DoD 5010.15.1-M
VOLUME V

STANDARDIZATION
OF
WORK MEASUREMENT

Defense
Work
Measurement
Standard
Time
Data
Program

19991217 110

VOLUME V
PROCESSING OCCUPATIONS

June 1975

REPLY
REFER TO

CHANGE NO. 1
DOD 5010.15.1-M

STANDARDIZATION OF WORK MEASUREMENT
PROCESSING OCCUPATIONS
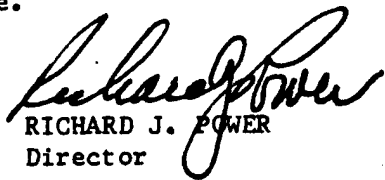
I.   DoD 5010.15.1-M, Volume V, 1 Dec 75, is changed as follows:

A. Page v, Part Two, Section I, Line 1: Delete the word "three" and substitute "four."

B. Page v, Part Two, Section I: Add the following paragraph:

The Verb Index which is an alphabetical listing of the "title" line of the DWMSTDP Operation/Element Description sequenced by the verb, page D-1.

C. Add pages D-1 thru D-3 after page C-3.

II. This change is an administrative addition of an index for the elements published in the volume.

III. This change sheet will be filed in front of the publication for reference purposes, after changes have been made.

RICHARD J. POWER
Director

ASSISTANT SECRETARY OF DEFENSE
WASHINGTON, D.C. 20301

INSTALLATIONS AND LOGISTICS

18 Jun 75

FOREWORD

This volume of DoD 5010.15.1-M, "Standardization of Work
Measurement," is one of a series published under the authority
of DoD Directive 5010.15, Defense Integrated Management
Engineering System (DIMES). It provides standard time data for
Processing Occupations as classified by Department of Labor codes
and includes guidelines for uniform application. Some of the tasks
covered in the occupations are electroplating, heat treating, cleaning
and degreasing, and others of this nature.

Maximum use of the guidelines and standard time data is mandatory
at each Department of Defense activity where Labor Performance
Standards are developed and applied.

All of the included standard time data have been reviewed and
approved by a Joint Service/Agency Standard Time Data Group
prior to publication.

John J. Bennett
Acting Assistant Secretary of Defense
(Installations and Logistics)

DISTRIBUTION
Defense Supply Agency:
3 less 7,9,10

STANDARD TIME DATA
FOR
PROCESSING OCCUPATIONS

TABLE OF CONTENTS

PART ONE - GUIDANCE

PART TWO - PROCESSING OCCUPATIONS STANDARD TIME DATA

DEFENSE WORK MEASUREMENT STANDARD TIME
DATA PROGRAM (DWMSTDP)

PROCESSING OCCUPATIONS

PART ONE - GUIDANCE

CHAPTER I - GENERAL INFORMATION

1.1 PURPOSE

This volume of Processing Occupations Standard Time Data is one of ten volumes of
standard time data in the 11 volume series included in DWMSTDP. Processing Occupa-
tions as categorized by the Department of Labor includes those occupations concerned
with refining, mixing, compounding, chemically treating, heat treating. or similarly
working materials and products. Knowledge of a process and adherence to formulae
or other specifications are required in some degree. Vats. stills. ovens. furnaces.
mixing machines, crushers, grinders, and related equipment or machines are usually
involved. This volume provides a single DoD source for Standard Time Data
which can be used in the development of labor standards for:

1.1.1 Organizations, activities, or functional areas whose primary missions correlate
to processing occupations. e.g., an activity whose primary responsibility is plating,
chemical cleaning, sandblasting, etc.

1.1.2 For processing operations within organizations, activities, or functional areas
engaged in other than processing occupations, e.g., a degreaser operator assigned to
an instrument repair shop.

1.1.3 Work performed by personnel whose primary jobs are other than processing,
but who may actually do that type work as a part of their jobs, e.g., a packer
performing a degreasing operation within a supply activity.

1.2 SCOPE

This publication applies to all military services and defense agencies. The data
contained herein will be used to the maximum extent practicable in the development
of labor performance standards in compliance with DoD Directive 5010.15.

1.3 APPLICATION

The Processing Occupations Standard Time Data contained in this volume must be
applied in accordance with the general information contained in the Basic Volume and
the specific instructions contained in this volume.

1.4 SUBMISSION OF NEW DWMSTDP ELEMENTS

All newly developed or existing Processing Occupations Standard Time Data
not now included herein will be submitted with back-up motion pattern analysis to the
Defense Industrial and Management Engineering Office (DIMEO) for review and possible
inclusion in the updating changes to this volume. The Basic Volume contains
procedures for submitting this input.

CHAPTER II - CODING

2.1 GENERAL

2.1.1 Information requirements applicable to DWMSTDP have been standardized. Applicable DoD Standard Data Elements have been utilized and all other data elements have been proposed for data representation standardization action in accordance with the provisions of DoD Instruction 5000.12, "Data Elements and Codes Standardization Procedures" and DoD 5000.12-M.

2.1.2 The complete coding structure for a Defense Work Measurement Standard Time Data Program element is explained in the Basic Volume. Figure 1 highlights a typical Occupation Code, Work Category Code, and Work Sub-Category Code for Processing Data.
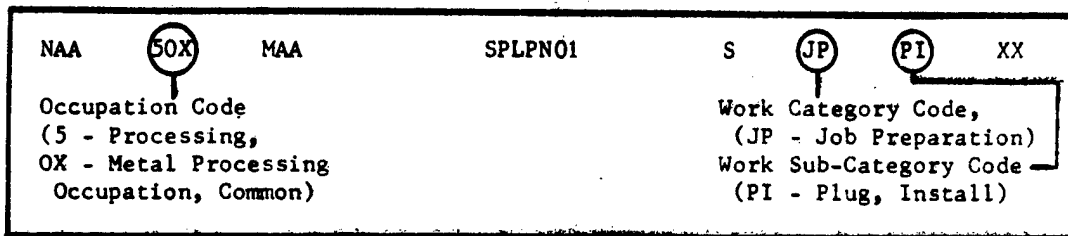

Figure 1. - DWMSTDP Coding Structure

2.2 TYPES OF CODES

2.2.1 Occupation Codes

The Occupation Codes for DWMSTDP elements in this volume conform to the numeric codes of Processing Occupations listed in the U.S. Department of Labor Dictionary of Occupational Titles. All Department of Labor Processing Occupations are shown in Figure 2. Figure 3 identifies the work ascribed to the specific occupations contained in this volume. There are occasions when a standard time data element may have common application to two or more divisions of the total 5 Processing Occupational category. If this is the case, an X is used in both the Occupation Division position (second numeric) and the Group Position (third numeric), e.g., 5XX. If the common application occurs only within the Occupation Division, an X is used in the Group position only (third numeric) e.g., 50X, 52X.

2.2.2 Work Category Code

The two position Work Category Code encircled in Figure 1 further identifies the various types of work performed within the occupation groups. This classification category indicates the major action being performed or major equipment involved in the DWMSTDP element. Figure 4 lists and defines the work categories used in coding Processing Occupations standard time data.

2.2.3 Work Sub-Category Code

The two position Work Sub-Category Code encircled in Figure 1 is a sub-division of the Work Category Code and identifies the object, process, or condition associated with the action or equipment. This code is generally oriented to a noun-verb sequence relationship, e.g., PI is the code for "Plug, Install" in the element description header line. However, if the noun-verb sequence in the element code causes a duplication of the code, the sequence has been modified. The noun-verb sequence will remain in the verbage of the element title whenever possible.

2.3 FUNDAMENTAL STANDARD TIME DATA

Every occupation includes general purpose elements such as get, place, read or write which are fundamental to each occupation but not specific to any one. These elements are called "Universal" and are contained in Volume X - Universal Standard Time Data.

5 - PROCESSING OCCUPATIONS

(PROCESSING)

50 Occupations in Processing of Metal
    (Metal Processing)

500. Electroplating occupations
         (Electroplating)
501. Dip plating occupations
         (Dip plating)
502. Melting, pouring casting, and related occupations
         (Melting, pouring, casting, and related work)
503. Pickling, cleaning, degreasing, and related occupations
         (Pickling, cleaning, degreasing, and related work)
504. Heat-treating occupations
         (Heat treating)
505. Metal spraying, coating, and related occupations
         (Metal spraying, coating, and related work)
509. Occupations in processing of metal, n.e.c.
         (Metal processing, n.e.c.)

51 Ore Refining and Foundry Occupations
         (Ore Refining and Foundry Work)

510. Mixing and related occupations
         (Mixing and related work)
511. Separating, filtering, and related occupations
         (Separating, filtering, and related work)
512. Melting occupations
         (Melting)
513. Roasting occupations
         (Roasting)
514. Pouring and casting occupations
         (Pouring and casting)
515. Crushing and grinding occupations
         (Crushing and grinding)
518. Molders, coremakers, and related occupations
         (Molding, coremaking, and related work)
519. Ore refining and foundry occupations, n.e.c.
         (Ore refining and foundry work, n.e.c.)

52 Occupations in Processing of Food, Tobacco, and Related Products
         (Processing, Food and Related Products)

520. Mixing, compounding, blending, kneading, shaping, and related occupations
         (Mixing, compounding, blending, kneading, shaping, and related work)
521. Separating, crushing, milling, chopping, grinding, and related occupations
         (Separating, crushing, milling, chopping, grinding, and related work)

n.e.c.-not elsewhere classified

Figure 2 - Processing Occupations Codes

522. Culturing, melting, fermenting, distilling, saturating, pickling, aging, and related occupations
    (Culturing, melting, fermenting, distilling, saturating pickling, aging, and related work)
523. Heating, rendering, melting, drying, cooling, freezing, and related occupations
    (Heating, rendering, melting drying, cooling, freezing, and related work)
524. Coating, icing, decorating and related occupations
    (Coating, icing, decorating, and related work)
525. Slaughtering, breaking, curing, and related occupations
    (Slaughtering, breaking, curing, and related work)
526. Cooking and baking occupations, n.e.c.
    (Cooking and baking, n.e.c.)
529. Occupations in processing of food, tobacco, and related products, n.e.c.
    (Processing, food and related products, n.e.c.)

53 Occupations in Processing of Paper and Related Materials
    (Processing, Paper and Related Materials)

530. Grinding, beating, and mixing occupations
    (Grinding, beating, and mixing)
532. Cooking and drying occupations
    (Cooking and drying)
533. Cooling, bleaching, screening, washing, and related occupations
    (Cooling, bleaching, screening, washing, and related work)
534. Calendering, sizing, coating, and related occupations
    (Calendering, sizing, coating, and related occupations)
535. Forming occupations, n.e.c.
    (Forming, n.e.c.)
539. Occupations in processing of paper and related materials, n.e.c.
    (Processing, paper and related materials, n.e.c.)

54 Occupations in Processing of Petroleum, Coal, Natural and Manufactured Gas, and Related Products
    (Processing, Petroleum and Related Products)

540. Mixing and blending occupations
    (Mixing and blending)
541. Filtering, straining, and separating occupations
    (Filtering, straining, and separating)
542. Distilling, subliming, and carbonizing occupations
    (Distilling, subliming, and carbonizing)
543. Drying, heating, and melting occupations
    (Drying, heating, and melting)
544. Grinding and crushing occupations
    (Grinding and crushing)
546. Reacting occupations, n.e.c.
    (Reacting, n.e.c.)
549. Occupations in processing of petroleum, coal, natural and manufactured gas, and related products, n.e.c.
    (Processing, petroleum and related products, n.e.c.)

n.e.c.-not elsewhere classified

Figure 2 - Processing Occupations Codes (Continued)

55 Occupations in Processing of Chemicals, Plastics, Synthetics, Rubber, Paint, and Related Products
        (Processing, Chemicals and Related Products)

550. Mixing and blending occupations
        (Mixing and blending)
551. Filtering, straining, and separating occupations
        (Filtering, straining, and separating)
552. Distilling occupations
        (Distilling)
553. Heating, baking, drying, seasoning, melting, and heat-treating occupations
        (Heating, baking, seasoning, melting, and heat treating)
554. Coating, calendering, laminating, and finishing occupations
        (Coating, calendering, laminating, and finishing)
555. Grinding and crushing occupations
        (Grinding and crushing)
556. Casting and molding occupations, n.e.c.
        (Casting and molding, n.e.c.)
557. Extruding occupations
        (Extruding)
558. Reacting occupations, n.e.c.
        (Reacting, n.e.c.)
559. Occupations in processing of chemicals, plastics, synthetics, rubber, paint, and related products, n.e.c.
        (Processing, chemicals and related products, n.e.c.)

56 Occupations in Processing of Wood and Wood Products
        (Processing, Wood and Wood Products)

560. Mixing and related occupations
      ▼   (Mixing and related work)
561. Wood preserving and related occupations
        (Wood preserving and related work)
562. Saturating, coating, and related occupation, n.e.c.
        (Saturating and related work, n.e.c.)
563. Drying, seasoning, and related occupations
        (Drying, seasoning, and related work)
569. Occupations in processing of wood and wood products, n.e.c.
        (Processing, wood and wood products, n.e.c.)

57 Occupations in Processing of Stone, Clay, Glass, and Related Products
        (Processing, Nonmetallic Minerals and Related Products)

570. Crushing, grinding, and mixing occupations
        (Crushing, grinding, and mixing)
571. Separating occupations
        (Separating)
572. Melting occupations
        (Melting)
573. Baking, drying, and heat-treating occupations

n.e.c.-not elsewhere classified

Figure 2 - Processing Occupations Codes (Continued)

(Baking, drying, and heat treating)
574. Impregnating, coating, and glazing occupations
(Impregnating, coating, and glazing)
575. Forming occupations
(Forming)
579. Occupations in processing of stone, clay, glass, and related products, n.e.c.
(Processing, nonmetallic minerals and related products, n.e.c.)

