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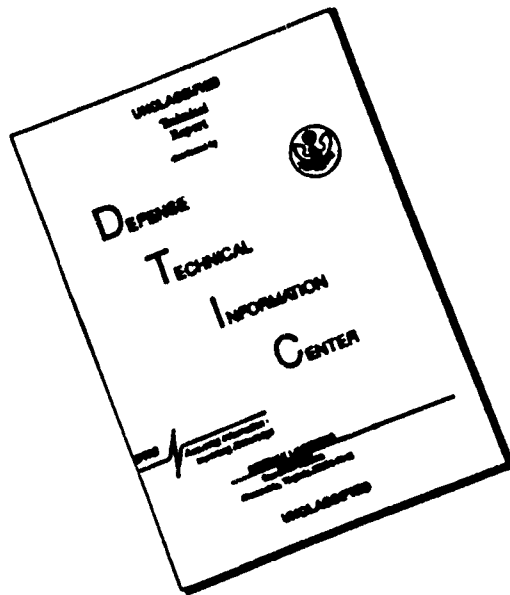
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**TECHNOLOGY INSERTION-ENGINEERING SERVICES
PROCESS CHARACTERIZATION
TASK ORDER NO. 1
(BLOCK II)**

DATABASE DOCUMENTATION BOOK

OC-ALC

MATPCM

**CONTRACT SUMMARY REPORT
11 SEPTEMBER 1989**

**CONTRACT NO. F33600-88-D-0567
CDRL SEQUENCE NO. B008**

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1.0 IDENTIFICATION OF RCC AND GENERAL INFORMATION

The Resource Control Center (RCC) identified as MATPCM is a machine shop which performs standard machine operations for parts and assemblies requiring rework and repair. These parts and assemblies are received from other RCC's. Once the items are repaired and reworked by MATPCM, they must be picked up by the respective RCC. MATPCM serves primarily as a support RCC to the other area work groups.

The area layouts is such that similar type machines are positioned together in one section of the shop. A problem exist for the Lathe Group in that the spacing between machines is sometime not sufficient for working some parts requiring large fixtures on the Lathes. However, adequate space exist for the other equipment in the area.

The square footage for MATPCM consists of 2928 square feet in the assigned production area for MATPCM and 1489 square feet allocated in MATPCB for the J-57 and TF-33 manifold assembly operations. Given the current workload requirements, there appears to be an adequate amount of equipment, workspace, and personnel. It is noted that the current MATPCM RCC will be integrated into a complete machining complex which has been proposed by AFLC Management. The detailed layout configuration for the new area has not been developed.

MATPCM is located in Building 3001, Column P-30 of the OC-ALC.

~~2.0 MATPCM INFORMATION SECTION~~

2.0 MATPCM INFORMATION

PAGE 2

2.1 FACILITY LAYOUT DRAWING

The current Facility Layout Drawing is accurate except for the absence of drill presses on work benches and the locations of cabinets and tool boxes. The red highlighted areas indicated on the Layout Drawing are numbered and represent the following:

- 1 - Drill Press
- 2 - Drill Press
- 3 - Cabinet (28x30)
- 4 - Bench Grinder
- 5 - Arbor Press #1
- 6 - Drill Press (not functional)
- 7 - Hole Punch (on top of cabinet)
- 8 - Drill Press
- 9 - Drill Press
- 10 - Hand Lapping Fixture

The milling machines, drills, and fixtures in the manifold assembly section are labeled as CM. Bins and cabinets in the drawing are used for the storage of interchangeable small parts and miscellaneous tools. Tables and benches illustrated in the layout are primarily used for storage of parts, tool, and other items. Since MATPCM is a job shop environment, the present layout is sufficient for the purpose of production. No significant changes for consideration were noted.

Although it appears that there is an adequate amount of space available between equipment and between storage areas, the blueprint is not accurate in this regard. Only approximately 2-4 feet of space exist between the Monarch Lathes in the east part of the MATPCM area. The lack of space tends to restrict movement of the operator. It is also difficult to work larger parts on the Lathes.

AFLC Personnel indicate that the current machine shop will be integrated into another area within the next few months. When the proposed layout is approved, the actual details of where the machines will be located in the new area have not been proposed.

The actual Blueprint Layout configuration and the attached combination of all machine shop areas is included in this section.

2.2 EQUIPMENT

The equipment in MATPCM consist of several types of standard machines to perform manufacturing function. There are 5 Engine Lathes (Two Cincinnati and three Monarchs), 6 Milling Machines (4 horizontal, 2 vertical; 3 are Cincinnati and 3 are Kearney-Trecker), 2 Radial Drill Presses, 3 Standard Drill Presses, 2 Arbor Presses, 1 Tapping Machine, 1 Oven, 1 Grinder and 1 Lapping fixture for manifold assemblies. A Thompson Surface Grinder, A Slot-Cutter, and a Hydraulic Press machine are available but rarely used. Most of the equipment age ranges anywhere from 15-25 years old. Three Drill Presses under one year old were recently added.

Maintenance on the equipment consist mainly of the operators adding lubricants as needed with the maintenance facility performing a thorough job on a six-month basis. The condition of the equipment is satisfactory with few incidents of breakdown occurring throughout the year.

2.3 WORKFORCE

The workforce of MATPCM is fairly stable. The workforce consist of 14 machine tool operators, 1 machinist, and 1 unit chief. The breakdown is as follow:

<u>SKILL CODE</u>	<u>SKILL LEVEL</u>	<u>QUANTITY</u>	<u>AVG. YRS. OF EXPERIENCE</u>
AJ	WG-09	14	3-25
AJ	WG-10	1	4

Although the WG-09's are described as basic machine tool operators, they often perform work on the same level as a WG-10 in the same unit. The WG-09's are cross-trained to perform nearly all operations of the shop and have similar skills of a WG-10.

2.4 REPAIR WORK TECHNOLOGIES

The MATPCM machien shop preforms standard machining operations typical of any machine-job shop Environment-Drilling, boring, reaming, threading, tapping, facing, cutting, grinding, and lapping tasks as necessary for a wide variety of parts Typical parts worked will be sub-assembly components which will have come from other RCC's and require rework. A general list of compontent will be actuators, manifold assemblies, nozzles, fuel support assemblies, pumps, hinges, engine parts, thermostats, and miscellaneous small parts which require hardware and machining opreations on an as needed basis. Replacement spare parts which come in from vendors will sometimes require machining work in order to meet T.O. Specifications.

2.5 WORKLOAD MIX AND VOLUME

The MATPCM machine shop will typically work control numbers and WCD's from MATPCA (servo control- engine igniter subunits), MATPCB (accessories, fuel pumps, manifold-nozzle subunits), MATPCD (engine accessories, governor/misc o/h, and regulator-control subunits). and MATPEA (fuel control overhaul subunit). Of these three, MATPCB supplies the majority of the workload to MATPCM. Work will arrive at the machine shop in various ways. If a part is considered a "Rush" priority by the home RCC Group, then the machine shop will work on the one part as soon as possible. Otherwise, any other part or group of parts which arrive at the shop will be worked on a FIFO Basis.

There are many parts which require considerable set-up time on either the Engine Lathes or the Milling Machines. In this case the home RCC's will take a bin of several parts to the machine shop at a time in order to reduce set-up time, especially if the machining time for the part is minimal. The machine operator will do all the necessary rework, return the parts to the traveling bin, and place the bin on the finished parts table for the home RCC group to pick up.

Volume of work for the unit will vary and is typical of a job-shop unit. The workload will primarily depend upon the conditions of the RCC's work and the frequencies of the parts in the home RCC's which actually require machine shop rework.

The specific aircraft models which are primarily worked are the J-57, TF33, J79, TF41, and TF 30 parts. All control numbers worked are MISTR.

Therefore, the program workload percent according to the 80/20 list is:

<u>PROGRAM</u>	<u>PERCENT</u>
MISTR	100
PDM	0
TEMP	0
MFG	0

2.6 MATERIAL HANDLING

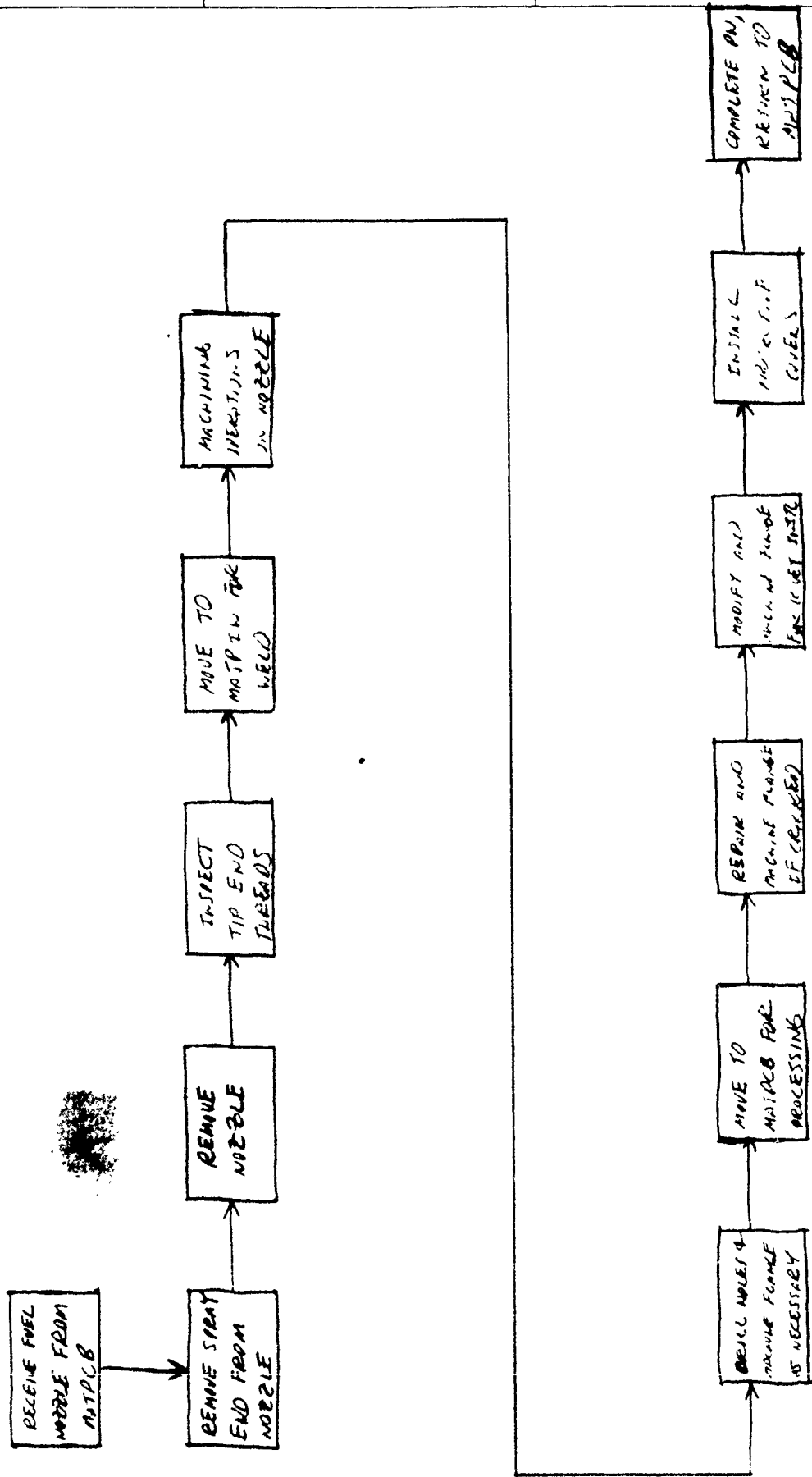
There is no special Material Handling Equipment required in MATPCM since it is a job-shop environment and no large assemblies are worked in the area requiring unique handling. As mentioned in Workload Mix and Volume, the parts to be worked will be transported to the appropriate work station in a bin which can be carried by the operator, large fixtures which have considerable weight can be moved with small carts which are available in the area.

2.7 STORAGE

Work tools, fixtures and miscellaneous hardware are the only items stored in MATPCM. The glass cabinets will contain the fixtures and the small cabinets with drawers will contain the small interchangeable parts and miscellaneous hardware. Each drawer is labeled as to what type of part or hardware it contains. Incoming and outgoing parts are stored on benches and tables next to the main shop aisle.

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PROCESS FLOW CHART - MATPCM
 EXAMPLE: C/N 5007A - MAIN FUEL NOZZLE FLOW



NOTE: THIS IS ONE FLOW EXAMPLE. MATPCM IS A JOB SHOP AND DOES NOT HAVE A SPECIFIC FLOW PROCEDURE.

3.0 80/20 WORKLOAD ANALYSIS

An 80/20 Analysis was performed for MATPCM using information obtained from AFLC analysis reports. From the earned hours reported for the control numbers worked by MATPCM, the following list of control numbers were identified as representing 80% of the workload:

<u>CONTROL NUMBER</u>	<u>WCD NAME</u>
49802 A	CBE401A
49806 A	CBE401B
49808 A	CBE401C
49810 A	CBE401D
98034 A	CBEC04A
98042 A	CBEC04B
98043 A	CBEC04C
98057 A	CBEC04D
50067 A	CMEM02
38691 A	CB945 A
38690 A	CB945 B
98206 A	CMEZ03
49779 A	CDEY38
38685 A	CMEM04
50126 A	EAEO1A
50127 A	EAEO1B
50191 A	EAEO1C
50281 A	CDEC01
61138 A	CDEY 39
38677 A	CMEM03
30241 A	CAEB05
37719 A	CAA601

97168 A	EA945A
98210 A	CD945A
38718 A	CAEM02
50134 A	Cmey02

Although 25 control numbers are listed as comprising the 80% workload, there is not an equal volume among this list. 12 of the 25 control numbers contain the significant volume of work within MATPCM and the remaining 13 were necessary to obtain the 80% workload figure.

3.1 VALIDATION

During the study, the control numbers listed on the 80/20 analysis were determined to be fairly representative of the machine shop workload. Note the above comment concerning what control numbers are considered significant within the 80/20

4.0 DATA COLLECTION

Of the profile data sheets available for data collection, it was determined that only the following were necessary for the conditions of MATPCM:

- Operation Profile
- Manpower Profile
- Equipment Profile

Disassembly/Assembly Profiles and Parallel Process Profiles were not warranted due to the nature of the work in MATPCM. The data obtained for MATPCM was from interviews conducted with shop personnel, primarily Bruce Cannon (WG10 Machinist) and Ron Dennis (WG09 Machine Tool Operator). Manpower available hours information was obtained from ALC Personnel. The Unit Chief for MATPCM has been absent due to medical reasons.

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4.1 DATA COLLECTION PROCESS

Each control number identified by the 80/20 analysis had an operation profile developed for it. The temporary shop foreman, Bruce Cannon, advised as to which shop personnel were responsible for the control numbers being studied. For nearly all the control numbers, either Cannon or Ron Dennis, a machine tool operator, provided the necessary information and data for the operation profiles. Since all operators are cross-trained on how to work parts and perform all machining operations, Cannon and Dennis were familiar with the control numbers.

The operators were interviewed to determine what operations and processes were actually occurring on the work control document (WCD) associated with the control number. If there was a discrepancy with WCD and what was actually occurring, it was noted in the source comments column of the operation profile and handled appropriately in the data columns. All transit times, flow times, manpower and equipment codes and times, and occurrence factors were determined primarily by operator information.

All profile sheets were reviewed for completeness and correctness and were processed according to instructions and accuracy of information given.

MANPOWER PROFILE

NAME <u>RANDY HARRIS</u> ALC <u>OC</u> DATE <u>5/25/89</u> RCC <u>HARPCM</u> SHEET <u>1</u> OF <u>1</u>		MANPOWER AVAILABLE (HOURS)												ALTERNATE SKILL CODE/LEVEL				
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE						HOLIDAYS						HOLIDAYS			
			WORK WEEK		WEEKEND		WEEKEND		WORK WEEK		WEEKEND		WEEKEND					
			1	2	3	1	2	3	1	2	3	1	2	3		1	2	3
AJ09	M.A.S.H.I.R.O.S.	1	12	2		14						6.0	6.0		6.0			AJ10
	MACHINE TOOL OPERATORS	2	12	2		14						5.9	5.9		5.9			
	- WORKS ALL UO'S OPERATIONS	3	12	2		14						5.9	5.9		5.9			
	- MACHINING OPERATIONS TO SPEC	4	12	2		14						5.9	5.9		5.9			
AJ10	M.A.S.H.I.R.O.S.	1	1			1						6.0	6.0		6.0			
	MACHINISTS - WORKS MACHINING	2	1			1						5.9	5.9		5.9			
	OPERATIONS AND ASSISTS OTHER	3	1			1						5.9	5.9		5.9			
	OPERATORS WHEN NEEDED	4	1			1						5.9	5.9		5.9			
		1																
		2																
		3																
		4																
		1																
		2																
		3																
		4																

EQUIPMENT PROFILE

EQUIPMENT CODE & #		EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			UNSCHEMULATED BREAKDOWN REPAIR TIME	PERCENT USED FOR OTHER RCCS (IF TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
			1st	2nd	3rd	FREQ	SHIFT	OL TIME	MTBF	MTTR	MIN			MAX			
116		L A I H E - S I M MONARCH LATHE	1	1	1	180 DAYS	2	50	180 DAYS	48 HRS	0	1	1	444, 5359			
444		L A I H E - S I M MONARCH LATHE	1	1	1	180 DAYS	2	50	180 DAYS		0	1	1	244, 5351			
1170		L A I H E - S I M CINCINNATI LATHE	1	1	1	180 DAYS	2	26	160 DAYS		0	1	1	1169	11707169		
1169		L A I H E - S I M CINCINNATI LATHE	1	1	1	180 DAYS	2	50	180 DAYS		0	1	1	1110			
3335		A R D E E N S I A STANDARD MODERN	1	1	1	180 DAYS	2		160 DAYS		1	1	1				
2816		A L L S S I M S L CINCINNATI MILL	1	1	1	180 DAYS	2	50	270 DAYS		0	1	1	279, 277, 281	These 4 types of mills		
		K - I - A L L S - HORIZONTAL MILL	1	1	1	180 DAYS	2		270 DAYS			1	1	226, 322, 321	CGN DC 1000 Inc 100 ACC Parts		
		K - I - A L L S - HORIZONTAL MILL	1	1	1	160 DAYS	2		270 DAYS		0	1	1	281			
207		A L L S S I M S L CINCINNATI MILL	1	1	1	160 DAYS	2		270 DAYS			1	1	279, 277			
4737		S H E - A L L S -	1	1	1	160 DAYS	2		270 DAYS			1	1		MINIFOLD Lug CUTTER		
4910		K - I - A L L S - VERTICAL MILL	1	1	1	180 DAYS	2		270 DAYS			1	1		MINIFOLD PARTS CUTTER		
111		S B L N D E R L - MINIFOLD GRINDER	1	1	1	180 DAYS	2	5	180 DAYS		0	1	1		MINIFOLD AREA		

NAME RANDY LARIS ALC 2 DATE 5/18/89 RCC MA TRM SHEET 1 OF 2

EQUIPMENT PROFILE

NAME <u>RODNEY HARRIS</u> ALC <u>OC</u> DATE <u>5/18/89</u> RCC <u>MATPCM</u> SHEET <u>2</u> OF <u>2</u>		QUANTITY PER SHIFT		EQUIPMENT TYPE/DESCRIPTION	PREVENTIVE MAINT.		DOWNTIME		PERCENT USED FOR OTHER RCCs (i.e. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
EQUIPMENT CODE	114	24	36		FREQ.	SHIFT	DOWN TIME	BREAkdOwN REPAIR TIME		MIN	MAX		
AF 1	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	180 DAYS	0	1			
AF 1	1	1	1	DRILL PRESS - CINCINNATI	N/A	N/A	N/A	N/A	0	1			MANUAL PRESS
5351	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	360 DAYS	0	1			
5351	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	180 DAYS	0	1		OC6442, OC3416	
0343	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	180 DAYS	0	1			
AF 1	1	1	1	DRILL PRESS - CINCINNATI	N/A	N/A	N/A	N/A	0	1			
AF 1	1	1	1	DRILL PRESS - CINCINNATI	N/A	N/A	N/A	N/A	0	1			
AF 1	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	180 DAYS	0	1			
6521	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	270	0	1		OC6522	
6522	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	270	0	1		OC6521	
1166	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	180	0	1			
0328	1	1	1	DRILL PRESS - CINCINNATI	180 DAYS	2	.50	270	11	1			

WORKLOAD PROFILE

Scheduling

NAME <u>GREEN STOKES</u>		ALC <u>OCALC</u>	DATE <u>5/25/89</u>	RCC <u>MIPCM</u>	SHEET <u>1</u> OF <u>2</u>						
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
					1	2	3	4			
49802A PCH HSH PHI	J57ALL	CBE401	4	Ø	148	161	137	159	Ø	25	2.5
49806A PCH HSH PHI	J57ALL	CBE401	11	Ø	166	115	163	175		25	2.5
49808A PCH HSH PHI	J57ALL	CBE401	"	Ø	81	71	100	91		20	2.5
49810A PCH HSH PHI	J57ALL	CBE401	"	Ø	95	107	69	83		10	2.5
98034A PCH HSH PHI	TF-33 P9	CBEC04	"	Ø	60	58	40	46		10	4.7
98042A PCH HSH PHI	TF-33 P7	CBEC04	"	Ø	81	105	63	46		25	2.5
98043A PCH HSH PHI	TF-33 P7	CBEC04	"	Ø	87	81	77	54		25	2.5
98057A PCH HSH PHI	TF-33 P9	CBEC04	"	Ø	52	50	40	42		20	4.7
50067A PCH HSH PHI	J79 15/17	CME01 CME02	"	Ø	1100	1035	870	730		190	.8
38691A PCH HSH PHI	J79 11/17	945	"	Ø	5	6	7	11		7	1.7
98206A PCH HSH PHI	TF41 A1	CMEZ03	"	Ø	9	8	16	18		6	2.0
38690A PCH HSH PHI	J79-15	CAEM02	"	Ø	3	4	2	3		10	1.8
49779A PCH HSH PHI	TF30P7/9	CDEY 38	"	Ø	20	17	11	25		10	1.0

WORKLOAD PROFILE

Scheduling

NAME _____			ALC _____			DATE _____			RCC <u>MTPCM</u>			SHEET <u>2</u> OF <u>2</u>		
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUANTER				NO. OF DEVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS			
					1	2	3	4						
PCN NSN PII 38685A	J79 15/17	CMEM 04-	4	Ø	10	11	8	14	Ø	10	25			
PCN NSN PII 50126A	TF30 P9	EAEO1 02	"	Ø	1	2	1	3	Ø	10	1.1			
PCN NSN PII 30241A	J-57 43/57	945	"	Ø	223	144	103	50	Ø	40	.7			
PCN NSN PII 38718A	J-79 15/17	945	"	Ø	97	97	87	84	Ø	25	1.5			
PCN NSN PII 50281A	TF-33 P7-100	945 945	"	Ø	178	174	133	178	Ø	40	1.2			
PCN NSN PII 61138A	TF-30 P100	CDEY 39	"	Ø	162	138	178	365	Ø	70	.9			
PCN NSN PII 38677A	J-79 15/17	CMEM 03	"	Ø	117	118	87	121	Ø	25	1.0			
PCN NSN PII 50127A	TF30 P7	EAEO1 02	"	Ø	2	3	2	4	Ø	10	1.2			
PCN NSN PII 37719A	E130	CAAG 01	"	Ø	49	48	62	42	Ø	20	.5			
PCN NSN PII 97168A	J54-43	945	"	Ø	137	154	115	131	Ø	30	.7			
PCN NSN PII 98210A	TF41 A1	945	"	Ø	181	136	96	89	Ø	35	.2			
PCN NSN PII 50191A	TF30 P111	EAEO1 02	"	Ø	7	12	17	6	Ø	20	4.4			
PCN NSN PII 50134A	TF30	CAEY 02	"	Ø	15	17	44	36	Ø	15	1.6			

NOTE ON ENVELOPS :

NONE OF THE EQUIPMENT IN MATPC:
FITS THE CRITERIA OF BEING BATCH
PROCESS EQUIPMENT. THIS DATA IS FOR
INFORMATION PURPOSES ONLY.

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC 05 RCC MA7PCM EQUIPMENT CODE 05050 510-CUTTER

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 36 cu ft

LIST OF PARTS BY ITEM NUMBER	SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN 37779A NSN PIN CAA601 w.c.o	65 cu ft	1	1	1	
PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					
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PCN NSN PIN					
PCN NSN PIN					
PCN NSN PIN					

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC OC RCC MAIPCM EQUIPMENT CODE AF# 80391 Drill lines
 TOTAL VOLUME OF EQUIPMENT IN CU. FT. 20 cu ft

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCH NSH PIN 50287	.1 cu ft	1	1	1	
PCH NSH PIN 209710					
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
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ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC <u>OC</u>	RCC <u>MMTCM</u>	EQUIPMENT CODE <u>OC # 1166</u>	TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>120 cu ft</u>			
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE	
PCN <u>49799A</u> NSN <u>7130 Nozzle Support</u> PIN <u>2184686</u>	<u>3 cu ft</u>	<u>1</u>	<u>1</u>	<u>1</u>		
PCN						
NSN						
PIN						
PCN						
NSN						
PIN						
PCN						
NSN						
PIN						
PCN						
NSN						
PIN						
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NSN						
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ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC <u>25</u>		RCC <u>MATK M</u>	EQUIPMENT CODE <u>OC # 6521, 6522, 6524, 6525</u>	TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>246 cu ft</u>			REMARKS/SOURCE
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM			
PCN 50121A NSN Transmitter PIN 2666488	1.5 cu ft	30	1	1			
PCN 50126A NSN PIN 2666488	11	30	1	1			
PCN 50127A NSN PIN 2666488	11	30	1	1			
PCN 50128 NSN PIN 2666488	11	30	1	1			
PCN 50129A NSN PIN 2666488	11	30	1	1			
PCN 50191B NSN PIN 2666488	11	30	1	1			
PCN 50206A NSN PIN	.05	1	1	1			
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC OS RCC MATEM EQUIPMENT CODE OC # 3446 # OC 4442 *DIAGNOSIS LATE ENGINE*

LIST OF PARTS BY ITEM NUMBER			SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCI NSH PIN	<u>50134A</u> <u>02469211901</u>	<u>1 cu ft</u>	<u>1</u>	<u>1</u>	<u>1</u>		
PCI NSH PIN	<u>38677A</u> <u>5120837A1</u>	<u>6 cu ft</u>	<u>6</u>	<u>1</u>	<u>1</u>		
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							
PCI NSH PIN							

ENVELOP

(For Internal Use, Not a Model Input) (BATCH PROCESS ONLY)

ALC 05 RCC MATREM EQUIPMENT CODE AR Proc Equip #1 V-# 2
 TOTAL VOLUME OF EQUIPMENT IN CU. FT. #1 3 cu ft #2 6 cu ft

LIST OF PARTS BY ITEM NUMBER	SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCH NSH PIN 38685A Cartridge 0213422201	2 cu ft	1	1	1	
PCH NSH PIN 38687A Cartridge 5120831P1	6 cu ft	3	1	1	
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
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ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC <u>05</u>		RCC <u>MATREM</u>		EQUIPMENT CODE <u>05359</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>48 cu ft</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCI	99168A	2.5 cu ft	2	1	1				
ISH	88729-1-01								
PII	99799								
PCI	99706	3 cu ft	2	1	1				
ISH	50067A								
PII	3031M13602	2 cu ft	1	1	1				
PCI									
ISH									
PII									
PCI									
ISH									
PII									
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ISH									
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PII									

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC <u>05</u>		RCC <u>MATREM</u>		EQUIPMENT CODE <u>28172816</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>3109.2327</u>		REMARKS/SOURCE <u>SINGI NAVA TI MILK</u> <u>3109 + 2327 - Kearsy, Kreider mill</u> <u>50 cu. ft</u>	
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM					
PCH 38718A ISH 276418 PIN #0387620001	2 cu ft	1	1	0					
PCH 38691A ISH 41600 PIN 602299	3 cu ft	2	1	1					
PCH 98210 ISH 41600 PIN 602299	2.5 cu ft	2	1	1					
PCH ISH PIN									
PCH ISH PIN									
PCH ISH PIN									
PCH ISH PIN									
PCH ISH PIN									
PCH ISH PIN									
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PCH ISH PIN									
PCH ISH PIN									

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC 05 RCC MPRE EQUIPMENT CODE 05# 170.F-05# H.P. CINCINNATI Engine Lath
 TOTAL VOLUME OF EQUIPMENT IN CU. FT. 400

LIST OF PARTS BY ITEM NUMBER	SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCI 97168 ISH PIN 88729	2.5	1	1	1	
PCI 61138A ISH PIN 94995	4	2	1	1	
PCI NSN PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					
PCI ISH PIN					

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC RS RCC MATEM EQUIPMENT CODE OC # 3325 Standard Modern Engine At the
 TOTAL VOLUME OF EQUIPMENT IN CU. FT. 62 cu ft REMARKS/SOURCE

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCI 38691A NSH PIN 102836	1 cu ft	1	1	1	
PCI 38680 NSH PIN 102836	1 cu ft	1	1	1	
PCN 38685A NSH PIN 02-13422	3 cu ft	3	1	1	
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					
PCI NSH PIN					

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC _____ RCC MATAM EQUIPMENT CODE OC-0343 M 38 0.1.20
 TOTAL VOLUME OF EQUIPMENT IN CU. FT. 140 FT³

LIST OF PARTS BY ITEM NUMBER	SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCH 78043A NSH PIN	2.0	1	1	1	MANE folds M-51 USE 2 OPERATORS TO BE DONE SIMULTANEOUSLY
PCH 49802A NSH PIN	2.0	1	1	1	
PCH 49806A NSH PIN	2.0	1	1	1	
PCH 49808A NSH PIN	2.0	1	1	1	
PCH 49810A NSH PIN	2.0	1	1	1	
PCH 78034A NSH PIN	2.0	1	1	1	
PCH 78042A NSH PIN	2.0	1	1	1	
PCH 78059A NSH PIN	2.0	1	1	1	
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					
PCH NSH PIN					

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC 22 RCC Mr. P.P. EQUIPMENT CODE 00-39 2.4 CME mill

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 61 cu ft

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN 78057A HSH PIN	2.0	1	1	1	MANUFACTURER'S
PCN 49802A HSH PIN	2.0	1	1	1	MANUFACTURER'S
PCN 47806A HSH PIN	2.0	1	1	1	
PCN 49808A HSH PIN	2.0	1	1	1	
PCN 49810A HSH PIN	2.0	1	1	1	
PCN 78034A HSH PIN	2.0	1	1	1	
PCN 78042A HSH PIN	2.0	1	1	1	
PCN 78057A HSH PIN	2.0	1	1	1	
PCN HSH PIN					
PCN HSH PIN					
PCN HSH PIN					
PCN HSH PIN					

ENVELOF

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC		RCC	EQUIPMENT CODE	TOTAL VOLUME OF EQUIPMENT IN CU. FT.			REMARKS/SOURCE
2C		M17C1M	OC 7 1192	75 CU FT			Source head
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM			
PCI 49802A ISH PII	2.0	1	1	1	MINs told		
PCI 49804A ISH PII	2.0	1	1	1	MAX T-SD'		
PCI 49808A ISH PIN	2.0	1	1	1			
PCI 49810A ISH PII	2.0	1	1	1			
PCI ISH PIN							
PCI ISH PII							
PCI NSH PIN							
PCI ISH PII							
PCI ISH PII							
PCI ISH PIN							
PCI ISH PIN							
PCI ISH PIN							
PCI ISH PIN							
PCI ISH PIN							
PCI ISH PIN							

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC <u>05</u>		RCC <u>001PCM</u>		EQUIPMENT CODE <u>2800</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	TOTAL VOLUME OF EQUIPMENT IN CU. FT.	
PCH 78043A NSH PIN	2.0	1	1	1	1	MANIFOLDS 220 C.A.S.	
PCH 49802A NSH PIN	2.0	1	1	1	1		
PCH 49806A NSH PIN	2.0	1	1	1	1		
PCH 47878A NSH PIN	2.0	1	1	1	1		
PCH 49807A NSH PIN	2.0	1	1	1	1		
PCH 98034A NSH PIN	2.0	1	1	1	1		
PCH 7852A NSH PIN	2.0	1	1	1	1		
PCH (21)A NSH PIN	2.0	1	1	1	1		
PCH NSH PIN							
PCH NSH PIN							
PCH NSH PIN							
PCH NSH PIN							

ENVELOP

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC 06 RCC MATPCM EQUIPMENT CODE 37355 TOTAL VOLUME OF EQUIPMENT IN CU. FT. 9.5 cu ft
Hand Lapping Fixture LSP#1

LIST OF PARTS BY ITEM NUMBER	SIZE VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS SOURCE
PCH 78034A NSH PHI	2.0	1	1	1	MANUFACTURED ONLY T-SS'S ARE HAND-LAPPED
PCH 78042A NSH PHI	2.0	1	1	1	
PCH 78043A NSH PIN	2.0	1	1	1	
PCH 78051A NSH PIN	2.0	1	1	1	
PCH NSH PIN					
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PCH NSH PIN					

FLOW PROCESS CHART

SUBJECT _____ DATE 05/11/89

ITEM CODE
PCN
NSN
PIN

WCD CAEBOS WCD DATE 89131
30241A

CHART BEGINS 025

CHART ENDS _____ PREPARED BY *[Signature]*

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
031	-	●DD□▽	REC			○DD□▽	
032	-	○DD□▽	INFO			○DD□▽	
033	-	○DD□▽	MACH.			○DD□▽	
034	-	○DD□▽	MACH.			○DD□▽	
034	-	○DD□▽	DES			○DD□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
 ◁ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME BANDY HARBELS ALC OC DATE 5/25/89 RCC MTP/CM WCD DATE 89033 SHEET 1 OF 2

FCI 3024) A WCD CA505

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INIS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
							QTY.	TIME REQUIRED % INIS	EQUIPMENT CODE	QTY.		TIME REQUIRED % INIS
030	MTP CA	IN DATE	1.0	TRANSIT	24							
				SETUP								
				PROCESS								
031	MTP CM	REC	1.0	TRANSIT				1			RECEIVE PART FROM MAINT. A/F PART WILL NORMALLY COME IN LOTS OF 5-20	
				SETUP								
				PROCESS								
032	↓	INFO	1.0	TRANSIT		N/A					REFERENCE TO TOP	
				SETUP								
				PROCESS								
033	↓	MACH	1.0	TRANSIT			1		JC2816	1	1.0	REPAIR LID FROM EXCITER
				SETUP								
				PROCESS								
034	↓	MACH.	1.0	TRANSIT			1		JC2816	1	1.0	
				SETUP								
				PROCESS								

OPERATION TIME TILE

NAME RANDI HARPER ALC AL DATE 5/25/89 NCC MATPCM SHEET 2 OF 2
 PCN 30241A WCD CAEBOS WCD DATE 87033

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INQUIRY		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	INS.	SKILL CODE/LEVEL	QTY.	%	INS.		EQUIPMENT CODE	QTY.
035	MATP CM	MOVE	1.0	TRANSIT	-	-	-	-	-	-	-	MOVE FINISHED MGT TO 1/15/89	
				SETUP	-	-	-	-	-	-	-		-
				PROCESS	-	-	-	-	-	-	-		-
9999	"	OUT DATE	1.0	TRANSIT	-	-	ADG	1	.12	002816	1	.02	
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	
				TRANSIT	0								
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
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				TRANSIT									
				SETUP									
				PROCESS									

"IN" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MTPCOM SHEET 1 OF 1

OBSERVATION NUMBER	"M" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88183	88184	1
2	88223	88224	1
3	88239	88240	1
4	88293	88295	2
5	89003	89006	3
6	89030	89031	1
7	89096	89097	1
8	89096	89097	1
9	89096	89098	2
10	89099	89100	1
			MEDIAN 1

NOTE: "M" DATE IS THE DATE THAT SCHEDULED FILTERS BE LOCK 5 OF WCD OR DATE

"OUT" DATES PROFILE

NAME <u>SHELCO BATES</u> ALC <u>OC</u> DATE <u>5/26/89</u> RCC <u>201624</u> SHEET <u>1</u> OF <u>1</u>		PARENT WCD DATE		PARENT WCD DATE		
PCI	HSH	PHI	OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
			1	88187	88187	0
			2	88227	88227	0
			3	88244	88245	1
			4	88298	88298	0
			5	89009	89009	0
			6	89034	89034	0
			7	89100	89101	1
			8	89100	89101	1
			9	89101	89102	1
			10	89103	89103	0
						0

FLOW PROCESS CHART

SUBJECT _____

DATE 05/23/89

ITEM CODE:
PCN:
MOM:
FM:

WCD CAAG 01

WCD DATE 89/43

37719A

CHART BEGINS 041

CHART ENDS 046

PREPARED BY RJP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
041	-	○□□▽	REC			○□□▽	
042	-	○□□▽	INSP			○□□▽	
043	-	○□□▽	MACH			○□□▽	
044	-	○□□▽	INSP			○□□▽	
045	-	○□□▽	MACH			○□□▽	
046	-	○□□▽	MOIE TO P/U			○□□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
 ▽ TRANSPORTATION D DELAY

OPERATION FILE

NAME Perker ALC OC DATE 05/23/89 RCC MAT PC M SHEET 1 OF 2
 WCD CAAG 01 WCD DATE 89143
 WCD 32219A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SHLL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
							QTY.	%	QTY.	%				
041	MAT PC M	REC	1.0	TURN PROCESS	-	AJ09	1	1.0	-	-	-	-	Run lots of approx. 40 ^{cc} per month	
042		Insp	1.0	TURN PROCESS	-		1	1.0	03	3416	1.0	0.03	still w/ g.o.f. Micrometer used on both ends of amp/dyne	
043		MACH	1.0	TURN SETUP PROCESS	-		1	1.0	12	0346	1	0.12	Placed on lathe for turning.	
044		Insp	1.0	TURN PROCESS	-		1	1.0	50	3416	1	1.0	0.50	repeat of 042 (after turnings).
045		MACH	1.0	TURN SETUP PROCESS	-		1	1.0	03	3416	1	1.0	0.03	Placed on slot cutter and slots machined into further surface of amp/dyne.

