 ID X 1.0	.09266		.106	
0080 E		RGR-HH-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		RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0100		JA 01		15		.25	JIG GRINDER LABOR	1.777	.067	.511	20
0010 E		RGR-SU-J1				.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217	

0020 E	KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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-OD	3.00	DRESS EXTERNAL WHEEL	.02308	3 DRESSES REQUIRED	.079		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3	.80697		.928		
0080 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093		
0090 E	KMG-OD-FF	1.00	GRIND .040 2 1/2 OD X 1	.13000		.149		
0100 E	RJP-FW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
0220	JA 01	15	.25	JIG GRINDER LABOR	.898	.034	.258	10
0010 E	RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217		
0020 E	KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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-OD	3.00	DRESS EXTERNAL WHEEL	.02308	3 DRESSES REQUIRED	.079		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-OD-CF	1.00	GRIND .040 1 OD X 1	.05200		.059		
0080 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093		
0090 E	RTL-MM-M3	1.00	MIC O D FIRST MEASUREMENT	.00616		.007		
0100 E	RJP-FW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
0230	JA 01	15	.25	JIG GRINDER LABOR	1.091	.041	.314	12
0010 E	RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217		
0020 E	KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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	.02458	3 DRESSES REQUIRED	.084		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-ID-EG	1.00	GRIND OUT .040 2 ID X 1	.19049		.219		
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	RJP-FW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
0240	JA 01	15	.25	JIG GRINDER LABOR	1.241	.047	.357	14
0010 E	RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS	.75732		.217		
0020 E	KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS	.09202		.105		
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	.02458	3 DRESSES REQUIRED	.084		
0060 E	KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	.06761	LOCATE AFTER EACH DRESS	.233		
0070 E	KMG-ID-EJ	1.00	GRIND OUT .040 2 ID X 2	.34082		.391		
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	RJP-FW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010			21NOV85 INITIAL INPUT NEW REPAIR					
0900			J.CALDWELL TECH MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROF NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPRB

09/16/88
4A4-22-3

A-E0468-MM1-DY-M45 PAGE 0001
86224

26338A F15 MLG L/H HW
OPER TECH S S W F PF A/R REV
SUB T K #R A FA SUPPORT
STEP D L K C DC ELEMENT

OCC <-----> DESCRIPTION ----->
FACT STORED SUPPLEMENTAL
BASE PFD STD A
HOURS TIME HOURS DLY PCT C

OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RS009	S	E	JA	EA	3		K	88190	.05	PERCENT ENGR 99.9	2.24		.11	
0001			JA	01			00		.00	GRIND JURY LINK PIN F-15M PART NUMBER/NSN	.000	.000	.000	0
0010										68A410756-1001 1620003386530				
0050			JA	01			15		1.00	1ST GRIND O.D.	.419	.063	.483	21
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				2.00	DRESS EXTERNAL WHEEL	.02308		.053	
0050 E			KMG	GW	LK				1.00	LOCATE WHEEL TO POSITION	.06761		.077	
0060 E			KMG	OD	CC				1.00	GRIND .010 1 OD X 2	.05867		.067	
0070 E			RGR	GE	D2				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 PAPRWRK SIGN OFF DOC	.01001		.011	
0055			JA	01			15		1.00	1ST GRIND O.D.	.455	.068	.523	23
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				2.00	DRESS EXTERNAL WHEEL	.02308		.053	
0050 E			KMG	GW	LK				1.00	LOCATE WHEEL TO POSITION	.06761		.077	
0060 E			KMG	OD	DC				1.00	GRIND .010 1 1/2 OD X 2	.08884		.102	
0070 E			RGR	GE	D2				1.50	DWELL (GAP GRINDER STEEL OD) OCCURRANCED FOR DIA	.01014		.017	
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	
0120			JA	01			15		1.00	GRIND CHROME O. D.	.554	.083	.637	28
0010 E			RGR	SU	C2				.25	SET UP SMALL MED CYL GRINDER PRORATE OVER 4 PARTS	.29197		.083	
0020 E			RLA	HP	C3				2.00	CHUCK SYMET PART IN 4 JAW	.09095		.209	
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	CH				1.00	GRIND .040 1 OD X 2	.09467		.108	
0070 E			RGR	GE	D3				2.00	DWELL (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 PAPRWRK SIGN OFF DOC	.01001		.011	
0125			JA	01			15		1.00	CHROME GRIND O.D.	.524	.079	.603	27
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				2.00	DRESS EXTERNAL WHEEL	.02308		.053	
0050 E			KMG	GW	LK				1.00	LOCATE WHEEL TO POSITION	.06761		.077	
0060 E			KMG	OD	DH				1.00	GRIND .040 1 1/2 OD X 2	.14334		.164	
0070 E			RGR	GE	D3				1.50	DWELL (GAP GRINDER CHROM OD) OCCURRANCED 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	
9000			JA	01			15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010										07SEP83 REVIEW & UPDATE NO OCC. FACTOR CHG 0.19				
0011										14NOV84 2 YR REVIEW W/NO CHANGE				
0016										18MAR85 DOWN GRADED NOT MARKET BASKET				
0900										J.CALDWELL TECH MANEAA				

OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE	PRD	STD	A
SUB	T	K	#R	A	FA	SUPPORT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT
STEP	D	L	K	C	DC	ELEMENT	FACT							C
39011	S	E	JA	EA	3	K	98194	.05	PERCENT ENGR 99.9	GRIND UPPER JURY LINK	1.00		.05	
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000	0
	0010								88A410794-1005	1620010403581				
	0020								88A410794-1006	1620010403580				
0050		JA	01			15		1.00		1ST GRIND O.D.	.414	.062	.477	47
	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	2.00	DRESS EXTERNAL WHEEL		.02308		.053	
	0050	E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
	0060	E					KMG-OD-DA	1.00	GRIND .010 1 1/2 OD X 1		.04850		.055	
	0070	E					RGR-GE-D2	1.50	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.017	
	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	
0120		JA	01			15		1.00		GRIND CHROME O.D.	.460	.069	.529	53
	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	2.00	DRESS EXTERNAL WHEEL		.02308		.053	
	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)	OCCURRANCED 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	
9000		JA	01			15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
	0010								07SEP83	REVIEW & UPDATE NO OCC. FACTOR CHG	0.09			
	0011								14NOV84	2 YR REVIEW W/NO CHANGE				
	0016								18MAR85	DOWN GRADED NOT MARKET BASKET				
	0900									J.CALDWELL TECH MANEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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 1234567890123456 ELSE PUT IN END

TECH S S W F P F A/R REV		SUPPORT OCC		DESCRIPTION		BASE	PFD	STD	A	
SUB	T K	#R A	FA	FACT	STORED	HOURS	TIME	HOURS	DLY PCT C	
STEP	D L	K C	DC	ELEMENT	SUPPLEMENTAL					
9E012	S N	JA EA 3	J 8.190	.10	PERCENT ENGR 75.9	GRIND RETRACT BOLT	1.40	.14		
0001		JA 01	15	.00		PART NUMBER/ NSN	.000	.000	.000	0
		0010			62A410768-1001	1620003336550				
0070		JA 01	15	1.00		1ST GRIND O.D.	.588	.028	.677	48
0010	E			1.00	RGR-SU-C2	SET UP SMALL MED CYL GRINDER	.29197		.335	
0020	E			1.00	RLA-HP-C6	LOAD&UNLOAD SML PART-CENTERS	.02466		.028	
0030	E			1.00	RGR-HM-T2	ADJUST TAPER - GAP GRINDER	.02632		.030	
0040	E			1.00	KMG-DW-OD	DRESS EXTERNAL WHEEL	.02308		.026	
0050	E			1.00	KMG-GW-LK	LOCATE WHEEL TO POSITION	.06761		.077	
0060	E			1.00	KMG-OD-BD	GRIND .010 3/4 X 2 1/2 L	.05417		.062	
0070	E			1.00	RGR-GE-D2	DWELL (GAP GRINDER STEEL OD)	.01014		.011	
0080	E			1.00	RGR-HM-C2	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090	E			1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0160		JA 01	15	1.00		FINISH GRIND O.D.	.635	.095	.731	52
0010	N			1.00		S/U GRINDER > RGRSUC2 <	.29500		.339	
0020	E			1.00	RLA-HP-C6	LOAD&UNLOAD SML PART-CENTERS	.02466		.028	
0030	E			1.00	RGR-HM-T2	ADJUST TAPER - GAP GRINDER	.02632		.030	
0040	E			1.00	KMG-DW-OD	DRESS EXTERNAL WHEEL	.02308		.026	
0050	E			1.00	KMG-GW-LK	LOCATE WHEEL TO POSITION	.06761		.077	
0060	E			1.00	KMG-OD-BJ	GRIND .040 3/4 OD X 2 1/2	.08734		.100	
0070	E			1.00	RGR-GE-D3	DWELL (GAP GRINDER CHROM OD)	.02029		.023	
0080	E			1.00	RGR-HM-C2	HANDLE & MEAS LENGTH 1 TO 5	.08102		.093	
0090	E			1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000		JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010						13SEP83 NEW INPUT-NO OCC FACTOR HISTORY				
0011						14NOV84 2 YR REVIEW W/NO CHANGE				
0016						18MAR85 DOWN GRADED NOT MARKET BASKET				
0900						J.CALDWELL TECH MANEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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 1234567890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPRB

09/16/88
4A4-22-3

A-E0448-HMI-DY-M45 PAGE 0001
86224

26338A F15 NLG L/H HW
OPER TECH S S W F PF A/R REV
SUB T K #R A FA SUPPORT
STEP D L K C DC ELEMENT FACT

OPER	TECH	S	S	W	F	PF	A/R	REV	OCC	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	DESCR	SUPPLE	HOURS	TIME	HOURS	PCT C
R5013	S	E	JA	EA	3	K	88197	.05	PERCENT ENGR 99.9	GRIND SPINDLE ASSY F-15M	1.80		.09	
0001			JA	01		00	.00			PART NUMBER/NSN	.000	.000	.000	0
0010									68A410624-1001	1620003337133				
0060			JA	01		15	1.00			1ST GRIND O.D.	.377	.057	.434	24
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	2.00			DRESS EXTERNAL WHEEL	.02308		.053	
0050	E					KMG-GW-LK	1.00			LOCATE WHEEL TO POSITION	.06761		.077	
0060	E					KMG-OD-AA	1.00			GRIND .010 1/2 DIA. X 1	.01617		.018	
0070	E					RGR-GE-D2	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			REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0070			JA	01		15	1.00			1ST GRIND O.D.	.377	.057	.434	24
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	2.00			DRESS EXTERNAL WHEEL	.02308		.053	
0050	E					KMG-GW-LK	1.00			LOCATE WHEEL TO POSITION	.06761		.077	
0060	E					KMG-OD-AA	1.00			GRIND .010 1/2 DIA. X 1	.01617		.018	
0070	E					RGR-GE-D2	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			REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0150			JA	01		15	1.00			GRIND CHROME O.D.	.407	.061	.469	26
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	2.00			DRESS EXTERNAL WHEEL	.02308		.053	
0050	E					KMG-GW-LK	1.00			LOCATE WHEEL TO POSITION	.06761		.077	
0060	E					KMG-OD-AF	1.00			GRIND .040 FROM 1/2D X 1	.03633		.041	
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			REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
0160			JA	01		15	1.00			GRIND CHROME O.D.	.407	.061	.469	26
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	2.00			DRESS EXTERNAL WHEEL	.02308		.053	
0050	E					KMG-GW-LK	1.00			LOCATE WHEEL TO POSITION	.06761		.077	
0060	E					KMG-OD-AF	1.00			GRIND .040 FROM 1/2D X 1	.03633		.041	
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			REM RPL PAPERWK SIGN OFF DOC	.01001		.011	
9000			JA	01		15	.01			LABOR STANDARD HISTORY	.000	.000	.000	0
0010										07SEP83 REVIEW & CHG OCC. FACTORS			0.10	
0011										14NOV84 2 YR REVIEW W/NO CHANGE				
0016										18MAR85 DOWN GRADED NOT MARKET BASKET				
0900										J.CALDWELL TECH MANEAA				