58 Occupations in Processing of Leather Textiles, and Related Products
(Processing, Leather and Textiles)

580. Shaping, blocking, stretching, and tentering occupations
(Shaping, blocking, stretching, and tentering)
581. Separating, filtering, and drying occupations
(Separating, filtering, and drying)
582. Washing, steaming, and saturating occupations
(Washing, steaming, and saturating)
583. Ironing, pressing, glazing, staking, calendering, and embossing occupations)
(Ironing, pressing, glazing, staking, calendering, and embossing)
584. Mercerizing, coating, and laminating occupations
(Mercerizing, coating, and laminating)
585. Singeing, cutting shearing, shaving, and napping occupations
(Singeing. cutting, shearing, shaving, and napping)
586. Felting and fulling occupations
(Felting and fulling)
587. Brushing and shrinking occupations
(Brushing and shrinking)
589. Occupations in processing of leather, textiles, and related products, n.e.c.
(Processing, leather and textiles, n.e.c.)

59 Processing Occupations, N.E.C.
(Processing, N.E.C.)

590. Occupations in processing products from assorted materials
(Processing, assorted materials)
599. Miscellaneous processing occupations. n.e.c.
(Miscellaneous processing, n.e.c.)

n.e.c. - not elsewhere classified

Figure 2 - Processing Occupations Codes (Continued)

DWMSTDP PROCESSING OCCUPATIONS CODES

Code	Occupation	Work Description
500	Electroplating Occupations (Electroplating)	Covering the surface of objects by electro-deposition or electrolysis
503	Pickling, Cleaning, De-greasing, and Related Occupations (Pickling, Cleaning, Degreasing, and Related Work)	Removing coatings of grease, scale, tarnish, oxide, etc., from metal objects to obtain a clean surface. Cleaning is usually accomplished by subjecting the metal objects to acid baths.
504	Heat-treating Occupations (Heat-treating)	Subjecting metal to heat, cold or chemicals to relieve or redistribute stresses and affect such characteristics as hardness, flexibility and ductility.
505	Metal Spraying, Coating, and Related Occupations (Metal Spraying, Coating, and Related Work)	Covering the surfaces of objects with metal or an accretion of metal and adjuncts in molten or semimolten form by spraying or brushing.
549	Occupations in Processing of Petroleum, Coal, Natural and Manufactured Gas, and Related Products, n.e.c. (Processing Petroleum and Related Products, n.e.c.)	Preparing for commercial use the products of oil shales, oil and gas wells, and coal mines not elsewhere classified.
599	Miscellaneous Processing Occupations, n.e.c. (Miscellaneous Processing, n.e.c.)	Miscellaneous Occupations concerned with processing materials and products, not elsewhere classified.

n.e.c.-not elsewhere classified

Figure 3 - Work Description of DWMSTDP Processing Occupations Codes

PROCESSING OCCUPATIONS WORK CATEGORY CODES

Work Category	Code	Definition
Clean	CL	The removal of foreign matter by chemical, mechanical, or manual process. (Examples: ultrasonic cleaning, abrasive cleaning, use of solvent, rubbing, wiping, sweeping.)
Disassembly/Assembly	DA	The action(s) required to remove, install or replace assemblies or components parts when the primary purpose is to place an object(s) or part(s) on or into another object or part so that they fit, connect or are secured to each other to form a unit. These actions do not include fabrication of parts or items. This category generally applies to special or higher level data.
Dip	DP	Motions necessary to dip or immerse an object in liquid or paste and/or remove excess. (Examples: dip brush, cloth, stick, parts, hand, finger.)
Job Preparation	JP	The actions required to prepare an object(s), work place, or employee, or any combination of the three for ensuing work. NOTE: Excluded from this category are layout, packaging and machine setup.
Non-threaded Fastener	NF	The permanent or semipermanent holding or locking of mating objects by other than threads or clamping actions.
Object Handling	OH	The process of manually moving an object for the purpose of changing its location, position, or alignment. The movement path may or may not be fixed. The primary purpose of this handling is not to activate another object or device.
Paint	PA	To cover a surface by applying and spreading liquid or paste with a brush, spray gun, or roller. (Examples: paint, varnish, lacquer, shellac, wax.)
Surface Treatment	ST	The application of chemicals to an object when the predominant purpose is to change the composition of its surface.

Figure 4 - Major Categories of Work Used in Coding Processing Occupations Data

PROCESSING OCCUPATIONS WORK CATEGORY CODES		
Work Category	Code	Definition
Vising	VS	The action required to accomplish the nonmanual holding of object(s) with a vise while repairs, modifications, or manufacturing operations are being performed. (Examples: tighten or loosen vise, rotate vise, quick acting vise.)

Figure 4 - Major Categories of Work Used in Coding Processing Occupations Data

DEFENSE WORK MEASUREMENT STANDARD TIME
DATA PROGRAM (DWMSTDP)

PROCESSING OCCUPATIONS

PART TWO - STANDARD TIME DATA

SECTION I - INDEXES

This provides four indexes as follows:

The Occupation Code Index which includes the page location for each Code in both the DWMSTDP Element Index and the DWMSTDP Element Listing, Page A-1.

The DWMSTDP Element Index which is sequenced according to the DWMSTDP Element Code, pages B-1 through B-3.

The Noun/Verb Index which is an alphabetical listing of the "title" line of the DWMSTDP operation/element description, pages C-1 through C-3.

The Verb Index which is an alphabetical listing of the "title" line of the DWMSTDP Operation/Element Description sequenced by the verb, page D-1.

OCCUPATION CODE INDEX

DEFENSE WORK MEASUREMENT STANDARD TIME DATA
ELEMENT INDEX

OCCUP-ATION	QUALITY	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION	PAGE
5XX	MAO	MOHBH01	92	BASKET(DIP),HANG ON SUSPENSION BAR	1
5XX	MAO	MOHBR01	141	BASKET(WITH PARTS),REMOVE FROM SUSPENSION BAR	
5XX	MAO	MOHHR01	81	HOOK OR RACK,REMOVE FROM SUSPENSION BAR	
5XX	MAO	MOHPMXX	VARIABLE	PART,MOUNT ON SPRING HOOK RACK	
5XX	MAO	MOHPP01	98	PART(SMALL),PLACE ON TREE RACK	
5XX	MAO	MOHPRXX	VARIABLE	PART,REMOVE FROM RACK	
5XX	MAO	MOHPR03	80	PART(LARGE),REMOVE FROM SPRING RACK	
50X	MAA	SODFAXX	VARIABLE	ERONEL,APPLY BY DIPPING	2
50X	MAO	SJPPA01	723	PUTTY(PLATER),APPLY TO PLUG UP HOLE	
50X	MAA	SJPPDXX	VARIABLE	PART,DIP IN WAX TO MASK FOR PLATING	
50X	MAA	SJPPIXX	TABLE	PLUG(MASKING-LEAD),INSTALL	
50X	MAA	SJPPPXX	VARIABLE	PART,PREPARE TO LOAD FOR PLATING	3
50X	MAA	SJPPRXX	VARIABLE	PLUG(MASKING),REMOVE	
50X	MAA	SJPPSXX	VARIABLE	PLUG(MASKING),SEAT IN HOLE	
50X	MAA	SJPPTXX	VARIABLE	PLUG(RUBBER MASKING),TAKE OUT	4
50X	MAA	SJPRP01	522	PUTTY(PLATERS),REMOVE FROM HOLE	
50X	MAA	SJPSIXX	VARIABLE	SEALANT,INSTALL IN CAVITY	
50X	MAA	SJPSRXX	VARIABLE	SEALANT,REMOVE	
50X	MAA	SOHPPXX	VARIABLE	PART,PLACE IN PLATING TANK	
50X	MAA	SPAEAXX	VARIABLE	ERONEL,APPLY WITH APPLICATOR(TOUCH UP)	
50C	MAA	SOPPE01	4400	PART,ETCH(NITAL)	5
500	MAA	SJPAI01	1561	ANODE,INSTALL AND REMOVE	
500	MAA	SJPBE01	427	BOOTH(SAND BLAST),ENTER/EXIT	
500	MAA	SJPETXX	TABLE	ERONEL,TRIM FROM PERIMETER PLATE AREA	
500	MAO	SJPLC01	268	LEAD(ELECTRIC PLATING),CONNECT TO ANODE	
500	MAA	SJPRI01	805	ROBBER(WIPE),INSTALL	6
500	MAA	SJPRRXX	VARIABLE	ROBBER,REMOVE	
500	MAA	SPAMAXX	TABLE	MICROMASK,APPLY TO PART WITH BRUSH	
503	TBA	MCLPBXX	VARIABLE	PART,BLAST(WET OR VAPOR),AND RINSE	7
503	TCA	MCLPB06	9350	PARTS(IN BASKET),BLAST(WET)	
503	MAA	MCLPD01	582	PARTS(IN BASKET),DRAIN	
503	TAA	MCLPR01	256	PARTS(IN BASKET),RINSE IN MACHINE	
503	TBW	TCLPCXX	TABLE	PART,CLEAN AND AIR DRY	8
503	MAA	SCLCDXX	VARIABLE	COMPONENT(S),DEGREASE	9
503	MAA	SCLDPXX	VARIABLE	PART,DIP TO CLEAN	
503	MAA	SCLDP03	1240	PART,DIP TO CLEAN	10

OCCUP-ATION	QUALITY	DWMSTOP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION	PAGE
503	FUA	SCLHV01	16792	HARDWARE,VACU-BLAST	10
503	TUA	SCLPBXX	VARIABLE	PART,BLAST(ABRASIVE)IN BOOTH	
503	FUA	SCLPB03	3478	PARTS,BLAST CLEAN WITH GLASS-VERY SMALL PARTS	11
503	FUA	SCLPB04	2922	PARTS,BLAST CLEAN WITH GLASS-SMALL PARTS	
503	FUA	SCLPC01	3634	PART,CLEAN WITH SOLVENT IN SPRAY BOOTH	
503	FUA	SCLPC02	6235	PARTS,CLEAN(ULTRASONIC)	12
503	FUA	SCLPC03	6991	PART,CLEAN IN ULTRASONIC CLEANING VAT	
503	TUA	SCLPC04	3483	PART OR BASKET OF PARTS,CLEAN AND DRY-SPRAY BOOTH	
503	TUA	SCLPD01	4238	PART(OR BASKET OF PARTS),DEGREASE	
503	MAA	SCLPD02	2023	PARTS(IN BASKET),DIP RINSE AFTER SONIC CLEAN	13
503	MAA	SCLPR01	2059	PARTS(IN BASKET),RINSE	
503	MAA	SCLPR02	1158	PARTS(IN BASKET),RINSE(DIP)	
503	MAF	MDPPD01	223	PART,DIP IN SOLVENT TO CLEAN,WEIGHT-LESS THAN 2.5 POUNDS	
503	MAA	MJPPP01	167	PARTS(IN BASKET),PLACE IN CLEANING TANK	
503	MAA	SJPBP01	2183	BLAST CLEAN,PREPARE(AGACITE OR AIR HONE)	14
503	MAA	SJPCLXX	VARIABLE	CLEANER(COBEHN),LOAD/UNLOAD(SMALL PART)	
503	MAA	SJPCL03	532	CLEANER(SONIC),LOAD	
503	MAA	SJPCU01	865	CLEANER(SONIC),UNLOAD(BASKET)	
503	MAA	SJPDU01	414	DRYER,UNLOAD	
503	MAF	SJPHP01	470	HELMET(SANDBLAST),PUT ON AND REMOVE	15
503	MAA	SJPOSXX	VARIABLE	OBJECTS,STRING ON WIRE FOR CLEANING	
503	MAA	SJPPC01	643	PREPARATION,MAKE FOR CLEANING PARTS IN SPRAY BOOTH	
503	MAA	SJPPM01	1234	PARTS(IN BASKET),MOVE FROM SONIC CLEANER TO RINSE TANK	
503	MAA	SJPPP01	228	PARTS(IN BASKET),PLACE IN DRYER	
504	MAA	SOMPB01	1109	PART,BAKE	16
505	MAA	SSTSC01	679	SURFACE(METAL),COAT AND RINSE	
549	MAA	MCLCC01	1537	CYLINDER(COMPRESSED GAS-EMPTY),CONNECT TO VACUUM MACHINE	
549	MUA	SCLCP01	3242	CYLINDER(COMPRESSED GAS),PURGE WITH OXYGEN	
549	MAA	SDACDXX	VARIABLE	CYLINDER(COMPRESSED GAS),DISASSEMBLE(AUTOMATIC WRENCH/HAND WRENCH)	17
549	TUA	MVSCC01	758	CYLINDER(COMPRESSED GAS),CLAMP IN VISE	
549	MAA	MVSV001	76	VISE(SPECIAL CYLINDER),OPEN OR CLOSE	
599	MAA	MCLPRXX	VARIABLE	PART,RINSE WITH PRESSURE SPRAY	
599	TBA	MCLPSXX	VARIABLE	PARTS,STEAM CLEAN(PROCESS TIME)	