✓

✓

"IN" DATES PROFILE

NAME LARREN STOKES ALC OC DATE 5/26/89 ICC MATPCM SHEET 1 OF 1

PCI 322197
 HSI [REDACTED]
 PII [REDACTED]

PARENT WCD

PARENT WCD DATE

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88292	88293	1
2	88300	88302	2
3	88323	88324	1
4	88340	88341	1
5	88349	88351	2
6	89005	89006	1
7	89008	89008	0
8	89013	89013	0
9	89020	89022	2
10	89029	89029	0
			MEDIAN: 1

"OUT" DATES PROFILE

NAME WARREN STOKES ALC OK DATE 5/26/89 RCC MATPCM SHEET 1 OF 1

PCI FISH PRI	PARENT WCD	PARENT WCD DATE	OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING/SELL DATE)	Δ TIME (DAYS)
			1	88296	88288	0
			2	88304	88304	0
			3	88327	88328	1
			4	88345	88345	0
			5	88354	88354	0
			6	89009	89010	1
			7	89041	89011	0
			8	89016	89016	0
			9	89025	89026	1
			10	89033	89033	0

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

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE
PCN
NON
PM

WCD C MEM 03

WCD DATE 88235

CHART BEGINS 010

CHART ENDS 070

PREPARED BY R NAERIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	RECL. PART FROM TRAY			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
020	030	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	TEMP STAKE MARKS			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
030	040,060	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	BACK & ST. SP BUSHING			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
040	050	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSTALL BUSHING			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
050	070	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	REWORK CLAMP FOR			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
060	080	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	TREAT WITH ALUMINE			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
070	090,100	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	PW			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
080	10	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MUSE TO P/V			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
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- OPERATION
- STORAGE
- INSPECTION
- TRANSPORTATION
- DELAY

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MILAN SHEET 1 OF 2
 PCN 38677A WCD CMEM03 WCD DATE 88235

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHIBITS %	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
							QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %		
00	MATP CO	IN DATE	1.0	TRANSIT	24							
				SETUP								
				PROCESS								
010	MATP CM	REC	1.0	TRANSIT			AJ09	1			RECEIVE PAPER FRESH incoming TRAY.	
				SETUP								
				PROCESS								
020 (030)	11	INSP	1.0	TRANSIT							OP 030 ON WCD	
				SETUP								
				PROCESS								
030 (040) (050)	11	MCL	1.0	TRANSIT			AJ09	1	02	0346		OP 040 & 050 ON WCD.
				SETUP								
				PROCESS								
040 (050)	11	ASSY	1.0	TRANSIT			AJ09	1	04	PRESS2		SET-UP OCCURS ONCE PER 25 BUSHINGS, BUT FIXTURE ON THE MACHINE PRESS
				SETUP								
				PROCESS								

OPERATIO. PROFILE

NAME ALC OC DATE RCG MATPCA SHEET 2 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
							QTY.	%	QTY.	%			
050 (070)	MATPCA CM	AEW	.75	TRANSIT SETUP PROCESS	- - -	- A509 A509	- 1 1	- .25 .02	- OC OC	- 1 1	- .25 .02	- .25 .02	OP 070 ON WCD
260 684	"	PROC	1.0	TRANSIT SETUP PROCESS	- - -	- - AJ09	- - 1	- - .05	- - -	- - -	- - -	- - -	14. APPLICABLE MATERIAL CONSIDERED, MATERIAL ON WCD
270 090 100	"	PW	1.0	TRANSIT SETUP PROCESS	- - -	- - AJ09	- - 1	- - .01	- - -	- - -	- - -	- - -	NO MATERIAL CONSIDERED MATERIAL ON WCD
280 (110)	"	MOVE	1.0	TRANSIT SETUP PROCESS	- - -	- - AJ09	- - 1	- - .02	- - -	- - -	- - -	- - -	MOVE PART TO FINISHED PARTS TRAY OP 110 ON WCD
9999	"	OUT DATE	1.0	TRANSIT SETUP PROCESS	- - -	- - -	- - -	- - -	- - -	- - -	- - -	- - -	

"IN" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 ICC MTPCM SHEET 1 OF 1

PCI IISH PII	PATIENT WCD	"IN" DATE (SCHEDULED DATE)	PATIENT WCD DATE	Δ TIME (DAYS)
38677A				
1	89093	89094		1
2	89093	89094		1
3	89100	89101		1
4	89100	89101		1
5	89109	89109		0
6	89109	89110		1
7	89129	89129		0
8	89129	89130		1
9	89131	89131		0
10	89131	89132		1
				AFDIAK : 1

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENITERS III BLOCK 5 OF WCD OR DATE

"OUT" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MTPCM SHEET 1 OF 1

PCN HSH PHI	PARENT WCD	PARENT WCD DATE	OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
38677A			1	89095	89095	0
			2	89095	89095	0
			3	89102	89102	0
			4	89102	89102	0
			5	89111	89111	0
			6	89111	89114	3
			7	89130	89130	0
			8	89130	89131	1
			9	89135	89135	0
			10	89135	89136	1
						MEDIAN: 0

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/17/89

ITEM CODE PCN 38685A WCD CMEM04 WCD DATE 88301
 NBN
 PN

CHART BEGINS 010
 CHART ENDS 060 PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ○ ○ □ ▽	RECEIVE PARTS			○ ○ ○ □ ▽	
020	020	○ ○ ○ □ ▽	REPLACE INSERTS			○ ○ ○ □ ▽	
025	-	○ ○ ○ □ ▽	ICE + WAX COAT PART			○ ○ ○ □ ▽	
030	030	○ ○ ○ □ ▽	REPLACE BOND RING			○ ○ ○ □ ▽	
035	030	○ ○ ○ □ ▽	REMOVE BOND TO CYCLE			○ ○ ○ □ ▽	
040	040	○ ○ ○ □ ▽	MAKELINE RING			○ ○ ○ □ ▽	
050	050	○ ○ ○ □ ▽	REPLACE T/P			○ ○ ○ □ ▽	
060	060, 070	○ ○ ○ □ ▽	PW-MOVE TO PU			○ ○ ○ □ ▽	
		○ ○ ○ □ ▽				○ ○ ○ □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
 ◊ TRANSPORTATION D DELAY

OPERATION PF FILE

NAME: RANDY W. WARREN ALC OC DATE 5/17/89 RCC MATPCM SHEET 1 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW (HRS)	MANIPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %
00	MATP CB	IN DATE	1.0	TRANSIT									
010	MATP CM	REC	1.0	TRANSIT	27								
				SETUP									
				PROCESS									
020	"	REAL	.30	TRANSIT									
				SETUP									
				PROCESS									
025	"	PROC	1.0	TRANSIT									
				SETUP									
				PROCESS									
030	"	REAL	1.0	TRANSIT									
				SETUP									
				PROCESS									

OPERATOR WILL PICK UP PART FROM FURNACE TRAY AND MAKE TO WORKSTATION

BODY MUST BE FEED AND HEAT-TREATED IN PRESS FOR CARBON RING TO BE PLACED IN THE BODY.

RING IS HEATED INTO THE BODY.

WCD DATE 88301

WCD CHEM04

OPERATION FILE

NAME RANDY W. HARRIS ALC OC DATE 5/17/87 RCC AWPCM SHEET 2 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHIBIT %	SKILL CODE/LEVEL	MANIPORER		EQUIPMENT		DATA SOURCE COMMENTS
							QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %	
035	MATP CM	PROC	1.0	TRANSIT							AFTER THE BINS AS INSTRUCTED, THE BODY MUST BE ALLOWED TO COOL FOR 24 HOURS
040	"	MACH	1.0	TRANSIT							THE BODY MUST BE WAL INDICATED TO AN OFF-CENTER POSITION AND REQUIRES SIGNIFICANT SET UP TIME
050	"	REPL	.01	TRANSIT							
060	"	PW	1.0	TRANSIT							PANELS OMINETED AND PLACED ON FINISHED PARTS TRAY TO BE PICKED UP BY MATPCB
9999	"	OUT DATE	1.0	TRANSIT							

"IN" DATE PROFILE

NAME SHEILA DATES ALC OC DATE 5/26/89 RCC MATPCM SHEET 1 OF 1

PCH NSN PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
<u>382685A</u>				
		<u>88292</u>	<u>88293</u>	<u>1</u>
		<u>88292</u>	<u>88293</u>	<u>1</u>
		<u>88293</u>	<u>88294</u>	<u>1</u>
		<u>88305</u>	<u>88306</u>	<u>1</u>
		<u>88305</u>	<u>88306</u>	<u>1</u>
		<u>88319</u>	<u>88320</u>	<u>1</u>
				<u>Acc. Co.</u>

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/17/89

ITEM CODE
PCN
NSN
P/N
□
□

WCD CB945B*

WCD DATE 89137*

NO WCD. WCD CODE AND QTY WERE OBTAINED

CHART BEGINS 010

CHART ENDS 070

PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	-	○ ○ ○ □ ▽	REC PART(S)			○ ○ ○ □ ▽	
020	-	○ ○ ○ □ ▽	MEASURE BUSHING			○ ○ ○ □ ▽	
030	-	○ ○ ○ □ ▽	MACHINE BUSHING			○ ○ ○ □ ▽	
040	-	○ ○ ○ □ ▽	INS. REC BUSHING			○ ○ ○ □ ▽	
050	-	○ ○ ○ □ ▽	MACHINE BUSHING			○ ○ ○ □ ▽	
060	-	○ ○ ○ □ ▽	SLIDE PINS			○ ○ ○ □ ▽	
070	-	○ ○ ○ □ ▽	MOVE TO P/U			○ ○ ○ □ ▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
◊ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/19/87 RCC MATPCM SHEET 2 OF 2

PCN NSH PRL	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW/JOBS		SKILL CODE/ LEVEL		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
						%	HRS.	QTY.	QTY.	EQUIPMENT CODE	QTY.	%	HRS.	
050	MATP CAR		MACH	.20	TRANSIT	-	-	-	-	-	-	-	-	REPAIR MILLING OPERATION - CUT GRINDING IAW. SPECIFICATIONS, (STEEL, BRID, ACORN, OR ALUMINUM MACHINES CAN BE USED)
060	"	"	MACH	.20	TRANSIT	-	-	-	-	-	-	-	-	SHEAR PIN SETTING ON MILLING MACHINE
070	"	"	MONE	1.0	TRANSIT	-	-	-	-	-	-	-	-	MOVE PART TO FINISHED PARTS TRAY FOR MATPCB TO PICK-UP. PART WILL BE FRAGGED
9999	"	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	-	
					PROCESS									
					SETUP									
					PROCESS									
					SETUP									
					PROCESS									
					TRANSIT									
					SETUP									
					PROCESS									

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(STEEL, BRID, ACORN, OR
ALUMINUM MACHINES CAN BE USED)

"IN" DATES PROFILE

NAME <u>SUELLA BATES</u> ALC <u>OC</u> DATE <u>5/26/89</u> NICC <u>MARTIN</u> SHEET <u>1</u> OF <u>1</u>			
PCH <u>38690R</u>	PARENT WCD <u> </u>		
PRI <u> </u>	PARENT WCD DATE <u> </u>		
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88277	88278	1
2	88277	88278	1
3	88285	88286	1
4	88285	88286	1
5	89019	89020	1
			NCC in: 1

FLOW PROCESS CHART

SUBJECT _____

DATE 5/17/89

ITEM CODE
PCN
NSN
PIN

WCD CB945A*

WCD DATE 89137*

38691A

THESE C/N'S ARE 745' T/F ABOVE NUMBERS ARE CREATED FOR THE MODEL

CHART BEGINS 010

CHART ENDS 070

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	-	○○○□▽	REC PARTS)			○○○□▽	
020	-	○○○□▽	MEASURE BUSHING			○○○□▽	
030	-	○○○□▽	MACHINE BUSHING			○○○□▽	
040	-	○○○□▽	SMALL BUSHING			○○○□▽	
050	-	○○○□▽	MACHINE BUSHING			○○○□▽	
060	-	○○○□▽	SUGAR PINS			○○○□▽	
070	-	○○○□▽	MOVE TO P/U			○○○□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
 ◊ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME RANDY HERRS ALC OC DATE 5/17/89 RCC HAIRPC/M SHEET 1 OF 2

PCN OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	%	HRS.	QTY.	%	HRS.	QTY.	
00	MATP CB	IN DATE	1.0	TRANSIT	24								
				SETUP									
				PROCESS									
010	MATP CM	REC	1.0	TRANSIT			A309	1					RECEIVE FIRE HORN BODY. FIRE COMPONENT 1 MATP MATP/B
				SETUP									
				PROCESS									
020	"	INSP	.20	TRANSIT						.03			MENSURE DURING SPEC. ≈ 6 BUT NOT REF MATERIAL AND MATERIALS ≈ 60 P/EC
				SETUP									
				PROCESS									
030	"	MACH	.20	TRANSIT									OPS EXPLODING REARMENT UPON WHETHER SP00 IS USED. THIS IS A TURNING OPERATION WHICH CAN BE MADE ON ANY OF THE LATHES.
				SETUP									
				PROCESS									
040	"	ASSY	.20	TRANSIT									IN-FULL INSPIRING IN BODY SUB- COMPONENT.
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/19/89 RCC MPT/AM SHEET 2 OF 2

PCN HSH PMT	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		TIME REQUIRED		EQUIPMENT		DATA SOURCE COMMENTS
						%	HRS.	QTY.	SKILL CODE/ LEVEL	QTY.	%	HRS.	QTY.	
050	MSP CAM		MACH	.80	TRANSIT	-	-	-	-	-	-	-	-	PERFORM MILLING OPERATION - CUT BRUSHING INAW SPECIFICATIONS, (1.116, 2.119, 3.022), (1.116, 2.119, 3.022), (1.116, 2.119, 3.022) MACHINES CAN BE USED)
060	"	"	MACH	.80	TRANSIT	-	-	-	-	-	-	-	-	SHEAR PIN SETTING ON MILLING MACHINE
070	"	"	MOVE	1.0	TRANSIT	-	-	-	-	-	-	-	-	MOVE PART TO FINISHED PAPER TRAY FOR MATING TO PICK-UP. PART WILL BE MILLED
9999	"	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	-	
					PROCESS									

"IN" DATES PROFILE

NAME: SUE/LA BATES ALC: OC DATE: 5/26/89 RCC: NAJPLCM SHEET 1 OF 1

PCHI PUSH PILL	PATIENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88280	88281	88281	1
2	88280	88281	88281	1
3	88293	88294	88294	1
4	88293	88294	88294	1
5	88293	88294	88294	1
6	88350	88351	88351	1
				MEDION: 1

SELL "OUT" DATES PROFILE

NAME SUEKA BUIEJ ALC DC DATE 5/26/89 RCC MAJPCA SHEET 1 OF 1

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING/SELL DATE)	4 TIME (DAYS)
1	88282	88282	0
2	88282	88282	0
3	88295	88295	0
4	88295	88295	0
5	88298	88298	0
6	88354	88354	0
			Remain = 0

FLOW PROCESS CHART

SUBJECT

DATE 5/18/89

ITEM CODE
PCN
NMN
P/N

38718 A

WCD CAEMO2

WCD DATE 88239

CHART BEGINS 030

CHART ENDS 145

PREPARED BY R HAERIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
030	030	○▷▷▷□▽	MACH LIDS			○▷▷▷□▽	
040	040/052	○▷▷▷□▽	MOVE TO -CA			○▷▷▷□▽	
060	060	○▷▷▷□▽	MACH RINSING EXE			○▷▷▷□▽	
145	145	○▷▷▷□▽	MACH CUP			○▷▷▷□▽	
146	-	○▷▷▷□▽	MOVE TO P/U			○▷▷▷□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME Randy N. Harris ALC OC DATE 5/16/89 RCC No TRCM SHEET 1 OF 2

PCH NSN PHI	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW % HRS.	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS				
							SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED % HRS.		
00		MATP CA	IN DATE	1.0	TRANSIT SETUP PROCESS	24	-	-	-	-	-				
030		MATP CM	MACH	1.0	TRANSIT SETUP PROCESS	-	AJ09	1	.33	.25	OC2816	1	.33	.25	CAN USE 4 POSSIBLE AILING MACHINES (OC2816, OC2817, OC3109, OC3327)
040 (040 050)		MATP CA	PRX	1.0	TRANSIT SETUP PROCESS	24	-	-	-	-	-	-	-	-	PART NEEDED TO - CA FARR DISASSEMBLY OPS 040 & 050 OF WCD PINE HERE
060		MATP CM	MACH	1.0	TRANSIT SETUP PROCESS	-	AJ09	1	.33	.25	OC2816	1	.33	.25	STATE COMMENTS AS IN OP 030
070 - 080		MATP IN			TRANSIT SETUP PROCESS	24	-	-	-	-	-	-	-	-	

WCD CAE002 ✓ WCD DATE 88239

OPERATION PROFILE

NAME _____ ALC OC DATE _____ RCC _____ SHEET 2 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		TIME REQUIRED		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	SKILL CODE/LEVEL	%	HRS.	QTY.	EQUIPMENT CODE		%	HRS.
					WCD	WCD DATE	WCD	WCD DATE	WCD	WCD DATE	WCD	WCD DATE			
090-140	MATA CA			TRANSIT SETUP PROCESS											
145	MATP CM	MEN	1.0	TRANSIT SETUP PROCESS		.50							NHT CUT ON ENGINE LATHIE ALL LATHIES WOULD BE USED		
146	"	MOVE	1.0	TRANSIT SETUP PROCESS			AJ09			.02			ADVE MADE TO FINISHED PADS RPT FIR - CA PICA JP		
9999	"	OUT DATE	1.0	TRANSIT SETUP PROCESS											
				TRANSIT SETUP PROCESS											

"IN" DATES PROFILE

NAME SHIELA BATE ALC QC DATE 5/26/87 RCC INTPCM SHEET 1 OF 1

PCN 38718A PARENT WCD DATE _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"H" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88277	88278	1
2	88298	88299	1
3	88312	88314	2
4	88322	88324	2
5	89003	89004	1
6	89019	89020	1
7	89048	89049	1
8	89097	89098	1
9	89102	89104	2
10	89139	89141	2

NOTE: "H" DATE IS THE DATE THAT SCHEDULING ERRORS III BLOCK 5 OF WCD OR DATE

"OUT" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/87 RCC NITROM SHEET 1 OF 1

PGH 38710A PARENT WCD PARENT WCD DATE

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULED SELL DATE)	Δ TIME (DAYS)
1	88281	88281	0
2	88201	88301	0
3	88318	88318	0
4	88327	88228	1
5	89007	89007	0
6	89024	89024	0
7	89051	89052	1
8	89101	89101	0
9	89107	89107	0
10	89144	89145	1
			MEDIAN: 1

FLOW PROCESS CHART

SUBJECT _____ DATE 5/18/89

ITEM CODE
PCN
NOM.
P/N

MC 49779A
□
□

WCD CDE435 WCD DATE 88/83

CHART BEGINS 065

CHART ENDS 100

PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
065	-	○	REMOVE UNIL			○	
070	070	○	WIE TO -CB, INSP			○	
080	080	○	MACH COWAL SEAT			○	
090	090	○	MACH SEALING SURFACE			○	
100	100	○	ZEP HEAD CLEANING			○	
		○				○	
		○				○	
		○				○	
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○ OPERATION ▽ STORAGE
 ◊ TRANSPORTATION D DELAY □ INSPECTION

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MATPCM SHEET 1 OF 2

PCN ASH PVI	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHIBITORS		MANIPULATOR		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
						%	HRS.	QTY.	SKILL CODE/ LEVEL	QTY.	%	HRS.	%	
00		MATP CD	IN DATE	1.0	TRANSIT SETUP PROCESS									
065		MATP CM	REM	1.0	TRANSIT SETUP PROCESS		24							WHEN MATPCM FIRST RECEIVES THE NOZZLE AND SUPPORT ASSY, THE OPERATOR WILL REMOVE THE CONNECTING LINE AND THEN ROUTE THE NOZZLE TO MATPCM
070		MATP CB	INSP	1.0	TRANSIT SETUP PROCESS				AT09					AFTER THE NOZZLE IS INSPECTED, IT IS REINJECTED TO MATPCM
080		MATP CM	MACH	1.0	TRANSIT SETUP PROCESS		48							THE ONE-NEAR SETUP OCCURS ONCE NEAR 50 PARTS AS AN AVERAGE,
090		11	MACH	1.0	TRANSIT SETUP PROCESS				AT09					C/N 49779A IS DONE ON THE GENERATOR (OC1166)

THIS OPERA-
TION IS NOT
CALLED OUT
ON THE
WCD.

WCD COEY38 WCD DATE 88/83

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE _____ WCD _____ WCD DATE _____

PCH _____ NSN _____ PHL 49999A RCC NATPCM SHEET 2 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.	
100	NATD	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	PART INSPECTED AND PLACED ON FINISHED PARTS TRAY FOR PICK-UP BY - CB
				SETUP		-	-	-	-	-	-	
				PROCESS		09	1	08	-	-	-	
9999	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	
				SETUP		-	-	-	-	-	-	
				PROCESS		-	-	-	-	-	-	
				TRANSIT	-	-	-	-	-	-	-	
				SETUP		-	-	-	-	-	-	
				PROCESS		-	-	-	-	-	-	
				TRANSIT	-	-	-	-	-	-	-	
				SETUP		-	-	-	-	-	-	
				PROCESS		-	-	-	-	-	-	
				TRANSIT	-	-	-	-	-	-	-	
				SETUP		-	-	-	-	-	-	
				PROCESS		-	-	-	-	-	-	

SELL
"OUT" DATES PROFILE

NAME SHIELLA BATES ALC OS DATE 5/26/89 RCC MATRCM SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	PARENT WCD DATE	Δ TIME (DAYS)
49779A					
1		88285	88285		0
2		88285	88285		0
3		88319	88319		0
4		88319	88319		0
5		89009	89009		0
6		89009	89009		0
					MEDIN 0

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

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE

WCD CBE401A

WCD DATE 89088

PCH
NRM.
PM

47806
 47808, 47810

CHART BEGINS 700

CHART ENDS 205

PREPARED BY R. HARLI

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
100	100	○▷▷▷▽	MACH BODY			○▷▷▷▽	
110	110	○▷▷▷▽	INSTALL SLEEVE			○▷▷▷▽	
120	120	○▷▷▷▽	INSID LVGS			○▷▷▷▽	
140	140-170	○▷▷▷▽	MOVE TO SW			○▷▷▷▽	
180	180	○▷▷▷▽	MACH LVGS			○▷▷▷▽	
190	190	○▷▷▷▽	MOVE TO SW			○▷▷▷▽	
195	195	○▷▷▷▽	MACH AND SD PART			○▷▷▷▽	
197	197	○▷▷▷▽	MOVE TO SW			○▷▷▷▽	
200	200, 210	○▷▷▷▽	MACH FLANGE			○▷▷▷▽	
215	215	○▷▷▷▽	MOVE TO MATPCB			○▷▷▷▽	
"	220	○▷▷▷▽	7			○▷▷▷▽	
"	221	○▷▷▷▽				○▷▷▷▽	
"	223	○▷▷▷▽				○▷▷▷▽	
"	224	○▷▷▷▽				○▷▷▷▽	
227	227	○▷▷▷▽ ○▷▷▷▽	DRILL HOLES			○▷▷▷▽ ○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION . . . OFILE

NAME RANDY WATERS ALC. OC DATE 5/12/89 RCC MATPCA SHEET 1 OF 3

PCH OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
00	MATP CB	IN DATE	1.0	TRANSIT							
100	MATP CA	REP	.25	TRANSIT		96					
				SETUP							
				PROCESS							
110	"	ASSY	.60	TRANSIT							
				SETUP							
				PROCESS							
120	"	INSP	1.0	TRANSIT							
				SETUP							
				PROCESS							
140	MATP IW	PROC	1.0	TRANSIT							
				SETUP							
				PROCESS							
(140- 150)				TRANSIT		6					
				SETUP							
				PROCESS							

THE SET-UP
IS REVIEWED
ONLY 0070
OF THE TIME.

OP 100 DEPENDS
WHEN OPD OF
WCD.

MUST ALSO CHECK
P-READS, SHOULD
BE INCLUDED ON
WCD. THESE
WILL BE
MAY BE
MAYBE

MAKE AMPLIFY
TO VERIFY UNIT
(CRIP 2M)
OPS 140-170
TAKE MAKE IN
FW

OPERATION PROFILE

NAME RANDY HARRIS ALC QC DATE 5/12/87 RCC HMPCM SHEET 2 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	SKILL CODE/LEVEL	%	HRS.	QTY.	EQUIPMENT CODE	%		HRS.	
180	MATD CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-	-	-	-		
				SETUP	-	AJ09	1	.08	0C4724	1	.08					
				PROCESS	-	AJ09	1	.05	XC4729	1	.05					
190	MATD EW	PROC	1.9	TRANSIT	-	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	-	-
195	MATD CM	MACH	.40	TRANSIT	-	-	-	-	-	-	-	-	-	-		
				SETUP	-	AJ09	1	.17	0C4737	1	.17					
				PROCESS	-	AJ09	1	.33	0C4739	1	.33					
199	MATD EW	PROC	.02	TRANSIT	-	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	-	-
200 (200) (210)	MATD CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-		
				SETUP	-	AJ09	1	.08	0C1192	1	.08					
				PROCESS	-	AJ09	1	.17	0C1192	1	.17					

THE DISTINGUISHING THE
TO 100
MATERIAL
THE A C/N
TAKES ONLY
1 MINUTE.
TO IS P
MANUFACT

OPS 200 & 210
OF THE WCD,
OP 210 ONLY
TAKES 1 MINUTE
AND IS INCLUDED
WITH THE TIME

OPERATION...OFFILE

NAME LEARDI HARRELS ALC α DATE 5/12/89 RCC MATPCM SHEET 3 OF 3

PCN NSN PRI	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						%	HRS.	QTY.	%	HRS.	QTY.	%	HRS.	
49807	215	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	MOVE TO MATPCB FOR PROCESSING OPERATIONS
49807	227	MATP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	-	DRILL OUT SUGAR INLET, THIS IS THE LAST OPERATION FOR MATPCM.
9999	11	11	OUT DATE	1.0	TRANSIT	-	-	1	-	-	-	-	-	
					SETUP									
					PROCESS									
					TRANSIT									
					SETUP									
					PROCESS									
					TRANSIT									
					SETUP									
					PROCESS									
					TRANSIT									
					SETUP									
					PROCESS									

5678A

SUBJECT J57 MANIFOLDS FLOW PROCESS CHART DATE 4/21/89

ITEM CODE WCD CBE401 WCD DATE 89088
 PCN 49802A, 49806A, 49808A, 49810A
 NBN
 PIN MAT PCB

CHART BEGINS _____ CHART ENDS _____ PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●○○□▽	RECEIVE MANIFOLDS IN BAG 3123	340	340	●○○□▽	CAP NOZZLES AND INLET FLANGE
011		●○○□▽	LINE UP MANIFOLDS (NOISE RESONANCE)	350A	350	○●○○□▽	MOVE TO TEST IN BAG 3108
012		○●○○□▽	MOVE MANIFOLDS TO BAG 3001 (H/S) 350B	350B	350	○●○○□▽	DELAY FOR TESTING IAW CBT401
013		●○○□▽	UNLOAD; STAGE ON SHIP FLOOR	350C	350	○●○○□▽	RETURN FROM TEST TO BAG 3001 O/H
014		●○○□▽	REMOVE MANIFOLD FROM SHIPPING COARDS	355		●○○□▽	REMOVE MANIFOLD FROM METAL SHIP EXTN
015		●○○□▽	REMOVE NOZZLE BUST CAPS; OIL NOZZLES	360A	360	○●○○□▽	DISTRIBUTION/INSPECT CHECK INSPECT FLANGE, ETC.
016		○●○○□▽	WAIT 1-10 HRS FOR OIL TO LOOSEN NOZZLES	360B	360	●○○□▽	COLD BEND MANIFOLD IF WARMED
020	020	●○○□▽	REMOVE NOZZLE (EA) ON MANIFOLD CLUST.	365	365	○●○○□▽	VISUALLY INSPECT NEXT SWEELS (WELDS FOR CRACKS
021		●○○□▽	REMOVE TABS AND SEAL FROM NOZZLES	368	368	●○○□▽	SEND TO WELDING FOR GRIND ROUND, IF NEEDED
022		●○○□▽	REPAIR NOZZLES; PLACE IN SHIP TANKS	369		○●○○□▽	
030		○●○○□▽	VISUALLY INSPECT MANIFOLD IDENTIFY	370	370	●○○□▽	CAP PORTS; SECURE BOLTS TO FRAME ETC.
050	050	●○○□▽	MEASURE INLET FLANGE THICKNESS DIMENSION	375		●○○□▽	REMOVE MANIFOLD FROM SHIPPING BAG
065	065	●○○□▽	DRILL & RESS HOLES IN CLUSTER BUNNY TUBES	380	380	●○○□▽	COMPLETE PROCESS (PRELIMINARY, IAW 344)
070		●○○□▽	INSTALL BUSHINGS IN HEAD; NOZZLE PORTS	390	390	●○○□▽	TAG MANIFOLD STRAIN PAPER/LOG
080	070	●○○□▽	CLEAN MANIFOLD AND T.B.	400	400	●○○□▽	COMPLETE IAW 344 (SEE 070)
090		●○○□▽	REMOVE BUST CAPS FROM NOZZLES; INSPECT; ITANK			○●○○□▽	
100		○●○○□▽	DRAG MANIFOLD TO BAY - MAIN B HAS			○●○○□▽	
150		●○○□▽	TRANSFER FROM MACHINE 5 AND P			○●○○□▽	
220	220	○●○○□▽	REMOVE MANIFOLD FROM DISTRIBUTION/SHIPPING AREA			○●○○□▽	
221	220	●○○□▽	COLD BEND MANIFOLD IF NEEDED			○●○○□▽	
222		○●○○□▽	INSPECT BUST CAPS; SWEELS FOR CRACKS			○●○○□▽	
	221	○●○○□▽	INSPECT FOR NOZZLE CLUSTER DISTRIBUTION			○●○○□▽	
		●○○□▽	ALIGN MANIFOLD STAGE			○●○○□▽	
	223	●○○□▽	IF PERMANENT MANIFOLD TO REMOVE BUST; LOCATING			○●○○□▽	
	223	●○○□▽	REPLACE BUST/BUSHING COMBUSTION CHAMBER IS			○●○○□▽	
250		●○○□▽	REMOVE MANIFOLD ON METAL SHIP EXTN; INSPECT			○●○○□▽	
260		●○○□▽	REGRIND MACHINE AND MELTING SHIPS			○●○○□▽	
290	290	●○○□▽	INSERT NOZZLE BUST CAPS; TIGHTEN; LAP SH			○●○○□▽	
300	300	●○○□▽	FLUSH MANIFOLD W/ PU-680			○●○○□▽	
305	290	○●○○□▽	MEASURE NOZZLE COR DEPTH DIMENSION			○●○○□▽	
310	310	●○○□▽	GRIND & INSTALL CORAL NOZZLES; SMOOTH THROATS			○●○○□▽	
330	330	○●○○□▽	INSPECT & DOCUMENT IN SHIP OR MANIFOLD			○●○○□▽	

B/S

B/S

B/S

○ OPERATION ▽ STORAGE □ INSPECTION
 ◊ TRANSPORTATION D DELAY

* INCLUDES WCD OPERATION 320
 NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE INCLUDED IN OPERATIONS.