TECH S S		W F PF A/R REV		DCC		DESCRIPTION		BASE	PFD	STD	A	
SUB	T K	#R	A	FA	SUPPORT	FACT	STOR	HOURS	TIME	HOURS	DLY	PCT C
STEP	D L	K C	DC	ELEMENT			SUPPLEMENTAL					
88019	S E	JA	EA	3	J	88190	.10 PERCENT ENGR 99.9	GRIND JURY BRACE APEX PIN	2.27		.22	
0001		JA	01	15			.00	PART NUMBER/NSN	.000	.000	.000	0
	0010						68A410755-2005	1620003337138				
0050		JA	01	15			1.00	1ST GRIND LARGE O.D.	.452	.068	.520	23
	0010 E				RGR-SU-C2		.50	SET UP SMALL MED CYL GRINDER PRORATE W/SUB OP 0055	.29197		.167	
	0020 E				RLA-HP-C6		.50	LOAD/UNLOAD SML PART-CENTERS PRORATE W/SUB OP 0055	.02466		.014	
	0030 E				RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER PRORATE W/SUB OP 0055	.02632		.015	
	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-DC		1.00	GRIND .010 1 1/2 OD X 2	.68884		.102	
	0070 E				RGR-GE-D2		1.00	DWELL (GAP GRINDER STEEL OD)	.01014		.011	
	0080 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	
0055		JA	01	15			1.00	1ST GRIND SMALL O.D.	.492	.074	.567	25
	0010 E				RGR-SU-C2		.50	SET UP SMALL MED CYL GRINDER PRORATE W/SUB OP 0050	.29197		.167	
	0020 E				RLA-HP-C6		.50	LOAD/UNLOAD SML PART-CENTERS PRORATE W/SUB OP 0050	.02466		.014	
	0030 E				RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER PRORATE W/SUB OP 0050	.02632		.015	
	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-DE		1.00	GRIND .010 1 1/2 OD X 3	.12934		.148	
	0070 E				RGR-GE-D2		1.00	DWELL (GAP GRINDER STEEL OD)	.01014		.011	
	0080 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	
0120		JA	01	15			1.00	FINISH GRIND LARGE O.D.	.516	.078	.594	26
	0010 E				RGR-SU-C2		.50	SET UP SMALL MED CYL GRINDER PRORATE W/SUB OP 0125	.29197		.167	
	0020 E				RLA-HP-C6		.50	LOAD/UNLOAD SML PART-CENTERS PRORATE W/SUB OP 0125	.02466		.014	
	0030 E				RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER PRORATE W/SUB OP 0125	.02632		.015	
	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-DH		1.00	GRIND .040 1 1/2 OD X 2	.14334		.164	
	0070 E				RGR-GE-D3		1.00	DWELL (GAP GRINDER CHROM OD)	.02029		.023	
	0080 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	
0125		JA	01	15			1.00	FINISH GRIND SMALL O.D.	.516	.078	.594	26
	0010 E				RGR-SU-C2		.50	SET UP SMALL MED CYL GRINDER PRORATE W/SUB OP 0120	.29197		.167	
	0020 E				RLA-HP-C6		.50	LOAD/UNLOAD SML PART-CENTERS PRORATE W/SUB OP 0120	.02466		.014	
	0030 E				RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER PRORATE W/SUB OP 0120	.02632		.015	
	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-DH		1.00	GRIND .040 1 1/2 OD X 2	.14334		.164	
	0070 E				RGR-GE-D3		1.00	DWELL (GAP GRINDER CHROM OD)	.02029		.023	
	0080 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	
9000		JA	01	15			.01	LABOR STANDARD HISTORY	.000	.000	.000	0
	0010							14SEP83 NEW INPUT-NO OCC FACTORS				
	0011							14NOV84 2 YR REVIEW W/NO CHANGE				
	0016							18MAR85 DOWN GRADED NOT MARKET BASKET				
	0900							J.CALDWELL TECH MANEAA				