DEFENSE WORK MEASUREMENT STANDARD TIME DATA
ELEMENT INDEX

OCCUP-ATION	QUALITY	DWMSTOP ELEMENT	THU VALUE	OPERATION/ELEMENT DESCRIPTION	PAGE
599	MAA	SCLCCXX	VARIABLE	COMPONENT,CLEAN WITH VACUUM	18
599	MAA	SCLPBXX	VARIABLE	PART,BRUSH OFF PAINT IN THINNER	
599	MAA	SCLPCXX	VARIABLE	PART,CLEAN WITH SOLVENT AND BRUSH	
599	FUA	SCLPC07	1800	PART,CLEAN WITH PRESSURE SPRAY OF CLEANING AGENT	19
599	TCA	SCLPR01	7327	PARTS(IN BASKET),RINSE(SPRAY)	
599	TBA	SCLPR02	1710	PARTS(IN BASKET),RINSE(SPRAY)	
599	MAA	SCLPSXX	VARIABLE	PAINT,STRIP FROM PART	
599	MAA	SCLPS03	1452	PAINT,STRIP FROM INSTRUMENT CASE	
599	MAA	SCLPW01	555	PART,WASH IN TANK WITH BRUSH	20
599	MAA	SDPPDXX	VARIABLE	PART,DIP IN SOLUTION(PAINT REMOVER)	
599	MAA	SJPDOXX	VARIABLE	DOORS(BASKET-HINGED,DOUBLE,SWINGING),OPEN AND CLOSE	
599	MAA	SJPGP01	311	GUN(SPRAY,RINSE),PREPARE TO USE	
599	MAA	SJPGP02	440	GUN(STEAM),PREPARE TO USE	
599	MAA	SJPPP01	937	PART(S),PREPARE TO CLEAN WITH VARSOL	
599	MAA	SJPPP02	787	PART,PREPARE TO TANK CLEAN	21
599	MAO	SJPRMXX	VARIABLE	ROCKS/COMPOUND,MOVE FROM DRUM TO CONTAINER	
599	MAA	SJPSS01	1518	STEAM UNIT,SET UP AND SECURE	
599	MAA	MNFDL01	105	DOOR(TUMBLER),LOCK OR UNLOCK	
599	MAO	MOHDP01	49	DOOR(TUMBLER),POSITION ON TUMBLER	
599	MAO	MOHDR01	39	DOOR(TUMBLER),REMOVE	

DEFENSE WORK MEASUREMENT STANDARD TIME DATA
NOUN/VERB INDEX

OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP-ATION	DWMSTDP ELEMENT	PAGE
ANODE,INSTALL AND REMOVE	1501	500	SJPAI01	5
BASKET(DIP),HANG ON SUSPENSION BAR	92	5XX	MOHBH01	1
BASKET(WITH PARTS),REMOVE FROM SUSPENSION BAR	141	5XX	MOHBR01	1
BLAST CLEAN,PREPARE(AGACITE OR AIR HONE)	2183	503	SJPBP01	14
BOOTH(SAND BLAST),ENTER/EXIT	427	500	SJPBE01	5
CLEANER(COBEHN),LOAD/UNLOAD(SMALL PART)	VARIABLE	503	SJPCLXX	14
CLEANER(SONIC),LOAD	532	503	SJPCL03	14
CLEANER(SONIC),UNLOAD(BASKET)	865	503	SJPCU01	14
COMPONENT(S),DEGREASE	VARIABLE	503	SCLCDXX	9
COMPCNENT,CLEAN WITH VACUUM	VARIABLE	599	SCLCCXX	18
CYLINDER(COMPRESSED GAS),CLAMP IN VISE	758	549	MVSCC01	17
CYLINDER(COMPRESSED GAS),PURGE WITH OXYGEN	3242	549	SCLCP01	16
CYLINDER(COMPRESSED GAS),DISASSEMBLE(AUTOMATIC WRENCH/HAND WRENCH)	VARIABLE	549	SDACDXX	17
CYLINDER(COMPRESSED GAS-EMPTY),CONNECT TO VACUUM MACHINE	1537	549	MCLCC01	16
DOOR(TUMBLER),LOCK OR UNLOCK	105	599	MNFDL01	21
DOOR(TUMBLER),POSITION ON TUMBLER	49	599	MOHDP01	21
DOOR(TUMBLER),REMOVE	39	599	MOHDR01	21
DOORS(BASKET-HINGED,DOUBLE,SWINGING),OPEN AND CLOSE	VARIABLE	599	SJPDOXX	20
DRYER,UNLOAD	414	503	SJPDU01	14
EPCNEL,APPLY BY DIPPING	VARIABLE	50X	SDPEAXX	2
EPCNEL,APPLY WITH APPLICATOR(TOUCH UP)	VARIABLE	50X	SPAEAXX	4
EPCNEL,TRIM FROM PERIMETER PLATE AREA	TABLE	500	SJPETXX	5
GUN(SPRAY,RINSE),PREPARE TO USE	311	599	SJPGP01	20
GUN(STEAM),PREPARE TO USE	440	599	SJPGP02	20
HARDWARE,VACU-BLAST	16792	503	SCLHV01	10
HELMET(SANDBLAST),PUT ON AND REMOVE	470	503	SJPHP01	15
HOOK OR RACK,REMOVE FROM SUSPENSION BAR	81	5XX	MOHHR01	1
LEAD(ELECTRIC PLATING),CCNNECT TO ANODE	268	500	SJPLC01	5
MICROMASK,APPLY TO PART WITH BRUSH	TABLE	500	SPAMAXX	6
OBJECTS,STRING ON WIRE FOR CLEANING	VARIABLE	503	SJPOSXX	15
PAINT,STRIP FROM INSTRUMENT CASE	1452	599	SCLPS03	19
PAINT,STRIP FROM PART	VARIABLE	599	SCLPSXX	19
PART(LARGE),REMOVE FROM SPRING RACK	80	5XX	MOHPR03	1
PART(OR BASKET OF PARTS),DEGREASE	4238	503	SCLPD01	12
PART(S),PREPARE TO CLEAN WITH VARSOL	937	599	SJPPP01	20

OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP- ATION	DWMSTDP ELEMENT	PAGE
PART(SMALL),PLACE ON TREE RACK	98	5XX	MUHPR01	1
PART,BAKE	1109	504	SOHPB01	16
PART,BLAST(ABRASIVE)IN BOOTH	VARIABLE	503	SCLPBXX	10
PART,BLAST(WET OR VAPOR),AND RINSE	VARIABLE	503	MCLPBXX	7
PART,BRUSH OFF PAINT IN THINNER	VARIABLE	599	SCLPBXX	18
PART,CLEAN AND AIR DRY	TABLE	503	TCLPCXX	8
PART,CLEAN IN ULTRASONIC CLEANING VAT	6991	503	SCLPC03	12
PART,CLEAN WITH PRESSURE SPRAY OF CLEANING AGENT	1800	599	SCLPC07	19
PART,CLEAN WITH SOLVENT AND BRUSH	VARIABLE	599	SCLPCXX	18
PART,CLEAN WITH SOLVENT IN SPRAY BOOTH	3634	503	SCLPC01	11
PART,DIP IN SOLUTION(PAINT REMOVER)	VARIABLE	599	SOPPDXX	20
PART,DIP IN SOLVENT TO CLEAN,WEIGHT-LESS THAN 2.5 POUNDS	223	503	MOPPD01	13
PART,DIP IN WAX TO MASK FOR PLATING	VARIABLE	50X	SJPPDXX	2
PART,DIP TO CLEAN	VARIABLE	503	SCLDPXX	9
PART,DIP TO CLEAN	1240	503	SCLDP03	10
PART,ETCH(NITAL)	4400	500	SOPPE01	5
PART,MOUNT ON SPRING HOOK RACK	VARIABLE	5XX	MOHPMXX	1
PART,PLACE IN PLATING TANK	VARIABLE	50X	SOHPPXX	4
PART,PREPARE TO LOAD FOR PLATING	VARIABLE	50X	SJPPPXX	3
PART,PREPARE TO TANK CLEAN	787	599	SJPPP02	21
PART,REMOVE FROM RACK	VARIABLE	5XX	MUHPRXX	1
PART,RINSE WITH PRESSURE SPRAY	VARIABLE	599	MCLPRXX	17
PART,WASH IN TANK WITH BRUSH	555	599	SCLPW01	20
PART OR BASKET OF PARTS,CLEAN AND DRY-SPRAY BOOTH	3483	503	SCLPC04	12
PARTS(IN BASKET),BLAST(WET)	9350	503	MCLPB06	7
PARTS(IN BASKET),DIP RINSE AFTER SONIC CLEAN	2023	503	SCLPD02	13
PARTS(IN BASKET),DRAIN	582	503	MCLPD01	7
PARTS(IN BASKET),MOVE FROM SONIC CLEANER TO RINSE TANK	1234	503	SJPPM01	15
PARTS(IN BASKET),PLACE IN CLEANING TANK	167	503	MJPPP01	13
PARTS(IN BASKET),PLACE IN DRYER	228	503	SJPPP01	15
PARTS(IN BASKET),RINSE	2059	503	SCLPR01	13
PARTS(IN BASKET),RINSE(DIP)	1158	503	SCLPR02	13
PARTS(IN BASKET),RINSE(SPRAY)	7327	599	SCLPR01	19
PARTS(IN BASKET),RINSE(SPRAY)	1710	599	SCLPR02	19

DEFENSE WORK MEASUREMENT STANDARD TIME DATA
NOUN/VERB INDEX

OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP- ATION	DWMSTD ELEMENT	PAGE
PARTS(IN BASKET),RINSE IN MACHINE	256	503	MCLPRO1	7
PARTS,BLAST CLEAN WITH GLASS-VERY SMALL PARTS	3478	503	SCLPB03	11
PARTS,BLAST CLEAN WITH GLASS-SMALL PARTS	2922	503	SCLPB04	11
PARTS,CLEAN(ULTRASONIC)	6235	503	SCLPC02	12
PARTS,STEAM CLEAN(PROCESS TIME)	VARIABLE	599	MCLPSXX	17
PLUG(MASKING),REMOVE	VARIABLE	50X	SJPPRXX	3
PLUG(MASKING),SEAT IN HOLE	VARIABLE	50X	SJPPSXX	3
PLUG(MASKING-LEAD),INSTALL	TABLE	50X	SJPPIXX	2
PLUG(RUBBER MASKING),TAKE OUT	VARIABLE	50X	SJPPTXX	4
PREPARATION,MAKE FOR CLEANING PARTS IN SPRAY BOOTH	643	503	SJPPCO1	15
PUTTY(PLATER),APPLY TO PLUG UP HOLE	723	50X	SJPPAO1	2
PUTTY(PLATERS),REMOVE FROM HOLE	522	50X	SJPRPO1	4
ROBBER(WIRE),INSTALL	805	500	SJPRIO1	6
ROBBER,REMOVE	VARIABLE	500	SJPRRXX	6
ROCKS/COMPOUND,MOVE FROM DRUM TO CONTAINER	VARIABLE	599	SJPRMXX	21
SEALANT,INSTALL IN CAVITY	VARIABLE	50X	SJPSIXX	4
SEALANT,REMOVE	VARIABLE	50X	SJPSRXX	4
STEAM UNIT,SET UP AND SECURE	1518	599	SJPSSO1	21
SURFACE(METAL),COAT AND RINSE	679	505	SSTSCO1	16
VISE(SPECIAL CYLINDER),OPEN OR CLOSE	76	549	MVSVOO1	17

OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP-ATION	DUMSTOP ELEMENT	PAGE
APPLY ERUNEL BY DIPPING	VARIABLE	50X	SDPEAXX	2
APPLY ERUNEL WITH APPLICATOR(TOUCH UP)	VARIABLE	50X	SPAEAXX	4
APPLY MICROMASK TO PART WITH BRUSH	TABLE	500	SPAMAXX	6
APPLY PLATER PUTTY TO PLUG UP HOLE	723	50X	SJPPA01	2
BAKE PART	1109	504	SOHPB01	16
BLAST PART(ABRASIVE)IN BOOTH	VARIABLE	503	SCLPBXX	10
BLAST PARTS CLEAN WITH GLASS-SMALL PARTS	2922	503	SCLPB04	11
BLAST PARTS CLEAN WITH GLASS-VERY SMALL PARTS	3478	503	SCLPB03	11
BLAST(WET OR VAPOR)PART AND RINSE	VARIABLE	503	MCLPBXX	7
BRUSH PAINT OFF PART IN THINNER	VARIABLE	599	SCLPBXX	18
CLAMP COMPRESSED GAS CYLINDER IN VISE	758	549	MVSCC01	17
CLEAN COMPONENT WITH VACUUM	VARIABLE	599	SCLCCXX	18
CLEAN PART AND AIR DRY	TABLE	503	TCLPCXX	8
CLEAN PART IN ULTRASONIC CLEANING VAT	6991	503	SCLPC03	12
CLEAN PART OR BASKET OF PARTS AND DRY-SPRAY BOOTH	3483	503	SCLPC04	12
CLEAN PART WITH PRESSURE SPRAY OF CLEANING AGENT	1800	599	SCLPC07	19
CLEAN PART WITH SOLVENT AND BRUSH	VARIABLE	599	SCLPCXX	18
CLEAN PART WITH SOLVENT IN SPRAY BOOTH	3634	503	SCLPC01	11
CLEAN ULTRASONIC PARTS	6235	503	SCLPC02	12
COAT METAL SURFACE AND RINSE	679	505	SSTSC01	16
CONNECT COMPRESSED GAS-EMPTY CYLINDER TO VACUUM MACHINE	1537	549	MCLCC01	16
CONNECT ELECTRIC PLATING LEAD TO ANODE	268	500	SJPLC01	5
DEGREASE COMPONENTS	VARIABLE	503	SCLCDXX	9
DEGREASE PART OR BASKET OF PARTS	4238	503	SCLPD01	12
DIP PART IN SOLUTION(PAINT REMOVER)	VARIABLE	599	SDPPDXX	20
DIP PART IN SOLVENT TO CLEAN,WEIGHT-LESS THAN 2.5 POUNDS	223	503	MDPPD01	13
DIP PART IN WAX TO MASK FOR PLATING	VARIABLE	50X	SJPPDXX	2
DIP PART TO CLEAN	1240	503	SCLDP03	10
DIP PART TO CLEAN	VARIABLE	503	SCLDPXX	9
DIP PARTS IN BASKET AFTER SONIC CLEAN	2023	503	SCLPD02	13
DISASSEMBLE COMPRESSED GAS CYLINDER (AUTOMATIC WRENCH/HAND WRENCH)	VARIABLE	549	SCACDXX	17
DRAIN PARTS(IN BASKET)	582	503	MCLPD01	7
ENTER OR EXIT SAND BLAST BOOTH	427	500	SJPBE01	5
ETCH PART(NITAL)	4400	500	SCPPE01	5
HANG DIP BASKET ON SUSPENSION EAR	92	5XX	MOHBH01	1

OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP- ATION	CWMSTDP ELEMENT	PAGE
INSTALL AND REMOVE ANODE	1561	500	SJPAI01	5
INSTALL MASKING-LEAD PLUG	TABLE	50X	SJPPIXX	2
INSTALL SEALANT IN CAVITY	VARIABLE	50X	SJPSIXX	4
INSTALL WIRE ROBBER	805	500	SJFRI01	6
LOAD AND UNLOAD COBEHN CLEANER(SMALL PART)	VARIABLE	503	SJPCLXX	14
LOAD SONIC CLEANER	532	503	SJPCL03	14
LOCK OR UNLOCK TUMBLER DOOR	105	599	MNFDL01	21
MAKE PREPARATION FOR CLEANING PARTS IN SPRAY BOOTH	643	503	SJPPC01	15
MOUNT PART ON SPRING HOOK RACK	VARIABLE	5XX	MOHPMXX	1
MOVE PARTS(IN BASKET)FROM SONIC CLEANER TO RINSE TANK	1234	503	SJPPM01	15
MOVE ROCKS/COMPOUND FROM DRUM TO CONTAINER	VARIABLE	599	SJPRMXX	21
OPEN AND CLOSE BASKET-HINGED,DOUBLE, SWINGING DOORS	VARIABLE	599	SJPDOXX	20
OPEN AND CLOSE SPECIAL CYLINDER VISE	76	549	MVSVO01	17
PLACE PART IN PLATING TANK	VARIABLE	50X	SOHPPXX	4
PLACE PARTS IN BASKET IN CLEANING TANK	167	503	MJPPP01	13
PLACE PARTS(IN BASKET) IN DRYER	228	503	SJPPP01	15
PLACE SMALL PART ON TREE RACK	52	5XX	MOHPP01	1
POSITION TUMBLER DOOR ON TUMBLER	49	599	POHOP01	21
PREPARE BLAST CLEAN(AGACITE OR AIR HONE)	2183	503	SJPBP01	14
PREPARE PART TO CLEAN TANK	787	599	SJPMP02	21
PREPARE PARTS TO CLEAN WITH VARSOL	537	599	SJPPP01	20
PREPARE TO LOAD PART FOR PLATING	VARIABLE	50X	SJPPPXX	3
PREPARE TO USE SPRAY,RINSE GUN	311	599	SJPGP01	20
PREPARE TO USE STEAM GUN	440	599	SJPGP02	20
PURGE COMPRESSED GAS CYLINDER WITH OXYGEN	3242	549	SCLCP01	16
PUT ON AND REMOVE SANDBLAST HELMET	470	503	SJPHP01	15
REMOVE BASKET WITH PARTS FROM SUSPENSION	141	5XX	MCHBR01	1
REMOVE HOOK OR RACK FROM SUSPENSION EAR	81	5XX	MOHHR01	1
REMOVE LARGE PART FROM SPRING RACK	80	5XX	MOHPR03	1
REMOVE MASKING PLUG	VARIABLE	50X	SJPPRXX	3
REMOVE PART FROM RACK	VARIABLE	5XX	MOHPRXX	1
REMOVE PLATERS PUTTY FROM HOLE	582	50X	SJPRP01	4
REMOVE SEALANT	VARIABLE	50X	SJPSRXX	4
REMOVE TUMBLER DOOR	35	599	MOHCR01	21
REMOVE WIRE ROBBER	VARIABLE	500	SJPRFXX	6
RINSE PART WITH PRESSURE SPRAY	VARIABLE	599	PCLPRXX	17
RINSE PARTS IN BASKET	2059	503	SCLPR01	13

OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP-ATION	DWMSTDP ELEMENT	PAGE
RINSE PARTS(IN BASKET),SPRAY	7327	599	SCLPR01	15
RINSE PARTS(IN BASKET)DIP	1158	503	SCLPR02	13
RINSE PARTS(IN BASKET)IN MACHINE	256	503	MCLPR01	7
SEAT MASKING PLUG IN HOLE	VARIABLE	50X	SJPPSXX	3
SET UP STEAM UNIT AND SECURE	1518	599	SJPSS01	21
SPRAY RINSE PARTS(IN BASKET)	1710	599	SCLPR02	15
STEAM PARTS CLEAN(PROCESS TIME)	VARIABLE	599	MCLPSXX	17
STRING OBJECTS ON WIRE FOR CLEANING	VARIABLE	503	SJPOSXX	15
STRIP PAINT FROM INSTRUMENT CASE	1452	599	SCLPS03	19
STRIP PAINT FROM PART	VARIABLE	599	SCLPSXX	15
TAKE OUT RUBBER MASKING PLUG	VARIABLE	50X	SJPPTXX	4
TRIM ENAMEL FROM PERIMETER PLATE AREA	TABLE	500	SJPETXX	5
UNLOAD DRYER	414	503	SJPDU01	14
UNLOAD SONIC CLEANER(BASKET)	865	503	SJPCU01	14
VACU-BLAST HARDWARE	16792	503	SCLHV01	10
WASH PART IN TANK WITH BRUSH	555	599	SCLPW01	20
WET BLAST PARTS(IN BASKET)	9350	503	MCLPB06	7

DEFENSE WORK MEASUREMENT STANDARD TIME DATA PROGRAM

PART TWO - PROCESSING OCCUPATIONS STANDARD TIME DATA

SECTION II - DWMSTDP ELEMENT LISTING

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION

NO	5XX	MAO	LDPC-1J	MOHBHO1	92	BASKET(DIP),HANG ON SUSPENSION BAR
						STARTS—WITH BASKET HELD IN BOTH HANDS
						INCLUDES—ALL THE MOTIONS NECESSARY TO MOVE
						    BASKET TO SOLUTION,RELEASE RIGHT HAND HANDLE
						    AND GRASP SUPPORT BAR(LEFT HAND MAINTAINS
						    CONTROL OF BASKET),MOVE BAR THROUGH BASKET
						    HANDLES,LIFT BASKET AND POSITION TO SUSPENSION
						    BAR,RELEASE BAR AND BASKET(SIMO)
						ENDS—WITH RELEASE BAR AND BASKET
						CONDITIONS—BASKET AND BAR WEIGH TO 14 POUNDS

NO	5XX	MAO	LDPC1D1	MOHBRO1	141	BASKET(WITH PARTS),REMOVE FROM SUSPENSION BAR
						STARTS—WITH REACH TO BASKET WITH BOTH HANDS
						INCLUDES—ALL THE MOTIONS NECESSARY TO REACH
						    AND GRASP BASKET BY BOTH HANDLES,LIFT BASKET
						    UP AND REMOVE BAR WITH RIGHT HAND,ASIDE BAR,
						    GRASP HANDLE WITH RIGHT HAND AND LIFT BASKET
						    OUT OF TANK,PLACE ASIDE,RELEASE
						ENDS—WITH BASKET ASIDE
						CONDITIONS—WEIGHT TO 14 POUNDS

NO	5XX	MAO	LDPC-1Y	MOHHRO1	81	HOOK OR RACK,REMOVE FROM SUSPENSION BAR
						STARTS—WITH REACH TO HOOK OR RACK
						INCLUDES—ALL THE MOTIONS NECESSARY TO REACH TO
						    OBJECT SUSPENDED OVER TANK OR VAT,GRASP OBJECT
						    AND LIFT CLEAR OF SUSPENSION BAR,MOVE CLEAR OF
						    TANK OR VAT
						ENDS—WITH HOOK OR RACK IN HAND CLEAR OF TANK
						CONDITIONS—WEIGHT TO 10 POUNDS

NO	5XX	MAO	LDPC-1G	MOHPMXX	VARIABLE	PART,MOUNT ON SPRING HOOK RACK
						STARTS—WITH REACH TO PART
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART
						    AND POSITION TO NOTCHES,MOVE INTO BOTTOM NOTCH
						    AND TOP NOTCH,RELEASE PART
						ENDS—WITH RELEASE PART
						CONDITIONS—RACK IS HELD BY LEFT HAND TO STEADY

					99	CASE 01 MOUNT SMALL(LESS THAN 2.5 POUNDS)PART, EASY TO HANDLE
					144	02 MOUNT MEDIUM(2.5 TO 10 POUNDS)PART

NO	5XX	MAC	LDPC-1L	MOHPPO1	98	PART(SMALL),PLACE ON TREE RACK
						STARTS—WITH REACH TO PART
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART
						    AND MOVE PART TO TREE RACK,POSITION PART ON
						    RACK AND RELEASE
						ENDS—WITH PART RELEASED
						CONDITIONS—PART UP TO 2.5 POUNDS

NC	5XX	MAO	LDPC-1Z	MOHPRXX	VARIABLE	PART,REMOVE FROM RACK
						STARTS—WITH REACH TO PART ON RACK
						INCLUDES—ALL THE MOTIONS NECESSARY TO REACH
						    AND GRASP PART,DISENGAGE PART FROM RACK,MOVE
						    PART ASIDE AND RELEASE
						ENDS—WITH PART ASIDE
						CONDITIONS—PART WEIGHS TO 2.5 POUNDS

					54	CASE 01 REMOVE FROM HANGER RACK—STEADY RACK WITH LEFT HAND
					61	02 REMOVE FROM TREE RACK

NC	5XX	MAO	LDPC141	MOHPRO3	80	PART(LARGE),REMOVE FROM SPRING RACK
						STARTS—WITH REACH TO PART ON RACK
						INCLUDES—ALL THE MOTIONS NECESSARY TO REACH
						    AND GRASP PART ON RACK,MOVE PART OUT OF
						    NOTCHES(4),DISENGAGE FROM RACK,ASIDE PART
						ENDS—WITH PART ASIDE
						CONDITIONS—PART WEIGHS 2.5 TO 10 POUNDS

1

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	50X	MAA	SPLEOXX	SOPEAXX	VARIABLE	ERONEL,APPLY BY DIPPING
						STARTS—WITH REACH TO GET PART
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART OFF BENCH,POSITION BOTTOM END IN ERONEL,ROTATE PART IN ERONEL,REMOVE PART FROM ERONEL AND ROTATE TO DRY,ASIDE PART TO DRIP RACK,REACH TO ERONEL RUNNERS,DISENGAGE ERONEL,REACH BACK TO RUNNERS AND ASIDE ERONEL TO VAT,GET PART OFF DRIP RACK,INVERT AND POSITION HANGER END IN ERONEL,ROTATE PART IN ERONEL,REMOVE PART AND ROTATE TO DRY,EXAMINE COAT,HANG ON COOLING RACK
						ENDS—WITH HANGER HANGING ON COOLING RACK
					1347	CASE 01 SMALL PART—TO 10 POUNDS
					1509	02 MEDIUM PART—10 TO 30 POUNDS
NO	50X	MAO	LDPCK61	SJPPA01	723	PUTTY(PLATER),APPLY TO PLUG UP HOLE
						STARTS—WITH REACH TO PUTTY CAN
						INCLUDES—ALL THE MOTIONS NECESSARY TO PICK UP PUTTY CAN,REMOVE AND ASIDE LID(HOLDING IN LEFT HAND),DIG PUTTY OUT AND KNEAD WITH RIGHT HAND, RELEASE CAN,REACH TO AND HOLD PART,MOVE RIGHT HAND WITH PUTTY TO PART AND PUSH INTO HOLE, PRESS FLUSH,PUT THUMB ON PUTTY AND WIPE LEVEL, RELEASE PART AND PUTTY,GET AND ASIDE PART,PICK UP PUTTY CAN LID,PLACE ON CAN,ASIDE CAN
						ENDS—WITH ASIDE CAN
						CONDITIONS—AVERAGE WEIGHT OF PART IS 17.5 POUNDS
NAA	50X	MAA	CPLPN13	SJPPOXX	VARIABLE	PART,DIP IN WAX TO MASK FOR PLATING
						STARTS—WITH REACH TO GET PART
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART,OPEN WAX TANK,DIP PART TO SPECIFIED DEPTH(TWICE),LIFT FROM WAX(TWICE),CHECK PART TO ASSURE PROPER COVERAGE
						ENDS—WITH CHECK COMPLETE
					1214	CASE 01 SMALL PART
					5086	02 MEDIUM PART—INCLUDES PUTTING PART INTO AN OVEN AND REMOVING PART FROM OVEN— ALSO INCLUDES 1500 TMUS WARMING TIME AND TIME TO PUT ON AND TAKE OFF GLOVES
NAA	50X	MAA	SPLPN01	SJPPIXX	TABLE	PLUG(MASKING—LEAD),INSTALL
						STARTS—WITH REACH TO CLOSED DRAWER
						INCLUDES—ALL THE MOTIONS NECESSARY TO OPEN DRAWER WITHOUT LATCH,GET CUTTERS,PLIERS,HAMMER AND KNIFE,CLOSE DRAWER,DETERMINE HOLE SIZE, CUT PIECE OF LEAD,ASIDE CUTTERS,POSITION PLUG IN HOLE AND POSITION AND CLOSE PLIERS ON PLUG, EXAMINE FIT,PEEN WITH HAMMER(6 BLOWS),ASIDE PLIERS,GET KNIFE AND TRIM LEAD,EXAMINE,OPEN DRAWER,ASIDE TOOLS TO DRAWER AND CLOSE
						ENDS—WITH DRAWER CLOSED
						CONDITIONS—PLUGS TO 1/2 INCH DIAMETER(LEAD)— PREFORMED PLUGS IN CAN—CAN IS PICKED UP AND MOVED TO POSITION FOR USE