LSC-20147

"IN" DATES PROFILE

NAME SHELLA DATES ALC OC DATE 5/26/89 RCC MIPCM SHEET 1 OF 1

PCN	OSERVATION NUMBER	PARENT WCD	"M" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
	1		88277	88279	2
	2		88282	88285	3
	3		88288	88292	4
	4		88294	88299	5
	5		88298	88300	2
	6		88308	88312	4
	7		89019	89023	4
	8		89024	89027	3
	9		89040	89044	4
	10		89047	89052	5
					4

"OUT" DATES PROFILE

NAME SHEILA DATES ALC OC DATE 5/26/89 RCC MAIPCM SHEET 1 OF 1

PCI 49802A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	78280	88280	0
2	88285	88286	1
3	88292	88292	0
4	88300	88300	0
5	88302	88302	1
6	88312	88313	1
7	89023	89023	0
8	89030	89031	1
9	89045	89045	0
10	89053	89054	1

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

OPERATION: FILE

NAME RANDY WARRIS ALC OC DATE 5/12/89 RCC MATPCN SHEET 1 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS									
						SKILL CODE/LEVEL	QTY.	%	HRS.		EQUIPMENT CODE	QTY.	%	HRS.					
00	MATP CB	IN DATE	1.0	TRANSIT	48	-	-	-	-	-	-	-	-	-	-	-	-	-	-
100	MATP CA	REP	.25	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	-	OP 100 DEPENDS UPON OP 00 OF WCD.
110	"	ASSY	.60	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	-	MUST ALSO CHECK FURBERS, SHOWN BE INCLUDED ON WCD. FURBER WHICH WOULD BE MADE FOR OP 110 HUBBELL
120	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	-	THE SET UP IS CLASSIFIED ONLY OPS OF THE TIME
140	MATP JW	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	-	MNE MATP 140 TO VERIFY UNIT (MATP 140) OPS 140-170 TAKE PLACE IN JW
(140-170)				TRANSIT	6	-	-	-	-	-	-	-	-	-	-	-	-	-	

THE SET UP IS CLASSIFIED ONLY OPS OF THE TIME

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE WCD CBE 4018 WCD DATE 89088
 PCK 49802, ~~49801~~
 N&N
 PIN 49808, 49810

CHART BEGINS 100

CHART ENDS 205

PREPARED BY R. HIGGINS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
100	100	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MACH BODY			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
110	110	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSTALL SLEEVE			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
120	120	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSO LVGS			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
140	140-170	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MOVE TO IW			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
180	180	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MACH LVGS			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
190	190	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MOVE TO IW			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
195	195	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MACH AND ID PART			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
197	197	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MOVE TO IW			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
200	200, 210	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MACH FLANGE			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
215	215	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MOVE TO MATPCD			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	220	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	7			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
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227	227	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	DRILL HOLES			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
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		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	

OPERATION STORAGE INSPECTION
 TRANSPORTATION DELAY

OPERATION: FILE

NAME KUNNY HARRIS ALC OC DATE 5/12/87 RCC MLTPCM SHEET 2 OF 3

PCH 49808 WCD CBE40/B WCD DATE 87088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
							QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %		
180	MATP CM	MACH	.80	TRANSIT	-	-	-	-	-	-		
				SETUP	-	AJ09	1	.08	0C4924	1	.08	
				PROCESS	-	AJ09	1	.05	0C4924	1	.05	
190	MATP EW	PROC	1.9	TRANSIT	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-		
				PROCESS	1	-	-	-	-	-		
195	MATP CM	MACH	.40	TRANSIT	-	-	-	-	-	-	THE DISTANCE IS THE	
				SETUP	-	AJ09	1	.17	0C4939	1	.17	IDENTIFICATION
				PROCESS	-	AJ09	1	.33	0C4939	1	.33	BETWEEN C/N
				TRANSIT	-	-	-	-	-	-	-	49808, 49809,
				SETUP	-	-	-	-	-	-	-	49806, AND 49802
				PROCESS	-	-	-	-	-	-	-	OCCURS HERE.
197	MATP EW	PROC	.02	TRANSIT	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	
				PROCESS	.75	-	-	-	-	-	-	
200	MATP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	OPS 200 & 210
				SETUP	-	AJ09	1	.08	0C1192	1	.08	OF THE WCD,
				PROCESS	-	AJ09	1	.17	0C1192	1	.17	OP 210 ONLY
				PROCESS	-	-	-	-	-	-	-	TAKES 1 MINUTE
				PROCESS	-	-	-	-	-	-	-	AND IS INCLUDED
				PROCESS	-	-	-	-	-	-	-	WITH THE TIME

THE DISTANCE IS THE
TO THE
HORIZONTAL
MEASUREMENT
TAKES 1 MINUTE
TO BE
MANIPULATED

OPERATION FILE

NAME RANDY HARRIS ALC α DATE 5/12/89 RCC MATPCM SHEET 3 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL		MAIPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	%	HRS.			
215	MATP CB	PRAC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	MUVE TO MATPCB FOR PROCESSING OPERATIONS
227	MATP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	BRILL OUT SUGONE HOURS. THIS IS THE LAST OPERATION FOR MATPCM.
9999	"	OUT DATE	1.0	TRANSIT	-	-	AJ09	-	-	-	-	-	-	-	
				SETUP	-	-	AJ09	1	.08	AF800596	1	.08			
				PROCESS	-	-	AJ09	1	.08	AF800596	1	.08			
				PROCESS	0										
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

42808 19810 98042, 98043

"IN" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 OCC MTPCOM SHEET 1 OF 1

PCH RSH PHI	PARENT WCD	"M" DATE (SCHEDULED DATE)	PARENT WCD DATE	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88277			88279	2
2	88282			88285	3
3	88287			88289	2
4	88293			88295	2
5	88299			88301	2
6	88308			88312	4
7	88314			88319	5
8	89018			89020	2
9	89024			89026	2
10	89030			89033	3
					MEDIAN: 2

NOTE: "M" DATE IS THE DATE THAT SCHEDULING EDITORS III BLOCK 5 OF WCD OR DATE

"OUT" DATES PROFILE

NAME SHELDON BATES ALC OC DATE 5/26/89 RCC WIPCM SHEET 1 OF 1
 PCI 49806A PATIENT WCD _____ PATIENT WCD DATE _____
 OBSERVATION NUMBER LAST OPERATION (COMPLETION DATE) "OUT" DATE (SCHEDULING SELL DATE) A TIME (DAYS)

1	88280	88280	0
2	88286	88286	0
3	88290	88290	0
4	88295	88296	1
5	88302	88305	3
6	88312	88312	0
7	88320	88321	1
8	89020	89020	0
9	89026	89027	1
10	89034	89034	0
			MEDIAN: 0

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

LSC-20108A

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE
PCH
NOM.
P/N

WCD CBE 401C

WCD DATE 89088

49802 49806
 ~~49802~~ 49810

CHART BEGINS _____

100

CHART ENDS _____

205

PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
100	100	□◇◇□▽	MACH BODY			○◇◇□▽	
110	110	□◇◇□▽	INSTALL STEEVE			○◇◇□▽	
120	120	○◇◇□▽	END LV65			○◇◇□▽	
140	140-170	○◇◇□▽	MIVE TO SW			○◇◇□▽	
180	180	○◇◇□▽	MACH LV65			○◇◇□▽	
190	190	○◇◇□▽	MIVE TO SW			○◇◇□▽	
195	195	○◇◇□▽	MACH AND IO PART			○◇◇□▽	
197	197	○◇◇□▽	MIVE TO SW			○◇◇□▽	
200	200, 210	○◇◇□▽	MACH FLANGE			○◇◇□▽	
215	215	○◇◇□▽	MIVE TO MTRCD			○◇◇□▽	
"	220	○◇◇□▽	}			○◇◇□▽	
"	221	○◇◇□▽				○◇◇□▽	
"	223	○◇◇□▽				○◇◇□▽	
"	224	○◇◇□▽				○◇◇□▽	
227	227	○◇◇□▽ ○◇◇□▽	DRILL HOLES			○◇◇□▽ ○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
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		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	

○ OPERATION ◇ TRANSPORTATION ▽ STORAGE □ INSPECTION
 ◇ TRANSPORTATION D DELAY

OPERATION FILE

NAME RANDY HARRIS ALC OC DATE 5/12/89 RCC NAIPGM SHEET 1 OF 3

PCH ERRAND, F110, F1806, F9802 WCD CBE901C WCD DATE 8/088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
00	MATP CB	IN DATE	1.0	TRANSIT							
				SETUP							
				PROCESS							
100	MATP CA	REP	.25	TRANSIT		96					OP 100 DETERMINED FROM QTY OF WCD.
				SETUP							
				PROCESS							
110	"	ASSY	.60	TRANSIT							MUST ALSO CIRC FABRICATION, SHOWN BE INCLUDED ON WCD - THREAD CHECK SHOULD BE MADE FOR THE MATERIAL
				SETUP							
				PROCESS							
120	"	INSP	1.0	TRANSIT							
				SETUP							
				PROCESS							
140 (140- 140)	MATP IW	PROC	1.0	TRANSIT							MATERIAL IN USE (MATERIAL) OPS 140-170 TAKE PLACE IN SW
				SETUP							
				PROCESS							

THE SET
IS REQUIRED
ONLY 00%
OF THE TIME

OPERATION: JFILE

NAME: RANDY HARRIS ALC: OC DATE: 5/12/87 RCC: WIP/CM SHEET: 2 OF 3

PCN: 1980 WCD: CBE40/C WCD DATE: 87088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	QTY.		%	HRS.
180	MATP CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	1	.08	OC4724	1	.02		
				PROCESS	-	-	1	.05	OC4724	1	.05		
190	MATP EW	PROC	1.9	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	
195	MATP CM	MACH	.40	TRANSIT	-	-	-	-	-	-	-	THE UNIT WAS IDENTIFIED BY THE NEW CM 49808, 49809, 49806, AND 49802 OCCURS HERE.	
				SETUP	-	-	1	.17	OC4737	1	.17		
				PROCESS	-	-	1	.33	OC4737	1	.33		
197	MATP EW	PROC	.02	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	.75	-	-	-	-	
200 (200) (210)	MATP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	OPS 200 & 210 OF THE WCD, OP 210 ONLY TAKES 1 MINUTE AND IS ENCLOSED WITH THE TIME	
				SETUP	-	-	1	.08	OC1192	1	.08		
				PROCESS	-	-	1	.17	OC1192	1	.17		

THE UNIT WAS IDENTIFIED BY THE NEW CM 49808, 49809, 49806, AND 49802 OCCURS HERE.

OPERATION; FILE

NAME RANDY HARRIS ALC AL DATE 5/12/89 RCC MATPCM SHEET 3 OF 3

PCN _____ WCD CBE401C WCD DATE 89088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE	%	HRS.	
215	MHTP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	MOVE TO MATPCB FOR PROCESSING OPERATIONS
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	50	-	-	-	-	-	-	
227	MHTP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	-	DRILL OUT SINGNE INDEX, THIS IS THE LAST OPERATION FOR MATPCM.
				SETUP	-	-	AJ09	1	AF800596	.08	.08		
				PROCESS	-	-	AJ09	1	AF800596	.08	.08		
9999	11	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-		
				PROCESS	-	24	-	-	-	-	-		
				TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-		
				PROCESS	-	-	-	-	-	-	-		

"IN" DAT. PROFILE

NAME SUELLA BATES ALC OC DATE 5/26/89 RCC MIPCM SHEET 1 OF 1

PCN _____ PARENT WCD _____ PARENT WCD DATE _____
 HSN 49808A PIN _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88277	88279	2
2	88281	88285	4
3	88294	88299	5
4	88295	88300	5
5	88299	88302	3
6	88322	88326	4
7	88364	89003	4
8	89018	89020	2
9	89029	89027	3
10	89031	89034	3
			MEDIAN: 4

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

SELL
"OUT" DATES PROFILE

NAME SHELCO DATES ALC 05 DATE 5/26/89 RCC MATPCOM SHEET 1 OF 1

PCN _____ PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	88279	88279	0
2	88285	88286	1
3	88300	88300	0
4	88301	88302	1
5	88305	88305	0
6	88327	88328	1
7	89004	89005	1
8	89023	89023	0
9	89024	89030	3
10	89034	89034	0
			MEAN 1

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

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE
 PCN 49802, 49806
 M/M
 P/N 49808, 49810

WCD CBE 4010

WCD DATE 89088

CHART BEGINS -100

CHART ENDS 205

PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
100	100	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MACH BODY			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
110	110	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	INSTALL SLEEVE			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
120	120	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	INS. LVGS			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
140	140-170	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MOVE TO IW			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
180	180	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MACH LVGS			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
190	190	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MOVE TO IW			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
195	195	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MACH AND TO PART			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
197	197	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MOVE TO IW			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
200	200, 210	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MACH FLANGE			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
215	215	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	MOVE TO MATCOB			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
"	220	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	}			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
"	221	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
"	223	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
"	224	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
227	227	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	DRILL HOLES			<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
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		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
		<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	

OPERATION STORAGE INSPECTION
 TRANSPORTATION DELAY

OPERATION FILE

NAME RANDY WARRIS ALC OC DATE 5/12/89 RCC MATP CM SHEET 1 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENT
					%	HRS.	QTY.	%	HRS.	QTY.	
00	MATP CB	IN DATE	1.0	TRANSIT							
				SETUP							
				PROCESS							
100	MATP CM	REP	.25	TRANSIT		72					OP 100 NECESSARY UPON OPD OF WCD.
				SETUP							
				PROCESS							
110	"	ASSY	.60	TRANSIT							MUST ALSO CHECK PLACARDS, SHOULD BE INCLUDED ON WCD. THROUGH TIME WILL BE TAKEN
				SETUP							
				PROCESS							
120	"	INSP	1.0	TRANSIT							
				SETUP							
				PROCESS							
140	MATP IW	PROC	1.0	TRANSIT							MATP MATP FOR WELDING UNIT (NOT IN)
(140-149)				SETUP							OP 140-149 TAKE PLACE IN IW
				PROCESS		6					

THE SET IS REQUIRED ONLY ON THE TIME OF THE TIME

OPERATION FILE

NAME RANDY HARRIS ALC OC DATE 5/12/87 RCC MTPCM SHEET 2 OF 3

PCN NSN 49808 WCD CBE40/D WCD DATE 87088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	QTY.		%	HRS.
180	MATP CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	1	.08	0C4924	1	.08		
				PROCESS	-	-	1	.05	0C4924	1	.05		
190	MATP EW	PROC	1.0	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	
195	MATP CM	MACH	.40	TRANSIT	-	-	-	-	-	-	-	TRUE UTILIZATION.	
				SETUP	-	-	1	.17	0C4937	1	.17	IDENTIFICATION BETWEEN C/N 49808, 49809, 49806, AND 49802 OCCURS HERE.	
				PROCESS	-	-	1	.33	0C4937	1	.33		
197	MATP EW	PROC	.02	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	.75	-	-	-	-	-	-	
200 (211) (212)	MATP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	OPS 200 & 210 OF TALE WCD.	
				SETUP	-	-	1	.08	0C192	1	.08	OP 210 ONLY TAKES 1 MINUTE AND IS ENCLOSED WITH THE TALE	
				PROCESS	-	-	1	.17	0C192	1	.17		

THE
TO AND
NUMBER
ON A C/N
LINES IN
1 MINUTE
TO THE
MANUFACTURED

OPERATION FILE

NAME RANDI HARLES ALC OK DATE 5/12/89 RCC MATPCM SHEET 3 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SHELL CODE/ LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	QTY.	
215	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	MOVE TO MATPCB FOR PROCESSING OPERATIONS
227	MATP CM	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	BRILL OUT SUGAR MILK. THIS IS THE LAST OPERATION FOR MATPCM.
9977	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

WCD CBE401D WCD DATE 89088

MANDATORY FLOW HOURS

TIME REQUIRED

EQUIPMENT

DATA SOURCE COMMENTS

OPERATION TYPE

MANDATORY OCCURRENCE FACTOR

RCC

OPERATION DESCRIPTION

OPERATION NUMBER

NAME

DATE

RCC

SHEET

OF

OPERATION FILE

"IN" DAT. PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MTPCM SHEET 1 OF 1

PCN NSN PIN	OBSERVATION NUMBER	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
	1	88279	88279	88281	2
	2	88285	88285	88287	2
	3	88294	88294	88299	5
	4	88298	88298	88301	3
	5	88308	88308	88312	4
	6	88347	88347	88350	3
	7	89018	89018	89023	5
	8	89034	89034	89040	6
	9	89045	89045	89047	2
	10	89061	89061	89063	2
					MEDIAN: 3

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

SELL
"OUT" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MAIPCM SHEET 1 OF 1

PCN NSN PIN	OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
	1	88281	88285	4
	2	88288	88288	0
	3	88299	88300	1
	4	88302	88302	0
	5	88313	88313	0
	6	88350	88351	1
	7	89024	89025	1
	8	89044	89045	1
	9	89048	89048	0
	10	89063	89064	1

REVISION: 1

NOTE: "OUT" DATE IS THE DATE CONTAINED IN THE PROFILE

FLOW PROCESS CHART

SUBJECT _____ DATE 5/13/89

ITEM CODE
PCN
NSN
PIN
 50067A

WCD CMEM02 WCD DATE 88180

CHART BEGINS 010

CHART ENDS 130

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	O D D □ ∇	RECEIVE PART			O D D □ ∇	
020	120	O D D □ ∇	REMOVE SPRAY END			O D D □ ∇	
030	030	O D D □ ∇	REMOVE NOZZLE			O D D □ ∇	
040	040	O D D □ ∇	INSPECT END TRENCH			O D D □ ∇	
050	050, 060, 070	O D D □ ∇	MOVE TO MATP IN			O D D □ ∇	
080	080(A)	O D D □ ∇	MACHINING OPERATION			O D D □ ∇	
085	080(B)	O D D □ ∇	DRILL HOLES NECESSARY			O D D □ ∇	
090	090	O D D □ ∇	MOVE TO MATPCS			O D D □ ∇	
100	100	O D D □ ∇	REP (SAND PLANE)			O D D □ ∇	
110	110	O D D □ ∇	REP (DRILL)			O D D □ ∇	
120	120	O D D □ ∇	ASSY			O D D □ ∇	
130	130, 140	O D D □ ∇	PW			O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	
		O D D □ ∇				O D D □ ∇	

○ OPERATION ∇ STORAGE □ INSPECTION
 ◊ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME RANDY H. HARRIS ALC OC DATE 5/12/89 RCC WJTKA WCD DATE 88161 SHEET 1 OF 3

PCN NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA COMMENTS
						%	HRS.	QTY.	%	HRS.	QTY.	
09		MTP CB	IN DATE	1.0	TRANSIT							
					SETUP							
					PROCESS							
010		MTP CM	REC	1.0	TRANSIT							RECEIVE PART FROM INCOMING WAKE BERTS AND RETURN TO WORK AREA
					SETUP							
					PROCESS			1				
020		"	MACH	1.0	TRANSIT							4 POSSIBLE MATERIALS AVAILABLE AT 2:00 PM DURING COLLECTOR DURATION 25% TO 40% OF TOTAL TIME
					SETUP			1	.03	.25	0C5359	.25
					PROCESS			1		.17	0C5359	.17
030		"	REN	1.0	TRANSIT							REMOVE SARVICE AMJ STAKE FROM TOP END
					SETUP							
					PROCESS			1		.01		
040		"	INSP	1.0	TRANSIT							INSPECT SURVIVAL USING SNAP GAGE
					SETUP							
					PROCESS			1		.01		

Focus
STORY.
DIGITAL
REPAIR
ON GAGE
TYPING

OPERATION FILE

NAME ALC DATE 5/12/89 RCC MATPCN SHEET 2 OF 3

PCN NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
						%	HRS.	QTY.	SKILL CODE/ LEVEL	QTY.	EQUIPMENT CODE	%	HRS.	
050		ANTP JEW	PROC	.05	TRANSIT	-	-	-	-	-	-	-	-	MINE TO WELD AS NECESSARY (TAKE HOUSING MAIN PART) FR TRACE & CE NOT MET
080		ANTP CM	MACH	.05	TRANSIT	-	-	-	-	-	-	-	-	OP 080 PART (A) OF WCD
085		ANTP CM	MACH	.03	TRANSIT	-	-	1	AJ09	1	0C5357	.03	.25	OP 080 PART (B) OF WCD 3 BRILL PREPES AVAILABLE (0C651, 0C652,) WHERE WILL WORK WHEN IS AVAILABLE
090		ANTP CB	PROC	.05	TRANSIT	-	-	1	AJ09	1	0C6521	.03	.19	FPI DONE ONLY IF OPS 080 & 085 WERE COMPLETED, ANKO TO MACH
100		ANTP CM	REP	.005	TRANSIT	-	-	1	AJ09	1	-	-	.25	WILL SAND THE FOUNGE TO REPAIR

OPS 050,
080, AND
090 OF
THE WCD

WCD

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/12/89 RCC PAJPCM SHEET 3 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE		QTY.	TIME REQUIRED	
								%	HRS.				%	HRS.
110	AJTP CM	MACH	.50	TRANSIT	-	-	-	-	-	-	-	ROLL UP BONE FAR THE "OLD" FLANGES NEW FUELLED AND ROLLS NEEDS BY LEADIC		
120	"	ASSP	1.0	TRANSIT	-	-	-	-	-	-	-	NOT COVERS ON INLET		
130 (120 x4)	"	PW	1.0	TRANSIT	-	AJ09	1	-	01	-	-	SIGN OFF PW JIS 1300 140 ON WCD		
9999	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-			
				SETUP	-	-	-	-	-	-	-			
				PROCESS	-	AJ09	1	-	01	-	-			
				PROCESS	-	-	-	-	-	-	-			
				PROCESS	0	-	-	-	-	-	-			
				PROCESS	-	-	-	-	-	-	-			
				PROCESS	-	-	-	-	-	-	-			

"IN" DAT PROFILE

NAME JUELA BATES ALC K DATE 5/26/89 RCC WALTON SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
50067A				
1	88285	88285	88286	1
2	88285	88285	88286	1
3	88285	88285	88286	1
4	88219	88219	88320	1
5	88219	88219	88320	1
6	88219	88219	88320	1
7	88333	88333	88334	1
8	88333	88333	88334	1
9	88333	88333	88334	1
10	89010	89010	89011	1
				REPORT 1

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

SELL
"OUT" DATES PROFILE

NAME <u>SHELLA BATES</u> ALC <u>OC</u> DATE <u>5/26/89</u> RCC <u>MAIPCM</u> SHEET <u>1</u> OF <u>1</u>						
PCN NSN PIN	PARENT WCD	PARENT WCD DATE	OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
			1	88286	88286	0
			2	88286	88286	0
			3	88286	88287	1
			4	88320	88320	0
			5	88320	88320	0
			6	88320	88321	1
			7	88334	88335	1
			8	88335	88335	0
			9	88335	88336	1
			10	89012	89012	0
						MEDIAN: 0

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

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE
PCH
NRX.
FIN

WCD EAEY01A

WCD DATE 79020

00X
000

50191A

501290

CHART BEGINS 010

CHART ENDS 110

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷▷▷□▽	DIS & CLEAN PART			○▷▷▷□▽	
012	012	○▷▷▷□▽	MACH IN MATPCM			○▷▷▷□▽	
015	015	○▷▷▷□▽	INS P PART			○▷▷▷□▽	
050	050	○▷▷▷□▽	PN			○▷▷▷□▽	
060	060	○▷▷▷□▽	TEST IN MATPET			○▷▷▷□▽	
070	070	○▷▷▷□▽	}			○▷▷▷□▽	
080	080	○▷▷▷□▽				○▷▷▷□▽	
100	100	○▷▷▷□▽				○▷▷▷□▽	
110	110	○▷▷▷□▽				○▷▷▷□▽	
110	120	○▷▷▷□▽				○▷▷▷□▽	
		○▷▷▷□▽				○▷▷▷□▽	
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		○▷▷▷□▽			○▷▷▷□▽		

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION FILE

NAME RANDY HARRIS ALC OC DATE 5/24/89 RCC MATPCM SHEET 1 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
00		IN DATE	1.0	TRANSIT							
				SETUP							
				PROCESS	0						
010	MATP EA	DIS	1.0	TRANSIT							MATPEA WILL DISASSEMBLE AND CLEAN THE PART. THEY WILL MAKE THE PART TO MATPCM IF NEEDED. LANCE A.D. (LINE)
				SETUP							
				PROCESS	2						
012	MATP CM	MACH	.02	TRANSIT							PART IS ASSEMBLED AND THEN PLACED IN INSPECTION TRAY TO BE PICKED UP BY MATPEA
				SETUP							
				PROCESS							
015	MATD EA	INSP	1.0	TRANSIT							VISUAL INSPECTION OF PART. CAN QUICKLY TELL IF PART OK. TO TESTING OR IF IT CAN BE REWORKED.
				SETUP							
				PROCESS							
050	MATD EA	PW	.95	TRANSIT							
				SETUP							
				PROCESS							

OPERATION FILE

NAME EADY HARRIS ALC OC DATE _____ RCC _____ SHEET 2 OF 2

PCH _____ WCD _____ WCD DATE _____

PHI-50127A, 50191A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					%	INS.	SKILL CODE/LEVEL	QTY.	%	INS.	QTY.	%	
060	MATP ET	TEST	.95	TRANSIT	—	—	—	—	—	—	—	—	OPS 60-120 ARE DONE IN PARTS AND ARE RECORDED AT FEOW TIME HERE.
				SETUP	—	—	—	—	—	—	—	—	
				PROCESS	—	—	—	—	—	—	—	—	
090				TRANSIT	—	—	N/A	—	—	—	—		
				SETUP	—	—	N/A	—	—	—	—	—	
				PROCESS	—	—	N/A	—	—	—	—	—	
080				TRANSIT	—	—	N/A	—	—	—	—		
				SETUP	—	—	N/A	—	—	—	—	—	
				PROCESS	—	—	N/A	—	—	—	—	—	
100				TRANSIT	—	—	N/A	—	—	—	—		
				SETUP	—	—	N/A	—	—	—	—	—	
				PROCESS	—	—	N/A	—	—	—	—	—	
110				TRANSIT	—	—	N/A	—	—	—	—		
				SETUP	—	—	N/A	—	—	—	—	—	
				PROCESS	—	—	N/A	—	—	—	—	—	

9999 OUT 10

(INDUCT. D.)
"IN" DA. PROFILE

NAME <u>R Harris</u>	ALC <u>DC</u>	DATE <u>5-26-89</u>	RCC <u>MA/KUM</u>	SHEET <u>1</u> OF <u>1</u>
PCN	NSN	PIN	PARENT WCD	PARENT WCD DATE
<u>50126</u>	<u>A</u>		<u>EAET01</u>	<u>89020</u>
OBSERVATION NUMBER	"M" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)	
<u>1</u>	<u>88013</u>	<u>88013</u>	<u>0</u>	

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

SELL "OUT" DATES PROFILE

NAME RANDY HARRIS ALC OC DATE 5-26-89 RCC MATHEN SHEET 1 OF 1

PCN _____ WSN _____ PIN 501267 PARENT WCD _____ WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	88013	88013.	0

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC. LSC-20108A

FLOW PROCESS CHART

SUBJECT _____ DATE 5/18/89

ITEM CODE WCD EAEY01 WCD DATE 99020
 PCH 50126A
 NCH 5191A
 PN

CHART BEGINS 010

CHART ENDS 110 PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◇◇□▽	DIS & CLEAN PART			○◇◇□▽	
012	012	○◇◇□▽	MACH IN MATPEM			○◇◇□▽	
015	015	○◇◇□▽	INSP PART			○◇◇□▽	
050	050	○◇◇□▽	PN			○◇◇□▽	
060	060	○◇◇□▽	TEST IN MATPET			○◇◇□▽	
070	070	○◇◇□▽	}			○◇◇□▽	
080	080	○◇◇□▽				○◇◇□▽	
100	100	○◇◇□▽				○◇◇□▽	
110	110	○◇◇□▽				○◇◇□▽	
110	120	○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
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		○◇◇□▽			○◇◇□▽		
		○◇◇□▽			○◇◇□▽		
		○◇◇□▽			○◇◇□▽		
		○◇◇□▽			○◇◇□▽		
		○◇◇□▽			○◇◇□▽		
		○◇◇□▽			○◇◇□▽		

OPERATION STORAGE INSPECTION
 TRANSPORTATION DELAY

OPERATION #1 ILE

NAME RANDY HERRIS ALC OC DATE 5/24/89 RCC MATPCM SHEET 1 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHIBIT	MANIPULATOR			EQUIPMENT			DATA SOURCE COMMENTS	
						QTY.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		TIME REQUIRED		
									%	HRS.	%		HRS.
00	MATP EA	IN DATE	1.0	TRANSIT	0	-	-	-	-	-	-		
				SETUP									
				PROCESS									
010	MATP EA	DIS	1.0	TRANSIT	2	-	-	-	-	-	-	MATPEA WILL DISASSEMBLE AND CLEAN THE PART. THEY WILL MAKE THE PART TO MATPCM IF NEEDED. (ONLY ADD OF TIME)	
				SETUP									
				PROCESS									
012	MATP CAM	MACH	.02	TRANSIT	-	-	-	-	-	-	-	PART IS ACQUIRED AND THEN PLACED ON FINISHED PARTS TRAY TO BE PICKED UP BY MATPEA	
				SETUP									
				PROCESS									
015	MATP EA	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	VISUAL INSPECTION OF PART. CAN QUICKLY TELL IF PART CAN GO TO TESTING OR IF IT CAN BE REWORKED	
				SETUP									
				PROCESS									
050	MATP. EM	PW	.95	TRANSIT	-	-	-	-	-	-	-		
				SETUP									
				PROCESS									

OPERATION FILE

NAME EMERY HARRIS ALC OC DATE _____ WCD _____ YCD DATE _____ SHEET 2 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	EMPLOYEE		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.		QTY.	TIME REQUIRED %	HRS.	QTY.	
060	MATP ET	TEST	.95	TRANSIT SETUP PROCESS	— — 48	— — —	— — —	— — —	— — —	— — —	— — —	QMS 60-120 ARE DONE IN MATLET AND ARE RECORDED AT FLOW TIME HERE,
090				TRANSIT SETUP PROCESS			N/A					
080				TRANSIT SETUP PROCESS			N/A					
100				TRANSIT SETUP PROCESS			N/A					
110 (110 120)				TRANSIT SETUP PROCESS			N/A					

(INDUCT. PROFILE)
"IN" DA

NAME K. Harris ALC OC DATE 5-26-89 RCC MATPCO SHEET 1 OF 1

PCH
NSH
PIN

50127A

PARENT
WCD

PARENT
WCD DATE

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88013	88013	0

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

SELL "OUT" DATES PROFILE

NAME R. Harris ALC OC DATE 5-26-89 RCC MAITPCM SHEET 1 OF 1

PCN NSN PIN	OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
	1	88013	88013	0

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/13/89

ITEM CODE
 PCN 5013FA
 NSM
 PN

WCD CMEY02 WCD DATE 88225

CHART BEGINS 010

CHART ENDS 030

PREPARED BY R Hoeris

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	$\odot\odot\Delta\square\triangledown$	RECEIVE PART			$\odot\odot\Delta\square\triangledown$	
015	015	$\odot\odot\Delta\square\triangledown$	N/A			$\odot\odot\Delta\square\triangledown$	
020	020	$\square\odot\odot\Delta\square\triangledown$	REPAIR PART			$\odot\odot\Delta\square\triangledown$	
030	030, 040	$\odot\odot\Delta\square\triangledown$	PH			$\odot\odot\Delta\square\triangledown$	
		$\odot\odot\Delta\square\triangledown$				$\odot\odot\Delta\square\triangledown$	
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\odot OPERATION \triangledown STORAGE \square INSPECTION
 \triangleright TRANSPORTATION D DELAY

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/12/89 RCC MATPCB SHEET 1 OF 1

PCN MSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
						%	HRS.	QTY.	SKILL CODE/ LEVEL	QTY.	%	HRS.	QTY.	
00		MATPCB	IN DATE	1.0	TRANSIT									
		CB			SETUP									
					PROCESS									
01D		MATPCB	REC	1.0	TRANSIT									MAT RECEIVED FROM MATPCB, PICK UP AND TAKE TO WIKI AREA,
					SETUP									
					PROCESS				AJ09	1		.02		
02S			INFO	1.0	TRANSIT				NA					
					SETUP									
					PROCESS									
020			REV	1.0	TRANSIT									4 ENGINE LATHES AVAILABLE FOR MENT ON - ONE DIGITAL, THREE MANUAL
					SETUP				AJ 09	1		.25		
					PROCESS				AJ 09	1		.167		
020			PW	1.0	TRANSIT									COMPLETE NETWORK, MAT BACK TO MATPCB, OPS
					SETUP									030 & 040 ON WCD
					PROCESS				AJ09	1		.05		

9999 " OUT DATE 1.0

INDUCTION
"IN" DATES FILE

NAME KAREN STAKES ALC OK DATE 5/30/89 RCC NATPCMI SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	8217	8278	8278	1
2	8291	8292	8292	1
3	8322	8323	8323	1
4	8341	8342	8342	1
5	9005	9005	9005	0
6	9009	9009	9009	0
7	9027	9028	9028	1
8	9044	9045	9045	1
9	9073	9073	9073	0

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

SELL
"OUT" DATES PROFILE

NAME MARREN STOKES ALC QC DATE 5/31/89 RCC MTPLM SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	PARENT WCD DATE	Δ TIME (DAYS)
1	8279	8279	8279		0
2	8293	8293	8293		0
3	8324	8324	8324		0
4	8343	8343	8344		1
5	9006	9006	9006		0
6	9010	9010	9010		0
7	9029	9029	9030		1
8	9046	9046	9046		0
9	9074	9074	9074		0
					MEDIA: 0

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/18/89

ITEM CODE WCD ENERGIC WCD DATE 99020
 PCN 50126A, 50127A,
 NON. [REDACTED]
 P/N [REDACTED]

CHART BEGINS 010
 CHART ENDS 110 PREPARED BY R. HERRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◇◇□▽	DIS & CLEAN PART			○◇◇□▽	
012	012	○◇◇□▽	MACH IN MAT PCM			○◇◇□▽	
015	015	○◇◇□▽	INS P PART			○◇◇□▽	
050	050	○◇◇□▽	PN			○◇◇□▽	
060	060	○◇◇□▽	TEST IN MAT PCM			○◇◇□▽	
070	070	○◇◇□▽	}			○◇◇□▽	
080	080	○◇◇□▽				○◇◇□▽	
100	100	○◇◇□▽				○◇◇□▽	
110	110	○◇◇□▽				○◇◇□▽	
110	120	○◇◇□▽				○◇◇□▽	
		○◇◇□▽				○◇◇□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
 ◇ TRANSPORTATION D DELAY