26338A F15 M/G L/H HW

RCC MNPRB

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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	STOKED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
RR026	S	E	JA	EA 3	J	88202	.33 PERCENT ENGR 99.9				
0001			JA	01	00		GRD.REPR.HIGH PRESSURE PSTN. PART NUMBER/N.S.N.	4.16		1.37	
0010						68A410790-2001	1620003654003	.000	.000	.000	0
0070			JA	01	15		IST.GRD.PISTON LANDS O.D.	.805	.121	.926	22
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-LE	1.00 GRIND .010 FROM 5 IN OD X 3	.42668		.490	
0070	E					RGR-GE-D2	5.00 DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA	.01014		.058	
0080	E					RTL-MM-M3	6.00 MIC D D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH	.00616		.042	
0090	E					RJP-PW-R1	1.00 REM RPL PAPRWK SIGN OFF DOC	.01001		.011	
0080			JA	01	15		IST.GRD.PISTON LANDS I.D.	1.346	.010	.077	2
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	E					KMG-ID-LE	1.00 GRIND OUT .010 5 ID X 3	.60998		.701	
0070	E					RGR-GE-D2	5.00 DWELL (GAP GRINDER STEEL OD)	.01014		.058	
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 PAPRWK SIGN OFF DOC	.01001		.011	
0090			JA	01	15		IST.GRD.PISTON GROOVE O.D.	.761	.077	.587	14
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-KE	1.00 GRIND .010 4 1/2 OD X 3	.38784		.446	
0070	E					RGR-GE-D2	4.50 DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA	.01014		.052	
0080	E					RTL-MM-M3	6.00 MIC D D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH	.00616		.042	
0090	E					RJP-PW-R1	1.00 REM RPL PAPRWK SIGN OFF DOC	.01001		.011	
0100			JA	01	15		IST.GRD.PISTON GROOVE I.D.	1.147	.009	.066	2
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	E					KMG-ID-HE	1.00 GRIND OUT .010 3.5 ID X 3	.42548		.489	
0070	E					RGR-GE-D2	3.50 DWELL (GAP GRINDER STEEL OD)	.01014		.040	
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 PAPRWK SIGN OFF DOC	.01001		.011	
			JA	01	15		FINISH GRD.LANDS O.D.	1.116	.167	1.283	31
0010	E					RGR-SU-C2	.25 SET UP SMALL MED CYL GRINDERPRORARE 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-LK	1.00	GRIND .040 FROM 5 IN OD X 3		.68668		.789	
0070	E	RGR-GE-D3	5.00	DWELL (GAP GRINDER CHROM OD) OCCURRANCED FOR DIA		.02029		.116	
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	
0190	JA 01	15	.33	FINISH GRD.LAND I.D.		1.436	.071	.545	13
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	E	KMG-ID-GK	1.00	GRIND OUT .040 3 ID X 3		.68914		.792	
0070	E	RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD)		.02029		.70	
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	
0240	JA 01	15	.67	FINISH GRIND GROOVE O.D.		.761	.077	.587	14
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-KE	1.00	GRIND .010 4 1/2 OD X 3		.38784		.446	
0070	E	RGR-GE-D2	4.50	DWELL (GAP GRINDER STEEL OD) OCCURRANCED FOR DIA		.01014		.052	
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	
0250	JA 01	15	.05	FINISH GRIND GROOVE I.D.		1.564	.012	.090	2
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	E	KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3		.80697		.928	
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 00	15	.00	LABOR STANDARD HISTORY		.000	.000	.000	0
0001				28AUG86 INITAL INPUT EST. NEW REQUIREMENT					
0010				20JUL88 OCC.FAC.CHGE,OLD STD..20					
0900				J.CALDWELL TECH MANEL					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD

OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPCP

08/01/88
4A4-22-3

A-E046B-MH1-DY-M45 PAGE 0001
8622A

26337A F15 MLG R/H HB

TECH 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
HOURS TIME HOURS
DLY PCT C