TYPE OF PLUG		FIRST PLUG A	EACH ADDITIONAL PLUG B
FORM PLUG FROM LEAD WIRE	A	1664	1027
PREFORMED PLUG (LEAD)	B	1178	941

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	500	MAA	CPLE0C7	SDPPE01	4400	PART,ETCH(NITAL) STARTS—WITH REACH TO GET PART INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART AND DIP INTO NITRIC ACID SOLUTION,REMOVE, RINSE PART IN COLD WATER,DIP PART IN HYDRO- CHLORIC ACID,REMOVE,RINSE IN COLD WATER,RINSE IN ALKALINE SOLUTION,AIR DRY PART,EXAMINE PART ENDS—WITH PART EXAMINED CONDITIONS—SMALL OR MEDIUM SIZE PART—TIME TO MOVE PART BETWEEN TANKS AND TO TANKS IS NOT INCLUDED—DRAIN AND TANK TIME NOT INCLUDED
NAA	500	MAA	SPLAR01	SJPAI01	1561	ANODE,INSTALL AND REMOVE STARTS—WITH SELECT ANODE IN STORAGE INCLUDES—ALL THE MOTIONS NECESSARY TO SELECT ANODE,PICK UP AND MOVE INTO POSITION,ALIGN HOLE WITH NOTCH OR STUD,REMOVE AND INSTALL THREE WING NUTS,REMOVE AND ASIDE ANODE ENDS—WITH ASIDE ANODE CONDITIONS—DOES NOT INCLUDE WALK TO GET ANODE AND RETURN
NAA	500	MAA	SCLDU01	SJPBE01	427	BOOTH(SAND BLAST),ENTER/EXIT STARTS—WITH REACH TO DOOR HANDLE INCLUDES—ALL THE MOTIONS NECESSARY TO GRASP AND TURN HANDLE 90 DEGREES TO UNLATCH,PULL HANDLE THRU SLOT AND PULL DOOR OPEN,WALK FOUR PACES THRU DOOR,TURN AND GRASP DOOR,PULL DOOR SHUT,REACH THRU SLOT TO HANDLE,PULL TO SEAT AND TURN 90 DEGREES TO LATCH ENDS—WITH DOOR CLOSED,HAND ON HANDLE
NAA	500	MAA	SPLEWXX	SJPETXX	TABLE	ERONEL,TRIM FROM PERIMETER PLATE AREA STARTS—WITH REACH TO PART ON DRIP RAIL INCLUDES—ALL THE MOTIONS NECESSARY TO GET ERONEL COATED PART,GET KNIFE,CUT ERONEL,ASIDE KNIFE,ASIDE ERONEL SCRAP,REPOSITION PART,ASIDE PART TO READY RACK ENDS—WITH PART ASIDE CONDITIONS—PART OVER 30 POUNDS—NOT POSITIONED PRIOR TO CUTTING—INTERNAL TRIMMING AND CUTTING IS DONE BLIND

		REMOVE ERONEL FROM		
SIZE OF PART		EXTERNAL SURFACE	INTERNAL SURFACE	
			EASY ACCESS	DIFFICULT ACCESS
		A	B	C
PART TO 30 POUNDS				
FIRST INCH	A	716	1217	1324
EACH ADDL.INCH	B	177	206	339
PART OVER 30 POUNDS				
FIRST INCH	C	394	652	755
EACH ADDL.INCH	D	244	243	488

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NC	500	MAD	LOPCK5J	SJPLC01	268	LEAD(ELECTRIC PLATING),CONNECT TO ANODE STARTS—WITH REACH TO GET "C" CLAMP INCLUDES—ALL THE MOTIONS NECESSARY TO GET "C" CLAMP,GET ELECTRICAL LEAD,POSITION CLAMP AND LEAD TO PART,TIGHTEN CLAMP ENDS—WITH CLAMP TIGHTEN,RELEASED

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP- ATION	QUALITY CODE	SOURCE CODE	DWNSTOP ELEMENT	THRU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	500	MAA	SPLRN01	SJPRI01	805	ROBBER(WIRE),INSTALL STARTS—WITH SIMO REACH TO CUTTERS AND WIRE INCLUDES—ALL THE MOTIONS NECESSARY TO GET AND CUT WIRE,ASIDE CUTTERS,POSITION AND HOLD ONE END OF WIRE IN GROOVE OF PART,WRAP WIRE AROUND TWICE,EXAMINE,TWIST WIRE WITH DUCKBILLS TO SECURE,HOLD WIRE WITH DUCKBILLS AND TRIM EXCESS,GET SCREWDRIVER AND PRESS END OF WIRE TO FLATTEN,ASIDE SCREWDRIVER,DUCKBILLS ENDS—WITH TOOLS ASIDE CONDITIONS—PARTS TO SIX INCHES DIAMETER
NAA	500	MAA	SPLRRXX	SJPRRXX	VARIABLE	ROBBER,REMOVE STARTS—WITH REACH TO GET TOOL INCLUDES—ALL THE MOTIONS NECESSARY TO GET TOOL AND PRY OR LIFT END OF ROBBER FROM GROOVE, GRASP ROBBER AND PULL FROM GROOVE,CUT WIRE, ASIDE ROBBER AND TOOLS AND WIRE ENDS—WITH ASIDE ROBBER AND TOOLS AND WIRE
					446	CASE 01 WIRE ROBBER—CUT AND REMOVE 12 INCHES— FIRST 12 INCHES—LIFT END WITH SCREW- DRIVER—PULL WITH PLIERS
					92	02 WIRE ROBBER—EACH ADDITIONAL 12 INCHES— PULL WITH PLIERS
					323	03 LEAD SOLDER ROBBER—LIFT END WITH KNIFE AND PULL LOOSE WITH PLIERS—FIRST SIX INCHES
					61	04 LEAD SOLDER ROBBER—EACH ADDITIONAL SIX INCHES—PULL LOOSE WITH PLIERS
					767	05 LEAD STRIP ROBBER—CUT TIE DOWN WIRE, PRY UP ROBBER WITH KNIFE,PULL LOOSE WITH PLIERS—FIRST SIX INCHES
					138	06 LEAD STRIP ROBBER—EACH ADDITIONAL SIX INCHES
NAA	500	MAA	SPLPDXX	SPAMAXX	TABLE	MICROMASK,APPLY TO PART WITH BRUSH STARTS—WITH REACH TO CAN OF MICROMASK INCLUDES—ALL THE MOTIONS NECESSARY TO GET CAN OF MICROMASK,REMOVE AND ASIDE CAN COVER,GET PAINT BRUSH FROM SOLVENT,SHAKE SOLVENT OFF BRUSH,DIP BRUSH IN MICROMASK,WIPE OFF EXCESS, APPLY MICROMASK TO SURFACE,RETURN BRUSH TO CAN,REPLACE LID ON MICROMASK CAN ENDS—WITH BRUSH RELEASED IN SOLVENT

		SURFACE TO PAINT	
		INTERNAL A	EXTERNAL B
ONE SQUARE INCH			
FIRST	A	426	373
EACH ADDL	B	109	88
ONE LINEAR INCH SURFACE ADJACENT TO EDGE OF PLATING			
FIRST	C	522	407
EACH ADDL	D	205	157

5

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWNSTOP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	503	MAA	SCLPCXX	SCLCDXX	VARIABLE	COMPONENT(S),DEGREASE

STARTS=WITH REACH TO GET GOGGLES
INCLUDES=ALL THE MOTIONS NECESSARY TO GET AND
PUT ON GOGGLES AND GLOVES,PUT PART/BASKET ON
PLATFORM AND STEP UP ON PLATFORM,GET ROLLER,
ROLL TANK COVER BACK,MOVE NOZZLE ASIDE AND
CONTINUE TO ROLL COVER BACK,REPLACE NOZZLE,
STEP TO HOOK,GET HOOK,GET PART OR BASKET
AND PLACE ON HOOK,LIFT PART OR BASKET AND
STEP TO DEGREASER,LOWER PART OR BASKET INTO
DEGREASER,REMOVE HOOK FROM PART OR BASKET
AND RAISE HOOK FROM TANK,ASIDE HOOK,CLOSE
TANK COVER(MOVE ASIDE AND REPLACE NOZZLE),
MOVE TO PLATFORM STEPS,STEP DOWN AND TURN
FROM STEPS,TAKE OFF GOGGLES AND GLOVES,
ASIDE,GET AND PUT ON GOGGLES AND GLOVES,TURN
TO PLATFORM,CLIMB STEPS TO PLATFORM,OPEN COVER
AND GET HOOK,HOOK PART OR BASKET IN DEGREASER
AND REMOVE FROM TANK,LOWER PART OR BASKET TO
FLOOR,REMOVE AND ASIDE HOOK,GET PART OR BASKET
AND STEP DOWN FROM PLATFORM,ASIDE PART OR
BASKET
ENDS=WITH ASIDE PART OR BASKET
CONDITIONS=PLACE ADDITIONAL PARTS OR BASKETS
ON PLATFORM IS NOT INCLUDED=SPRAYING AND
WALKING TO GET PARTS AND EQUIPMENT IS NOT
INCLUDED

					3196	CASE 01 DEGREASE=FIRST PART OR BASKET OF PARTS=40 POUNDS
					436	02 EACH ADDITIONAL PART OR BASKET OF PARTS=40 POUNDS
					2447	03 DEGREASE PART OVER 40 POUNDS=TWO MEN PLACE PART/BASKET ON CART AND MOVE CART TO HOIST AND RETURN PART/BASKET TO WORK BENCH=FIRST PART OR BASKET= HOIST TIME NOT INCLUDED
					733	04 DEGREASE PART OVER 40 POUNDS=TWO MEN= EACH ADDITIONAL PART=HOIST TIME NOT INCLUDED

| NAA | 503 | MAA | SCLPOTX | SCLDPXX | VARIABLE | PART,DIP TO CLEAN |

STARTS=WITH TURN TO BATH
INCLUDES=ALL THE MOTIONS NECESSARY TO TURN AND
REACH TO BATH LID HANDLE,RAISE LID AND GET
BASKET OUT OF BATH,PLACE BASKET ON RAIL,GET
PART FROM CART AND PLACE IN BASKET,LIFT BASKET
FROM RAIL AND LOWER INTO VAT,LOWER LID,OPEN
VAT LID,REMOVE BASKET WITH PART(S)FROM VAT,
POSITION BASKET ON RAIL,DRAIN PARTS,GET PART
AND PLACE ON GRILLE IN SPRAY BOOTH,RETURN
BASKET TO VAT AND CLOSE LID
ENDS=WITH CLOSE VAT LID
CONDITIONS=ENW OF PART AND BASKET IS 10
POUNDS=DOES NOT INCLUDE WALKING TO AND FROM
CART,TO AND FROM SPRAY BOOTH OR VAT TIME=DIP
IS TURCO=CARB SOLUTION=OR EQUAL=NO DRAIN TIME
INCLUDED

| | | | | | 554 | CASE 01 DIP FIRST PART |
| | | | | | 111 | 02 DIP EACH ADDITIONAL PART |

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	OWNSTOP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	503	MAA	SCLPOT3	SCLOPO3	1240	PART,DIP TO CLEAN STARTS-WITH TURN TO VAT INCLUDES-ALL THE MOTIONS NECESSARY TO TURN TO VAT,OPEN LID,REMOVE LARGE BASKET AND POSITION BASKET ON RAIL,PICK UP SMALL BASKET FROM STACK AND PLACE ON CART,GET CONTAINER OF SMALL PARTS AND DUMP PARTS INTO BASKET,ASIDE CONTAINER, PLACE SMALL BASKET IN LARGE BASKET,LIFT FROM RAIL AND LOWER INTO VAT,CLOSE LID,OPEN VAT LID,REMOVE BASKET OF PARTS,POSITION BASKET ON RAIL AND DRAIN,ASIDE PARTS TO SPRAY BOOTH GRILLE(SMALL BASKET),RETURN LARGE BASKET TO VAT,CLOSE LID,REMOVE PARTS FROM SMALL BASKET AND ASIDE BASKET TO STORAGE ENDS-WITH ASIDE BASKET CONDITIONS-ENW OF LARGE BASKET IS 10 POUNDS- SMALL BASKET WITH PARTS WEIGHS TO 10 POUNDS- DOES NOT INCLUDE WALKING TO GET SMALL BASKET, FROM CART TO TANK AND RETURN OR TO AND FROM BOOTH-NO TANK TIME IS INCLUDED-DIP SOLUTION IS TURCO-CARB OR EQUAL-NO DRAIN TIME INCLUDED
NAA	503	FUA	CPLPCO3	SCLHVO1	16792	HARDWARE,VACU-BLAST STARTS-WITH REACH TO GET BUSS BARS(TWO) INCLUDES-ALL THE MOTIONS NECESSARY TO GET TWO BUSS BARS,TWO ANODES AND FIVE HANGERS AND PLACE IN VACU-BLAST,ACTUATE VACU-BLAST AND BLAST PARTS(HARDWARE)TO ASSURE GOOD ELECTRICAL CONTACT,GET AND ASIDE TWO ANODES AND FIVE HANGERS TO BENCH,GET BUSS BARS AND POSITION ON PLATING TANK ENDS-WITH BUSS BARS IN POSITION ON TANK CONDITIONS-DOES NOT INCLUDE WALK TO GET HARD- WARE OR WALK TO AND FROM VACU-BLAST-15540 TMUS PROCESS(VACU-BLAST)TIME IS INCLUDED
NAA	503	TUA	OCLBAXX	SCLPBXX	VARIABLE	PART,BLAST(ABRASIVE)IN BOOTH STARTS-WITH REACH TO OBJECT TO BE BLASTED IN- SIDE BOOTH INCLUDES-ALL THE MOTIONS NECESSARY TO REACH AND POSITION OBJECT IN BOOTH,OBTAIN NOZZLE, OPEN CONTROL VALVE,REMOVE CONTAMINATION FROM OBJECT,CLOSE CONTROL VALVE,SHAKE PART TO RE- MOVE EXCESS ABRASIVE,ASIDE PART IN BOOTH ENDS-WITH ASIDE PART CONDITIONS-CLEAN PARTS TO FIVE SQUARE FEET-PER SQUARE FOOT BLASTED(12 INCHES X 12 INCHES)- SEED OR GARNET ABRASIVE-INCLUDES PRORATED ADDITION OF ABRASIVE MATERIAL TO BOOTH-SIMPLE SURFACE IS DEFINED AS READILY ACCESSIBLE REQUIRING LITTLE OR NO REPOSITIONING DURING CLEANING-COMPLEX SURFACE IS DEFINED AS SURFACE HAVING SOME RECESSED,RESTRICTED OR DIFFICULT ACCESS AREAS REQUIRING REPOSITIONING OF THE OBJECT DURING CLEANING(PANGBORN REACH-IN BOOTH)
					259 383	CASE 01 BLAST SQUARE FOOT-SIMPLE SURFACE 02 BLAST SQUARE FOOT-COMPLEX SURFACE