OPERATION FILE

NAME RANDY HARRIS ALC OC DATE 5/24/89 RCC MATPCM SHEET 1 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	INS.	QTY.	TIME REQUIRED %	INS.	QTY.		TIME REQUIRED %	INS.
00			1.0	TRANSIT SETUP PROCESS	0						88013		
010	MATP EA	DIS	1.0	TRANSIT SETUP PROCESS	2						MATPEA WILL DISASSEMBLE AND CLEAN THE PARTS. THEY WILL MAKE THE PART TO MATPCM IF NEEDED. (ONLY 20% OF TIME)		
012	MATP CM	MACH	.02	TRANSIT SETUP PROCESS							PART IS ASSEMBLED AND THEN PLACED IN FINISHER TRAYS TO BE PICKED UP BY MATPEA		
015	MATD EA	INSP	1.0	TRANSIT SETUP PROCESS							VISUAL INSPECTION OF PART. CAN QUICKLY TELL IF PART CAN GO TO TESTING OR IF IT CAN BE REWORKED.		
050	MATP EA	PLW	.95	TRANSIT SETUP PROCESS									

OPERATION FILE

NAME HARRY HARRIS ALC OC DATE _____ WCD _____ WCD DATE _____ SHEET 2 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	EMPLOYER			EQUIPMENT			DATA SOURCE COMMENTS
							QTY.	TIME REQUIRED % HRS.	TIME REQUIRED % HRS.	QTY.	EQUIPMENT CODE	TIME REQUIRED % HRS.	
060	MATP ET	TEST	.95	TRANSIT SETUP PROCESS	48	- - -	- - -	- - -	- - -	- - -	- - -	- - -	OPS 60-120 ARE DONE IN MATLET AND ARE RECORDED AS PLAN TIME HERE,
070				TRANSIT SETUP PROCESS		N/A							
080				TRANSIT SETUP PROCESS		N/A							
100				TRANSIT SETUP PROCESS		N/A							
110 (110) (120)				TRANSIT SETUP PROCESS		N/A							

9779 0 88013

(INDUCTION)
 "IN" DATES PROFILE

NAME RANDY HARRIS ALC OC DATE 5/26/89 RCC PAIPCM SHEET 1 OF 1

PCN NSN PIN		PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
50191A			88013	88013	0

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

LSC-20107A

SELL
"OUT" DATES PROFILE

NAME RANDY HARRIS ALC OC DATE 5/26/89 RCC MATRIM SHEET 1 OF 1

PCN MSN P/N	PARENT WCD	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
50191A		88013	88013	0

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/22/89

ITEM CODE
PCN
NON
PIN

50287A
000

WCD C0E001 WCD DATE 88217

CHART BEGINS 061

CHART ENDS 069

PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
061	-	○▷▷▷□▽	RECEIVE PART			○▷▷▷□▽	
062	-	○▷▷▷□▽	ASSY			○▷▷▷□▽	
063	-	○▷▷▷□▽	REMOVE BUSHING			○▷▷▷□▽	
064	-	○▷▷▷□▽	REMOVE HELICOUS			○▷▷▷□▽	
065	-	○▷▷▷□▽	REMOVE BUSHINGS			○▷▷▷□▽	
066	-	○▷▷▷□▽	ASSY			○▷▷▷□▽	
067	-	○▷▷▷□▽	DRILL & TAP DRILLING			○▷▷▷□▽	
068	-	○▷▷▷□▽	REMOVE BUSHING			○▷▷▷□▽	
069	-	○▷▷▷□▽	SHIP PART			○▷▷▷□▽	
		○▷▷▷□▽				○▷▷▷□▽	
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION FILE

NAME RANDY HARRIS ALC AL DATE 5/22/89 RCC WALICM SHEET 1 OF 2
 PCH _____ WCD COECO WCD DATE 28217
 NSH _____ WCD _____
 PPI 50287A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%
00	MATP CO	IN DATE	1.0	TRANSIT	24								
				SETUP									
				PROCESS									
061	MATP CUT	REC	1.0	TRANSIT			1	AJ09				RECEIVE PART NO. 1, 2, 3, 4 AND SET UP AT WORK STATION	
				SETUP									
				PROCESS									
062	"	ASSY	1.0	TRANSIT	4		1					INSTALL STUDS IN HOUSING OF ACTUATOR	
				SETUP									
				PROCESS									
063	"	REM	.90	TRANSIT			1	AJ09				KNOCK OUT OLD BUSHING FROM INLET PART ON HOUSING	
				SETUP									
				PROCESS									
064	"	MACH	.20	TRANSIT			1	AJ09		AF 801391	1		BEAM HELICOIDS OF HOUSING ON ANNUAL ARM ROLL
				SETUP									
				PROCESS									

OPERATION FILE

NAME <u>RANDY HARRIS</u>		ALC <u>OC</u>		DATE _____		RCC _____		SHEET <u>2</u> OF <u>2</u>				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME RECORDED	DATA SOURCE COMMENTS
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE		
065	MASP CM	MACH	.70	TRANSIT	-	-	-	-	-	-	-	REAM HOUSING INLET PORT USING SMALL FIXTURE
				SETUP	-	-	-	-	-	-	-	
				PROCESS	1	.06	-	-	-	-	-	
066	1	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	INSTALL NEW DUSHING IN HOUSING
				SETUP	-	-	-	-	-	-	-	
				PROCESS	1	.02	-	-	-	-	-	
067	"	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	DRILL OUT INLET AND ENSURE A PIN
				SETUP	-	-	-	-	-	-	-	
				PROCESS	1	.04	-	-	-	-	-	
068	"	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	REAM OUT NEW DUSHING WITH A FIXTURE AND THEN DEBUR
				SETUP	-	-	-	-	-	-	-	
				PROCESS	1	.05	-	-	-	-	-	
069	"	MASP	1.0	TRANSIT	-	-	-	-	-	-	-	INSPECT PART TO TREE'S AND MOVE TO FINISHED MACH TERRY FIR MATED TO PICK UP
				SETUP	-	-	-	-	-	-	-	
				PROCESS	1	.02	-	-	-	-	-	

9999 11 OUT 1.0

"IN" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MTRCM SHEET 1 OF 1

PCH 50281A PARENT WCD PARENT WCD DATE

OBSERVATION NUMBER	"I" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88277	88278	1
2	88277	88278	1
3	88277	88279	2
4	88286	88287	1
5	88288	88288	1
6	88288	88289	1
7	88292	88293	1
8	88294	88295	1
9	88299	88299	0
10	88312	88313	1
			PENDING: 1

NOTE: "I" DATE IS THE DATE THAT SCHEDULING ENITERS III BLOCK 5 OF WCD OR DATE

"OUT" DATES PROFILE

NAME SHELLA BATES ALC OC DATE 5/26/89 RCC MTRCM SHEET 1 OF 1

PCI 50281A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	88281	88281	0
2	88281	88281	0
3	88283	88284	1
4	88290	88290	0
5	88291	88291	0
6	88291	88291	0
7	88296	88297	1
8	88298	88299	1
9	88302	88303	1
10	88316	88317	1
			MEV, DIV 1

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

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE

PCN
NBY.
P/M

61135A

WCD CDEY39

WCD DATE 88183

CHART BEGINS 065

CHART ENDS 100

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
065	—	$\bigcirc \diamond \square \nabla$	REMOVE LINK			$\bigcirc \diamond \square \nabla$	
070	070	$\bigcirc \diamond \square \nabla$	MOVE TO - CD, INSP			$\bigcirc \diamond \square \nabla$	
080	080	$\bigcirc \diamond \square \nabla$	MACH CONICAL SEAT			$\bigcirc \diamond \square \nabla$	
090	090	$\bigcirc \diamond \square \nabla$	MACH SEALING SURFACE			$\bigcirc \diamond \square \nabla$	
100	100	$\bigcirc \diamond \square \nabla$	INSP THROUGH CLEARANCE			$\bigcirc \diamond \square \nabla$	
		$\bigcirc \diamond \square \nabla$				$\bigcirc \diamond \square \nabla$	
		$\bigcirc \diamond \square \nabla$				$\bigcirc \diamond \square \nabla$	
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OPERATION STORAGE INSPECTION
 TRANSPORTATION DELAY

OPERATIO. PROFILE

NAME RANDY V. HARRIS ALC OC DATE 5/16/89 RCC MATPCM SHEET 1 OF 2

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANIPULATOR			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	QTY.	TIME REQUIRED %	HRS.	QTY.	EQUIPMENT CODE	TIME REQUIRED %		HRS.
00	MATP CD	IN DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	27									
065	MATP CM	REM	1.0	TRANSIT										SAME OPS AS C/N 9999A
				SETUP										
				PROCESS										
070	MATP CB	INSP	1.0	TRANSIT										
				SETUP										
				PROCESS	48									
080	MATP CM	MACH	1.0	TRANSIT										
				SETUP										
				PROCESS										
090	11	MACH	1.0	TRANSIT										
				SETUP										
				PROCESS										

WCD COEY39 WCD DATE 88/83

C/N 61138A
USES OC9992
FOR THE INTERING VARIATION.

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE _____ RCC _____ SHEET 2 OF 2

PCH _____ WCD _____ WCD DATE _____

NSN 61138A MANDATORY FLOW HOURS

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %
100	MATP CM	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-
				PROCESS	-	AJ 09	1	-	00	-	-	-	-
9999	11	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-
				PROCESS	0	-	-	-	-	-	-	-	-
				TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-
				PROCESS	-	-	-	-	-	-	-	-	-
				TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-
				PROCESS	-	-	-	-	-	-	-	-	-

"IN" DAT PROFILE

NAME HEIKA BATES ALC DC DATE 5/26/89 RCC NAIPCM SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
61138A		89066	89067	1
		89066	89067	1
		89058	89059	1
		89058	89059	1
		89058	89058	0
		89083	89084	3
		89083	89084	3
		89083	89084	3
		89096	89096	0
		89096	89096	0
				1

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

"OUT" DATES PROFILE

NAME SUELLA DATES ALC OC DATE 5/26/89 RCC MATLGM SHEET 1 OF 1

PCH _____ PARENT WCD _____

RSH 61138A PIR _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	89068	89068	0
2	89068	89068	0
3	89060	89060	0
4	89060	89060	0
5	89068	89060	0
6	89087	89087	0
7	89087	89087	0
8	89087	89087	0
9	89097	89097	0
10	89097	89097	0

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/17/89

ITEM CODE
PCN
NAM.
P/N
 79168A

WCD EA 945A * WCD DATE 89139*

* NO WCD. ABOVE NUMBERS ARE CREATED.

CHART BEGINS 010

CHART ENDS 070 PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
011	-	○▷▷▷▽	REC PARTS			○▷▷▷▽	
020	-	○▷▷▷▽	REMOVE CUP			○▷▷▷▽	
030	-	○▷▷▷▽	REMOVE INLET			○▷▷▷▽	
040	-	○▷▷▷▽	REAM CUP TO SEAL			○▷▷▷▽	
050	-	○▷▷▷▽	INSPECT FUEL TUBE			○▷▷▷▽	
060	-	○▷▷▷▽	INSTALL CUP			○▷▷▷▽	
070	-	○▷▷▷▽	MOVE TO P/V			○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
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		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	
		○▷▷▷▽				○▷▷▷▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/12/89 RCC DAIPCM SHEET 1 OF 2

PCN 97768A WCD EA945A WCD DATE 89137

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
00	MOTP EA	IN DATE	1.0	TRANSIT							
010	MOTP CM	REC	1.0	TRANSIT		0					RECEIVE AIDS FROM INCOMING TABLE AND RETURN TO AIRPROBABLE IMPROBABLE OR MAGNANAE
120	"	REM	1.0	TRANSIT				1			RECEIVE SUP FROM ELEMENT NOT SET TO 100 A. S. 100.
130	"	REPL	1.0	TRANSIT				1			RECEIVE WORKSTATION FROM WORKSTATION ELEMENT NOT SET TO 100.
140	"	MINCH	1.0	TRANSIT				1			RECEIVE FROM ELEMENT OF TABLE. SEAL.

OPERATION PROFILE

NAME _____ ALC 2 DATE _____ RCC _____ SHEET 2 OF 2

PCN NSN PIN 99168A WCD ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	QTY.	%	HRS.	%	
250	MTRP EA	INSP	1.0	TRANSIT	48	-	-	-	-	-	-	-	-	FUEL HEAD PART WILL BE INSPECTED BY HIR/PEA
				SETUP		-	-	-	-	-	-	-		
				PROCESS		-	-	-	-	-	-	-		
260	MTRP CA	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	After 2 checks in 10 minutes, RE check is required by HIR/PEA
				SETUP	-	-	AS11	1	17	100%	1	17	100%	
				PROCESS	-	-	AS19	1	17	100%	1	17	100%	
277	1	MTRP	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	Old part in the plant, MTRP
				SETUP	-	-	-	-	-	-	-	-		
				PROCESS	-	-	AS19	1	13	100%	1	13	100%	
9999	"	OUT DATE	1.0	TRANSIT	0	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-		
				PROCESS	-	-	-	-	-	-	-	-		
				TRANSIT										
				SETUP										
				PROCESS										

(INSTRUCTIONS)
"IN" DATES FILE

NAME RANDY HARRIS ALC OC DATE 5/26/89 RCC MATPCM SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
97165A		88136	88136	0
1				

SELL
"OUT" DATES PROFILE

NAME RANDY HARRIS ALC OC DATE 5/26/89 RCC MATRCM SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	"OUT" DATE 4 TIME (DAYS)
99168A		88136	88136	0

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

LSC-20108A

FLOW PROCESS CHART

SUBJECT _____

DATE 5/18/89

ITEM CODE
PCN
NH.
PM

WCD CBEC04A

WCD DATE 89087

78043A, 79342A
 78059A

CHART BEGINS 090

CHART ENDS 380

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
090	090	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	REPAIR NOZZLE BODY			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
100	100	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	REPLACE SLEEVES			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
110	110	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSP LUGS			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
120	120	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MWVE TO -IW			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
120	140	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
120	145	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
120	150	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
142	142	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MPCH LUGS			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
150	150	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	F. P INSP IN-IW			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
155	155	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	MPCH AND SO MANIFOLDS			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
160	160	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	IPVC IN -CB			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
161	165	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	170	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
210	210	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	DRILL LUGS FOR SW-GNE			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
215	215	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	PROC IN - IW			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	220	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	230	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
250	250	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	PROC IN -CB			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	260	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	270	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	280	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	290	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	320	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	330	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	340	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	350	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	360	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
"	370	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
380	380	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	LAP ADAPTER			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	

OPERATION STORAGE INSPECTION
 TRANSPORTATION DELAY

OPERATION ... FILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MAIPCM SHEET 1 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
00	MATP CB	IN DATE	1.0	TRANSIT SETUP PROCESS												
090	MATP CM	REP	.25	TRANSIT SETUP PROCESS	72		AJ09	1	.25		OCJ343	1	.25		OP 090 DEPENDENT ON OP 060 OF WCD. THE OPERATIONS ARE	
100	"	ASSY	.60	TRANSIT SETUP PROCESS			AJ09	1	.50		XJ343	1	.50		BASED ON THE SAME IF NOT IDENTICAL TO THE OPERATIONS OF CBE401	
110	"	INSTR	1.0	TRANSIT SETUP PROCESS											(CEN'S 99808, 99811, 99806 99802). HOWEVER,	
120	MATP (120) (140) (145) 150	PRCK	1.0	TRANSIT SETUP PROCESS			AJ09	1	.03						ORDER OF OCCURRENCE AND OCCURRENCE FACTORS ARE SIGNIFICANTLY DIFFERENT,	

OPERATION ... OFILE

NAME RANDY HARRIS ALC OK DATE 5/15/89 RCC MAIPCM SHEET 2 OF 3

PCN NSN 78034A, 98042A, 98043A, 98050A WCD CBECOF ✓ WCD DATE 89089

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
							QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %			
172	MOTP CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	.08	AJ09	1	.08	0C4924	1	.08	
				PROCESS	-	.05	AJ09	1	.05	0C4924	1	.05	
150	MATO IL	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-
				PROCESS	-	-	-	-	-	-	-	-	-
155	MOTP CM	ID	.40	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	.17	AJ09	1	.17	0C4939	1	.17	
				PROCESS	-	.33	AJ09	1	.33	0C4939	1	.33	
160 (0P160, 165, 170)	MOTP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-
				PROCESS	-	2	-	-	-	-	-	-	-
210	MOTP CM	MACH	.50	TRANSIT	-	-	-	-	-	-	-	-	
				SETUP	-	.08	AJ09	1	.08	AF6N516	1	.08	
				PROCESS	-	.08	AJ09	1	.08	AF80516	1	.08	

UPS 160, 165,
AND 170 OF WCD

OPERATION PROFILE

NAME RODOLPH WARRIS ALC OC DATE 5/15/89 RCC MATPCM SHEET 3 OF 3

WCD CBELC09 WCD DATE 89089

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANIPULATOR			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS		
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.			
215	MATP IW	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	OPS 215-230 ON WCD. WORK WAS IN WELD RCC.	
				SETUP	-	-	-	-	-	-	-	-	-	-	-		-
				PROCESS	-	24	-	-	-	-	-	-	-	-	-		-
250	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	OPS 250-370 ON WCD. WORK WAS IN MATPCB.	
				SETUP	-	-	-	-	-	-	-	-	-	-	-		-
				PROCESS	-	78	-	-	-	-	-	-	-	-	-		-
380	MATP CM	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	SETUP FOR HAND-CAP OPERATION.	
				SETUP	-	-	AJ09	1	-	.03	LAP1	1	-	.03	-		-
				PROCESS	-	-	-	-	-	-	-	-	-	-	-		-
380	"	"	1.0	TRANSIT	-	-	AJ09	1	95	.25	LAP1	1	95	.25	-	WJ CODE ON EQUIPMENT, COPE WAS DEVELOPED AND IS LISTED ON EQUIP. PROFILE	
				SETUP	-	-	AJ09	1	5	2.0	LAP1	1	5	2.0	-		
				PROCESS	-	-	-	-	-	-	-	-	-	-	-		-
9999	"	OUT DATE.	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	-	-	-		-
				PROCESS	-	24	-	-	-	-	-	-	-	-	-		-

MADE
FOR
P/U
BY
MATPCB

"IN" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MIPCM SHEET 1 OF 1
 PCI 98034A PATIENT WCD PATIENT WCD DATE

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88305	88307	2
2	88308	88312	4
3	88320	88323	3
4	88328	88333	5
5	88334	88336	2
6	88335	88340	5
7	88355	88358	3
8	89012	89017	5
9	89045	89047	2
10	89059	89061	2
			MEDIAN = 3

"OUT" DATES PROFILE

NAME SUELLA BATES ALC OC DATE 5/26/89 RCC MAIPCM SHEET 1 OF 1

PCI 98034A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING/SELL DATE)	Δ TIME (DAYS)
1	88309	88309	0
2	88314	88315	1
3	88327	88328	1
4	88335	88335	0
5	88341	88342	1
6	88342	88342	0
7	88363	88365	2
8	89020	89020	0
9	89052	89053	1
10	89065	89065	0
			MEDIAN: 1

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/18/89

ITEM CODE WCD CREC04A WCD DATE 89087
 PCN 98134A, 9742A
 N&N. 73049A, 78059A
 P/N

CHART BEGINS 090
 CHART ENDS 380 PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
090	090	○▷▷▷□▽	REPAIR NOZZLE BODY			○▷▷▷□▽	
100	100	○▷▷▷□▽	REPLACE SLEEVES			○▷▷▷□▽	
110	110	○▷▷▷□▽	INSP LUGS			○▷▷▷□▽	
120	120	○▷▷▷□▽	MOVE TO -IN			○▷▷▷□▽	
120	140	○▷▷▷□▽	?			○▷▷▷□▽	
120	145	○▷▷▷□▽	/			○▷▷▷□▽	
120	150	○▷▷▷□▽	/			○▷▷▷□▽	
142	142	○▷▷▷□▽	INCH LUGS			○▷▷▷□▽	
150	150	○▷▷▷□▽	F.P INSP IN-IN			○▷▷▷□▽	
155	155	○▷▷▷□▽	INCH END 20 MINIFLUGS			○▷▷▷□▽	
160	160	○▷▷▷□▽	PROC IN - CB			○▷▷▷□▽	
160	165	○▷▷▷□▽	?			○▷▷▷□▽	
160	170	○▷▷▷□▽	?			○▷▷▷□▽	
210	210	○▷▷▷□▽	DRILL LUGS FOR IN IN			○▷▷▷□▽	
215	215	○▷▷▷□▽	PROC IN - IN			○▷▷▷□▽	
"	220	○▷▷▷□▽	?			○▷▷▷□▽	
"	230	○▷▷▷□▽	?			○▷▷▷□▽	
250	250	○▷▷▷□▽	PROC IN - CB			○▷▷▷□▽	
"	260	○▷▷▷□▽	?			○▷▷▷□▽	
"	270	○▷▷▷□▽	?			○▷▷▷□▽	
"	280	○▷▷▷□▽	?			○▷▷▷□▽	
"	290	○▷▷▷□▽	?			○▷▷▷□▽	
"	320	○▷▷▷□▽	?			○▷▷▷□▽	
"	330	○▷▷▷□▽	?			○▷▷▷□▽	
"	340	○▷▷▷□▽	?			○▷▷▷□▽	
"	350	○▷▷▷□▽	?			○▷▷▷□▽	
"	360	○▷▷▷□▽	?			○▷▷▷□▽	
"	370	○▷▷▷□▽	?			○▷▷▷□▽	
380	380	○▷▷▷□▽	LAP ADAPTER			○▷▷▷□▽	
		○▷▷▷□▽				○▷▷▷□▽	
		○▷▷▷□▽				○▷▷▷□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
 ▷ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME RANDY HAERS ALC OC DATE 5/15/89 RCC ATPCM SHEET 1 OF 3

PCN NSN 98034A WCD CBEC07A WCD DATE 89081

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	QTY.	
00	MATP CB	IN DATE	1.0	TRANSIT SETUP PROCESS		96					
090	MATP CM	REP	.25	TRANSIT SETUP PROCESS							OP 090 DEMANDS UPON OP 060 OF WCD. THE OPERATIONS ARE
100	"	ASSY	.60	TRANSIT SETUP PROCESS							BASICALLY THE SAME FF AS IDENTICAL TO THE OPERATIONS OF CBEC01
110	"	INSTR	1.0	TRANSIT SETUP PROCESS							(CIN'S 99808, 99810, 99806, 99802), HOWEVER,
120	MATP "	PROC	1.0	TRANSIT SETUP PROCESS							ORDER OF OCCURRENCE AND OCCURRENCE FACTORS ARE SUFFICIENTLY DIFFERENT,
(120) (140) (145) 152						6					

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MAJPCM SHEET 2 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAINTENANCE			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE	QTY.	%	HRS.	%		HRS.
142	MATP CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	1	AJ09	1	0C4924	1	.08	-	.08		
				PROCESS	-	-	1	AJ09	1	0C4924	1	.05	-	.05		
150	MATP IU	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	1	-	-	-	-	-	-	-	-	-	
155	MATP CM	IO	.40	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	1	AJ09	1	0C4939	1	.17	-	.17		
				PROCESS	-	-	1	AJ09	1	0C4939	1	.33	-	.33		
160 (OP 160, 165, 170)	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	OPS 160, 165, AND 170 OF WCD
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	2	-	-	-	-	-	-	-	-	-	
210	MATP CM	MACH	.50	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	1	AJ09	1	AF602576	1	.08	-	.08		
				PROCESS	-	-	1	AJ09	1	AF802576	1	.08	-	.08		

OPERATIC PROFILE

NAME Randy Harris ALC OC DATE 5/15/89 RCC MATPCM SHEET 3 OF 3

PCN 98034A WCD CBEC04 WCD DATE 89089

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
					%	HRS.	QTY.	%	HRS.	QTY.		%
215	MATP ILW	PROC	1.0	TRANSIT	-	-	-	-	-	-	OPS 215-230 ON WCD. WORK ONE IN WELD RCC.	
				SETUP	-	-	-	-	-	-		-
				PROCESS	-	24	-	-	-	-		-
250	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	OPS 250-370 ON WCD. WORK AMF IN MATPCB.	
				SETUP	-	-	-	-	-	-		-
				PROCESS	-	48	-	-	-	-		-
380	MATP CAM	PROC	1.0	TRANSIT	-	-	-	-	-	-	SET UP FOR HAND-CAP OPERATION.	
				SETUP	-	-	1	-	03	1		03
				PROCESS	-	-	-	-	-	-		-
380	"	"	1.0	TRANSIT	-	-	1	95	1	95	NO CODE ON EQUIPMENT, CODE WAS DEVELOPED AND IS LISTED ON FAIR. PROFILE	
				SETUP	-	-	1	5	1	5		2.0
				PROCESS	-	-	-	-	-	-		-
9999	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-		-
				PROCESS	-	0	-	-	-	-		-

NONE
FIX
P/V
BY
MHR

"IN" DATES PROFILE

NAME SHERIL BATES ALC OC DATE 5/25/87 RCC MTPcm SHEET 1 OF 1

PCI# 98042A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"H" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	88281	88286	5
2	88288	88293	5
3	88295	88299	4
4	88298	88300	2
5	88312	88314	2
6	88323	88328	5
7	88342	88344	2
8	88351	88355	4
9	89005	89009	4
10	89023	89026	3
			MEASUREMENT: 4

NOTE: "H" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE
 THAT FOURTH DIGIT ATTACHES A WCD TO AN ASSET TO BE WORKED

"OUT" DATES PROFILE

NAME SHIELLA BATES ALC α DATE 5/26/89 RCC NAIP CO SHEET 1 OF 1

PCN _____ PARENT WCD _____ PARENT WCD DATE _____

ISSN 98042A

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	88287	88287	0
2	88294	88295	1
3	88300	88300	0
4	88300	88301	1
5	88319	88320	1
6	88330	88330	0
7	88344	88348	4
8	88356	88356	0
9	89010	89010	0
10	89027	89027	0
			REMAIN: 0

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

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MTJCM SHEET 1 OF 3

PCN NSN 78034A, 78042A, 78057A WCD CBEC04A WCD DATE 87087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE		%	HRS.
00	MATP CB	IN DATE	1.0	TRANSIT	48								
				SETUP									
				PROCESS									
090	MATP EM	REP	.25	TRANSIT			AJ09	1		OC0343	.25		
				SETUP									
				PROCESS									
100	"	ASSY	.60	TRANSIT			AJ09	1		OC0343	.70	.17	
				SETUP									
				PROCESS									
110	"	INSTR	1.0	TRANSIT									
				SETUP									
				PROCESS									
120 (120) (142) (145) 153	MATP "	PRK	1.0	TRANSIT			AJ09	1			.03		
				SETUP									
				PROCESS									

OF 090 REFERRED TO
BY 060 OF
WCD. THE
OPERATIONS ARE
BASICALLY THE
SAME IF NOT
IDENTICAL TO
THE OPERATIONS
OF CBEC01
(CUN'S 99808,
99810 99876
99802). HOWEVER,
ORDER OF
OCCURRENCE
AND OCCURRENCE
FACTORS ARE
SIGNIFANTLY
DIFFERENT,

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MAJPCM SHEET 2 OF 3

PCN 98934A, 98042A, 78051A WCD CBEC04 WCD DATE 89089

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					%	HRS.	SKNL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
142	MTP CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	AJ09	1	-	.08	OC4724	1	-	.08	
				PROCESS	-	-	AJ09	1	-	.05	OC4724	1	-	.05	
150	MTP IV	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	
155	MTP CM	ID	.40	TRANSIT	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	AJ09	1	-	.17	OC4727	1	-	.17	
				PROCESS	-	-	AJ09	1	-	.33	OC4727	1	-	.33	
160 (OP160, 145, 170)	MTP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	OPS 160, 145, AND 170 OF MCD	
				SETUP	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	
210	MTP CM	MACH	.50	TRANSIT	-	-	-	-	-	-	-	-	-		
				SETUP	-	-	AJ09	1	-	.08	AF 620576	1	-	.08	
				PROCESS	-	-	AJ09	1	-	.08	AF 620576	1	-	.08	

OPERATION PROFILE

NAME Randy Morris ALC OC DATE 5/15/89 RCC MAIPEM SHEET 3 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPEM		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	TIME REQUIRED %	HRS.	QTY.	TIME REQUIRED %	HRS.	
215	MATP IW	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	OPS 215-230 ON WCD. WORK TIME IN WELD RCC.	
				SETUP	-	-	-	-	-	-	-		
				PROCESS	-	24	-	-	-	-	-		
250	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	OF 250-390 ON WCD. WORK DONE IN MATPCB.	
				SETUP	-	-	-	-	-	-	-		
				PROCESS	-	48	-	-	-	-	-		
380	MATP CM	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	SET UP FOR HAND-CAP OPERATION.	
				SETUP	-	-	1	03	1	03	-		
				PROCESS	-	-	-	-	-	-	-		
380	"	"	1.0	TRANSIT	-	-	1	95	1	95	1	95	W CODE ON EQUIPMENT, CODE WAS DEVELOPED AND IS LISTED ON EQUIP. PROFILE
				SETUP	-	-	1	5	1	5	1	5	
				PROCESS	-	-	-	-	-	-	-		
9999	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-		
				PROCESS	-	24	-	-	-	-	-		

MUE
TAK
P/V
BY
MUE

FLOW PROCESS CHART

SUBJECT _____

DATE 5/16/89

ITEM CODE

WCD CBEC04A

WCD DATE 89087

PCH
MOM.
PM

98134A, 7742A
 98134A, 78057A

CHART BEGINS 090

CHART ENDS 380

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
090	090	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	REPAIR NOZZLE BODY			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
100	100	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	REPLACE SLEEVES			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
110	110	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	INSP LUGS			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
120	120	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	MOVE TO-INW			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
120	140	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
120	145	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
120	150	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
142	142	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	INSP LUGS			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
150	150	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	F.P INSP IN-INW			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
155	155	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	INSP END 20 MANIFOLDS			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
160	160	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	INSP IN - CB			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
165	165	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	170	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
210	210	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	DRILLABLES FOR S.W. LINE			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
215	215	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	PROC IN - INW			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	220	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	230	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
250	250	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	PROC IN - CB			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	260	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	270	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	280	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	290	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	320	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	330	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	340	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	350	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	360	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
"	370	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
380	380	<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	LAP REPORTER			<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
		<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	
		<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>				<input checked="" type="circle"/> <input checked="" type="square"/> <input checked="" type="triangle-down"/> <input checked="" type="square"/>	

OPERATION

STORAGE

INSPECTION

TRANSPORTATION

DELAY

CLAUDEVILLE
"IN" DATES . . . FILE

NAME SUELLA DATES ALC QC DATE 5/26/89 RCC MTPCM SHEET 1 OF 1

PCN NSN PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
	98043A			
1	88281		88286	5
2	88293		88295	2
3	88299		88301	2
4	88308		88312	4
5	88320		88322	2
6	88326		88328	2
7	88348		88350	2
8	89004		89006	2
9	89011		89013	2
10	89032		89034	2
				MEDIAN: 2

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

LSC-20107A

"OUT" DATES PROFILE

NAME SHUELLA DATED ALC OC DATE 5/26/89 RCC MRJRCM SHEET 1 OF 1

PCI# 93043A PARENT WCD PARENT WCD DATE

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	88286	88286	0
2	88295	88298	3
3	88302	88302	0
4	88312	88313	1
5	88322	88323	1
6	88328	88328	0
7	88350	88351	1
8	89009	89009	0
9	89014	89014	0
10	89037	89038	1

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

FLOW PROCESS CHART

SUBJECT _____ DATE 5/18/89

ITEM CODE

WCD C0EC04A

WCD DATE 89087

PCN 98734A, 77142A,
 NSM. 73047A, 78059A
 P/N

CHART BEGINS 090

CHART ENDS 380

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	
090	090	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	REPAIR NOZZLE BODY			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
100	100	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	REPLACE SLEEVES			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
110	110	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSP LVES			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
120	120	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	HIVE TO-IN			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
120	147	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	}			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
120	145	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
120	150	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
142	142	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSP LVES			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
150	150	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	F.P INSP IN-IN			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
155	155	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	INSP END SO MANIFOLDS			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
160	160	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	PROC IN - CB			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
170	165	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	}			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
170	170	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
210	210	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	DRILLABLES FOR SW INE			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
215	215	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	}			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
215	215	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		PROC IN - IN			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
220	220	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	}			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
220	220	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
230	230	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	}			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
250	250	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		PROC IN - CB			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
260	260	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
270	270	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
280	280	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
290	290	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
300	300	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
310	310	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
320	320	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
330	330	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
340	340	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
350	350	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
360	360	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
370	370	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
380	380	<input checked="" type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		LAP ADAPTER			<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		
		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>		

OPERATION STORAGE INSPECTION
 TRANSPORTATION DELAY

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/15/89 RCC MATPCM SHEET 1 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.	QTY.	TIME REQUIRED		EQUIPMENT CODE		QTY.	TIME REQUIRED	
								%	HRS.				%	HRS.
00	MATP CB	IN	1.0	TRANSIT										
		DATE		PROCESS										
090	MATP CM	REP	.25	TRANSIT										
				SETUP										
				PROCESS										
100	"	MSY	.60	TRANSIT										
				SETUP										
				PROCESS										
110	"	INSB	1.0	TRANSIT										
				SETUP										
				PROCESS										
120	MATP "	PRK	1.0	TRANSIT										
				SETUP										
				PROCESS										
(120) (140) (145) 153														

OP 090 DEFERRED
VIEW OP 060 OF
WCD. THE
OPERATIONS ARE
BASICALLY I.F.
SAME .IF NOT
IDENTICAL TO
THE OPERATIONS
OF CBESA1
(CAN'S 99808,
99810 99806,
99802). HOWEVER,
ORDER OF
OCCURRENCE
AND OCCURRENCE
FACTORS ARE
SIGNIFICANT
DIFFERENT,

WCD CBESA1 WCD DATE 89081

MANDATORY FLOW HOURS: 48

WCD CBESA1

OPERATION PROFILE

NAME Randy Harris ALC OC DATE 5/15/89 RCC MATPCM SHEET 2 OF 3

PCN OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAINTOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	QTY.		%	HRS.
142	MATP CM	MACH	.80	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	1	.08	0C4924	1	.08		
				PROCESS	-	-	1	.05	0C4924	1	.05		
150	MATP IL	PROC	1.0	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	1	-	-	-	-	-	-	
155	MATP CM	ID	.40	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	1	.17	0C4939	1	.17		
				PROCESS	-	-	1	.33	0C4937	1	.33		
160 COP160, 165, 170	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	OPS 160, 165, AND 170 OF NCD	
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	2	-	-	-	-	-	-	
210	MATP CM	MACH	.50	TRANSIT	-	-	-	-	-	-	-		
				SETUP	-	-	1	.08	AF602576	1	.08		
				PROCESS	-	-	1	.08	AF800576	1	.08		