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	C
00010	E	N	HB	EA	5	J 88204	1.00	PERCENT ENGR	.0	STRUT ASSY F-15	11.60		11.60		
0001			HB	01	00		.00			PART NUMBER /NSN	.000	.000	.000		0
0010								68A410501-2007		1620010360335					
0020								68A410501-2008		1620010360336					
0030								68A410501-2009		1620010672791					
0040								68A410501-2010		1620010799928					
0050								68A410501-2011		1620011671000					
0060								68A410501-2012		1620011670999					
0501			HB	01	21		1.00			PRE CLEAN	1.000	.210	1.210		10
0010			N				1.00			CLEAN	1.00000		1.210		
0502			HB	01	21		1.00			OK CLOSE/ASSEMBLE	6.000	1.260	7.260		63
0010			N				1.00			ASSY	6.00000		7.260		
0504			HB	01	21		1.00			CHECK STROKE	.710	.149	.859		7
0010			N				1.00			CHECK STROKE	.71000		.859		
0505			HB	01	21		1.00			FINGER LOCK CHECK	1.000	.210	1.210		10
0010			N				1.00			CHECK	1.00000		1.210		
0506			HB	01	21		1.00			PRESSURE TEST	.880	.185	1.065		9
0010			N				1.00			TEST	.88000		1.064		
9000			HB	01	21		.01			LABOR STD HISTORY	.000	.000	.000		0
0010								15MAR83 UPDATE E STD 2 YR REVIEW							3.14
0011								14NOV84 2 YR REVIEW W/NO CHANGE							

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD HRCP NR

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26337A F15 MLG R/H HW

RCC MNPGR

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86224

STEP	D L	K C DC	ELEMENT	FACT	STORER	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
0000	S	E	DI EA 5	K 88204	1.00	PERCENT ENGR 99.9	MATCH UP STRUT ASSY	.90		.90	
0001		DI 01	00		.00		PART NUMBER /NSN	.000	.000	.000	0
0010						68A410501-2007	1620010360335				
0020						68A410501-2008	1620010360336				
0030						69A410501-2009	1620010672791				
0040						68A410501-2010	1620010799928				
0050						68A410501-2011	1620011671000				
0060						68A410501-2012	1620011670999				
0010		DI 01	21		1.00		MATCH UP	.750	.158	.908	100
0110	E		RLG-MU-01		1.00	MATCH UP PARTS FOR ASSEMBLY		.52681		.637	
0120	E		GCE-JP-T0		1.00	T.O. RESEARCH		.19359		.234	
0130	E		RJP-PW-R1		2.00	REM RPL PAPWRK SIGN OFF DOC OCC FOR NO. 758 IN PACKAGE		.01001		.024	
0140	E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000		DI 01	21		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010						15MAR83 PRGR HISTORY ON 00-ALC FORM 494					
0011											
0020						ADD SUB OP 0002 PARTS HANDLING NON					
0030						RCUTED PARTS					
0031						14NOV84 2 YR REVIEW W/NO CHANGE					
0033						18MAR85 ICWN GRADED NOT MARKET BASKET					
0900						J.CALDWELL TECH MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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26337A F15 MLG R/H HW

RCC MNPGR

4A4-22-3

86224

TCH S S W F PF A/R REV

T K #R A FA SUPPORT OCC

DESCRIPTION

BASE PFD STD A
HOURS TIME HOURS DLY PCT C

STEP D L K C DC ELEMENT FACT STORED

SUPPLEMENTAL

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
PH02	E	N	DI	EA	5	J 88204	1.00	PERCENT ENGR .0	MATCH UP PISTON/HEAD F-15		.20		.20	
0001			DI	01	00		.00		PART NUMBER/NSN		.000	.000	.000	0
0010								68A410704-1001	1620003486501					
0020								68A410704-1002	1620003486502					
0030								68A410704-1011	1620018033404					
0040								68A410704-1012	1620018033407					
0050								68A410704-1005	1620018033401					
0060								68A410704-1006	1620018188799					
0257			DI	01	21		1.00		PISTON & HEAD MATCH UP		.167	.035	.202	100
0010	H						1.00		MATCH UP		.16700		.202	
9000			DI	01	00		.00		LABOR STANDRD HISTORY		.000	.000	.000	0
0900									8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRP:1					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MNPGR NR

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