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	503	MAA	OITITKJ	SCLPD02	2023	PARTS(IN BASKET),DIP RINSE AFTER SONIC CLEAN

STARTS-WITH REACH TO SONIC CLEANER LID HANDLE
INCLUDES-ALL THE MOTIONS NECESSARY TO OPEN
   SONIC CLEANER LID,REMOVE BASKET OF PARTS,DRAIN
   BASKET OF PARTS,PLACE BASKET ON ADJOINING TANK
   OR BENCH,CLOSE SONIC CLEANER LID,PICK UP
   BASKET OF PARTS AND PLACE NEAR RINSE TANK,OPEN
   RINSE TANK LID, PLACE BASKET OF PARTS IN FLUID
   AND AGITATE,REMOVE FROM FLUID,SET DOWN NEAR
   TANK,CLOSE RINSE TANK LID
ENDS-WITH RINSE TANK LID CLOSED
CONDITIONS-BASKET OF PARTS WEIGHS 10 TO 20
   POUNDS-LIDS 2.5 TO 10 POUNDS-WALK TO CLEANER
   TANK AND BETWEEN CLEANER AND RINSE TANK NOT
   INCLUDED

| FFE | 503 | MAA | IOFEGKD | SCLPR01 | 2059 | PARTS(IN BASKET),RINSE |

STARTS-WITH REACH TO HANDLES OF BASKET
INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP
   AND RAISE FOLDED HANDLES OF BASKET,RAISE
   BASKET FROM CLEANER TANK,TILT BASKET TO DRAIN,
   PLACE BASKET ON EDGE OF TANK,GET RINSE TANK
   DRAIN PLUG AND SEAT IN DRAIN HOLE,ARISE,GET
   BASKET OF PARTS AND PLACE IN RINSE TANK,LOWER
   TANK LID,TURN ON SWITCH,TURN OFF SWITCH,RAISE
   LID,GET BASKET HANDLES AND MOVE BASKET IN
   FLUID TO AGITATE,REMOVE BASKET FROM FLUID,
   DRAIN,PLACE BASKET ON EDGE OF TANK,GET DRAIN
   PLUG AND REMOVE FROM DRAIN HOLE,POSITION
   SPLINE ON DRAIN,ARISE
ENDS-WITH ARISE FROM BEND
CONDITIONS-BASKET OF PARTS HAS ENW OF 20
   POUNDS-LID HAS ENW OF 10 POUNDS

| FFE | 503 | MAA | IOFEGKJ | SCLPR02 | 1158 | PARTS(IN BASKET),RINSE(DIP) |

STARTS-WITH REACH TO GET BASKET OF PARTS
INCLUDES-ALL THE MOTIONS NECESSARY TO PICK UP
   BASKET,AND PLACE ON ADJOINING TANK,RAISE RINSE
   TANK LID,GET BASKET OF PARTS, PLACE IN FLUID
   AND MOVE BASKET IN FLUID TO AGITATE,REMOVE
   BASKET FROM FLUID,PLACE BASKET ON ADJOINING
   TANK,LOWER RINSE TANK LID,RELEASE LID
ENDS-WITH RELEASE RINSE TANK LID-CLOSED
CONDITIONS-DOES NOT INCLUDE WALK WITH BASKET
   TO RINSE TANK-ENW OF BASKET OF PARTS IS 20
   POUNDS-ENW OF TANK LID IS 10 POUNDS-AGITATE
   FLUID WITH SIX MOVES(SIX INCHES EACH)

| AF | 503 | MAF | 76 | 40PPD01 | 223 | PART,DIP IN SOLVENT TO CLEAN,WEIGHT-LESS THAN 2.5 POUNDS |

STARTS-WITH PART IN HAND
INCLUDES-ALL MOTIONS NECESSARY TO MOVE PART
   INTO SOLVENT,SWISH PART BACK AND FORTH TO
   CLEAN,REMOVE PART FROM SOLVENT,AND SHAKE TO
   REMOVE SOLVENT AND DRY
ENDS-WITH PART IN HAND

| FFE | 503 | MAA | IOFEGKH | MJPPP01 | 167 | PARTS(IN BASKET),PLACE IN CLEANING TANK |

STARTS-WITH BASKET HANDLES IN HAND
INCLUDES-ALL THE MOTIONS NECESSARY TO MOVE
   BASKET OF PARTS OVER TANK,LOWER TO BOTTOM
ENDS-WITH BASKET AT BOTTOM OF TANK
CONDITIONS-ENW OF BASKET OF PARTS IS 20 POUNDS

DATA SOURCE	CCCUP- ATION	QUALITY	SOURCE CODE	DWMSTOP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	503	MAA	RLGJPB7	SJPBP01	2183	BLAST CLEAN,PREPARE(AGACITE OR AIR HONE)

STARTS-WITH REACH TO SLIDING DOOR
INCLUDES-ALL THE MOTIONS NECESSARY TO OPEN
   BLAST BOOTH DOOR,AND ENTER BOOTH,CLOSE DUOR,
   WALK TWO PACES IN BOOTH,WALK SIX PACES TO
   BASKET ENTRY DOOR,RAISE DOOR,GET BASKET OF
   PARTS,PLACE BASKET ON TURNTABLE,MAKE DIRECTION
   CHANGE OF TURNTABLE,CLOSE ENTRY DOOR,PUT ON
   HOOD AND GLOVES,TURN BLAST MACHINE ON AND OFF,
   WALK FIVE PACES TO BASKET EXIT DOOR,PUSH DOOR
   UP,GET BASKET OF PARTS,PLACE ON CONVEYOR AND
   PUSH OUT BOOTH,CLOSE EXIT DOOR,WALK TWO PACES
   TO BOOTH DOOR AND OPEN DOOR,STEP OUT OF BOOTH
   AND CLOSE DOOR
ENDS-WITH CLOSE BOOTH DOOR

| FFE | 503 | MAA | OIGCC01 | SJPCLXX | VARIABLE | CLEANER(COREHN),LOAD/UNLOAD(SMALL PART) |

STARTS-WITH REACH TO HOLDER
INCLUDES-ALL THE MOTIONS NECESSARY TO POSITION
   HOLDER,GET TWEEZERS,PICK UP PART(SMALL)AND
   PLACE ON HOLDER,ASIDE TWEEZERS,GET AND PLACE
   HOLDER WITH PART IN CLEANER,TURN ON CLEANER,
   TURN OFF DRYER,REMOVE HOLDER FROM CLEANER,GET
   TWEEZERS,REMOVE AND ASIDE PART FROM HOLDER,
   ASIDE TWEEZERS
ENDS-WITH ASIDE TWEEZERS

| | | | | | 349 | CASE 01 LOAD AND UNLOAD FIRST PART |
| | | | | | 81 | 02 LOAD AND UNLOAD EACH ADDITIONAL PART UP TO CAPACITY OF HOLDER |

| FFE | 503 | MAA | IOFEGKA | SJPCL03 | 532 | CLEANER(SONIC),LOAD |

STARTS-WITH REACH TO GET BASKET OF PARTS
INCLUDES-ALL THE MOTIONS NECESSARY TO PICK UP
   A BASKET OF PARTS,PLACE BASKET ON LID OF RINSE
   TANK,OPEN CLEAN LID,GET BASKET AND PLACE IN
   CLEANER,LOWER BASKET TO BOTTOM OF TANK,CLOSE
   TANK LID,SET TIMER
ENDS-WITH TIMER SET
CONDITIONS-DOES NOT INCLUDE WALKING WITH
   BASKET TO CLEAN-INCLUDES NECESSARY WALKING AT
   CLEANER TO MOVE BETWEEN LID AND BASKET-BASKET
   OF PARTS HAS ENW OF 20 POUNDS-LID HAS ENW OF
   10 POUNDS

| FFE | 503 | MAA | IOFEGKI | SJPCU01 | 865 | CLEANER(SONIC),UNLOAD(BASKET) |

STARTS-WITH REACH TO CLEANER LID
INCLUDES-ALL THE MOTIONS NECESSARY TO RAISE
   CLEANER LID,GET AND RAISE BASKET HANDLES,MOVE
   BASKET IN FLUID TO AGITATE,REMOVE BASKET FROM
   FLUID,PLACE BASKET ON LID OF ADJOINING TANK,
   LOWER CLEANER LID,RELEASE LID
ENDS-WITH RELEASE LID
CONDITIONS-ENW OF BASKET PARTS IS 20 POUNDS,
   ENW OF LID IS 10 POUNDS

| FFE | 503 | MAA | IOFEGKF | SJPDU01 | 414 | DRYER,UNLOAD |

STARTS-WITH REACH TO DRYER SWITCH
INCLUDES-ALL THE MOTIONS NECESSARY TO TURN OFF
   DRYER SWITCH,RAISE DRYER LID,GET AND RAISE
   FOLDED HANDLES ON BASKET OF PARTS,REMOVE
   BASKET OF PARTS FROM DRYER,PLACE BASKET ON
   RINSE TANK LID,CLOSE DRYER LID,GET BASKET FROM
   DRYER LID AND PLACE ON WORKBENCH
ENDS-WITH ASIDE BASKET OF PARTS ON WORKBENCH
CONDITIONS-DOES NOT INCLUDE WALKING TO DRYER
   AND FROM DRYER TO WORKBENCH-DOES INCLUDE MOVES
   NECESSARY TO ASIDE BASKET,CLOSE LID AND GET
   BASKET AGAIN-BASKET OF PARTS HAS ENW OF 20
   POUNDS-DRYER LID HAS ENW OF 10 POUNDS

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	OWNSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NF	503	MAF	3236	SJPHP01	470	HELMET(SANDBLAST),PUT ON AND REMOVE STARTS-WITH REACH TO HELMET INCLUDES-ALL MOTIONS NECESSARY TO GET HELMET, GET CLOTH FROM POCKET,WIPE VISION PORT,RETURN CLOTH TO POCKET,PLACE HELMET OVER HEAD,FASTEN WAIST BUCKLE,FASTEN CHEST BUCKLE,ADJUST CLOTH BIB;UNSNAP WAIST BUCKLE,UNSNAP CHEST BUCKLE, AND REMOVE,BEND AND RELEASE HELMET ON FLOOR, ARISE ENDS-WITH ARISE FROM BEND
FFE	503	MAA	01GCG03	SJPOSXX	VARIABLE	OBJECTS,STRING ON WIRE FOR CLEANING STARTS-WITH REACH TO GET DYKES INCLUDES-ALL THE MOTIONS NECESSARY TO GET DYKES AND CUT LENGTH OF WIRE FROM ROLL,ASIDE DYKES,GET AND PLACE OBJECT OVER WIRE,PULL WIRE OVER OBJECT AND PULL SNUG,GET TWO ENDS OF WIRE AND TWIST OBJECT AND WIRE TO SECURE,PLACE STRING OVER ARM,PLACE STRING OF OBJECTS ON BENCH ENDS-WITH STRING OF OBJECTS ASIDE CONDITIONS-OBJECTS WEIGH 2.5 TO 10 POUNDS-DOES NOT INCLUDE WALKING TO GET OBJECTS,WIRE OR TO BENCH TO ASIDE STRING
					561	CASE 01 STRING FIRST OR ONLY OBJECT
					223	02 STRING EACH ADDITIONAL OBJECT
FFE	503	M&A	GJPPCA1	SJPPC01	643	PREPARATION,MAKE FOR CLEANING PARTS IN SPRAY BOOTH STARTS-WITH REACH TO FACE SHIELD INCLUDES-ALL MOTIONS NECESSARY TO GET AND PUT ON FACE SHIELD,GET AND PUT ON CLOSE FITTING RUBBER GLOVES,,AND TURN FAN SWITCH ON;AND TURN FAN SWITCH OFF,REMOVE AND ASIDE GLOVES,AND REMOVE AND ASIDE FACE SHIELD ENDS-WITH RELEASE OF FACE SHIELD
FFE	503	MAA	IOTEGKC	SJPPM01	1234	PARTS(IN BASKET),MOVE FROM SONIC CLEANER TO RINSE TANK STARTS-WITH GET HANDLE OF RINSE TANK LID INCLUDES-ALL THE MOTIONS NECESSARY TO RAISE RINSE TANK LID,GET AND OPEN SONIC CLEANER LID,REACH AND GET HANDLES(SIMO)OF BASKET OF PARTS,RAISE HANDLES,MOVE BASKET FOUR TIMES IN FLUID TO AGITATE,REMOVE BASKET FROM SONIC CLEANER,PLACE ON TANK RIM,DRAIN PARTS,PLACE BASKET INTO RINSE TANK,FOLD HANDLES(SIMO),GET RINSE TANK LID HANDLE AND CLOSE LID,TURN ON RINSE SWITCH,TURN OFF SWITCH,GET RINSE TANK LID HANDLE AND OPEN LID ENDS-WITH LID OPEN,HAND ON HANDLE CONDITIONS-DOES NOT INCLUDE WALKING TO RINSE TANK OR RETURN TO WORKBENCH-WALKING OR SIDE-STEPS BETWEEN TANKS IS INCLUDED(THREE SIDE-STEPS)-BASKET OF PARTS ENW IS 20 POUNDS-LIDS ENW IS 10 POUNDS
FFE	503	MAA	IOTEGKE	SJPPP01	228	PARTS(IN BASKET),PLACE IN DRYER STARTS-WITH REACH TO DRYER LID INCLUDES-ALL THE MOTIONS NECESSARY TO GET LID HANDLE AND OPEN DRYER LID,GET BASKET OF PARTS, AND PLACE IN DRYER,FOLD BASKET HANDLES(SIMO), GET LID HANDLE AND CLOSE LID,REACH AND TURN ON DRYER ENDS-WITH TURN ON DRYER SWITCH CONDITIONS-DOES NOT INCLUDE WALKING TO RINSE TANK,DRYER,BETWEEN TANK AND DRYER OR RETURN TO WORKBENCH-ENW OF BASKET OF PARTS IS 20 POUNDS-ENW OF LID IS 10 POUNDS