OPERATIC PROFILE

NAME Randy Harris ALC DC DATE 5/15/89 RCC MATPCB SHEET 3 OF 3

PCN 98034A, 98042A, 98043A, 98052A WCD CRK04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
					%	INS.	QTY.	%	INS.	QTY.	%	INS.		
215	MATP IW	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	OPS 215-230 ON WCD. WORK DONE IN WFLD RCC.	
				SETUP	-	-	-	-	-	-	-	-		-
				PROCESS	-	24	-	-	-	-	-	-		-
250	MATP CB	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	OPS 250-370 ON WCD. WORK DONE IN MATPCB.	
				SETUP	-	-	-	-	-	-	-	-		-
				PROCESS	-	48	-	-	-	-	-	-		-
380	MATP CM	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	SET UP FOR HAND-CAP OPERATION.	
				SETUP	-	-	1	109	1	03	1	03		-
				PROCESS	-	-	-	-	-	-	-	-		-
380	"	"	1.0	TRANSIT	-	-	-	-	-	-	-	-	NO CODE ON EQUIPMENT, CODE WAS DEVELOPED AND IS LISTED ON EQUIP. PROFILE	
				SETUP	-	-	1	109	1	25	1	25		-
				PROCESS	-	-	-	-	-	-	-	-		-
9999	"	OUT DATE	1.0	TRANSIT	-	-	-	-	-	-	-	-		
				SETUP	-	-	-	-	-	-	-	-		-
				PROCESS	-	24	-	-	-	-	-	-		-

NONE
N/A
BY
DATE

"IN" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MPC M SHEET 1 OF 1

OBSERVATION NUMBER	OBS DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)	PARENT	
				WCD	WCD DATE
1	88277	88279	2		
2	88277 88292	88294	2		
3	88302	88306	4		
4	88326	88328	2		
5	88347	88350	3		
6	89604	89006	2		
7	89015	89020	5		
8	89026	89029	3		
9	89032	89034	2		
10	89060	89062	2		

"OUT" DATES PROFILE

NAME SHIELLA BATES ALC OC DATE 5/26/89 RCC MATRCM SHEET 1 OF 1

PCI 98057A PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	88281	88281	0
2	88298	88299	1
3	88308	88308	0
4	88330	88333	3
5	88350	88350	0
6	89008	89008	0
7	89022	89025	3
8	89034	89034	0
9	89036	89039	3
10	89063	89063	0

PARENT WCD DATE _____

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

FLOW PROCESS CHART

SUBJECT _____

DATE 5/17/89

ITEM CODE
 PCN 98206
 NHX
 P/N

WCD CMEZ03

WCD DATE 89090

CHART BEGINS 010

CHART ENDS 040

PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○D□▽	RECEIVE PART			○D□▽	
020	020(A)	○D□▽	RAM PLATES, SWIRL BODY			○D□▽	
021	020(B)	○D□▽	BEAM L. JCS, R. RET. HOLE			○D□▽	
022	020(C)	○D□▽	REMOVE DRUMS FROM INLET			○D□▽	
023	020(D)	○D□▽	DRILL & REAM HOLE			○D□▽	
024	020(E)	○D□▽	DRILL & REAM HOLE			○D□▽	
025	020(F)	○D□▽	REMOVE ASSEMBLY			○D□▽	
026	025	○D□▽	REMOVE BEINS&ULL HINGE			○D□▽	
030	040, 050	○D□▽	PW			○D□▽	
040	030	○D□▽	MOVE TO P/U			○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
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		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	
		○D□▽				○D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
 ◊ TRANSPORTATION D DELAY

OPERATION ... OF FILE

NAME RANDY HARRELS ALC OC DATE 5/2/89 RCC MATPCM SHEET 1 OF 3

PCN NSN P/N	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
						%	HRS.	QTY.	%	HRS.	QTY.		EQUIPMENT CODE	TIME REQUIRED %	TIME REQUIRED HRS.
98226	00	MATP CS	IN DATE	1.0	TRANSIT										
					SETUP										
					PROCESS	24									
910		MATP CM	REC	1.0	TRANSIT							OPER. OF P/CS OF PART AND IN-ET O WORK 3/4 (1 MINUTE)			
					SETUP										
					PROCESS			1							
020		"	REM	1.0	TRANSIT							020 PART (A) OF MCD			
					SETUP										
					PROCESS										
021		"	ASSY	1.0	TRANSIT							020 PART (B)			
					SETUP										
					PROCESS			1							
022		"	REM	1.0	TRANSIT							020 PART (C)			
					SETUP										
					PROCESS										

OPERATION . . . OF FILE

NAME RANDY HARRIS ALC OC DATE 5/12/89 RCC RAIACN SHEET 2 OF 3

PCN OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.		QTY.	TIME REQUIRED		EQUIPMENT CODE		QTY.	TIME REQUIRED	
									%	HRS.				%	HRS.
023	"	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	OP TO PMS(0)			
				SETUP	-	-	AJ09	1	-	OC6522	1		03	05	
				PROCESS	-	-	AJ09	1	-	OC6522	1		08	08	
024	"	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	OP TO PMS(0)			
				SETUP	-	-	AJ09	1	-	OC6522	1		03	08	
				PROCESS	-	-	AJ09	1	-	OC6522	1		08	08	
025	"	MACH	1.0	TRANSIT	-	-	-	-	-	-	-	OP TO PMS(0)			
				SETUP	-	-	AJ09	1	-	OC6522	1		03	08	
				PROCESS	-	-	AJ09	1	-	OC6522	1		169	08	
026 (025)	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	OP TO PMS(0)			
				SETUP	-	-	-	-	-	-	-		-	-	
				PROCESS	-	-	AJ09	1	-	-	-		08	-	
030 (025)	"	PW	1.0	TRANSIT	-	-	-	-	-	-	-	OP TO PMS(0)			
				SETUP	-	-	-	-	-	-	-		-	-	
				PROCESS	-	-	AJ09	1	-	-	-		-	05	

FLOW PROCESS CHART

SUBJECT _____ DATE 5/17/89

ITEM CODE
PCK X 9821WA
NOM.
PIN
WCD C0945A* WCD DATE 89137*
* HOME NUMBERS CREATED - NO WCD EX S.S. - T.O. IS A 945

CHART BEGINS 010

CHART ENDS 040 PREPARED BY R. HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
<u>010</u>	<u>-</u>	<u>○◇◇□▽</u>	<u>MACH. THE SURFACES</u>			<u>○◇◇□▽</u>	
<u>020</u>	<u>-</u>	<u>○◇◇□▽</u>	<u>REPLACE STUDS</u>			<u>○◇◇□▽</u>	
<u>030</u>	<u>-</u>	<u>○◇◇□▽</u>	<u>REPLACE SLEEVES</u>			<u>○◇◇□▽</u>	
<u>040</u>	<u>-</u>	<u>○◇◇□▽</u>	<u>MOVE TO P/U</u>			<u>○◇◇□▽</u>	
		<u>○◇◇□▽</u>				<u>○◇◇□▽</u>	
		<u>○◇◇□▽</u>				<u>○◇◇□▽</u>	
		<u>○◇◇□▽</u>				<u>○◇◇□▽</u>	
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		<u>○◇◇□▽</u>				<u>○◇◇□▽</u>	
		<u>○◇◇□▽</u>				<u>○◇◇□▽</u>	
		<u>○◇◇□▽</u>				<u>○◇◇□▽</u>	

OPERATION STORAGE
 TRANSPORTATION INSPECTION
 DELAY

OPERATION PROFILE

NAME RANDY W. HARRIS ALC JC DATE 5/17/89 RCC MATPCM SHEET 1 OF 1

PCH 98210A WCD CD945A WCD DATE 89137 OPERATIONS: REPL
 NSN 98210A WCD CD945A WCD DATE 89137 111 FUEL FLANK
 PRI 98210A WCD CD945A WCD DATE 89137

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	QTY.	%			HRS.
00	MATP CO	IN DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	24									
010	MATP CM	MACH	1.0	TRANSIT									1122-1 253107 CAN BE USED FACE SEALING 3.16.15	
				SETUP			AJ09	1	7	.50	023111	1	1	SET-UP
				PROCESS			AJ09	1	17	.17	023111	1	.17	SET-UP CHECKS 1 APR 15 1989
020	11	REPL	.02	TRANSIT										REPLACEMENT NECESSARY
				SETUP										
				PROCESS			AJ09	1		.50				
030	11	REPL	.02	TRANSIT										REPLACEMENT NECESSARY
				SETUP										
				PROCESS			AJ09	1		.50				
143	11	REPL	1.0	TRANSIT										REPLACEMENT NECESSARY
				SETUP										
				PROCESS			117	1		.12				

9999 11 OUT DATE 10

REQUESTED COST DATA FOR RRB-QF7

Cost Savings:

Present Condition Cost For the Last 12 Months:

Rework costs associated with repairing supplier parts received from stores and delivered to the production RCC when the noted reason for repair is already documented on a QDR = \$_____.

Scrap costs for parts associated for the above = \$_____.

Return to supplier (stores) costs for parts associated with the above = \$_____.

Labor costs associated with the above parts = \$_____.

Proposed Implementation Cost:

Costs either to return or to screen all parts in stores identified as discrepant on a QDR = \$_____.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = \$_____.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-0E4

**T1 PROGRAM
COST BENEFIT ANALYSIS REPORT**

TYPE PROPOSAL

COMMAND _____ DATE 19 JUN 89
ALC ALL ITEM NO. _____
NOUN UNCONTROLLED TECH ORDERS

- QUICK FIX
- FOCUS STUDY
- OTHER _____

BOB BUTTRY

CURRENT METHOD : MECHANICS WORK TO TECH ORDER REQUIREMENTS AS REFERENCED PER WCD INSTRUCTIONS. THE TECH ORDERS ARE USUALLY UNAUTHORIZED AND UNCONTROLLED COPIES THAT THEY KEEP HANDY AT THEIR WORK STATIONS. THESE COPIES ARE SUBJECT TO BEING OUT-OF-DATE AT ANY TIME. THE MECHANICS MAKE NEW COPIES FOR THEIR USE WHEN "WORD OF MOUTH" INFORMS THEM THAT A TECH ORDER REVISION HAS BEEN ISSUED.

PROPOSED METHOD : REPLACE ALL TECH ORDER MANUALS WITH PAPERLESS, COMPUTER GENERATED, ELECTRONICALLY UPDATED, CRT-AVAILABLE TECH ORDERS. LOCATE THE CRT'S SO THAT THEY ARE CONVENIENT AND ACCESSIBLE TO ALL MECHANICS. KEEP THE TECH ORDERS UPDATED SO THAT THE MECHANICS WILL ALWAYS HAVE ACCESS TO THE MOST CURRENT PROCEDURES.

BENEFIT OF CHANGE : (1) REPAIRED PARTS WILL ALWAYS BE DONE TO THE CORRECT CONFIGURATION AND PROCEDURE.
(2) TECH ORDER MANUALS WILL NOT REQUIRE PERIODIC, TIME CONSUMING UPDATING. (3) TECH ORDER UPDATES WILL OCCUR SIMULTANEOUSLY THROUGHOUT ALL THE ALC'S.

PRODUCTIVITY IMPROVEMENT SUMMARY: (1) PERSONNEL WHO USED TO UPDATE TECH ORDER MANUALS CAN BE RETRAINED FOR OTHER DUTIES. (2) PARTS THAT FORMERLY WERE REPAIRED TO OUT-OF-DATE PROCEDURES WILL NOT HAVE TO BE REDONE.

REQUESTED COST DATA FOR RRB-QF4

Cost Savings:

Present Condition Cost For the Last 12 Months:

Rework and scrap costs associated with mechanics repairing parts to unauthorized/uncontrolled copies of technical orders = \$_____.

Cost to print, distribute and incorporate all changes to the technical orders = \$_____.

Proposed Implementation Cost:

Cost involved to install CRTs on the production floor so that all mechanics will have convenient access to a CRT = \$_____.

The special data processing cost required to initiate/implement this system = \$_____.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = \$_____.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-QF2

TYPE PROPOSAL

- QUICK FIX
- FOCUS STUDY
- OTHER _____

T1 PROGRAM COST BENEFIT ANALYSIS REPORT

COMMAND _____
 ALC WIDE DATE 19 JUN 89
 RCC ALL ITEM NO. _____
 NOUN NEW PART IDENTIFICATION

808 BUTTRY

CURRENT METHOD: USUALLY, ONLY THE OUTER PACKAGING OF NEW PARTS HAS THE SUPPLIER'S CONTRACT NUMBER, VENDOR CODE, AND DATE OF MANUFACTURE. THIS IDENTIFICATION MAY BE LOST IF THE PART IS REMOVED FROM ITS OUTER PACKAGING IN ORDER TO BE STAGED FOR INSTALLATION. IF, DURING INSTALLATION, A PART IS FOUND TO BE DISCREPANT, A QDR MAY NOT RESULT IN SUPPLIER CORRECTIVE ACTION DUE TO THE LACK OF ANY OF THIS I.D. INFORMATION ON THE QDR.

PROPOSED METHOD: MANDATE A GENERAL CONTRACT P.O. REQUIREMENT THAT THE ABOVE 3 PIECES OF I.D. BE AFFIXED TO EACH PART BY THE SUPPLIER PER AN ACCEPTABLE METHOD. THE P.O. SHOULD ALSO STIPULATE THAT THE PART(S) MAY BE RETURNED TO THE SUPPLIER WHENEVER THE OUTER PACKAGE IS OPENED AND THE NOTED I.D. INFORMATION IS MISSING.

BENEFIT OF CHANGE: (1) SUPPLIERS WILL BE REQUIRED TO TAKE CORRECTIVE ACTION FOR EVERY SUPPLIER RELATED QDR. (2) ALL SUPPLIER RELATED QDR'S WILL BE ANSWERED IN A TIMELY MANNER. (3) NO PARTS STILL UNDER WARRANTY WILL BE SCRAPPED OR REPAIRED AT THE EXPENSE OF THE ALC.

PRODUCTIVITY IMPROVEMENT SUMMARY: THERE WILL BE LESS DOWNTIME FROM RECURRING DISCREPANCIES FOR NEW PARTS AS SUPPLIERS ARE REQUIRED TO ACCEPT THE RESPONSIBILITY FOR CORRECTIVE ACTION ON QDR'S WITH PROPERLY DOCUMENTED PART IDENTIFICATION.

REQUESTED COST DATA FOR RRB-QF2

Cost Savings:

Cost Improvement Data:

Present Condition Cost For the Last 12 Months:

Cost to replace all new purchased parts that were scrapped at the expense of the ALC due to the lack of necessary supplier I.D. at installation = \$_____.

Cost to repair all new purchased parts at the expense of the ALC due to the lack of necessary supplier I.D. at installation = \$_____.

Proposed Implementation Cost:

Cost incurred by ALC purchasing office to insert the noted P.O. requirement (ref. "Proposed Method," page 1) = \$_____.

Estimated additional annual cost by all ALC new parts suppliers to implement the noted I.D. requirement as specified (ref. "Proposed Method," page 1) = \$_____.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = \$_____.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-QF1

TI PROGRAM COST BENEFIT ANALYSIS REPORT

COMMAND _____
 ALC WIDE _____ DATE 19 JUN 89
 RCC ALL _____ ITEM NO. _____
 NOUN NEW PART WARRANTIES _____

TYPE PROPOSAL

- QUICK FIX
- FOCUS STUDY
- OTHER _____

CURRENT METHOD : SUPPLY RECEIVES AND STORES NEW SUPPLIER PARTS FOR SUBSEQUENT DISTRIBUTION AND USAGE BY ALC SHOPS. NO STOCK ROTATION METHOD IS BEING USED TO ASSURE A "FIRST IN - FIRST OUT" DISTRIBUTION OF THESE PARTS. NEW PARTS HAVE A WARRANTY THAT IS VALID FOR A SPECIFIED PERIOD OF TIME. THIS WARRANTY BECOMES VOID WHEN DISCREPANT NEW PARTS ARE NOT DISCOVERED WITHIN THIS TIME PERIOD.

PROPOSED METHOD : TO AVOID THE ABOVE, SUPPLY SHOULD DATE STAMP EVERY PART, OR THE OUTER PACKAGE OF EVERY PART, AS IT IS RECEIVED. SUPPLY SHOULD THEN STORE AND ROTATE THE NEW PARTS STOCK SO THAT THE OLDEST DATE STAMPED PART IS ISSUED TO THE PRODUCTION SHOP FIRST.

BENEFIT OF CHANGE: (1) SUPPLIERS OF DISCREPANT PARTS UNDER WARRANTY WILL BE REQUIRED TO REPLACE OR REPAIR THEM AT NO COST TO THE ALC. (2) THE DISCOVERY OF NUMEROUS DISCREPANT PARTS WITHIN A CONTRACT LOT USUALLY ALLOWS THE ALC TO RETURN THAT ENTIRE LOT TO THE SUPPLIER FOR PARTS SCREENING AND SUBSEQUENT REPLACEMENT OR REPAIR AT THE SUPPLIER'S EXPENSE. (3) SUPPLIER CORRECTIVE ACTION BECOMES MORE TIMELY, RESPONSIVE, AND EFFECTIVE. (4) UNRELIABLE SUPPLIERS ARE ELIMINATED EARLY-ON.

PRODUCTIVITY IMPROVEMENT SUMMARY: CYCLE AND FLOW TIMES BECOME REDUCED WHEN MECHANICS NO LONGER MUST REPAIR NEW PARTS PRIOR TO USING THEM.

OR IN ACCORDANCE WITH THE WARRANTY TERMS.

REQUESTED COST DATA FOR RRB-QF1

Cost Savings:

Present Condition Cost For the Last 12 Months:

- (A) Cost of scrapping all new purchased parts at the expense of the ALC due to expired warranties = \$_____.
- (B) Cost of repairing all new purchased parts at the expense of the ALC due to expired warranties = \$_____.

Proposed Implementation Cost:

Labor costs involved to date stamp the new purchased parts and rotate the oldest stock forward during the storage of new parts = \$_____.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = \$_____.

"IN" DAT PROFILE

NAME HEILA BATES ALC OK DATE 5/26/87 RCC MATPCM SHEET 1 OF 1

FCN MSN PIN	PARENT WCD	"M" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	PARENT WCD DATE	Δ TIME (DAYS)
98210A					
1	88305	88305	88306		1
2	88305	88305	88306		1
3	88305	88305	88306		1
4	88334	88334	88335		1
5	88334	88334	88335		1
6	89006	89006	89009		3
7	89006	89006	89009		3
8	89012	89012	89013		1
9	89012	89012	89013		1
10	89012	89012	89013		1
					MISSION: 1

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

"OUT" DATES PROFILE

NAME SHEILA BATES ALC OC DATE 5/26/89 RCC MATPCA SHEET 1 OF 1

PCH 98210A PARENT WCD 88336 PARENT WCD DATE 5/26/89

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	TIME (DAYS)
1	883367	88307	0
2	883367	88307	0
3	883367	88307	0
4	88336	88336	0
5	88336	88336	0
6	89010	89010	0
7	89010	89010	0
8	89017	89017	0
9	89017	89017	0
10	89017	89017	0
			MEDIAN 0

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

5.1 PROFILE DATA FILES

The profile data files for RCC MATPCM were previously submitted under memo number NKE-E016-7687, dated August 29, 1989.

5.2 MODEL INPUT FILES

The model input files for RCC MATPCM were previously submitted under memo number NKE-E016-7687, dated August 29, 1989.

6.0 VALIDATION OF INPUT DATA

All profile data was validated in accordance with paragraph 7.2 and 7.3 of the Simulation Model Definition Document (SMDD). The profile data files included in this document were validated and accurately represent MATPCM.

7.0 COMPUTER SIMULATION ANALYSIS OF RCC

The computer simulation analysis for RCC MATPCM was previously submitted under memo number NKE-E016-7687, dated August 29, 1989.

8.0 VALIDATION OF SIMULATION ANALYSIS

The validation of simulation analysis for RCC MATPCM was previously submitted under memo number NKE-E016-7687, dated August 29, 1989.

9.0 BRAINSTORMING

The minutes for RCC MATPCM brainstorming were previously submitted under memo number NKE-E016-7687, dated August 29, 1989.

10.0 EXPERIMENTATION

Experimentation is the process by which the factors and levels developed in brainstorming are tested for interaction and effect. The factors and levels identified are fitted into a Taguchi orthogonal array, which then defines the experimental design. Changes in quality characteristics, such as throughput and/or simulated process flow times, are then analyzed as experimental results. Taguchi methodology is used in performing this analysis.

It is important to understand the process by which experimentation is developed if useful information is to be obtained. For this reason, the following discussion will attempt to define certain terms, approaches, and desired results in regard to the experimentation process.

It is often the case that technical information needed for making a decision regarding a process or product is unknown. Since this information is in most cases needed as quickly and inexpensively as possible, the Taguchi method of using fractional factorials in the form of orthogonal arrays is considered a method of choice.

Two terms require definition due to their fundamental importance in developing and interpreting the orthogonal array. A factor is a parameter purposefully altered so that resulting changes in the output variable may be observed. Levels are the different settings for each factor in a designed experiment.

The advantages of using orthogonal arrays are: ~~but~~ The main effects of factors under test are balanced and separable, the number of experiments required is greatly reduced, and the ease with which test planning and data analysis may be performed. This allows the arrays to be applied to a broad spectrum of problem identification and analysis.

Test matrices developed by Dr. Taguchi, et al, are applied to the orthogonal array for which it is applicable. Mathematical analysis of the quality characteristic chosen is then accomplished using the test matrices to find the best combination of factors and levels. The convention for identification of test matrices is as follows:

Where $N = \text{number of experimental runs.}$ $L_n(J^k)$ ← capital J
 $J = \text{number of levels.}$

K = maximum number of factors that may be included in test.

Two factors are said to interact (in their effect on the output variable) if the effect of one factor is different at the different levels of another factor. If two factors physically interact, that effect can be identified in the test results.

Control

A note on noise: ~~control~~ control factors are those factors easily adjusted during product design and process design. Noise factors are ~~noise~~ factors which are difficult or impossible to adjust during production or customer use. Selection of those factors easiest to adjust is the best procedure when test planning begins. Because the UDOS 2.0 model produces noise-free output (100% reproducible), only control factors are included in model experimental designs.

It is important to remember that for the effective use of the UDOS 2.0 simulation model for experimental simulation analysis, the correct factors and levels must be identified and developed during initial test planning. The model allows a comparative analysis of the selected factors and levels, with identification of the best combination of these. It must be remembered that this may not be the optimal solution to a process or product problem, the factors and levels of which may not have been defined.

Numerous works have been produced regarding the use of Taguchi analysis in problem identification and solving in industrial settings. The reader is encouraged to examine this material, including the fundamental work of Dr. Taguchi, for specific applications and techniques.

10.1 MATPCM EXPERIMENTATION RESULTS

A statistical analysis was performed on throughput and flow time (actual vs. simulated) for the validated model run. The results of this analysis are shown in Tables 10-1. These results form a baseline to which the quality characteristics from the experimental model runs are compared.

The orthogonal array developed during brainstorming is shown in table 10-2. It lists the factors and levels which will form the experimental design. The use of this array reduces the number of experimental runs from 8 to 4. The experimental runs are performed on the UDOS 2.0 model using the existing (AS-IS) conditions for FY88. Note that due to the fact that throughput was 100% for all experimental runs, it is now necessary to use average simulated flow time as the quality characteristic for comparative analysis. Table 10-3 gives the result of this analysis, beginning with the average flow times of each experimental run and showing the interaction among factors and levels. The Taguchi test matrix is shown to the right of these listings. The optimal configuration is given as:

FACTOR:	A	B	C
LEVEL:	1	N/A	N/A

This configuration is interpreted as the following: (1) The AS-IS condition for manpower is slightly more advantageous than reducing the number of AJ09s by six, (2) No appreciable benefit seen from reducing the machine setup times, and (3) No appreciable savings by reducing the machine process times by 2%. Note that the average savings in flow time is (simulated) 90.71 vs. 90.84 hours for the AS-IS condition. Given these

results, it would be very difficult to recommend any of the changes suggested. In the case of manpower, redistribution of these highly skilled machine tool operators into machine shops less well staffed might be considered. It may also be the case that effects of batching is obscuring benefits gained from setup time reduction.

The detailed results of these runs by PCN may be found in appendix A. The computer generated analysis sheets contained in appendix A, which is formed from a LOTUS 123 spreadsheet program, contain an extensive Taguchi analysis using the quality characteristics of Throughput (simulated vs. actual) and Simulated Flow Time.

10.2 SURGE ANALYSIS

Surge production capability for this RCC was performed by running a model Usage Report using the FY88 data with the surge conditions for various weapons systems as reported by ALC Headquarters. The usage report was adjusted to show the surge conditions for manpower and equipment of a seven day work week and two twelve hour shifts. The analysis of this data shows that MATPCM is a very robust production area, fully capable of meeting projected surge conditions with the present level of manpower and equipment. It should be mentioned that the existing level of experience and expertise may be directly affecting the throughput and flow hours shown. In general, skilled machinists are more difficult to train and replace than certain other skills, and often capable of being immediately productive if needed in other, less well manned areas.

**MATPCM AVERAGE SIMULATED
THROUGHPUT STATISTICAL ANALYSIS**
TABLE ~~5752~~ 10-1

PART CONTROL NUMBER (PCN)	SIMULATED	FY 88 ACTUALS	% VARIANCE (SIM /ACTUALS)
49802A	574	578	-1%
49805A	610	612	-.33%
49806A	332	338	-2%
49810A	363	363	0%
98034A	206	199	3%
98042A	285	280	2%
98043A	306	300	2%
98057A	190	195	-3%
50067A	3,736	3,732	-.11%
38691A	27	27	0%
98206A	50	50	0%
38690A	12	12	0%
49779A	70	70	0%
38685A	39	39	0%
50126A	6	6	0%
30241A	528	525	1%
38718A	355	355	0%
50281A	659	659	0%
61138A	843	851	-1%
38677A	434	433	-.23%
50127A	8	8	0%
37719A	193	192	1%
97168A	545	539	1%
98210A	510	512	-.39%
50161A	44	44	0%
50134A	106	107	-1%
SHOP AVERAGE	11,031	11,026	.05%

LSC-20515

L₄ ORTHOGONAL ARRAY EXPERIMENTAL RESULTS FOR MATPCM

TABLE ~~6-10-2-2~~ 10-2

EXP #	A MANPOWER	B SET-UP REDUCTION	C PROCESS TIME REDUCTION	NORMAL WORKLOAD		
				AVG	BEST	WORST
1	AS-IS	AS-IS	AS-IS	100 %	98034A 100%	98067A 89%
2	AS-IS	30% REDUCTION	2% REDUCTION	100 %	98034A 102%	98067A 84%
3	6 LESS AJOs	AS-IS	2% REDUCTION	100 %	98034A 102%	98067A 84%
4	6 LESS AJOs	30% REDUCTION	AS-IS	100 %	98034A 102%	98067A 82%

LSC-20512

**MATPCM EXPERIMENTAL
FLOW TIME AVERAGES STATISTICAL COMPARISON
TABLE ~~10-3~~ 10-3**

EXPERIMENTAL FLOW TIME AVERAGES -

EXP. 1	90.04
EXP. 2	89.83
EXP. 3	92.24
EXP. 4	92.82

FACTOR	LEVEL	
1	1	89.84
	2	92.53
2	1	91.14
	2	91.33
3	1	91.43
	2	91.04

$L_4(2^3)$

NO	1	2	3
1	1	1	1
2	1	2	2
3	2	1	2
4	2	2	1

LSC-20514

APPENDIX A
TAGUCHI ANALYSIS BY PCN
FOR EXPERIMENTAL RUNS

TAGUCHI EXPERIMENT ANALYSIS
 ALC 4 00

REQ: MATPCH RUN: AVE:SH

14 BRDLY FILE: FCHC8808

31-Jan-84

RUN NO.	LEVEL	FACTOR	RESULT	TOTAL	NOT	INJECTED	THRU	PUT	FLOW TIME	THRU	PUT
			FOR RUN	FOR RUN	FOR RUN	FOR RUN	FOR RUN	FOR RUN	EFFECT	EFFECT	PERCENT
									PERCENT	PERCENT	
1	1	1	161	167	167	167	167	167	0.12	0.00	-0.51
2	1	2	165	165	165	165	165	165	0.12	0.00	0.51
3	2	1	154	147	159	159	159	159	-0.47	0.00	0.51
4	2	2	159	168	168	168	168	168	0.47	0.00	-0.51
TOTAL			651	497	497	497	497	497	161.8	1.78	0.51
AVERAGE			162.8	124.8	124.8	124.8	124.8	124.8	0.50	1.01	0.00
MAXIMUM			166	165	165	165	165	165	1.02	1.01	0.51
MINIMUM			159	147	147	147	147	147	-1.02	1.00	-0.51

TRUCK EXPERIMENT ANALYSIS

ALC : 00 PCC : MATCH FOR : 40R1/A

LS 4000 01-Jan-90

FILE : PCH19D10

RUN NO.	FACTOR LEVEL		C	FLOW TIME	THRU PUT	RESULT	THRU PUT	INDUCTED	THRU PUT	NET	FACTOR	FOR	P/M	FLOW TIME		THRU PUT	
	1	2												EFFECT	PERCENT	EFFECT	PERCENT
1	1	1	1.00	159	196	1.00	96	96	96	176	A 1	1.00	1.00	152.0	0.14	1.00	-0.12
2	1	2	1.00	165	198	1.00	198	198	198	176	A 2	1.00	1.00	162.8	-0.14	1.00	0.12
3	2	1	1.00	163	205	1.00	205	205	205	176	B 1	1.00	1.00	157.7	0.31	1.00	0.12
4	2	2	1.00	162	02	1.00	02	02	02	176	B 2	1.00	1.00	157.7	-0.51	1.00	-0.12
TOTAL			4.00	649	573	4.00	573	573	573	176				160.5	1.01	1.00	-0.12
AVERAGE			1.00	162.2	147.3	1.00	147.3	147.3	147.3	176				162.2	0.00	1.00	0.00
MAXIMUM			1.00	165	205	1.00	205	205	205	176				167.1	1.04	1.00	0.12
MINIMUM			1.00	159	02	1.00	02	02	02	176				150.5	1.00	1.00	-0.12

TAGUCHI EXPERIMENT ANALYSIS
 ALC : OC

DATE : 01 JAN 89

FILE : PC47807A

FACTORS	LEVEL	RESULT	NET	THRU PUT	THRU PUT	THRU PUT
FACTORS	LEVEL	RESULT	THRU PUT	THRU PUT	THRU PUT	THRU PUT
FACTORS	LEVEL	RESULT	THRU PUT	THRU PUT	THRU PUT	THRU PUT
1	1	195	91	202.5	1.00	0.79
2	1	210	114	203.8	1.02	0.79
3	2	210	126	203.7	1.02	0.79
4	2	198	93	204.1	1.00	-0.79
				174.2	1.00	-0.79
				210.2	1.02	0.79
TOTAL		813	410			
AVERAGE		203.2	107.5	203.5	1.01	0.60
MAXIMUM		210	126	210.2	1.02	0.79
MINIMUM		195	93	196.5	1.00	-0.79

TAGUCHI EXPERIMENT ANALYSIS

ALC : 00 REC : MATCOY PCN : 93012A

DATE : 91-Jan-80 FILE : 00R08042

RUN NO.	LEVEL	LEVEL	LEVEL	RESULT	FLOW TIME	THRU PUT	TOTAL	NET	FACTORS	EFFECT	PERCENT	EFFECT	PERCENT
1	1	1	1	205	1.00	141	141	141	4.1	304.0	0.75	1.00	-0.15
2	1	2	1	205	1.00	187	187	187	4.7	297.1	-0.75	1.00	0.15
3	2	1	2	214	1.00	172	172	172	8.1	296.4	-1.39	1.00	0.15
4	2	2	1	200	1.00	154	154	154	8.2	292.7	1.39	1.00	-0.15
TOTAL				822	4.00	654	654	654	21.1	291.6	1.91	1.00	-0.15
AVERAGE				205.5	1.00	163.5	163.5	163.5	6.6	305.6	0.00	1.00	0.00
MAXIMUM				214	1.00	187	187	187	8.1	289.5	-1.91	1.00	0.15
MINIMUM				200	1.00	154	154	154	8.2	291.6	-1.91	1.00	0.15

TADUCHI EXPERIMENT ANALYSIS
 REC: 00

REC: MATCOM

FORM: 92055A

LA AREA

91-Jan-89

FILE: 8049804Z

RUN NO.	LEVEL	FACTOR	LEVEL	TOTAL NET	FLOW TIME THRU FBT INDUCED THIS FBT		FLOW TIME		THRU PUT		
					RESULT	RESULT	EFFECT	PERCENT	EFFECT	PERCENT	
1	1	1	1	202	1.00	129	135	0.00	0.00	1.00	0.00
2	1	2	1	210	1.00	176	178	0.00	0.00	0.99	-0.29
3	2	1	1	207	0.99	171	189	0.00	0.00	0.99	-0.29
4	2	2	1	202	1.00	172	172	0.00	0.00	1.00	0.00
TOTAL				820	3.99	607	605	0.00	0.00	0.99	-0.29
AVERAGE				205.0	1.00	151.8	151.5	0.00	0.00	1.00	0.00
MAXIMUM				210	1.00	176	176	0.00	0.00	1.00	0.00
MINIMUM				202	0.99	172	172	0.00	0.00	0.99	-0.29

TAGUCHI EXPERIMENT ANALYSIS

ALC : OC REC : MATERN FCN : 00057A

21 PRGNY 01-29-90

FILE : P002037

RUN NO.	FACTOR LEVEL		TOTAL YFT	FLOW TIME THRU PUT INDUCED THRU PUT		7.0% TIME		THRU PUT		
	LEVEL	LEVEL		RESULT	PERCENT FOR 50%	EFFECT PERCENT	EFFECT PERCENT	EFFECT PERCENT	PERCENT	
1	1	1	97	202	1.00	97	205.5	-3.54	1.00	0.74
2	1	2	113	209	1.00	113	202.1	2.84	1.00	-6.24
3	2	1	105	206	0.99	105	205.1	0.98	1.00	-0.24
4	2	2	87	188	1.00	87	203.5	0.46	1.00	0.74
							202.0	1.02	1.00	0.74
							202.6	-1.08	1.00	-0.24
			TOTAL	815	7.99	400				
			AVERAGE	203.8	1.00	100.0	202.0	0.00	1.00	0.00
			MAXIMUM	207	1.00	113	207.4	1.08	1.00	0.29
			MINIMUM	188	0.99	87	202.6	-1.08	1.00	-0.24