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	504	MAA	SPLPH01	SDHPR01	1109	PART,BAKE

STARTS-WITH REACH TO GET GLOVES
INCLUDES-ALL THE MOTIONS NECESSARY TO GET AND
        PUT ON GLOVES,OPEN OVEN DOOR,GET PART AND PUT
        IN OVEN,CLOSE OVEN DOOR,REMOVE AND ASIDE
        GLOVES,GET AND PUT ON GLOVES,OPEN OVEN DOOR,
        REMOVE PART FROM OVEN AND ASIDE,CLOSE OVEN
        DOOR,REMOVE AND ASIDE GLOVES,GET PENCIL FROM
        POCKET HOLDER,RECORD TIME OUT OF OVEN,RETURN
        PENCIL TO POCKET
ENDS-WITH PENCIL RETURNED TO POCKET
CONDITIONS-PART WEIGHS TO 30 POUNDS-DOES NOT
        INCLUDE PROCESS(BAKE)TIME

| NAA | 505 | MAA | JACMD01 | SSTSC01 | 679 | SURFACE(METAL),COAT AND RINSE |

STARTS-WITH REACH TO WATER HOSE
INCLUDES-ALL THE MOTIONS NECESSARY TO GET
        WATER HOSE,MOVE HOSE TO SURFACE TO BE RINSED
        AND MOVE OVER SURFACE TO CUVER(FOUR MOVES)
        ASIDE WATER HOSE,GET BRIGHT DIP HOSE AND MOVE
        TO WORK,MOVE OVER SURFACE(FOUR TIMES)TO COVER,
        ASIDE BRIGHT DIP HOSE,GET WATER RINSE HOSE AND
        RINSE OFF BRIGHTENER(DIFFICULT TO REMOVE-MOVE
        HOSE NINE TIMES OVER SURFACE),ASIDE HOSE,GET
        ALODINE SPRAY HOSE,MOVE TO SURFACE,MOVE SPRAY
        (NINE TIMES)OVER SURFACE TO AGITATE,ASIDE HOSE
        AND GET RINSE WATER HOSE,RINSE OFF ALODINE
        WITH FOUR MOVES OVER SURFACE,ASIDE HOSE
ENDS-WITH ASIDE ALODINE RINSE HOSE
CONDITIONS-DOES NOT INCLUDE WALK TO GET AND
        RETURN WITH HOSE

| NAA | 549 | MAA | NOYCC02 | MCLCC01 | 1537 | CYLINDER(COMPRESSED GAS-EMPTY),CONNECT TO VACUUM MACHINE |

STARTS-WITH REACH TO CYLINDER VALVE
INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP
        AND PULL VALVE THROUGH HOLE IN OVEN DOOR,GET
        VACUUM HOSE AND CONNECT TO CYLINDER VALVE,OPEN
        CYLINDER VALVE,OPEN HOSE VALVE,TURN ON VACUUM
        PUMP,TURN ON OVEN,CHECK VACUUM READING FOUR
        TIMES,TURN OFF ALL VALVES,VACUUM PUMP AND OVEN
ENDS-WITH ALL VALVES,PUMP AND OVEN OFF
CONDITIONS-CYLINDER IS IN OVEN AT START AND
        END-DOES NOT INCLUDE WALKING TO AND FROM OVEN
        TO CHECK OPERATION-DOES NOT INCLUDE PROCESS
        TIME TO PUMP DOWN VACUUM

| NAA | 549 | MUA | NOYCC02 | SCLCP01 | 3242 | CYLINDER(COMPRESSED GAS),PURGE WITH OXYGEN |

STARTS-WITH REACH TO GET TOOL
INCLUDES-ALL THE MOTIONS NECESSARY TO GET TOOL
        AND REMOVE SAFETY CAP FROM CYLINDER VALVE,
        REACH AND GET PURGE HOSE,CONNECT TO VALVE,OPEN
        VALVE ON CYLINDER,OPEN MANIFOLD VALVE,PURGE
        CYLINDER WITH OXYGEN,CLOSE CYLINDER AND MANI-
        FOLD VALVE,DISCONNECT AIR HOSE FROM VALVE,
        ASIDE HOSE,GET TOOL AND SAFETY CAP,INSTALL
        CAP AND TIGHTEN,ASIDE TOOL,ASIDE CYLINDER
ENDS-WITH ASIDE CYLINDER
CONDITIONS-EMPTY CYLINDER WEIGHS TO 50
        POUNDS-PROCESS TIME TO PURGE IS 600 TMUS

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	549	MAA	NOYCR03	SOACDXX	VARIABLE	CYLINDER(COMPRESSED GAS),DISASSEMBLE(AUTOMATIC WRENCH/HAND WRENCH)
						STARTS=WITH PLACE CYLINDER IN VISE
						INCLUDES=ALL THE MOTIONS NECESSARY TO GET
						CYLINDER,GET WRENCH AND PLACE ON VALVE,REMOVE
						VALVE,ASIDE TOOL,INSPECT VALVE AND CYLINDER
						INTERIOR WITH FLASHLIGHT,REMOVE CYLINDER FROM
						VISE AND ASIDE
						ENDS=WITH ASIDE CYLINDER
						CONDITIONS=CYLINDER WEIGHS TO 20 POUNDS
					2071	CASE 01 DISASSEMBLE WITH AUTOMATIC WRENCH= PROCESS TIME(AUTO WRENCH)=200 TMUS INCLUDED
					2371	02 DISASSEMBLE WITH HAND WRENCH
NAA	549	TUA	NOYCT02	MVSCC01	758	CYLINDER(COMPRESSED GAS),CLAMP IN VISE
						STARTS=WITH REACH TO VISE PIN
						INCLUDES=ALL THE MOTIONS NECESSARY TO GRASP,
						REMOVE AND ASIDE VISE PIN,SWING VISE PIN OPEN,
						WALK 10 FEET TO CYLINDER STORAGE,GET CYLINDER
						AND ROLL 10 FEET INTO VISE,SWING VISE SECTION
						CLOSED,REPLACE PIN IN VISE,TIGHTEN VISE
						ENDS=WITH HAND ON VISE HANDLE
						CONDITIONS=CYLINDER OVER 30 POUNDS
NAA	549	MAA	NOYVQ01	MVSVO01	76	VISE(SPECIAL CYLINDER),OPEN OR CLOSE
						STARTS=WITH REACH TO VISE HANDLE
						INCLUDES=ALL THE MOTIONS NECESSARY TO GRASP
						HANDLE AND LOOSEN OR TIGHTEN(AVERAGE DISTANCE
						OF 1/2 INCH)BY TURNING HANDLE,RELEASE HANDLE
						ENDS=WITH RELEASE HANDLE
FFE	599	MAA	OIGSRL3	MCLPRXX	VARIABLE	PART,RINSE WITH PRESSURE SPRAY
						STARTS=WITH PART IN HAND
						INCLUDES=ALL THE MOTIONS NECESSARY TO MOVE
						PART TO TANK,HOLD PART AND TURN DURING RINSE
						TO COVER ALL SURFACES,SHAKE PART TO REMOVE
						RESIDUE AFTER RINSE,LAY PART ASIDE
						ENDS=WITH HAND ON PART
						CONDITIONS=NO WALKING INCLUDED
					288	CASE 01 PART=2.5 TO 10 POUNDS
					228	02 PART=LESS THAN 2.5 POUNDS
FFD	599	TBA	GECCHSX	MCLPSXX	VARIABLE	PARTS,STEAM CLEAN(PROCESS TIME)
						STARTS=WITH STEAM VALVE OPEN,NOZZLE IN HAND
						INCLUDES=ALL THE TIME AND MOTIONS NECESSARY TO
						STEAM PART,RACK OR BASKET OF PARTS
						ENDS=WITH STEAM VALVE OPEN
					5377	CASE 01 RACK OF PARTS,PERFORATED PLATE OR SIX HOOK RACK LOADED WITH PARTS
					1445	02 MEDIUM PART
					3750	03 LARGE PART
					8217	04 VERY LARGE PART
					5327	05 LARGE BASKET OF PARTS=1 1/2 X 3 1/2 X 3 1/2 TO 2 X 4 X 4 FEET
					3925	06 MEDIUM BASKET OF PARTS=5 X 17 X 27 TO 8 X 18 X 61 INCHES

DATA SOURCE	OCCUP-ATION	QUALITY CODE	SOURCE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	599	MAA	SCLCC44	SCLCCXX	VARIABLE	COMPONENT, CLEAN WITH VACUUM
						STARTS—WITH REACH TO VACUUM HOSE
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET HOSE AND TURN VACUUM ON, UNCOIL VACUUM HOSE, GET EXTENSION, CONNECT EXTENSION, VACUUM SURFACE TO REMOVE WATER AND LOOSE PAINT, DISCONNECT EXTENSION, ASIDE EXTENSION, COIL AND ASIDE HOSE, TURN VACUUM OFF
						ENDS—WITH HOSE COILED AND VACUUM OFF
						CONDITIONS—COMPLEX, AN AREA WITH OBSTRUCTIONS SUCH AS RIBS, FORMERS, ETC., BUT ACCESSIBLE—VERY COMPLEX—OBSTRUCTED AREA CLEANED THROUGH AN OPENING SUCH AS ACCESS OR INSPECTION DOORS—APPLIES TO INVISIBLE VACUUM, TYPE AC, MODEL 8098—WALK TO GET HOSE AND EXTENSION NOT INCLUDED
					2166	CASE 01 VACUUM COMPLEX SURFACE—FIRST SQUARE FOOT
					449	02 VACUUM COMPLEX SURFACE—EACH ADDITIONAL SQUARE FOOT
					2606	03 VACUUM VERY COMPLEX SURFACE—FIRST SQUARE FOOT
					661	04 VACUUM VERY COMPLEX SURFACE—EACH ADDITIONAL SQUARE FOOT
FFE	599	MAA	OIGSRL4	SCLP9XX	VARIABLE	PART, BRUSH OFF PAINT IN THINNER
						STARTS—WITH REACH TO GET PART
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART AND HOLD IN THINNER, GET LARGE BRUSH AND BRUSH PART IN THINNER WITH PRESSURE, ASIDE LARGE BRUSH AND GET SMALL BRUSH, BRUSH REMAINING AREA, ASIDE SMALL BRUSH AND GET RAG, WIPE PART DRY AND ASIDE RAG, INSPECT PART(VISUAL), ASIDE PART
						ENDS—WITH ASIDE PART
						CONDITIONS—PAINT REMOVER HAS BEEN APPLIED PRIOR TO THIS OPERATION
					1483	CASE 01 PART—2.5 TO 10 POUNDS
					1057	02 PART—LESS THAN 2.5 POUNDS
FFE	599	MAA	OIGCHO2	SCLPCXX	VARIABLE	PART, CLEAN WITH SOLVENT AND BRUSH
						STARTS—WITH REACH TO GET PART(S)
						INCLUDES—ALL THE MOTIONS NECESSARY TO GET PART(S) AND PLACE ON WORKBENCH, PUT ON FACE SHIELD AND GLOVES, GET PART AND BRUSH, SIT, HOLD PART AND BRUSH IN SOLVENT TANK, BRUSH TO CLEAN RUST OR CORROSION FROM PART, STAND, ASIDE PART AND BRUSH, REMOVE AND ASIDE GLOVES AND FACE SHIELD
						ENDS—WITH REMOVE AND ASIDE FACE SHIELD
						CONDITIONS—DOES NOT INCLUDE WALKING TO GET PART OR TO AND FROM TANK
					1982	CASE 01 CLEAN FIRST PART—16 TO 25 SQUARE INCHES
					1271	02 CLEAN EACH ADDITIONAL PART—16 TO 25 SQUARE INCHES
					1742	03 CLEAN FIRST PART—NINE TO 16 SQUARE INCHES
					1031	04 CLEAN EACH ADDITIONAL PART—NINE TO 16 SQUARE INCHES
					1502	05 CLEAN FIRST PART—FOUR TO NINE SQUARE INCHES
					791	06 CLEAN EACH ADDITIONAL PART—FOUR TO NINE SQUARE INCHES

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	DWMSTD ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	599	MAA	O1GCG06	SCLPW01	555	PART,WASH IN TANK WITH BRUSH

PART,WASH IN TANK WITH BRUSH
STARTS—WITH REACH TO TANK COVER HANDLE
INCLUDES—ALL THE MOTIONS NECESSARY TO RAISE
TANK COVER, OPEN VALVE,GET PART,DIP IN FLUID,
GET BRUSH,DIP BRUSH IN FLUID,WIPE PART CLEAN
WITH BRUSH,REMOVE PART AND BRUSH FROM FLUID
AND ASIDE,REACH TO AGITATOR VALVE AND CLOSE,
RELEASE VALVE,REACH AND GET TANK LID HANDLE,
CLOSE LID,RELEASE LID HANDLE
ENDS—WITH LID CLOSED,HANDLE RELEASED
CONDITIONS—TANK LID WEIGHS TO 10 POUNDS

| FFE | 599 | MAA | O1GSRL2 | SDPPOXX | VARIABLE | PART,DIP IN SOLUTION(PAINT REMOVER) |

PART,DIP IN SOLUTION(PAINT REMOVER)
STARTS—WITH REACH TO GET PART
INCLUDES—ALL THE MOTIONS NECESSARY TO PICK UP
PART,PLACE PART IN SOLUTION,GET PART FROM
SOLUTION,SHAKE TO REMOVE RESIDUE FROM PART,
ASIDE PART
ENDS—WITH ASIDE PART
CONDITIONS—TANK PARTIALLY FULL OF PAINT
REMOVER

| | | | | | 181 | CASE 01 PART—2.5 TO 10 POUNDS |
| | | | | | 154 | 02 PART—LESS THAN 2.5 POUNDS |

| FFD | 599 | MAA | GEC4C9X | SJPDOXX | VARIABLE | DOORS(BASKET—HINGED,DOUBLE,SWINGING),OPEN AND CLOSE |

DOORS(BASKET—HINGED,DOUBLE,SWINGING),OPEN AND
CLOSE
STARTS—WITH REACH TO LATCH
INCLUDES—ALL THE MOTIONS NECESSARY TO UNLATCH
DOOR(S)AND SWING FIRST DOOR OPEN,WALK TO
SECOND DOOR AND SWING OPEN,GET FIRST DOOR AND
SWING TO CLOSE,WALK TO SECOND,GET AND SWING TO
CLOSE,ALIGN DOORS,PUSH SHUT AND SWING LATCH
INTO EYE
ENDS—WITH DOORS FULL OPEN OR CLOSED AND
LATCHED
CONDITIONS—5X5 FOOT BASKET

| | | | | | 399 | CASE 01 OPEN |
| | | | | | 464 | 02 CLOSE |

| FFD | 599 | MAA | GECCHR5 | SJPGP01 | 311 | GUN(SPRAY,RINSE),PREPARE TO USE |

GUN(SPRAY,RINSE),PREPARE TO USE
STARTS—WITH REACH TO VALVE ON SPRAY GUN
INCLUDES—ALL THE MOTIONS NECESSARY TO GRASP
SPRAY GUN VALVE(WHEEL),TURN TWO REVOLUTIONS TO
OPEN,GET SPRAY GUN AND POSITION FOR USE,PLACE
GUN ASIDE,GRASP AND TURN VALVE WHEEL TWO
REVOLUTIONS TO CLOSE,RELEASE VALVE
ENDS—WITH RELEASE VALVE

| FFD | 599 | MAA | GECCHS2 | SJPGP02 | 440 | GUN(STEAM),PREPARE TO USE |

GUN(STEAM),PREPARE TO USE
STARTS—WITH SIDESTEP TO STEAM VALVE(ONE STEP)
INCLUDES—ALL THE MOTIONS NECESSARY TO SIDESTEP
AND GRASP VALVE WHEEL,TURN WHEEL TWO REVOLU-
TIONS TO OPEN,GET STEAM GUN,STEP BACK(TWO
STEPS)CHANGE HANDS WITH GUN,STEP FORWARD(TWO
STEPS),PLACE GUN IN SLOT IN GRATING,PLACE GUN
ASIDE,GRASP VALVE WHEEL AND TURN TWO REVOLU-
TIONS TO CLOSE
ENDS—WITH STEAM VALVE CLOSED,RELEASED

| NFA | 599 | NFA | SCLVCO1 | SJPPP01 | 937 | PART(S),PREPARE TO CLEAN WITH VARSOL |

PART(S),PREPARE TO CLEAN WITH VARSOL
STARTS—WITH REACH TO GOGGLES
INCLUDES—ALL THE MOTIONS NECESSARY TO GET AND
PUT ON GOGGLES,GET PART OR BASKET AND PLACE
ASIDE IN SPRAY BOOTH,TURN FROM SPRAY BOOTH,
PUT ON GLOVES,START EXHAUST FAN,GET AND ASIDE
SPRAY GUN,GET AND ASIDE AIR GUN,GET PART OR
BASKET,TURN AND ASIDE TO WORKBENCH,REMOVE
GOGGLES,REMOVE GLOVES,TURN OFF EXHAUST FAN
ENDS—WITH PART OR BASKET ASIDE,GLOVES REMOVED
CONDITIONS—APPLIES TO SUCTION TYPE,VARSOL—AIR
SPRAY WASH,AIR DRY,EQUIVALENT TO PAASCHE MODEL
NUMBER SP L-4—DOES NOT INCLUDE TIME TO WASH OR
DRY PART—DOES NOT INCLUDE WALKING

DATA SOURCE	OCCUP- ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFF	509	FUA	OIGCG08	SCLPC07	1800	PART,CLEAN WITH PRESSURE SPRAY OF CLEANING AGENT STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND POSITION TO SPRAY NOZZLE,TURN SWITCH ON, PLACE FOOT ON FOOT PEDAL AND DEPRESS,SPRAY PART,REMOVE FOOT FROM PEDAL,TURN OFF SWITCH, PLACE PART ON WORK BENCH ENDS-WITH PART ASIDE CONDITIONS-1667 TMUS SPRAY TIME IS INCLUDED-WALKING AND TURNS AT WORK AREA NOT INCLUDED
FFD	599	TCA	GECCHR8	SCLPR01	7327	PARTS(IN BASKET),RINSE(SPRAY) STARTS-WITH REACH TO SPRAY VALVE TO OPEN INCLUDES-ALL THE MOTIONS NECESSARY TO TURN ON SPRAY VALVE(WHEEL)(TWO REVOLUTIONS),GET SPRAY GUN AND SPRAY PARTS IN BASKET TO RINSE,ASIDE SPRAY GUN,CLOSE VALVE ENDS-WITH GUN ASIDE,VALVE CLOSED CONDITIONS-TIME IS TO SPRAY RINSE A SMALL BASKET OF PARTS-PARTS CLOSE TOGETHER-COMPLEX SURFACES
FFD	599	TBA	GECCHR3	SCLPR02	1710	PARTS(IN BASKET),RINSE(SPRAY) STARTS-WITH REACH TO GET HOSE NOZZLE INCLUDES-ALL THE TIME AND MOTIONS NECESSARY TO GET NOZZLE,POINT NOZZLE AT BASKET,TURN ON SPRAY,RINSE BASKET OF PARTS,TURN SPRAY OFF, ASIDE NOZZLE ENDS-WITH ASIDE NOZZLE CONDITIONS-PARTS IN 5X5 FOOT BASKET OVER VAT-PARTS LOOSELY PLACED IN BASKET-SIMPLE SURFACES-TIME IS PER BASKET OF PARTS
FFE	599	MAA	OIGSRL1	SCLPSXX	VARIABLE	PAINT,STRIP FROM PART STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND DIP IN PAINT REMOVER,REMOVE PART AND SHAKE TO REMOVE RESIDUE,ASIDE PART,GET PART AND HOLD IN PRESSURE SPRAY,TURN PART SO THAT ALL AREAS ARE SPRAYED,SHAKE OFF RESIDUE,ASIDE PART,GET PART AND HOLD IN THINNER,GET LARGE BRUSH AND BRUSH PART TO REMOVE PAINT,ASIDE BRUSH,GET SMALL BRUSH AND BRUSH OFF REMAINING AREA OF PART,ASIDE BRUSH,GET RAG AND WIPE PART DRY, ASIDE RAG AND PART ENDS-WITH ASIDE PART CONDITIONS-PAINT REMOVER TANK IS PARTIALLY FULL-NO WALKING IN CONNECTION WITH THIS OPERATION IS INCLUDED
					1952	CASE 01 PART-2.5 TO 10 POUNDS
					1439	02 PART-LESS THAN 2.5 POUNDS
FFE	599	MAA	OITITKI	SCLPS03	1452	PAINT,STRIP FROM INSTRUMENT CASE STARTS-WITH REACH TO INSTRUMENT CASE IN BASKET OF CASES INCLUDES-ALL THE MOTIONS NECESSARY TO GET ONE CASE FROM BASKET,GET BRUSH,CLEAN CASE WITH BRUSH,ASIDE BRUSH,GET WIPING RAG,GET AND OPEN SOLVENT CONTAINER,WET TOWEL,ASIDE CONTAINER, MOVE WET TOWEL TO SURFACE AND CLEAN SURFACE, ASIDE WET TOWEL,GET DRY TOWEL AND WIPE SURFACE,CLOSE AND ASIDE SOLVENT CONTAINER, VISUALLY INSPECT CASE,ASIDE CASE TO TRAY ENDS-WITH ASIDE CASE CONDITIONS-CASES HAVE BEEN REMOVED FROM DRYER IN A BASKET-CLEAN AREA TO ONE SQUARE FOOT-REMOVE LOOSE PAINT

19

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FEE	599	MAA	OIGCP01	SJPPP02	787	PART,PREPARE TO TANK CLEAN STARTS—WITH REACH TO GET PART(S)TO BE CLEANED INCLUDES—ALL THE MOTIONS NECESSARY TO PICK UP PART,PLACE PART ON WORKBENCH,SIT IN CHAIR,PUT ON FACE SHIELD,PUT ON GLOVES,GET PART AND DIP INTO SOLVENT IN TANK,REMOVE AND ASIDE PART, TAKE OFF AND ASIDE GLOVES AND FACE SHIELD, STAND UP ENDS—WITH STAND UP
NO	599	MAO	LTUM1G1	SJPRMXX	VARIABLE	ROCKS/COMPOUND,MOVE FROM DRUM TO CONTAINER STARTS—WITH REACH TO GET SCOOP INCLUDES—ALL THE MOTIONS NECESSARY TO GRASP, DIP INTO DRUM AND GET SCOOP LOAD,REMOVE LOAD FROM DRUM AND TO CONTAINER,DUMP SCOOP LOAD IN CONTAINER,RETURN SCOOP TO DRUM AND RELEASE ENDS—WITH RELEASE SCOOP IN DRUM
					234	CASE 01 FIRST OR ONLY SCOOP LOAD
					197	02 EACH ADDITIONAL SCOOP LOAD
NAA	599	MAA	SCLCC49	SJPSS01	1518	STEAM UNIT,SET UP AND SECURE STARTS—WITH REACH TO PLUG INCLUDES—ALL THE MOTIONS NECESSARY TO PLUG IN AND UNPLUG POWER CORD,OPEN AND CLOSE TWO GLOBE TYPE STEAM VALVES(NOT MORE THAN SEVEN TURNS EACH),OPEN AND CLOSE WATER VALVE(LEVER TYPE OR PETCOCK,TURN NOT MORE THAN 180 DEGREES), OPEN AND CLOSE SOAP VALVE(PUSH TYPE SWITCH), OPEN AND CLOSE WATER TANK VALVE(LEVER TYPE OR PETCOCK,TURN NOT MORE THAN 180 DEGREES) ENDS—WITH PULL POWER PLUG CONDITIONS—DOES NOT INCLUDE WALKING TO OR FROM MACHINE OR TO OR FROM POWER CORD PLUG
NO	599	MAA	LTUM-1N	MNFDL01	105	DOOR(TUMBLER),LOCK OR UNLOCK STARTS—WITH REACH TO DOOR LATCH INCLUDES—ALL THE MOTIONS NECESSARY TO REACH TO AND HIT DOOR LATCH WITH FIRST ONE HAND AND THEN THE OTHER TO LOOSEN OR TIGHTEN LATCH, GRASP LATCH IN BOTH HANDS AND MOVE TO LOOSEN OR TIGHTEN,RELEASE LATCH ENDS—WITH RELEASE LATCH CONDITIONS—HIT LATCH THREE TIMES WITH EACH HAND—DOOR IS 12 X 14 INCHES WITH 2 DOG LOCKS
NO	599	MAO	LTUM-1R	MOHDP01	49	DOOR(TUMBLER),POSITION ON TUMBLER STARTS—WITH DOOR IN HANDS INCLUDES—ALL THE MOTIONS NECESSARY TO MOVE DOOR TO MACHINE,POSITION DOOR ON MACHINE,MOVE OTHER END OF DOOR INTO PLACE,POSITION,RELEASE DOOR ENDS—WITH RELEASE DOOR CONDITIONS—DOOR IS 12 X 14 INCHES
NO	599	MAO	LTUM-1Q	MOHDR01	39	DOOR(TUMBLER),REMOVE STARTS—WITH REACH TO DOOR HANDLE INCLUDES—ALL THE MOTIONS NECESSARY TO GRASP DOOR HANDLE,DISENGAGE DOOR AND MOVE DOOR ASIDE ENDS—WITH DOOR MOVED ASIDE,STILL IN HAND CONDITIONS—DOOR IS 12 X 14 INCHES