US ARMY 01-Jan-80
 FILE: REP51667

TABUCHI EXPERIMENT ANALYSIS
 ALC: 00 REG: MAYFOR PDU: SADATA

FACTOR	LEVEL	RESULT	TURB. TIME	FLOW TIME	THRU PUT
1	2	3	4	5	6
1	1	39	1.00	1.00	1.00
1	2	39	1.00	1.00	1.00
2	1	39	1.00	1.00	1.00
2	2	38	1.00	1.00	1.00
TOTAL		155	4.00	7513	7554
AVERAGE		39.0	1.00	1257.0	1289.5
MAXIMUM		39	1.00	2153	2158
MINIMUM		38	1.00	1634	1674

FACTOR	LEVEL	RESULT	TURB. TIME	FLOW TIME	THRU PUT
1	2	3	4	5	6
1	1	39	1.00	1.00	1.00
1	2	39	1.00	1.00	1.00
2	1	39	1.00	1.00	1.00
2	2	38	1.00	1.00	1.00
TOTAL		155	4.00	7513	7554
AVERAGE		39.0	1.00	1257.0	1289.5
MAXIMUM		39	1.00	2153	2158
MINIMUM		38	1.00	1634	1674

TABUCHI EXPERIMENT ANALYSIS

ALC : 00 RCD : WATER PDI : 363710

LS 46649 FILE : 00479971

21-3-70-20

RUN NO.	LEVEL	FACTOR	RESULT	NET	FOR RUN	FOR RUN	FOR RUN	NET	FLOW TIME	EFFECT PERCENT	THRU PUT	EFFECT PERCENT
1	2	3	4	5	6	7	8	9	10	11	12	13
1	1	1	41	1.00	57	53	0 1	53	78.1	6.73	1.00	6.03
2	1	2	39	1.00	12	12	0 2	12	77.0	6.70	1.00	6.63
3	2	1	42	1.00	11	11	0 1	11	76.2	-1.03	1.00	6.43
4	2	2	35	1.00	56	54	0 2	54	76.5	1.07	1.00	6.00
							0 1		75.1	-4.19	1.00	6.20
							0 2		73.5	6.70	1.00	6.55
			TOTAL	145	4.00	172		172				
			AVERAGE	35.8	1.00	77.9		77.9	75.3	0.00	1.00	6.60
			MAXIMUM	51	1.00	56		56	75.1	6.74	1.00	7.00
			MINIMUM	32	1.00	11		11	77.5	-6.38	1.00	6.63

LAB APPAR 01-140-83
FILE 1 PER0206

TRAGUCHI EXPERIMENT ANALYSIS
ALC 1 00 RCU 1 MATFON PCY 00006A

RUN NO.	FACTOR LEVEL		RESULT	FLOW TIME THRU PUT INDICIES THRU SU		TOTAL NET	FLOW TIME		THRU PUT	
	A	B		PERCENT	PERCENT		EFFECT	PERCENT		
1	1	1	34	1.06	22	37.7	2.50	1.00	-1.54	
2	1	2	31	1.00	24	35.1	-2.50	1.03	1.54	
3	2	1	36	1.06	17	34.9	-1.48	1.52	1.54	
4	2	2	35	1.00	24	33.9	1.48	1.00	-1.54	
TOTAL			136	4.06	213	34.4	0.00	1.02	0.00	
AVERAGE			34.4	1.02	53.3	35.1	2.50	1.03	1.54	
MAXIMUM			36	1.06	22	33.7	-2.50	1.00	-1.54	
MINIMUM			31	1.00	24					

TAGUCHI EXPERIMENT ANALYSIS

ALC : OC REC : MATCOX PVM : 321218

LA AREA

11-100-80
FILE : 90218770

RUN NO.	LEVEL	A	B	C	FLOW TIME THRU PUT RESULT	RESULT	DESIGN FOR RUN	INDICATED THRU PUT	TOTAL	NCT	FACTOR	EFFECT PERCENT	F OR TYPE	EFFECT PERCENT	THRU PUT	EFFECT PERCENT
1	1	1	1	1	38	1.00	80	80	164	177	A 1	32.5	10.67	1.00	0.80	
2	1	2	1	1	35	1.00	7	7	40.9	43.3	A 2	45.5	-10.87	1.00	0.80	
3	2	1	1	2	57	1.00	8	8	57	59	B 1	47.8	-16.78	1.00	0.80	
4	2	2	1	1	37	1.00	76	76	164	177	B 2	33.9	16.78	1.00	0.80	
									164	177	C 1	35.7	12.75	1.00	0.80	
									164	177	C 2	36.1	-12.75	1.00	0.80	
									40.9	43.3		10.1	0.00	1.00	0.80	
									57	59		47.8	16.98	1.00	0.80	
									33	3		37.5	-16.68	1.00	0.80	

TOTAL

AVERAGE

MAXIMUM

MINIMUM

TAGUCHI EXPERIMENT ANALYSIS

ALC : OC RCO : MATPCN PCN : 47754

LD ARRAY

01-24-80
PCN47779

RUN NO.	LEVEL	LEVEL	LEVEL	FACTOR	NET	TOTAL		FLOW TIME		THRU/PUT		
						RESULT	PERCENT FOR RUN	RESULT	PERCENT	EFFECT	PERCENT	
1	1	1	1	1	412	97	1.00	75.4	0.17	1.00	-0.65	
2	1	2	1	2	76	94	1.00	95.7	-0.17	1.01	0.55	
3	2	1	2	1	79	98	1.03	77.7	0.25	1.01	0.45	
4	2	2	1	2	309	93	1.00	92.4	0.31	1.00	-0.65	
				1				95.1	0.27	1.00	-0.45	
				2				95.9	-0.27	1.01	0.45	
				TOTAL	879	382	1.07					
				AVERAGE	219.8	95.6	1.01	95.6	0.00	1.01	0.00	
				MAXIMUM	416	98	1.07	97.7	2.05	1.01	0.55	
				MINIMUM	74	93	1.00	77.4	-2.05	1.00	-0.45	

TAGUCHI EXPERIMENT ANALYSIS

ALC : QC REC : MATCON PCH : T305FA

L4 ARRAY 01-146-89

FILE : PORTPASS

RUN NO.	FACTOR LEVEL		TOTAL NET	FLOW TIME (THRU) FOR INJECTED THRU FWT	RESULT	FURTHER FOR RUN FOR RUN	FURTHER	FLOW TIME		THRU PUT	
	A	B						EFFECTY PERCENT	EFFECTY PERCENT	EFFECT PERCENT	EFFECT PERCENT
1	1	1	177	70	1.00	177	0.1	59.8	1.02	1.00	-1.12
2	1	2	15	69	1.00	15	0.2	63.6	1.27	1.02	1.12
3	2	1	45	69	1.05	45	0.1	52.6	1.27	1.22	1.12
4	2	2	112	66	1.00	112	0.2	47.8	1.20	1.00	-1.12
							0.1	56.5	0.22	1.00	-1.12
							0.2	45.8	-0.22	1.02	1.12
			275		1.05	272					
			AVERAGE	28.7	1.11	42.0		10.7	0.00	1.01	0.00
			MAXIMUM	70	1.05	177		69.8	1.67	1.02	1.12
			MINIMUM	66	1.00	15		57.6	-1.03	1.00	-1.12

TAPUCHI EXPERIMENT ANALYSIS

ALC 3 -0C
 REF : MATOON PEA SWITZER
 FILE : POMESIGA

RUN NO.	FACTOR LEVEL		TOTAL	NPT	FLOOR TIME	PERCENT INDICES THRU PIT	RESULT	RESULT FOR RUN	FOR RUN	FACTOR	FLSM TIME		THRU PUT	
	LEVEL	LEVEL									PERCENT	PERCENT	EFFECT	PERCENT
1	1	1	1.00	37	1.77	1.00	1.77	1.00	1.00	1.00	1.00	1.00	1.00	1.00
2	1	2	1.00	7	1.77	1.00	1.77	1.00	1.00	1.00	1.00	1.00	1.00	1.00
3	2	1	1.00	4	1.77	1.00	1.77	1.00	1.00	1.00	1.00	1.00	1.00	1.00
4	2	2	1.00	79	1.77	1.00	1.77	1.00	1.00	1.00	1.00	1.00	1.00	1.00
TOTAL			4.00	173	1.77						1.77	1.77	1.77	1.77
AVERAGE			1.00	43.3	1.77						0.44	0.44	0.44	0.44
MAXIMUM			1.00	97	1.77						1.77	1.77	1.77	1.77
MINIMUM			1.00	7	1.77						1.77	1.77	1.77	1.77

TAGUCHI EXPERIMENT ANALYSIS

FILE: 01-128-80
 FILE: 00000001

RUN NO.	LEVEL	FACTOR	RESULT	FLOW TIME	THRU PUT	EFFECT PERCENT	EFFECT PERCENT	TOTAL	NET	FLOW TIME		THRU PUT	
										PERCENT	PERCENT	EFFECT PERCENT	EFFECT PERCENT
1	1	1	37	1.50	12	37.2	0.52	1.00	0.21	37.4	1.00	0.52	0.21
2	1	2	37	1.00	372	37.4	0.52	1.00	0.21	37.4	1.00	0.52	0.21
3	2	1	37	1.00	357	37.6	0.76	1.00	0.21	37.6	1.00	0.76	0.21
4	2	2	39	1.00	30	37.8	-0.96	1.00	-0.21	37.8	1.00	-0.96	-0.21
TOTAL			150	4.00	704	37.5	-0.31	1.00	0.21	37.5	1.00	-0.31	0.21
AVERAGE			37.4	1.00	236.3	37.4	0.00	1.00	0.00	37.4	1.00	0.00	0.00
MAXIMUM			39	1.00	307	37.8	0.76	1.00	0.21	37.8	1.00	0.76	0.21
MINIMUM			37	1.00	30	37.0	-0.96	1.00	-0.21	37.0	1.00	-0.96	-0.21

TAGUCHI EXPERIMENT ANALYSIS

ALC : OC REC : HATPCB PCN : 50821A

US ARMY FILE : PMS0281

RUN-NO.	LEVEL	LEVEL	LEVEL	LEVEL	RESULT	RESULT	RESULT	RESULT	RESULT	FACT	EFFECT	PERCENT	EFFECT	PERCENT	EFFECT	PERCENT
1	1	1	1	1	61	1.00	292	372	A	1.00	1.11	0.50	1.00	1.00	-0.50	
2	1	2	1	1	51	1.00	328	372	A	1.00	1.11	0.50	1.00	1.00	0.50	
3	2	1	1	2	60	1.02	351	350	B	0.72	-0.72	0.50	1.00	1.00	-0.50	
4	2	2	1	2	58	1.00	265	354	B	0.72	0.72	0.50	1.00	1.00	-0.50	
TOTAL					240	4.02	1271	1270			0.7	0.50	1.00	1.00	0.50	
AVERAGE					60.1	1.00	307.8	317.0			0.50	0.50	1.00	1.00	0.50	
MAXIMUM					61	1.02	351	350			1.11	0.50	1.00	1.00	0.50	
MINIMUM					58	1.00	265	351			-1.11	0.50	1.00	1.00	-0.50	

TAGUCHI EXPERIMENT ANALYSIS

ACC: DC ACC: MATPC PDR: 21138A

EX: 0804Y FILE: PERM1130

RUN NO.	LEVEL	FACTOR	RESULT	THRU PUT	TOTAL	NET	FLOW TIME	EFFECT	PERCENT	THRU PUT	EFFECT	PERCENT
A	B	C	FLOW TIME	THRU PUT	INDUCTED	THRU PUT	FLOW TIME	EFFECT	PERCENT	THRU PUT	EFFECT	PERCENT
1	1	1	99	1.00	285	375	99.2	1.00	-0.57	1.00	1.00	-0.68
2	1	2	97	1.00	291	341	97.0	1.00	0.56	1.00	1.00	0.88
3	2	1	98	1.00	310	311	99.1	1.00	-0.73	1.00	1.00	0.60
4	2	2	96	1.00	309	339	96.9	1.00	0.55	1.00	1.00	-0.68
TOTAL			390	4.00	1195	1197	97.7	1.00	-0.13	1.00	1.00	-0.68
AVERAGE			97.6	1.00	298.5	298.8	97.5	1.00	0.00	1.00	1.00	0.00
MAXIMUM			99	1.00	319	311	97.3	1.00	0.77	1.00	1.00	0.88
MINIMUM			96	1.00	285	335	96.9	1.00	-0.77	1.00	1.00	-0.68

TASUCHI EXPERIMENT ANALYSIS

ALC : QC

REQ : NAIPEH

REV: 00527A

14 AFREY

01-Jan-80

FE : 0039677

RUN NO.	FACTOR LEVEL			TOTAL	NET	FLOW TIME THRU FIT INCLUDED THRU FIT RESULT	PERCENT FOR RUN	FACTOR	FLOW TIME		GRIND TIME	
	A	B	C						EFFECT	PERCENT	EFFECT	PERCENT
1	1	1	1	150	180	37	1.00	A 1	37.3	-1.80	1.70	-0.33
2	1	2	1	241	241	37	1.00	A 2	34.2	1.40	1.91	0.33
3	2	1	2	227	220	36	1.01	B 1	36.8	-0.37	1.61	1.33
4	2	2	1	172	172	36	1.00	B 2	36.5	0.37	1.90	-0.33
								E 1	34.7	-0.12	1.70	-0.33
								E 2	36.6	0.12	1.61	0.33
				147	806							
						36.7	1.00		36.7	0.00	1.60	0.00
						37	1.01		37.7	1.40	1.61	0.33
						36	1.00		36.0	1.40	1.60	0.33

TOTAL

AVERAGE

MAXIMUM

MINIMUM

TAGUCHI EXPERIMENT ANALYSIS
 ALC: 100

REQ: MATPCB PWS: 50127A

14 ARRAY FILE: PCH50127
 91-JAN-60

RUN-NO.	FACTOR-LEVEL		C	FLOW-TIME THRU PUT RESULT	INDUCED THRU PUT FOR RUN	NET	TOTAL	A	B	C	FLOW TIME		THRU PUT		
	1	2									EFFECT	PERCENT	EFFECT	PERCENT	
1	1	1	2	1.00	19	39	4	1	1	1	2.3	1.70	1.00	0.00	
2	1	2	2	1.00	7	6	4	1	1	1	2.3	-1.70	1.00	0.00	
3	2	1	2	1.00	5	5	6	1	1	1	2.3	2.17	1.00	0.00	
4	2	2	2	1.00	19	75	8	2	1	1	2.3	2.17	1.00	0.00	
TOTAL				9	4.0	89	94					2.3	1.70	1.00	0.00

AVERAGE 2.3 1.00 22.3 77.7 2.3 2.00 1.00 0.00

MINIMUM 2 1.00 39 79 2.3 2.17 1.00 0.00

MAXIMUM 2 1.00 5 5 2.3 -2.17 1.00 0.00

TAKUCHI EXPERIMENT ANALYSIS

ALC # 00

REQ # MATPCB

PCN 071620

DATE

01-Jan-80

TIME : 0847:00

RUN NO.	LEVEL	A	B	C	D	FLEX TIME	THRU PUT	RESULT	NET	TOTAL	NET	THRU PUT	EFFECT	PERCENT	THRU PUT	EFFECT	PERCENT		
																		PERCENT	PERCENT
1	1	1	1	1	1	67	1.00	222	222	222	1.00	1.00	0.00	0.00	1.00	0.00	0.00		
2	1	2	1	1	1	66	1.00	277	277	277	1.00	1.00	0.79	0.79	1.00	0.79	0.79		
3	2	1	1	2	1	64	1.00	318	318	318	1.00	1.00	0.35	0.35	1.00	0.35	0.35		
4	2	2	1	1	2	65	1.00	219	219	219	1.00	1.00	-0.79	-0.79	1.00	-0.79	-0.79		
TOTAL		263		4.12		1052		1052		1052		1.00		1.00		1.00		0.00	
AVERAGE		65.6		1.00		263.0		263.0		263.0		1.00		1.00		1.00		0.00	
MAXIMUM		67		1.00		318		318		318		1.00		1.00		1.00		0.35	
MINIMUM		64		1.00		219		219		219		1.00		1.00		1.00		-0.79	

TAGUCHI EXPERIMENT ANALYSIS

ALC : DC REC : MATCOH PER : ST2024

SI : ANOVA 01-24-80

FILE : PCKR90C

RUN NO.	LEVEL	A		B		C		TOTAL	VCT	FLUX TIME		YIELD PBT	
		LEVEL	RESULT	LEVEL	RESULT	LEVEL	RESULT			PERCENT	PERCENT	PERCENT	PERCENT
1	1	1	187	1	1.01	195	1	185.1	1.00	1.00	1.00	0.15	
2	1	2	167	1	1.00	206	2	181.1	1.00	1.00	1.00	0.15	
3	2	1	185	2	0.98	201	1	181.9	0.99	0.99	0.99	1.00	
4	2	2	157	1	1.07	184	2	182.1	0.97	1.01	1.01	1.00	
								181.0	1.00	1.01	1.01	1.00	
								180.2	1.00	0.99	0.99	-1.22	
								962	901				
								249.5	249.7	100.0	100.0	0.00	
								167	204	100.0	1.01	1.20	
								157	184	100.0	0.97	-1.22	

TABULAR EXPERIMENT ANALYSIS

ALC : 00 REC : MATTEL FCN : 001104

SE ARMY

SI 30109
TITLE : PMSRBL1

RUN NO.	FACTOR LEVEL		TOTAL NET	FLOW PIPE THROUGH INDICATED THRU CUT RESULT	FLOW PIPE THROUGH INDICATED THRU CUT RESULT	FLOW TIME EFFECT PERCENT	THRU PUT EFFECT PERCENT
	A	B					
1	1	1	380	35	1.00	75.8	1.57
2	1	2	370	37	1.00	75.8	1.57
3	2	1	392	36	1.01	75.9	0.75
4	2	2	475	35	1.00	75.2	-0.75
TOTAL			1527	144	1.01	1551	1505
AVERAGE			381.7	36.1	1.00	375.7	371.1
MAXIMUM			482	37	1.01	482	482
MINIMUM			302	35	1.00	302	302

RUN NO.	FACTOR LEVEL		TOTAL NET	FLOW PIPE THROUGH INDICATED THRU CUT RESULT	FLOW PIPE THROUGH INDICATED THRU CUT RESULT	FLOW TIME EFFECT PERCENT	THRU PUT EFFECT PERCENT
	A	B					
1	1	1	380	35	1.00	75.8	1.57
2	1	2	370	37	1.00	75.8	1.57
3	2	1	392	36	1.01	75.9	0.75
4	2	2	475	35	1.00	75.2	-0.75
TOTAL			1527	144	1.01	1551	1505
AVERAGE			381.7	36.1	1.00	375.7	371.1
MAXIMUM			482	37	1.01	482	482
MINIMUM			302	35	1.00	302	302

TAGUENT EXPERIMENT ANALYSIS
 SLC : 00 RDC : MATCOX FCN : 30134 Q APPA : 01-140-00 FILE : 2025013

RUN NO.	FACTOR LEVEL		RESULT	FLOW TIME	TYPE PUT	INDICATED	TOTL	NET	FLOW TIME		TYPE PUT	
	A	B							POP RUN	POP RUN	EFFECT	PERCENT
1	1	1	37	1.02	157	107	0.1	107	37.5	-3.18	1.00	-0.50
2	1	2	39	1.00	99	79	0.2	79	34.9	3.40	1.02	0.80
3	2	1	35	1.03	31	72	0.1	72	34.0	0.55	1.02	0.95
4	2	2	34	1.00	156	156	0.2	156	33.4	-0.56	1.00	-0.80
TOTAL			145	4.02	375	777	0.2	777	35.5	2.12	1.00	-0.80
AVERAGE			36.2	1.01	93.7	93.7		93.7	35.2	0.00	1.01	0.00
MAXIMUM			39	1.02	157	157		157	37.6	3.08	1.02	0.80
MINIMUM			34	1.00	20	20		20	34.9	-3.58	1.00	-0.80

TABULAR EXPERIMENT ANALYSIS

ALC 00 REC: MATDN PCT: 5.0124

EXACTY FILE: 0155191

RUN NO.	LEVEL	FACTOR	LEVEL	RESULT	FLOW TIME	TRYS	TIME	PERCENT	PERCENT	PERCENT	PERCENT
1	1	1	1	1.00	51	14	0.1	0.00	0.00	0.00	0.00
2	1	2	1	1.00	43	17	0.1	0.00	0.00	0.00	0.00
3	2	1	2	1.00	47	17	0.1	0.00	0.00	0.00	0.00
4	2	2	1	1.00	42	17	0.1	0.00	0.00	0.00	0.00
		TOTAL		9	180	145					
		AVERAGE		2.3	47.0	47.0					
		MAXIMUM		2	43	17					
		MINIMUM		2	47	17					

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-QF7

**T1 PROGRAM
COST BENEFIT ANALYSIS REPORT**

TYPE PROPOSAL	
<input checked="" type="checkbox"/>	QUICK FIX
<input type="checkbox"/>	FOCUS STUDY
<input type="checkbox"/>	OTHER

ALC ALL DATE 13 JUN 89
 RCC ALL ITEM NO. _____
 NOUN INSPECTION

BOB BUTTRY

CURRENT METHOD : QDR'S ARE WRITTEN DESCRIBING KNOWN DISCREPANCIES ON PARTS IN STORAGE. THE STORE'S MANAGER DECIDES ON HIS OWN INITIATIVE IF A PART SO DESCRIBED AS POTENTIALLY DISCREPANT WILL OR WILL NOT BE INSPECTED (SCREENED) FOR THE NOTED QDR DISCREPANCY PRIOR TO RELEASING THESE PARTS FROM THE STORAGE AREA. THIS AFFECTS PRODUCTIVITY AS BAD PARTS ARE FIRST DISCOVERED ON THE PRODUCTION FLOOR.

PROPOSED METHOD: REQUIRE ALL PARTS IN STORES TO BE SCREENED FOR QDR NOTED DISCREPANCIES ACCORDING TO A SET CRITERIA RELATING TO THE NUMBER OF PARTS OR THE NUMBER OF TIMES A PART IS FOUND TO BE DISCREPANT ON THE PRODUCTION FLOOR.

BENEFIT OF CHANGE : PRODUCTIVITY WILL NOT BE IMPACTED IF DISCREPANT PARTS ARE REMOVED FROM STORES BEFORE SENDING THESE SCREENED PARTS TO THE PRODUCTION FLOOR.

PRODUCTIVITY IMPROVEMENT SUMMARY: DOWNTIME AND FLOWTIME WILL BE REDUCED BY REMOVING DISCREPANT PARTS FROM SUSPECT LOTS OF PARTS IN STORAGE PRIOR TO SENDING THESE PARTS INTO PRODUCTION.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 89-035F

TI PROGRAM COST BENEFIT ANALYSIS REPORT

ALC OC DATE 5/13/89
RCC MATPCM ITEM NO. _____
NOUN DIGITAL REARVIEW ENGINE CATHES

TYPE PROPOSAL

- QUICK FIX
- FOCUS STUDY
- OTHER _____

CURRENT METHOD

THERE ARE CURRENTLY 3 MANUAL ENGINE CATHES AND 1 DIGITAL REARVIEW POSITIONING ENGINE CATHES IN MACHINE SHOP MATPCM. THE DIGITAL ENGINE CATHES IS WORKED ONLY WHEN IT IS AVAILABLE.

PROPOSED METHOD

INCREASE THE LED DIGITAL REARVIEW POSITIONING EQUIPMENT FOR ALL THE MANUAL ENGINE CATHES.

BENEFIT OF CHANGE

SET-UP TIMES CAN BE REDUCED BY AT LEAST 25% AND THE QUALITY OF FINISHED PARTS ARE FAR SUPERIOR TO MANUALLY GAINED PARTS.

PRODUCTIVITY IMPROVEMENT SUMMARY

A COST JUSTIFICATION STUDY WILL BE NEEDED TO DETERMINE THE PAYBACK PERIOD.

RF

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 89-036F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- QUICK FIX
- FOCUS STUDY
- OTHER _____

ALC OC DATE 5/13/89
RCC BACK SHOPS ITEM NO. _____
NOUN COMPUTERIZED MRP II SYSTEM

CURRENT METHOD

PARTS THAT NEED MACHINING OR REPAIR FROM OTHER RCCS WILL BE PLACED ON THE RECEIVING CABET IN DARTPEN. THE PARTS WILL BE WORKED ON A FIFO BASIS TYPICALLY, HOWEVER, IF A PARTICULAR PART COMES TO THE UNIT AND IS CONSIDERED A "RUSH", IT MIGHT NOT GET WORKED UNTIL LATER BE THE OPERATORS DO NOT KNOW IT IS A "RUSH".

PROPOSED METHOD

INSTALL AN RCC-WIDE MRP II SYSTEM TO ENABLE OPERATORS AND SUPERVISORS TO KNOW THE SCHEDULE STATUS OF ANY PARTICULAR PART THEY ARE CONCERNED WITH. A TERMINAL COULD BE PLACED IN EACH RCC.

BENEFIT OF CHANGE

SIGNIFICANTLY IMPROVED FLOW TIME THROUGH BETTER COORDINATION AND COMMUNICATION.

PRODUCTIVITY IMPROVEMENT SUMMARY

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

TI PROGRAM COST BENEFIT ANALYSIS REPORT

CONTROL NO. 89-071F

TYPE PROPOSAL

- QUICK FIX
- FOCUS STUDY
- OTHER

ALC OC DATE 5/16/89
 RCC MATPCM ITEM NO. C/N 38697A
 NOUN FACING OPERATION ON BUSHING

CURRENT METHOD

THE BUSHING WHICH IS REPLACED ON THE INLET GUIDE VANE ACTUATOR (PART NUMBER 111952) WILL BE REPLACED WITH A VENDOR SUPPLIER WHICH MUST BE MACHINED TO TOLERANCE, THE REMAINING TIME REQUIRED FOR THE BUSHING PASSES APPROX 1-2 HOURS.

PROPOSED METHOD

RETURN THE BUSHINGS TO THE VENDOR AND MACHINE THE BUSHINGS TO TOLERANCE, EVENTUALLY THE VENDOR SHOULD SEND THE BUSHINGS IN COMPLIANCE WITH THE T.O. SPECIFICATIONS

BENEFIT OF CHANGE

BUSHINGS SENT BY THE VENDOR WHICH COMPLY TO SPEC WOULD SAVE 24-40 MANHOURS PER MONTH IN MATPCM. * NOTE: MANY OTHER PARTS COME INTO THE MACHINE SHOP FROM VENDORS WHICH DO NOT MEET SPECIFICATIONAL REQUIREMENTS. COMPLIANCE TO SPECS NEEDS TO BE STUDIED FOR ALL VENDORS PARTS.

PRODUCTIVITY IMPROVEMENT SUMMARY

THE BUSHING IS FACED AND BEARED BY MATPCM BEFORE INSTALLATION IN THE ACTUATOR. THIS IS NOT WHAT THE VCO STATES. THE BUSHING IS SUPPOSED TO BE AFTER INSTALLATION IN ORDER TO MEET COMPLIANCE WITH THE ACTUATOR CENTERLINE. HOWEVER, MATPCM MACHINISTS CLAIM THE SIAC CAN BE MET EASILY BY MACHINING BEFORE THE ACTUATOR COULD BE STUDIED.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-FS2

**TI PROGRAM
COST BENEFIT ANALYSIS REPORT**

ALC ALL DATE 13 JUN 89

RCC ALL ITEM NO. _____

NOUN SCRAP _____

BOB BUTTRY

TYPE PROPOSAL

- QUICK FIX
- FOCUS STUDY
- OTHER _____

CURRENT METHOD: PRODUCTION OPERATIONS GENERATE SCRAP THROUGH A VARIETY OF CAUSES. THIS SCRAP IS ORDINARILY REMOVED FROM THE RCC FOR DISPOSAL, ALONG WITH THE ACCOMPANYING WCD'S.

PROPOSED METHOD: EACH RCC SHOULD MAINTAIN A SCRAP LOGBOOK THAT LISTS EACH PART AS IT IS SCRAPPED AND THE CAUSE FOR SCRAPPING THE PART.

BENEFIT OF CHANGE: A PERIODIC REVIEW OF AN RCC'S SCRAP LOGBOOK COULD BE USED TO DETERMINE HOW TO REDUCE EXCESSIVE SCRAP BY IMPLEMENTING METHODS TO ELIMINATE, OR REDUCE, THE REPETITIVE CAUSES FOR SCRAPPING PARTS.

PRODUCTIVITY IMPROVEMENT SUMMARY: PRODUCTIVITY IMPROVEMENT IS DIRECTLY RELATED TO REDUCING SCRAP BY CORRECTLY REPAIRING A PART OVER THE SAME TIME PERIOD THAT A PART PREVIOUSLY WAS INCORRECTLY REPAIRED. ALSO, MATERIAL WASTE IS REDUCED BY NOT HAVING TO DISPOSE OF THE SCRAPPED PART. ALSO SAVES COST OF PURCHASING A BRAND NEW REPLACEMENT PART.

REQUESTED COST DATA FOR RRB-FS2

Present Condition Cost for Last 12 Months:

Annual cost associated with maintaining a scrap logbook within each RCC. Each part scrapped must be identified, dated, and the reason for scrap indicated.

Cost of Logbook(s) = \$ _____

Labor Cost for Entries = \$ _____

ENGINEERING NOTES

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC																								
		MATPCD																								
5/11/89	<p>DISASSEMBLY/ASSEMBLY PROFILES HAVE BEEN DEVELOPED FOR THE CONTROL NUMBERS STUDIED IN THE AP WORK UNIT OF RCC MATPCD. CUILD WCD'S WERE DEVELOPED FOR WCD'S WHICH HAD NO SPECIFIC WCD ESTABLISHED FOR THEM.</p> <p>(PROCESS) FLOW CHARTS WERE CREATED WITH THE INTENT OF CLOELY RELATING THE OPERATION PROFILE OPERATION NUMBERS WITH THOSE OF THE WCD.</p> <p>IN A STUDY OF C/N 97175A FOR CREATING A DISASSEMBLY/ASSEMBLY PROFILE, IT WAS NOTED</p>																									
QF #3	<p>THAT APPROXIMATELY 1 OUT OF EVERY 20 VALVES WILL NEED TO BE ADDED TO MACHINE SHOP MATPJM IN ORDER TO HAVE BEARING PLATE ON VALVE INLETS WHICH FOR SOME REASON DO NOT HAVE THEM. THE ENTIRE VALVE WILL BE HELD UP IN THE SHOP FOR AN AVERAGE OF THREE DAYS BEFORE BEING RETURNED TO MATPCD FOR DISASSEMBLY OPERATIONS TO BEGIN. IN ORDER TO DECREASE THE FLOW TIME ASSOCIATED WITH THIS DELAY, THE POSSIBILITY OF HAVING SOMEONE ROUTE THE VALVES TO MATPJM BEFORE AN OPERATOR EVEN BEGINS TO WORK THE PART NEEDS TO BE CONSIDERED.</p>																									
5/12/89	<p>SEVERAL CONTROL NUMBERS AND THEIR RESPECTIVE WCD'S WERE STUDIED IN THE MATPCA MACHINE SHOP. THE C/N'S AND THE WCD'S ARE:</p>	MATPCM																								
	<table border="1"> <thead> <tr> <th>C/N</th> <th>WCD</th> <th>DESCRIPTION</th> </tr> </thead> <tbody> <tr> <td>50067A</td> <td>CME02</td> <td>MAIN FUEL NOZZLE</td> </tr> <tr> <td>49806A</td> <td>CRE401</td> <td>MANIFOLD ASSEMBLY</td> </tr> <tr> <td>49802A</td> <td>CRE401</td> <td>MANIFOLD ASSEMBLY</td> </tr> <tr> <td>50134A</td> <td>CAEY02</td> <td>HYDRAULIC FUEL PUMP</td> </tr> <tr> <td>49810A</td> <td>CRE401</td> <td>MANIFOLD ASSEMBLY</td> </tr> <tr> <td>49808A</td> <td>CRE401</td> <td>MANIFOLD ASSEMBLY</td> </tr> <tr> <td>78206A</td> <td>CHER03</td> <td>FUEL INJECTOR</td> </tr> </tbody> </table>	C/N	WCD	DESCRIPTION	50067A	CME02	MAIN FUEL NOZZLE	49806A	CRE401	MANIFOLD ASSEMBLY	49802A	CRE401	MANIFOLD ASSEMBLY	50134A	CAEY02	HYDRAULIC FUEL PUMP	49810A	CRE401	MANIFOLD ASSEMBLY	49808A	CRE401	MANIFOLD ASSEMBLY	78206A	CHER03	FUEL INJECTOR	
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49808A	CRE401	MANIFOLD ASSEMBLY																								
78206A	CHER03	FUEL INJECTOR																								
	<p>THE FUEL NOZZLE, FUEL PUMP, AND INJECTOR ARE WORKED IN ONE AREA OF MATPCA WHERE THE STANDARD DRILL PRESSES AND LATHE'S ARE LOCATED WHILE THE MANIFOLD ASSEMBLIES ARE WORKED IN ANOTHER SECTION.</p>																									

ENGINEERING NOTES

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/15/89		
-	THE WCD'S WORKED IN THE MATPCM	MATPCM
5/19/89	<p>UNIT CONSISTED OF NOZZLES, THERMOSTAT ASSEMBLIES, AND MINOR ASSEMBLIES. CERTAIN CONTROL NUMBERS WERE WORKED WHICH DO NOT HAVE WCD'S ASSOCIATED WITH THEM ARE CALLED 945'S. THE 945 IS BASICALLY A SMALL WORK ORDER WRITTEN BY THE HOME RCC WHICH NAMES THE PART AND LISTS BRIEF INSTRUCTIONS. ONLY SMALL ASSEMBLIES WITH VERY FEW OPERATIONS WILL BE CLASSIFIED AS SUCH.</p>	
	<p>THE WORKLOAD, MANPOWER, AND EQUIPMENT PROFILES FOR MATPCM HAVE BEEN COMPLETED. 18 UNITS OF EQUIPMENT WERE IDENTIFIED WITH THE RELEVANT DATA OBTAINED.</p>	
	<p>THE ENVELOPS ARE IN THE PROCESS OF BEING REVISED ACCORDING TO THE 80/20 CONTROL NUMBERS WHICH HAD OPERATION PROFILES DEVELOPED FOR THEM. HOWEVER, AN ENVELOP IS DEVELOPED ONLY FOR BATCH PROCESS EQUIPMENT OF WHICH THE MACHINE SHOP EQUIPMENT CAN NOT BE IDENTIFIED AS. THE DATA COMPILED FOR THE EQUIPMENT IS USED FOR INFORMATIONAL PURPOSES ONLY.</p>	
FS # 6	<p>MANY PARTS WHICH COME THROUGH THE MACHINE SHOP WILL HAVE TO HAVE SMALL PARTS REPLACED ON THEM. SOMETIMES THE SMALL PARTS ARE RECEIVED FROM THE VENDOR OR SUPPLIER AND MUST BE MACHINE TO THE REQUIRED SPECIFICATION. FOR EXAMPLE, C/N 38677A IS A BUSHING ASSEMBLY WHICH REQUIRES A BUSHING TO BE REPLACED ON IT IN THE MACHINE SHOP. THE BUSHING MUST BE CUT TO SPECIFICATION IN ORDER TO SATISFY A CENTERLINE CONDITION ON THE BUSHING. HOWEVER, THE MACHINE SHOP PERSONNEL INSIST THAT THE PART CAN BE MACHINE TO SPEC BY THE VENDOR BEFORE IT IS SENT TO THE LOGISTICS CENTER. THIS WOULD SAVE THE MACHINE SHOP MANY HOURS IN LABOR AND</p>	

ENGINEERING NOTES

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
	<p>TO THE VOLUME OF BUSHINGS WORKED AS DESCRIBED PREVIOUSLY, THERE ARE OTHER SMALL SIZE PARTS NOT LISTED WHICH COULD FIT THE SAME CRITERIA.</p>	<p>MATPCM</p>
<p>5/24/89</p>	<p>IN REVIEW OF THE EQUIPMENT PROFILE DEVELOPED BY SHOP PERSONNEL, SOME BRIEF EXPLANATION IS NECESSARY CONCERNING THE TIME POINT OF REFERENCE FOR FREQUENCY OF MAINTENANCE AND MEAN TIME BETWEEN FAILURE, THE STARTING POINTS FOR THE 180 DAYS GIVEN ON A PARTICULAR PIECE OF EQUIPMENT ARE NOT THE SAME. THE FIGURES GIVEN ARE ALSO WHAT THE MACHINIST BELIEVES TO BE THE AVERAGE FIGURES.</p> <p>WITH REGARD TO THE LATHES, THE LENGTH OF THE SWING IS AN IMPORTANT CRITERION IN DETERMINING WHETHER A PARTICULAR PART CAN BE WORKED ON IT. FOR EXAMPLE, THE MONARCH LATHES HAVE 6" SWINGS AND CANNOT WORK PARTS REQUIRING THAT THE MACHINE HAVE A 10" SWING.</p> <p>PCN'S FROM MATPCA WERE COMPLETED FOR MACHINE SHOP OPERATIONS AND CONCLUDED AT OPERATION PROFILE WORK FOR MATPCM. IT WAS NOTED THAT FOR C/N 37719A (SERVO CONTROL PART) THAT WORK REQUESTED FROM MATPCM IS OFTEN REQUESTED BY A MECHANIC IN MATPCA WITH PRIORITY EMPHASIS. THIS IS NOT AN ATYPICAL SITUATION FOR MATPCA. A COMPUTERIZED SCHEDULING SYSTEM WHICH THE MACHINE SHOP COULD UTILIZE WOULD HELP CONTROL THIS PROBLEM. AN EARLIER FOCUS STUDY WAS WRITTEN TO ADDRESS THIS.</p>	

115.DISP.16.PDN/

STATION OP. NO. 117.WORK TO BE AC. 02.1500 118.MECH.19"P" 120"Q"

380 UNIT HERMETIC

M

440 PRESSURIZE
DRY AIR PAVING

M

450 ... IN WA-
... MINUTE.

M

450

M

497 ... FOR

M

500

M

510 ... HAD
... 1010
... REPORTS &
... 1010

M

520 ... WORK

M

590 ... PARA 13.

M

 1. AAUOI * WORK CONTROL DOCUMENT * SM 1. DATE 88301 PAGE 1 OF 1 PAGES

 2. ORIG/PRD NR 13. QUANTITY 14. PRD SECTION/KCC 15. DATE SCHED 16. DATE COMP
 5717A 1 1 1 89143 1

17. PART NUMBER 17. ITEM SERIAL NR 18/19. TECH DATA/OPTIONAL
 665720 1 5A14-2-16-3 87091H
 CHD 31
 20. MODEL/DESIGN/SERIES 21. STOCK NR
 E4 AUTOPILOT 1 6615002221343
 22. MISC 23. NOUN/END ITEM NOUN
 1 SRVD CONTROL PAGE
 YEAR/MATEAA/65720

15. DISP	16. FOM	STATION/OP NO.	17. WORK TO BE ACCOMPLISHED	18. RECH	19. "P"	20. "W"
			ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.			
U-43		010	RECEIVE, IDENTIFY & ATTACH WCU		n	
		020	DISASSEMBLE		n	
		030	CLEAN		n	
		040	INSPECT		n	
		050	REPAIR & REPLACE AS REQUIRED		n	
		060	REASSEMBLE		n	
		070	TEST		n	
		080	COMPLY WITH MAUI 66-36, PARA 13 REPAIR WORK PERFORMED		n	
		090	CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TOTO CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.		n	
		100	OPERATIONS COMPLETE, PAIRWORK PROCESSED.			

5/11/88
 37719
 225

PCN 38677A

1. CREW3 + WORK 20.11.11 00:35 PAGE 1 OF 3 PAGES
2. ORIG/PROD NR 13. QUANTITY 14. UNIT SPECIFIED REC 15. DATE SCHED 16. DATE COMP
38677A 89135

8. PART NUMBER 9. LITER SERIES NO. 10.12.13.14.15.16.17.18.19.20.21.22.23.24.25.26.27.28.29.30.31.32.33.34.35.36.37.38.39.40.41.42.43.44.45.46.47.48.49.50.51.52.53.54.55.56.57.58.59.60.61.62.63.64.65.66.67.68.69.70.71.72.73.74.75.76.77.78.79.80.81.82.83.84.85.86.87.88.89.90.91.92.93.94.95.96.97.98.99.100.101.102.103.104.105.106.107.108.109.110.111.112.113.114.115.116.117.118.119.120.121.122.123.124.125.126.127.128.129.130.131.132.133.134.135.136.137.138.139.140.141.142.143.144.145.146.147.148.149.150.151.152.153.154.155.156.157.158.159.160.161.162.163.164.165.166.167.168.169.170.171.172.173.174.175.176.177.178.179.180.181.182.183.184.185.186.187.188.189.190.191.192.193.194.195.196.197.198.199.200.201.202.203.204.205.206.207.208.209.210.211.212.213.214.215.216.217.218.219.220.221.222.223.224.225.226.227.228.229.230.231.232.233.234.235.236.237.238.239.240.241.242.243.244.245.246.247.248.249.250.251.252.253.254.255.256.257.258.259.260.261.262.263.264.265.266.267.268.269.270.271.272.273.274.275.276.277.278.279.280.281.282.283.284.285.286.287.288.289.290.291.292.293.294.295.296.297.298.299.300.301.302.303.304.305.306.307.308.309.310.311.312.313.314.315.316.317.318.319.320.321.322.323.324.325.326.327.328.329.330.331.332.333.334.335.336.337.338.339.340.341.342.343.344.345.346.347.348.349.350.351.352.353.354.355.356.357.358.359.360.361.362.363.364.365.366.367.368.369.370.371.372.373.374.375.376.377.378.379.380.381.382.383.384.385.386.387.388.389.390.391.392.393.394.395.396.397.398.399.400.401.402.403.404.405.406.407.408.409.410.411.412.413.414.415.416.417.418.419.420.421.422.423.424.425.426.427.428.429.430.431.432.433.434.435.436.437.438.439.440.441.442.443.444.445.446.447.448.449.450.451.452.453.454.455.456.457.458.459.460.461.462.463.464.465.466.467.468.469.470.471.472.473.474.475.476.477.478.479.480.481.482.483.484.485.486.487.488.489.490.491.492.493.494.495.496.497.498.499.500.501.502.503.504.505.506.507.508.509.510.511.512.513.514.515.516.517.518.519.520.521.522.523.524.525.526.527.528.529.530.531.532.533.534.535.536.537.538.539.540.541.542.543.544.545.546.547.548.549.550.551.552.553.554.555.556.557.558.559.560.561.562.563.564.565.566.567.568.569.570.571.572.573.574.575.576.577.578.579.580.581.582.583.584.585.586.587.588.589.590.591.592.593.594.595.596.597.598.599.600.601.602.603.604.605.606.607.608.609.610.611.612.613.614.615.616.617.618.619.620.621.622.623.624.625.626.627.628.629.630.631.632.633.634.635.636.637.638.639.640.641.642.643.644.645.646.647.648.649.650.651.652.653.654.655.656.657.658.659.660.661.662.663.664.665.666.667.668.669.670.671.672.673.674.675.676.677.678.679.680.681.682.683.684.685.686.687.688.689.690.691.692.693.694.695.696.697.698.699.700.701.702.703.704.705.706.707.708.709.710.711.712.713.714.715.716.717.718.719.720.721.722.723.724.725.726.727.728.729.730.731.732.733.734.735.736.737.738.739.740.741.742.743.744.745.746.747.748.749.750.751.752.753.754.755.756.757.758.759.760.761.762.763.764.765.766.767.768.769.770.771.772.773.774.775.776.777.778.779.780.781.782.783.784.785.786.787.788.789.790.791.792.793.794.795.796.797.798.799.800.801.802.803.804.805.806.807.808.809.810.811.812.813.814.815.816.817.818.819.820.821.822.823.824.825.826.827.828.829.830.831.832.833.834.835.836.837.838.839.840.841.842.843.844.845.846.847.848.849.850.851.852.853.854.855.856.857.858.859.860.861.862.863.864.865.866.867.868.869.870.871.872.873.874.875.876.877.878.879.880.881.882.883.884.885.886.887.888.889.890.891.892.893.894.895.896.897.898.899.900.901.902.903.904.905.906.907.908.909.910.911.912.913.914.915.916.917.918.919.920.921.922.923.924.925.926.927.928.929.930.931.932.933.934.935.936.937.938.939.940.941.942.943.944.945.946.947.948.949.950.951.952.953.954.955.956.957.958.959.960.961.962.963.964.965.966.967.968.969.970.971.972.973.974.975.976.977.978.979.980.981.982.983.984.985.986.987.988.989.990.991.992.993.994.995.996.997.998.999.1000.1001.1002.1003.1004.1005.1006.1007.1008.1009.1010.1011.1012.1013.1014.1015.1016.1017.1018.1019.1020.1021.1022.1023.1024.1025.1026.1027.1028.1029.1030.1031.1032.1033.1034.1035.1036.1037.1038.1039.1040.1041.1042.1043.1044.1045.1046.1047.1048.1049.1050.1051.1052.1053.1054.1055.1056.1057.1058.1059.1060.1061.1062.1063.1064.1065.1066.1067.1068.1069.1070.1071.1072.1073.1074.1075.1076.1077.1078.1079.1080.1081.1082.1083.1084.1085.1086.1087.1088.1089.1090.1091.1092.1093.1094.1095.1096.1097.1098.1099.1100.1101.1102.1103.1104.1105.1106.1107.1108.1109.1110.1111.1112.1113.1114.1115.1116.1117.1118.1119.1120.1121.1122.1123.1124.1125.1126.1127.1128.1129.1130.1131.1132.1133.1134.1135.1136.1137.1138.1139.1140.1141.1142.1143.1144.1145.1146.1147.1148.1149.1150.1151.1152.1153.1154.1155.1156.1157.1158.1159.1160.1161.1162.1163.1164.1165.1166.1167.1168.1169.1170.1171.1172.1173.1174.1175.1176.1177.1178.1179.1180.1181.1182.1183.1184.1185.1186.1187.1188.1189.1190.1191.1192.1193.1194.1195.1196.1197.1198.1199.1200.1201.1202.1203.1204.1205.1206.1207.1208.1209.1210.1211.1212.1213.1214.1215.1216.1217.1218.1219.1220.1221.1222.1223.1224.1225.122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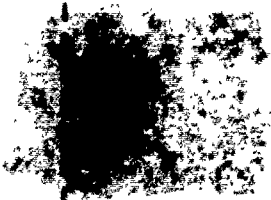
10. DISP. LA. PDM/

11. STATION/OP. NO. 117. WORK TO BE ACCOMP. BY

18. RECH/19"P" 20"Q"

110 1. ALL PROTECTIVE GOGGLES
RETURN TO WIPED.

M



PCN 38685A

CREM04 * WORK CONTROL 000 1. DATE 88301 PAGE 1 OF 1 PAGES
12. ORIG/PROD NR 13. QUANTITY 14. DATE SCHED 15. DATE COMP
38685A 89136

PART NUMBER 02-13422 ITEM SECT DATA/OPTIONAL 87288H

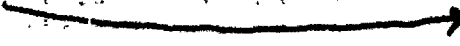
10. MODEL DESIGN/SERIES 11. STA 079-15417

13. MISC 14. NOUN 15. NO 16. DISP 16. STATION OF V. 17. MESH 18. 20" Q"

010 MTPCR NETWORK M
020 MTPCR REQ M
030 MTPCR 4 REQ M

035-SEE 6 UNIT TEST

035



010	MTPCR	NETWORK	M
020	MTPCR	REQ	M
030	MTPCR	4 REQ	M
040	MTPCR	REPLACE BACK	M
050	MTPCR	REPLACE BACK	M
060	MTPCR	REPLACE BACK	M
070	MTPCR	ROUTE TO MTPCR	M

PCN 38712A

CASINO WORK CONTROL DOCUMENT NO. DATE 08/39 PAGE 1 OF 3 PAGES
ORIG/PROD NR 13 QUANTITY 14. ROD SECTION REC 15. DATE SCHED 16. DATE COMP
38712A MTPC4P 89135

PART NUMBER	LITER	SERIAL NR	SIZE	TECH DATA/OPTIONAL	
10-397625-1			851	2-36-23	87032H
10. MODEL/DESIGN/SERIES	11. STD		851	2-36-3	87121H
13. MISC	14. NOUN		851	2-36-506	83001H
			851	2-36-506C	83346H
			851	2-36-506E	84305H
			851	2-36-506F	85005H
			851	2-36-506H	87001H

STATION OR NO.			18. MECH	19 "P"	20 "Q"
		904PL 33670A			
010			M		
020		ALL REPAIRS MUST BE TO THE SPECIFIC T.O. AND ALL REPAIRS TO BE TO THE SPECIFIC TECH DATA (INCLUDING TAI) TO WHICH THE PARTS, MATERIALS, DIMENSIONS, AND TOLERANCES REFER TO IN THE T.O.	M		
025		ALL PARTS MUST BE PRECISION METALS. SEE MACHINE 4 FOR REPAIRING & CONTROL.	M		
030	MTPCM	RECEIVE EXCITER: REMOVE LID AND WELDS: RETURN TO MTPCM.	M		
040		DISASSEMBLE	M		
050		HOUSING ASSEMBLY, CHECK FLANGES MINIMUM HEIGHT 1.00 INCH SEE BEL-2 36 13 14A (8).	M		
060	MTPCM	WELD HOUSING EXTENSION: ACT: 1.00 INCH	M		
070	MTPIM	WELD EXTENSION ON HOUSING	M		
080	MTPIM	WELD BRACKETS AND STOPS TO MODIFIED HOUSING, WHEN FINISHED MTPIM WILL RETURN BOX TO MTPCA.	M		
090	MTPCA	MTPCA WILL REPAIR EXCITER AS REQ. BY TOTO.	M		

100	TEST HOUSING AND TRANSFORMER ASSY. MEASURE PRIMARY AND SECONDARY RESISTANCE. GREENWIRE-WHITE WIRE ACT OHMS BROWN WIRE-RED WIRE ACT OHMS OHMMETER	
110	TEST L.B. VOLTAGE ASSY. (25) (26) INVOLVE CURRENT FLUX ACT MA CURRENT FLUX MEASUREMENT ACT MA CURRENT FLUX MEASUREMENT TEST SET	M
120	ACT OHMS	M
130	ACT LB/INS ACT LB/INS ACT LB/INS ACT LB/INS ACT LB/INS ACT LB/INS ACT LB/INS	M
140	WINDING STAND AND CA WINDING ASSEMBLY TAKE APART AND PLACE ACT LBS IN WORK AREA.	M
145	WINDING TO MACHINE SHOULD BE CUT OFF AT WINDING LINE.	M
150	THE BOX MAY HAVE TO GO TO MTPIM AFTER ANY ONE PROCEDURE TO HAVE THE PLATE ON THE VIBRATOR ASSY. WELDED TO THE PARTITION. AT THIS TIME THE FILTER ASSY. CONNECTOR AND CUP COULD BE WELDED TO THE HOUSING. EXCITER WILL THEN BE RETURNED TO MTPCA FOR TESTING.	M
155		
160	TEST WILL BE TESTED IAW MTPCA 2-14-3 EXCEPT FOR DIFFERENCES IN TCTD.	M
170	"BEFORE" COVER TEST: 90 VAC ACT TRASK RATE (S/R) 115 VAC ACT S/R ACT OUTPUT 120 VAC ACT S/R MAIN 14 VDC ACT S/R 24 VDC ACT S/R ACT OUTPUT 30 VDC ACT S/R	M
180	FINISH PACKING COVER THEN SEND WITH COVER TO MTPIM FOR	M

(CONTINUED)

15 DISP 16 PDN/ STATION TOP NO. 117. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

	REMOVE COVER TO HOUSING, RTPIW REPLACE BACK TO RT26A	
190	NOT FOR LEAKAGE, EVACUATE, AND PURGE IAW 261 2 4 7.	M
195	TORQUE PLUG 112 ACT: 112 112	M
200	TEST EXETER "METER" TEST AND 20 20AL ACT 2/R 21 21AL ACT 2/R 22 22AL ACT 2/R 23 23AL ACT 2/R 24 24AL ACT 2/R 25 25AL ACT 2/R 26 26AL ACT 2/R 27 27AL ACT 2/R 28 28AL ACT 2/R 29 29AL ACT 2/R 30 30AL ACT 2/R 31 31AL ACT 2/R 32 32AL ACT 2/R 33 33AL ACT 2/R 34 34AL ACT 2/R 35 35AL ACT 2/R 36 36AL ACT 2/R 37 37AL ACT 2/R 38 38AL ACT 2/R 39 39AL ACT 2/R 40 40AL ACT 2/R 41 41AL ACT 2/R 42 42AL ACT 2/R 43 43AL ACT 2/R 44 44AL ACT 2/R 45 45AL ACT 2/R 46 46AL ACT 2/R 47 47AL ACT 2/R 48 48AL ACT 2/R 49 49AL ACT 2/R 50 50AL ACT 2/R 51 51AL ACT 2/R 52 52AL ACT 2/R 53 53AL ACT 2/R 54 54AL ACT 2/R 55 55AL ACT 2/R 56 56AL ACT 2/R 57 57AL ACT 2/R 58 58AL ACT 2/R 59 59AL ACT 2/R 60 60AL ACT 2/R 61 61AL ACT 2/R 62 62AL ACT 2/R 63 63AL ACT 2/R 64 64AL ACT 2/R 65 65AL ACT 2/R 66 66AL ACT 2/R 67 67AL ACT 2/R 68 68AL ACT 2/R 69 69AL ACT 2/R 70 70AL ACT 2/R 71 71AL ACT 2/R 72 72AL ACT 2/R 73 73AL ACT 2/R 74 74AL ACT 2/R 75 75AL ACT 2/R 76 76AL ACT 2/R 77 77AL ACT 2/R 78 78AL ACT 2/R 79 79AL ACT 2/R 80 80AL ACT 2/R 81 81AL ACT 2/R 82 82AL ACT 2/R 83 83AL ACT 2/R 84 84AL ACT 2/R 85 85AL ACT 2/R 86 86AL ACT 2/R 87 87AL ACT 2/R 88 88AL ACT 2/R 89 89AL ACT 2/R 90 90AL ACT 2/R 91 91AL ACT 2/R 92 92AL ACT 2/R 93 93AL ACT 2/R 94 94AL ACT 2/R 95 95AL ACT 2/R 96 96AL ACT 2/R 97 97AL ACT 2/R 98 98AL ACT 2/R 99 99AL ACT 2/R 100 100AL ACT 2/R	M
210	NOT DOING 11 4 30-1 TESTER AND 11 30-1 SPARK GAP TEST. TESTER. 24 24AL DO INHIT ACT: 24 24AL FIRING PLUGS ACT: 24 24AL	M
230	CLEAN AS REQUIRED	M
230	PAINT AS REQUIRED	M
240	MARK NEW PART NUMBER TO 247325-1 (GE 10505281P5), A LETTER R IN REV BLOCK, AND ORIGINAL SERIAL NUMBER, CURRENT, VOLTAGE, AND TYPE LETTERS ON NEW IDENT. PLATE. DO NOT APPLY WARNING PLATE AS WARNING PLATE APPLIES. (AS PER ITO) IDENT. PLATE.	M
250	VERIFY THAT THE IDENT. PLATE HAS OVERHAULED IAW I.O., ITO, CURRENT REVISIONS, COMPLAINTS, AND APPLICABLE PROCESS CHANGES.	M
260	OPERATIONS COMPLETE. WORK FORWARDED.	M
270	COMPLY WITH PART 13 PARA 13 TYPE WORK PERFORMED	M

PCN 49779A

COEYD8 *TRK DATE 83183 PAGE 1 OF 2 PAGES

12. DRIB/PROD NO. 13. DATE SCHED 14. DATE COMP
49779A 89135

PART NUMBER 217705 DATA/OPTIONAL

SWIFT 86349L

19. ADDL DESIGN/SERIES
TI 30 17 199

SWIFT 87258H

13. MISC. DIMENSIONS

15. DESP. STATION

19. MECH 19"R 20"R

3091	211	TO...	WCSK	
	0100		P.O.	M
			TECH	
			AND	
	070		NECESSARY	M
	040			M
	050	INSPECTION		M
		TABLE 4-1.		
		REQUIRED. RUB		
		ABL DOCUMENT		
	040	IF ABOVE	APPLIED	M
		WITH. IF RECD	BLOG	
3108	070		TECK	M
	MISC			
			TEST FOR	
			PACKAGE	
			MIN	
			ACT.	

18. RECH 19 "P" (20 "Q")

3001 080 CONNECTOR CONNECTOR REPAIR 1AW
 NYPCN 4-12-1950

N
 N

090 SEALING SURF
 NYPCN 4-13-1950

N

100
 NYPCN

N

110
 NYPCN

N

130
 NYPCN

N

3001 140
 NYPCN 4-17-1950

N

150
 NYPCN

N

160 ROUTE SUPPLEMENT AT
 NYPCN 4-18-1950

N

170 EQUAL VERTICAL INTERSECTION
 NYPCN 4-18-1950
 LOCK RING.

N

180 OPERATIONS COMPLETED & REPAIRS
 APPLICABLE

N

190 OPERATIONS COMPLETED & REPAIRS
 PROCEEDED. INTERSECTION AT THIS END
 ITEM HAS BEEN OPENED TO 1AW T.O.P.
 DATA, CURRENT SUPPLEMENTS
 AND APPLICABLE ORDERS.

N

200 COMPLY WITH MAINTENANCE PARAGRAPH 17
 TYPE WORK PERFORMED

N

WORK CONTROL DOCUMENT * JC 1. DATE 59088 PAGE 1 OF 3 PAGES
12. ORG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP
NTPCB 89131

PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL
6J8-25-3 88334H
CHG 43
10. MODEL/DESIGN/SERIES 11. STOCK NR
J57 2915007646062RU

13. MISC 14. NOUN/END ITEM NOUN
MANIFOLD ASSEMBLY PACI
SHREVE/MATEAC/65920

15. DISP 16. PON/
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

- 50199A 783011 2915010865195RU
"GOLD/NIC R.H."
 - 50200A 783009 2915010865194RU
"GOLD/NIC L.H."
 - 49808A 8246498-10 2915011431130RU
"COP/NIC L. H."
 - 49810A 8246498-20 2915011431131RU
"COP/NIC R.H."
 - 49806A 8246498-30 2915011431129RU
"GOLD/NIC L.H."
 - [REDACTED] 8246498-40 2915011431128RU
"GOLD/NIC R.H."
- END ITEM CONTAINS PRECIOUS METAL
(GOLD NICKEL) PROCESS IAW MAOI 65-4

3117	010	RECEIVE, IDENTIFY & ATTCH. PAPERWORK CAUTION: MANIFOLD MUST BE PROPERLY MOUNTED TO HOLDING FIXTURE SPECIFIED IN T.O.'S. THEY WILL REMAIN MOUNTED ON HOLDING FIXTURES AT ALL TIMES EXCEPT AS REQUIRED FOR REPAIR. REFERENCES ARE TO THE BASIC T.O. APPLICABLE PROCESS ORDERS. TECH CONTAINS DETAILED NOTES, WARNINGS, DIMENSIONS AND REQUIREMENTS REQUIRING COMPLIANCE.	R
3001	020	REMOVE NOZZLE, PLACE IN APPLICABLE STORAGE CONTAINER. REQ NOT REQ	R
	040	CHECK SHIPPING FIXTURE FOR DISTORTION. NONE ALLOWED	R
	050	MEASURE INLET FLANGE THICKNESS WITH 0-1 INCH OD MICROMETER. MINIMUM THICKNESS 0.260. CHECK FLANGE ALIGNMENT. ACT:	R

(15.818P-14.P0W) STATION/OP NO. 117 WORK TO BE ACCOMPLISHED (18.MECH) 19"P" 20"0"

040	NOZZLE BODY DISTORTION CHECK GAUGE PWA17795	R
045	DRILL NUMBER 53 HOLE IN GUNNY TUBE 180 DEG FROM FACTORY HOLE.	R
3001 070	CLEAN MANIFOLD, IAW APPLICABLE PROCEDURE. NOTE: EXTERIOR HEATSHIELD MUST BE CLEAN.	R
090	WELD BUILD-UP NOZZLE BODY O+O.	W
NTPIN	REQ NOT REQ	
100	REGRINDING NOZZLE BODY, DRILL & CHARFER HOLES.	R
NTPCR	REQ NOT REQ	
110	INSTALL SLEEVE AND STAKE FIG 4-3 & FIG 4-15.	R
NTPCR	REQ NOT REQ	
120	DIMENSIONAL INSPECT LUGS RECORD ACTUAL LUG THICKNESS.	R
NTPCR		
	R.H. L.H.	
	CLSTR 1 CLSTR 5	
	CLSTR 2 CLSTR 6	
	CLSTR 3 CLSTR 7	
	CLSTR 4 CLSTR 8	
140	PREPARE AND BUILD UP LUGS WITH WELD. LUG THICKNESS BELOW 0.162 WILL REQ. BUILDUP WITH AWS 5480.	W
NTPIN	REQ NOT REQ	
145	WELD AIR BUTER LUGS	W
NTPIN	REQ NOT REQ	
150	WELD FILL THREADED HOLE	W
NTPIN	REQ NOT REQ	
160	WELD LOOSE OR CRACKED HEATSHIELDS	W
NTPIN	REQ NOT REQ	
162	INSPECT FUEL MANIFOLD ASSY. FOR GOLD NICKEL-COPPER IF REQUIRED. COPPER NICKLE GOLD NICKLE	W
NTPIN		
164	REWORK COPPER BRAZE MANIFOLDS IAW PARA 4-8A	W
NTPIN		

(CONTINUED)

PCN 49802 A

		NOT REQ.	
170	REMOVE AND REPLACE DAMAGED HEAT- NTPIM SHIELDS.		M
	REQ.	NOT REQ.	
180	MACHINE LUGS. CHECK LUG THICKNESS NTPCM 0.177 TO 0.181. (O.D. MICROMETER) ACT.		M
	RH	LH	
	CLSTR 1	CLSTR 5	
	CLSTR 2	CLSTR 6	
	CLSTR 3	CLSTR 7	
	CLSTR 4	CLSTR 8	
190	SPOT ZYGO ALL LUGS. NTPIM INNER AND OUTER		K
195	PERFORM FLEX MOUNT MOD IAW NTPCM 6J8-25-3, PARAGRAPH 4-39A. IF APPLICABLE CANDIDATE. REQ. NOT REQ.		M
197	BEADWELD AS PER PARA 4-42; B.4 IF REQ NTPCM REQ. NOT REQ.		M
200	RESURFACE INLET FLANGE, CHECK FLANGE NTPCM THICKNESS, MIN .260 IF REQUIRED ACT		M
210	CHECK FERRULE DEPTH MIN .145 NTPCM ACT		M
215	SPOT FLUORESCENT PENETRANT INSPECT NTPCM INLET FLANGE AS PER T.O. 2J-J57-83-1 DIESS.		M
		NOT REQ.	
220	DISTORTION CHECK. COLD BEND NTPCM REQUIRED, TABLE 4-2 AND FIG 4-2.		M
221	INSPECT HEATSHIELDS & WELDS FOR NTPCM CRACKS.		M
223	FLEX MOUNT MINIFOLOS ONLY. NTPCM STANDARD TORQUE BOLTS & LOCKWIRE WITH 8892226-05 WIRE. REQ. NOT REQ.		M
224	REPLACE DAMAGED COMBUSTION CHAMBER NTPCM ELBOW. REQ. NOT REQ.		M
227	DRILL HOLES FOR SILICONE INJECTION. NTPCM		M

20N 492/2 H

250	SELECT SILICONE, BAKE MANIFOLD, TRIM RTPIM EXCESS SILICONE AND INSTALL PROTEC- TIVE BASKET-ROUTE TO BUILD-UP-RTPCB.	M
290	INSPECT NOZZLE BODY. IAW FIG. 4-3 & RTPCB PARA 4-34. A. INSPECT SEATS AND THREADS B. LAP SEAL SEAT IF NECESSARY C. INSPECT SEATS FOR DEPTH DIMENSIONS. ASSURE SEALING SURFACES ARE WITHIN .0005 PLANE.	R
300	FLUSH MANIFOLD	M
310	INSTALL SEALS, NOZZLES & TAB LOCKS	M
320	ASSURE CORRECT NOZZLES ARE SELECTED. TORQUE NOZZLES 425 +/- 25 IN/LBS SEE TABLE 7-1. ACT	M
330	IDENTIFY PART NUMBER: IDENTIFY SERIAL NO:	M
340	CAP NOZZLES & PROTECT INLET FLANGES	M
350	MOVE TO AND RECEIVE FROM TEST. BLOB 3108, RTPCT.	
360	PERFORM DISTORTION CHECK, PERFORM COLD BEND IF REQUIRED. CHECK FLANGE ALIGNMENT. SLEEVES TIGHT & FLARED & SET TABLOCKS. NOTE: MANIFOLD MUST BE RETESTED AFTER COLD BEND TO COMPLY WITH T.O. REQUIREMENTS.	M
365	INSPECT HEATSHIELDS & WELDS FOR RTPCB CRACKS.	M
368	WELD CRACKS RTPIM REQ. NOT REQ.	M
370	CAP ALL PORTS, SECURE ALL BOLTS TO RTPCB FRAME AND ASSURE PROTECTIVE BASKET ON INLET FLANGE	M
380	AFTO FORM 349 COMPLETED AS APPLI- CABLE & FORWARDED FOR PROCESSING.	M
390	INSPECT, TAG & PROCESS PAPERWORK. I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT	M

(CONTINUED)

432 20

| CSE401 - WORK CONTROL DOCUMENT - JC | 1. DATE 89088 PAGE 3 OF 3 PAGES |
| 15. DISP-14. PDM/ |
| STATION/OP NO. 117. WORK TO BE ACCOMPLISHED | 118. RECH 19"P" 120"Q" |

REVISIONS, SUPPLEMENTS AND APPLI-
CABLE PROCESS ORDERS.

400 COMPLY WITH RADI 66-36, PARA 13.
TYPE WORK PERFORMED. R




CBE401 WORK CONTROL DOCUMENT JC 1. DATE 89088 PAGE 1 OF 3 PAGES
12. ORIS/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP
ATPCB 89131

PART NUMBER 17. ITER SERIAL NR 18/12. TECH DATA/OPTIONAL
6J8-25-3 88336H
CHG 43

10. MODEL/DESIGN/SERIES 11. STOCK NR
J87 2915007646062RU

13. NISC 14. NOUN/END ITER NOUN
MANIFOLD ASSEMBLY PACI
SHREVE/NATEAC/65920

15. DISP 16. PON/
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19 "P" 20 "Q"

- 50199A 783011 2915010865195RU
"BOLD/NIC R.H."
 - 50200A 783009 2915010865194RU
"BOLD/NIC L.H."
 - 49808A 8246498-10 2915011431130RU
"COP/NIC L. H."
 - 49810A 8246498-20 2915011431131RU
"COP/NIC R.H."
 -  8246498-30 2915011431129RU
"BOLD/NIC L.H."
 - 49802A 8246498-40 2915011431128RU
"BOLD/NIC R.H."
- END ITER CONTAINS PRECIOUS METAL
(BOLD NICKEL) PROCESS IAM NA01 65-4

3117 010 RECEIVE, IDENTIFY & MTC. PAPERWORK
CAUTION: MANIFOLD MUST BE PROPERLY
MOUNTED TO HOLDING FIXTURE SPECIFIED
IN T.O.'S. THEY WILL REMAIN MOUNTED
ON HOLDING FIXTURES AT ALL TIMES
EXCEPT AS REQUIRED FOR REPAIR.
REFERENCES ARE TO THE BASIC T.O.
APPLICABLE PROCESS ORDERS. TECH
CONTAINS DETAILED NOTES,
INSTRUCTIONS, WARNINGS, DIMENSIONS AND
TOLERANCES REQUIRING COMPLIANCE.

3001 020 REMOVE NOZZLE, PLACE IN APPLICABLE
ATPCB STORAGE CONTAINER.
REQ NOT REQ

040 CHECK SHIPPING FIXTURE FOR
DISTORTION. NONE ALLOWED

050 MEASURE INLET FLANGE THICKNESS WITH
0-1 INCH OD MICROMETER. MINIMUM
THICKNESS 0.260.
CHECK FLANGE ALIGNMENT.
ACT:

	040	NOZZLE BODY DISTORTION CHECK GAUGE P/N 17795.	M
	045	DRILL NUMBER 53 HOLE IN DUMMY TUBE 180 DEG FROM FACTORY HOLE.	M
3001	070	CLEAN MANIFOLD, IAW APPLICABLE PROCEDURE. NOTE: EXTERIOR HEATSHIELD MUST BE CLEAN.	M
	090	WELD BUILD-UP NOZZLE BODY D-O.	M
		REQ. NOT REQ.	
	100	RE MACHINE NOZZLE BODY, DRILL & CHARFER HOLES.	M
		REQ. NOT REQ.	
	110	INSTALL SLEEVE AND STAKE FIG 4-3 & FIG 4-15.	M
		REQ. NOT REQ.	
	120	DIMENSIONAL INSPECT LUGS RECORD ACTUAL LUG THICKNESS.	M
		R.H. L.H.	
		CLSTR 1 CLSTR 5	
		CLSTR 2 CLSTR 6	
		CLSTR 3 CLSTR 7	
		CLSTR 4 CLSTR 8	
	140	PREPARE AND BUILD UP LUGS WITH WELD. LUG THICKNESS BELOW 0.162 WILL REQ. BUILDUP WITH AWS 5680.	M
		REQ. NOT REQ.	
	145	GRIND OUTER LUGS	M
		REQ. NOT REQ.	
	150	WELD FILL THREADED HOLE	M
		REQ. NOT REQ.	
	160	WELD LOOSE OR CRACKED HEATSHIELDS	M
		REQ. NOT REQ.	
	162	INSPECT FUEL MANIFOLD ASSY. FOR GOLD NICKEL-COPPER IF REQUIRED. COPPER NICKLE GOLD NICKLE	M
	164	REWORK COPPER BRAZE MANIFOLDS IAW PARA 4-8A	M

15. DISP 14. PDM / STATION / DP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

		REG.	NOT REQ.	
170	NTPIM	REMOVE AND REPLACE DAMAGED HEAT-SHIELDS.		W
		REG.	NOT REQ.	
180	NTPCR	MACHINE LUGS. CHECK LUG THICKNESS 0.177 TO 0.181. (O.D. MICROMETER) ACT		M
		RH	LH	
		CLSTR 1	CLSTR 5	
		CLSTR 2	CLSTR 6	
		CLSTR 3	CLSTR 7	
		CLSTR 4	CLSTR 8	
190	NTPIM	SPOT ZYGO ALL LUGS. INNER AND OUTER		K
195	NTPCR	PERFORM FLEX MOUNT MOD IAW 6J8-25-3, PARAGRAPH 4-39A. IF APPLICABLE CANDIDATE. REG. NOT REQ.		M
197	NTPIM	BEADWELD AS PER PARA 4-42:8.4 IF REQ. REG. NOT REQ.		M
200	NTPCR	RESURFACE INLET FLANGE, CHECK FLANGE THICKNESS, MIN .260 IF REQUIRED ACT		M
210	NTPCR	CHECK FERRULE DEPTH MIN .145 ACT		M
215	NTPCB	SPOT FLUORESCENT PENETRANT INSPECT INLET FLANGE AS PER T.O. 2J-J57-83-1 01000.		M
			NOT REQ.	
220	NTPCB	WARP DISTORTION CHECK. COLD BEND REQUIRED. TABLE 4-2 AND FIG 4-2.		M
221	NTPCB	INSPECT HEATSHIELDS & WELDS FOR CRACKS.		M
223	NTPCB	FLEX MOUNT RINIFOLDS ONLY. STANDARD TORQUE BOLTS & LOCKWIRE WITH AS92226-05 WIRE. REG. NOT REQ.		M
224	NTPCB	REPLACE DAMAGED COMBUSTION CHAMBER ELBOW. REG. NOT REQ.		M
227	NTPCB	DRILL HOLES FOR SILICONE INJECTION.		M

250	REJECT SILICONE, BAKE MANIFOLD, TRIM NTPIM EXCESS SILICONE AND INSTALL PROTECTIVE BASKET-ROUTE TO BUILD-UP-NTPCB.	M
290	INSPECT NOZZLE BODY. IAW FIG. 4-3 & PARA 4-34. A. INSPECT SEATS AND THREADS B. LAP SEAL SEAT IF NECESSARY C. INSPECT SEATS FOR DEPTH DIMENSIONS. ASSURE SEALING SURFACES ARE WITHIN .0005 PLANE.	M
300	FLUSH MANIFOLD	M
310	INSTALL SEALS, NOZZLES & TAB LOCKS	M
320	ASSURE CORRECT NOZZLES ARE SELECTED. TURQUE NOZZLES 425 +/- 25 IN/LBS SEE TABLE 7-1.	M
	ACT	
330	IDENTIFY PART NUMBER: IDENTIFY SERIAL NO:	M
340	CAP NOZZLES & PROTECT INLET FLANGES	M
350	MOVE TO AND RECEIVE FROM TEST. BLDS 3108, NTPCT.	
360	PERFORM DISTORTION CHECK, PERFORM COLDBEND IF REQUIRED. CHECK FLANGE ALIGNMENT. SLEEVES TIGHT & FLARED & SET TABLOCKS. NOTE: MANIFOLD MUST BE RETESTED FOR COLD BEND TO COMPLY WITH T.O. REQUIREMENTS.	M
365	INSPECT HEATSHIELDS & WELDS FOR CRACKS. NTPCB	M
368	WELD CRACKS NTPIM REQ. NOT REQ.	M
370	CAP ALL PORTS, SECURE ALL BOLTS TO FRAME AND ASSURE PROTECTIVE BASKET ON INLET FLANGE NTPCB	M
380	AFTO FORM 349 COMPLETED AS APPLICABLE & FORWARDED FOR PROCESSING.	M
390	INSPECT, TAB & PROCESS PAPERWORK. I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT	M

(CONTINUED)

PON 10724

CBE401 * WORK CONTROL DOCUMENT * JC 1. DATE 89088 PAGE 5 OF 5 PAGES
15. DISP-16. PON/
STATION/OP NO. 117. WORK TO BE ACCOMPLISHED 118. RECH 19 "P" 20 "Q"

REVISIONS, SUPPLEMENTS AND APPLI-
CABLE PROCESS ORDERS.

400 COMPLY WITH NADI 65-36, PARA 13.
TYPE WORK PERFORMED

M

115. DISP-14. PON/ STATION/OP NO. 117. WORK TO BE ACCOMPLISHED 18. MECH 19"P" 20"Q"

	060	NOZZLE BODY DISTORTION CHECK GAUGE PWA17795.	M
	065	DRILL NUMBER 53 HOLE IN DUMMY TUBE 180 DEG FROM FACTORY HOLE.	M
3001	070	CLEAN MANIFOLD, IAW APPLICABLE PROCEDURE. NOTE: EXTERIOR HEATSHIELD MUST BE CLEAN.	M
	070	WELD BUILD-UP NOZZLE BODY O.D.	M
		REQ. NOT REQ.	
	100	RE-MACHINE NOZZLE BODY, DRILL & CHAMFER HOLES.	M
		REQ. NOT REQ.	
	110	INSTALL SLEEVE AND STAKE FIG 4-3 & FIG 4-15.	M
		REQ. NOT REQ.	
	120	DIMENSIONAL INSPECT LUGS RECORD ACTUAL LUG THICKNESS.	M
		R.H. L.H.	
		CLSTR 1 CLSTR 5	
		CLSTR 2 CLSTR 6	
		CLSTR 3 CLSTR 7	
		CLSTR 4 CLSTR 8	
	140	PREPARE AND BUILD UP LUGS WITH WELD. LUG THICKNESS BELOW 0.162 WILL REQ. BUILDUP WITH AWS 5680.	M
		REQ. NOT REQ.	
	148	REPAIR OUTER LUGS	M
		REQ. NOT REQ.	
	150	WELD FILL THREADED HOLE	M
		REQ. NOT REQ.	
	160	WELD LOOSE OR CRACKED HEATSHIELDS	M
		REQ. NOT REQ.	
	162	INSPECT FUEL MANIFOLD ASSY. FOR GOLD NICKEL-COPPER IF REQUIRED. COPPER NICKLE GOLD NICKLE	M
	164	REWORK COPPER BRAZE MANIFOLDS IAW PARA 4-8A	M

	REQ.	NOT REQ.	
170 MTPIM	REMOVE AND REPLACE DAMAGED HEAT-SHIELDS.		M
180 MTPCM	MACHINE LUGS. CHECK LUG THICKNESS 0.177 TO 0.181. (O.D. MICROMETER) ACT		M
	RH	LH	
	CLSTR 1	CLSTR 5	
	CLSTR 2	CLSTR 6	
	CLSTR 3	CLSTR 7	
	CLSTR 4	CLSTR 8	
190 MTPIM	SPOT ZYBLO ALL LUGS. INNER AND OUTER		K
195 MTPCM	PERFORM FLEX MOUNT MOD IAW 6J8-25-3, PARAGRAPH 4-39A. IF APPLICABLE CANDIDATE. REQ. NOT REQ.		M
197 MTPCA	BEADWELD AS PER PARA 4-42:8.4 IF REQ. REQ. NOT REQ.		M
200 MTPCM	RESURFACE INLET FLANGE, CHECK FLANGE THICKNESS, MIN .260 IF REQUIRED ACT		M
210 MTPCM	CHECK FERRULE DEPTH MIN .145 ACT		M
215 MTPCB	SPOT FLUORESCENT PENETRANT INSPECT INLET FLANGE AS PER T.O. 2J-J57-83-1 SUPP 01002. NOT REQ.		M
220 MTPCB	PERFORM DISTORTION CHECK. COLD BEND REQUIRED. TABLE 4-2 AND FIG 4-2.		M
221 MTPCB	INSPECT HEATSHIELDS & WELDS FOR CRACKS.		M
223 MTPCB	FLEX MOUNT MINIFOLDS ONLY. STANDARD TORQUE BOLTS & LOCKWIRE WITH N892226-05 WIRE. REQ. NOT REQ.		M
224 MTPCB	REPLACE DAMAGED CONDUCTION CHAMBER ELBOW. REQ. NOT REQ.		M
227	DRILL HOLE FOR SILICONE INJECTION.		M

*****		PCN 49208A	
CBE401 * WORK CONTROL DOCUMENT * JC		1. DATE 59085	
15. DISP-16. PDM/		PAGE 4 OF 5 PAGES	
STATION/OP NO. 117. WORK TO BE ACCOMPLISHED		18. RECH 19" P 20" Q	
250	REJECT SILICONE, BAKE MANIFOLD, TRIM NTPIM EXCESS SILICONE AND INSTALL PROTECTIVE GASKET-ROUTE TO BUILD-UP-NTPCB.	M	
290	INSPECT NOZZLE BODY. IAW FIG. 4-3 & NTPCB PARA 4-36. A. INSPECT SEATS AND THREADS B. LAP SEAL BEAT IF NECESSARY C. INSPECT SEATS FOR DEPTH DIMENSIONS. ASSURE SEALING SURFACES ARE WITHIN .0005 PLANE.	M	
300	FLUSH MANIFOLD	M	
310	INSTALL SEALS, NOZZLES & TAB LOCKS	M	
320	ASSURE CORRECT NOZZLES ARE SELECTED. TORQUE NOZZLES 425 +/- 25 IN/LBS SEE TABLE 7-1.	M	
	ACT		
330	IDENTIFY PART NUMBER: IDENTIFY SERIAL NO:	M	
340	CAP NOZZLES & PROTECT INLET FLANGES	M	
350	MOVE TO AND RECEIVE FROM TEST. BLOB 3108, NTPCT.		
360	PERFORM DISTORTION CHECK, PERFORM COLD BEND IF REQUIRED. CHECK FLANGE ALIGNMENT. SLEEVES TIGHT & FLARED & SET TABLOCKS. MANIFOLD MUST BE RETESTED COLD BEND TO COMPLY WITH T.O. REQUIREMENTS.	M	
368	INSPECT HEATSHIELDS & WELDS FOR NTPCB CRACKS.	M	
368	WELD CRACKS NTPIM REQ. NOT REQ.	M	
370	CAP ALL PORTS, SECURE ALL BOLTS TO NTPCB FRAME AND ASSURE PROTECTIVE BASKET ON INLET FLANGE	M	
380	AFTO FORM 349 COMPLETED AS APPLI- CABLE & FORWARDED FOR PROCESSING.	M	
390	INSPECT, TAG & PROCESS PAPERWORK. I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., ICIO, CURRENT (CONTINUED)	M	

PCN AGP EA

CBE401 * WORK CONTROL DOCUMENT * JC 1. DATE 89088 PAGE 5 OF 5 PAGES
115-DISP-16-PDN/
STATION/OP NO. 117. WORK TO BE ACCOMPLISHED 118. RECH 19"P" 20"Q"

REVISIONS, SUPPLEMENTS AND APPLI-
CABLE PROCESS ORDERS.

400 COMPLY WITH NAD 65-36, PARA 13.
TYPE WORK PERFORMED

M

1. OPERATIONAL WORK CONTROL DOCUMENT - 12 QUANTITY 13. QUANTITY 14. PROD SECTION 15. DATE CHECKED 16. DATE CORRECTED
12. ORIGIN/PROD NR 13. QUANTITY 14. PROD SECTION 15. DATE CHECKED 16. DATE CORRECTED
17. REVISIONS

PART NUMBER ITEM SERIAL NR TECHN DATA OPTIONAL

10. NO. OF DESIGN/SERIES 11. STOCK NO.

11. R. C. WORK CENTER ITEM NO. ON

12. CONTROL ASSEMBLY

13. CONTROL IDENTIFICATION

14. CONTROL NO.

15. CONTROL NO. 17. WORK TO BE DONE

49801A 321643-00 2910011111111111

"GOLD NICKEL R.H."

49802A 321643-00 2910011111111111

"GOLD NICKEL R.H."

49803A 321643-00 2910011111111111

"GOLD NICKEL R.H."

[REDACTED] 428643-00 2910011111111111
"GOLD NICKEL R.H."

49807A 321643-00 2910011111111111

"GOLD NICKEL R.H."

49802A 321643-00 2910011111111111

"GOLD NICKEL R.H."

END ITEM CONTAINS PREVIOUS SERIAL
(GOLD NICKEL) PROCESS TAP MAGN 65--

3017 010 RECEIVE, IDENTIFY & MATCH PART NUMBER
CAUTION: PARTS MUST BE PROPERLY
MOUNTED TO HOLDING FIXTURE SPECIFIED
IN T.O.'S. THEY WILL REMAIN MOUNTED
ON HOLDING FIXTURES AT ALL TIMES
EXCEPT AS REQUIRED FOR REPAIR
REPAIRS ARE TO THE 24-100 P.I.L.
FOR THE PROPER ORDERS. TECH
SPECIFICATIONS DETAILED HOLES,
DIMENSIONS, TOLERANCES, DIMENSIONS AND
FINISHES REQUIRING COMPLIANCE.

3001 020 REMOVE NOZZLE. PLACE IN APPLICABLE
STORAGE CONTAINER.

REQ NOT REQ

040 CHECK SHIPPING FIXTURE FOR
DISTORTION. NONE ALLOWED

050 MEASURE INLET FLANGE THICKNESS WITH
0-1 INCH OD MICROMETER. MINIMUM
THICKNESS 0.260.
CHECK FLANGE ALIGNMENT.

ACT

060	NOZZLE BODY DISTORTION CHECK GAUGE PART 17795.	
065	DRILL NUMBER OF HOLES IN D TUBE 180 DEG FROM ...	
3001 070	CLEAN MANIFOLD IAW APPLICABLE PROCEDURE. NOTE: EXHAUST HEATSHIELD MUST BE CLEAN	
080	WELD BUILD UP ... REQ NOT REQ	
100	REWORKING NOZZLE BODY, DRILL 3 Diameter Holes.	
110	INSTALL SLEEVE AND TAKE FIG 4-3 & FIG 4-15.	
120	DIMENSIONAL INSPECT LUGS RECORD ACTUAL LUG THICKNESS.	
	R.H. L.H.	
	CLSTR 1 CLSTR 5	
	CLSTR 2 CLSTR 6	
	CLSTR 3 CLSTR 7	
	CLSTR 4 CLSTR 8	
140	PREPARE AND BUILD UP LUGS WITH WELD. LUG THICKNESS BELOW 0.162 WILL REQ. BUILDUP WITH AWS 5680. REQ NOT REQ	W
145	REWORK OUTER LUGS REQ NOT REQ	W
150	WELD FILL THREADED HOLE REQ NOT REQ	W
160	WELD LOOSE OR CRACKED HEATSHIELDS REQ NOT REQ	W
162	INSPECT FUEL MANIFOLD ASSY. FOR GOLD NICKEL-COPPER IF REQUIRED. COPPER NICKLE GOLD NICKLE	W
164	REWORK COPPER BRAZE MANIFOLDS IAW PARA 4-8A	W

115. DISF-16. PDM/

117. WORK TO BE ACCOMPLISHED

118. RECH 1977 2070

250 I REMOVE SILICONE, BAKE MANIFOLD, TRIM
NTPIM I EXCESS SILICONE AND INSTALL PROTECTIVE
I GASKET-ROUTE TO BUILD UP-NOZZLES.

M

290 I INSPECT NOZZLE BODY. IAW FIG. 4-3 &
NTPCB I PARA 4-36.
I A. INSPECT SEATS AND WREDS
I B. LAP SEAL SPAT IF NECESSARY
I C. INSPECT SEATS FOR DEPTH
I DIMENSIONS.
I ASSURE SEALING SURFACES ARE WITHIN
I TOLERANCE.

M

300 I FLUSH MANIFOLD

M

310 I INSTALL SEALS, NOZZLES & TAB LOCKS

M

320 I ASSURE CORRECT NOZZLES ARE SELECTED.
I TORQUE NOZZLES 425 FT-LBS INL 30.
I SEE TABLE 7-1.

M

ADD

330 I IDENTIFY PART NUMBER

M

I IDENTIFY SERIAL NO.

340 I CAP NOZZLES & PROTECT INLET FLANGES

M

350 I MOVE TO AND RECEIVE FROM TEST.
I BLOC 3108, NTPCT.

360 I PERFORM DISTORTION CHECK, PERFORM
I CLOSEEND IF REQUIRED, CHECK FLANGE
I ALIGNMENT, SLEEVES TIGHT & FLARED &
I SET TABLOCKS.

M

I COVER MANIFOLD MUST BE RECHECKED
I FOR CLOSE END BEND TO COMPLY WITH T.O.
I REQUIREMENTS.

365 I WELD HEATSHIELDS & HELDS FOR
NTPCB I WELDS.

M

368 I WELD CRACKS
NTPIM I REQ. NOT REQ.

M

370 I CAP ALL PORTS, SECURE ALL BOLTS TO
NTPCB I FRAME AND ASSURE PROTECTIVE GASKET
I ON INLET FLANGE

M

380 I AFTO FORM 349 COMPLETED AS APPLI-
I CABLE & FORWARDED FOR PROCESSING.

M

390 I INSPECT, TAB & PROCESS PAPERWORK. I
I CERTIFY THAT THIS SHO ITEM HAS BEEN
I OVERHAULED IAW T.O. 100. CURRENT

M

(CONTINUED)

ISSUES, SUPPLIES AND APPLI-
CABLE PROCESS ORDERS.

400 COMPLY WITH PART 65 3 + 1.74 13.
TYPE WORK PERFORMED



1. CREW NO. 2. WORK CONTROL DOCUMENT # 3. DATE 4. PAGE 5. OF 6 PAGES
12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP
50067A 1 1 RTPCM 80110

PART NUMBER .031N36P02 ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL
10. MODEL/DESIGN/SERIES 11. STOCK NR 12. TOPS 4-8-16-3TP-1 16074H
379-15/17 1 2915001265730PL: 608-16-503 832440
13. MISC 14. MOUNT/END ITEM MOUNT 15. TAG 16
15. DTSP 16. PDH
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED

010 RECEIVE FROM RTPCM FOR DISASS-
MODIFICATION, AND REPAIR OF HOUSING
HOUSING SUBASSEMBLY. IDENTIFY AND
ATTACH PAPERWORK. ALL REFERENCE ARE
TO THE BASIC T.O. AND APPLICABLE
PROCESS ORDERS. TECH DATA CONTAINS
DETAILED NOTES, CAUTIONS, WARNINGS
DIMENSIONS, AND TOLERANCES REQUIRING
COMPLIANCE.
REQ: NOT REQ:
ROUTE TO RTPCM
REQ: NOT REQ:

020 REMOVE WELDED SPRAY END FROM HOUSING
ASSEMBLY IAW TCTO PARA 6F.
REQ: NOT REQ:

030 REMOVE PRIMARY NOZZLE AND SAVE
METERING SET.
REQ: NOT REQ:

040 INSPECT TIP END THREADS FOR DAMAGE.
IAW TCTO PARA 6F (9).
REPAIR IF REQUIRED.
ACCEPT REJECT
INSPECT TIP END TO HOUSING SHOULDER
IF MEASUREMENT EXCEEDS 0.492 INSTALL
TIP CAPS AND ROUTE TO RTPCM
FOR BUILDUP.
REQ: NOT REQ:

050 REPAIR BY WELD BUILD-UP OF HOUSING
END TIP IAW TCTO PARA 6G.
REQ: NOT REQ:

WELD 060 REPAIR BALLING IN MOUNTING BOLT AREA
OF FLANGE IAW TCTO PARA 6G (3).
REQ: NOT REQ:

070 INSTALL COVER HAND TIGHT AND INSTALL
PROTECTIVE COVERS. RETURN TO RTPCM
REQ: NOT REQ:

080 PERFORM FINAL MACHINE OPERATIONS
A. IF WELD BUILD UP END TIP WAS
PERFORMED. MACHINE IAW TCTO
PARA 6H (2F). ACT:
REQ: NOT REQ:

(CONTINUED)

IF FLANGE WELD REPAIR WAS PER-
FORMED, MACHINE FLANGE TO
ORIGINAL DIMENSION. ROUTE TO
MTPCB FOR NDI.
REQ: _____ NOT REQ: _____

090 PERFORM FLUORESCENT PENETRANT
MTPCB TION FOR CRACKS PER MIL-1-6040
FLANGE WELDED AREAS.
REQ: _____ NO. REQ: _____
ACCEPT: _____ REJECT: _____

100 IF FLANGE REPAIR WAS PERFORMED
MTPCB BENCH OUT CRACKS IF FOUND DURING
AND REPEAT PROCEDURES AS REQUIRED

110 MODIFY FLANGE FOR PIVOT INSTALLATION
MTPCB LAW TUTO PARA 64. DEBURR HOLES

130 INSTALL ALL PROTECTIVE COVERS AND
MTPCB RETURN TO MTPCB FOR FINAL ASSEMBLY
VERIFY THAT THIS ITEM HAS BEEN
REVISIONS, SUPPLEMENTS, AND
APPLICABLE PROCESS ORDERS.

130 170 0901 64-307 PARA 13
MTPCB TYPE WORK PERFORMED

140 07W TUTO 608-16-503

PCN 50126A

12. JRG/PROD NR 13. QUANTITY 14. PROD SECTION/ACC 15. DATE SCHED 16. DATE COMP

PART NUMBER 2065483 ITEM SERIAL NO. 50126A-13 87227H

10. MODEL/DESIGN/SERIES 11. STOCK NO. 129150087182

13. MISC 14. NOUN/END ITEM NO IN THERMOSTAT ASSY.

15. DISP 16. PCN/STATION

18. RECH 19 "P" 20 "Q"

COMPONENT OF PART CONTROL

50126A P103 613-2-2-14/513

50126A P104 613-2-2-14/513

50126A P105 613-2-2-14/513

50126A P106 613-2-2-14/513

50126A P107 613-2-2-14/513

50126A P108 613-2-2-14/513

50126A P109 613-2-2-14/513

50126A P110 613-2-2-14/513

50126A P111 613-2-2-14/513

REFERENCES ARE TO THE FAST T.O. AND APPLICABLE PRO AND PERG. TECH DATA CONTAINS CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE

3001 010 DISASSEMBLE & REVERT TO T.O. ATPEA IAW T.O. M

3001 012 REMARK THERMOSTAT ON BOARD (REF FIG. 2 OF 3) PERG 3344. A. INSTALL PERG 3344 WELDING AND ALLOWING PERG 3344 MACHINE TO DIMENSION

(CONTINUED)

15. DISP 15. PONY STATION ID NO. 117. WORK TO BE ACCOMPLISHED 118. RECH 19"P" 20"Q"

6. REIDENTIFY & ETCH NEW P/N ON ASSY.
REINSTALL COVER OVER PROBE IMMEDIATELY AFTER WORK PROCEED WITH ASSEMBLY.

VERIFICATION DATA RE IDENTIFICATION IS ... CALIFORNIA

019 ... REFERENCE ... I-59 ... R-37

VERIFICATION DATA RE IDENTIFICATION IS ... CALIFORNIA

050 ... ASSY HAS ... DIMENSIONS AND ... ORDERS.

060 ... PWA 15-19

ALL REFERENCE ARE TO THE BASIC T.O. AND APPLICABLE PRO-59 ORDERS. TECH DATA CONTAINS CAUTIONS, WARNINGS, DIMENSIONS, & TOLERANCES REQUIRING ATTENTION.

3108 070 ... BELLOWS SYN ... COMPENSATING

080 ... BELLOWS ... HEIGHT ... COMPENSATING BELLOWS ... ETCH ... COMPARISON ... WITHIN .010 IN

NO FURTHER ... ABOVE LIMITS ARE ...

PART NUMBER 2486488
 WRITER SERIAL NR 18/12. TECH DATA/OPTIONAL 87227H
 6J3-4-86-13
 CHG 1
 10. ADDEL/DESIGN/SERIES/11. STOCK NR 6J3-4-86-509
 TFCO-P103-107-1 2915009871821PQ1
 -07-111
 13. RISC/14. NOUN/END ITEM NOUN
 THERMOSTAT ASSY. PACSI
 STREUN/MATEAC/45920

15. DISP 16. PON/
 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19 "P" 20 "Q"

		COMPONENT OF MAIN FUEL CONTROL		
		COMPONENT OF A/B FUEL CONTROL		
		C/N	T.O.	
	50277A	P103	6J3-4-75-13/52/512C	
			CHG 4 88183H	
	50123A	P107	SEE BLK 12	
	50124A	P109	6J3-4-89-13/506	
			CHG 5 88183H	
	50325A	P109C		
	50192A	P111	6J3-4-94-13/505	
			CHG 2 88122H	
	50128A	P103	6J3-2-22-13/513	
			CHG 4 88183H	
	50128A	P107	6J3-2-26-13/505	
			CHG 3 87319H	
	50126A	P109	6J3-2-27-3/13/503	
			CHG 3 87319H	
	50126A	P109C		
	50126A	P111	6J3-2-29-13/505	
			CHG 2 87244H	

ALL REFERENCES ARE TO THE BASIC T.O.
 AND APPLICABLE PROCESS ORDERS. TECH
 DATA CONTAINS CAUTIONS, WARNINGS,
 DIMENSIONS AND TOLERANCES REQUIRING
 COMPLIANCE

3001	010	DISASSEMBLE & CLEAN THERMOSTAT ASSY.		
	RTPEA	IAM T.O.		R
3001	012	REWORK THERMOSTAT AS FOLLOWS:		
	RTPCN	(REF FIG. 2 OF DATA PKG 834).		R
		A. INSTALL PROBE ON HOLDING AND		
		ALIGNING FIXTURE & MACHINE TO		
		DIMENSIONS IN FIG 2.		

(CONTINUED)

REIDENTIFY & ETCH NEW P/N ON
 ASSY.
 REINSTALL COVER OVER PROBE
 IMMEDIATELY AFTER REWORK
 PROCEDURES ARE COMPLETE.

NOTE:
 VIBRATION DAMPENER MODIFICATION IS
 INSTALLED FOLLOWING FINAL CALIBRA-
 TION OF FUEL CONTROL.

015 INSPECT IAW TABLE 5-1, REFERENCE S
 T.O. 6JJ-2-29-13. N
 XRAY CAPILLARY TUBE MOCIA, POST I-69
 REQD. NOT REQD.
 ARCOR REPAIR MTPIW, POST N-37
 REQD. NOT REQD.
 BOLDER & BRAZE MTPIW, POST K-73
 REQD. NOT REQD.

NOTE:
 VIBRATION DAMPENER MODIFICATION IS
 INSTALLED FOLLOWING FINAL CALIBRA-
 TION OF FUEL CONTROL.

050 I CERTIFY THIS THERMOSTAT ASSY HAS
 BEEN INSPECTED IAW T.O., TCTO,
 CURRENT REVISIONS, SUPPLEMENTS AND
 PROCESS ORDERS. N

060 TEST STAND: PWA 15519
 LOC

 ALL REFERENCES ARE TO THE BASIC T.O.
 AND APPLICABLE PROCESS ORDERS. TECH
 DATA CONTAINS CAUTIONS, WARNINGS,
 DIMENSIONS, & TOLERANCES REQUIRING
 COMPLIANCE.

3108 370 COMPENSATING BELLOWS S/N
 MTPET COMPENSATING BELLOWS S/N

080 +80 DEGREES FACTORY ETCHED HEIGHT
 COMPARISON:
 MOTOR BELLOWS COMPENSATING BELLOWS
 ETCHED HEIGHT:
 COMPARISON HEIGHT:

 COMPARISON MUST BE WITHIN .010 IN

NOTE
 NO FURTHER TESTING REQUIRED IF ABOVE
 LIMITS ARE MET. T

100 RECORD DATA FOR ROTOR & COMPENSATING BELLOWS
 ROTOR-BELLOWS

PROBE TEMP.	BELLOWS TEMP.	LOAD LBS	LIMIT INCH	TRAVEL
-65 DF	-65 DF	11.5	0.0000	0.0000
+80 DF	-65 DF	13.0	.0439	.0489
+510DF	-65 DF	14.0	.1781	.1951
+80 DF	+80 DF	13.0	.0926	.1036
-65 DF	+80 DF	11.0	.0458	.0518
-55 DF	+300DF	10.0	.1282	.1438

COMPENSATING-BELLOWS

PROBE TEMP.	BELLOWS TEMP.	LOAD LBS.	LIMITS INCH	TRAVEL
-65 DF	-65 DF	10.0	0.0000	
+80 DF	-65 DF	10.0	0.0000	
+510DF	-65 DF	10.0	0.0000	
+80 DF	+80 DF	12.0	.0458	.0514
-65 DF	+80 DF	12.0	.0458	.0514
-55 DF	+300DF	19.0	.1273	.1421

110 PLGT READINGS OF LAST CHART LINE FOR ROTOR BELLOWS IAW T.O. T

120 I CERTIFY THAT THIS COMPONENT HAS BEEN TESTED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS. T

17. PART NUMBER 19. ITEM SERIAL NR 10/12. TECH DATA/OPTIONAL
 024672-117-01 1 6J10 5 6 3 88274H
 10. MODEL/DESIGN/SERIES 11. STOCK NR 1 6J10 5 6 3L 3
 1130 1 2915012514453101 1 6J10 5 6 3L 4

18. DISC/14. NON/END ITEM NUM
 1 HYD. PULL PUMP PART
 BUSHY/DATEAG/1978

12. ORID-13. PPN/
 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 10. TECH 19. 12. 01

- FIG. 1 (SH2) ITEM #42 (SLEEVE)
 LABYRINTH
 P/N 02 14720 NSN 5330009454603PU
- FIG. 1 (SH2) ITEM #43 (BUSHING)
 SLEEVE
 P/N 02 14580 02 NSN 3120009409977PU
- FIG. 1 (SH4) ITEM #116 (SLEEVE)
 LABYRINTH
 P/N 02 14721 NSN 5330009250610PU
- FIG. 1 (SH4) ITEM #120 (SLEEVE)
 BEARING
 P/N 02 14551 NSN 3120009226400PU

- MTPCM 010 RECEIVE & IDENTIFY FROM MTPCB FOR REWORK. H
- 015 ALL REFERENCE TO THE BASIC I.D. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, INSTRUCTIONS, WARNINGS, DIMENSIONS & APPLICABLE PROCESS ORDERS. H
- 020 ACCOMPLISH REWORK IAW FIG. 9 11 & FIG. 9-12, 6J10 5 6 H
- 030 ALL REWORK OPERATIONS COMPLETE. I CERTIFY THAT THIS ITEM HAS BEEN REPAIRED IAW I.D., I.D.O. CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS. H
- 040 RETURN TO MTPCB, AFTER REWORK BLDC 3001, P. 39. H

12. Q10/PROD NR 13. QUANTITY 14. PROD SLECTION/RCC 15. DATE SCHED 16. DATE COMP
RTPEA 89135

PART NUMBER 18. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL
286448 6J3-4-86-13 87227H
CHG 1

10. MODEL/DESIGN/SERIES 11. STOCK NR 12. J3-4-86-509
P103-P107-1 2915009871821P01
-09-111

13. MISC 14. NOUN/END ITEM NOUN
THERMOSTAT ASSY. PAC81
-STREUN/MATEAC/65920

15. DISP 16. PON/ STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19. 20. "G"

- COMPONENT OF MAIN FUEL CONTROL
- COMPONENT OF A/B FUEL CONTROL
- C/M T.O.
- 50277A P103 6J3-4-75-13/52/512C
CHG 4 88183H
- 50123A P107 SEE BLK 12
- 50124A P109 6J3-4-97-13/506
CHG 5 88183H
- 50325A P109C
- 50192A P111 6J3-4-94-13/505
CHG 2 88122H
- 50128A P103 6J3-2-22-13/513
CHG 4 88183H
- 50127A P107 6J3-2-26-13/505
CHG 3 87319H
- 50126A P109 6J3-2-27-3/13/503
CHG 3 87319H
- 50125A P109C
- 50111A P111 6J3-2-29-13/505
CHG 2 87244H

ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE

3001 010 DISASSEMBLE & CLEAN THERMOSTAT ASSY.
RTPEA IAM T.O. A

3001 012 REMARK THERMOSTAT AS FOLLOWS
RTPCA (REF FIG. 2 OF DATA PKG 834). A
A. INSTALL PROBE ON HOLDING AND
ALIGNING FIXTURE & MACHINE TO
DIMENSIONS IN FIG 2.

(CONTINUED)

B. REIDENTIFY & ETCH NEW P/N ON
 ASSY.
 REINSTALL COVER OVER PROBE
 IMMEDIATELY AFTER REMARK
 PROCEDURES ARE COMPLETE.

NOTE:
 VIBRATION DAMPENER MODIFICATION IS
 INSTALLED FOLLOWING FINAL CALIBRA-
 TION OF FUEL CONTROL.

015

INSPECT IAW TABLE 5-1, REFERENCE
 T.O. 6J3-2-29-13.
 XRAY CAPILLARY TUBE AQCIA, POST I-69
 REQD NOT REQD.
 ARMOR REPAIR MTPIM, POST H-37
 REQD NOT REQD.
 SOLDER & BRAZE MTPIM, POST K-73
 REQD NOT REQD.

5

2 AINS

NOTE:
 VIBRATION DAMPENER MODIFICATION IS
 INSTALLED FOLLOWING FINAL CALIBRA-
 TION OF FUEL CONTROL.

050

I CERTIFY THIS THERMOSTAT ASSY HAS
 BEEN INSPECTED IAW T.O., TC10,
 CURRENT REVISIONS, SUPPLEMENTS AND
 PROCESS ORDERS.

M

060

TEST STAND: PWA 15519
 LOC

ALL REFERENCES ARE TO THE BASIC T.O.
 AND APPLICABLE PROCESS ORDERS. TECH
 DATA CONTAINS CAUTIONS, WARNINGS,
 DIMENSIONS, & TOLERANCES REQUIRING
 ATTENTION.

3108

070 ROTOR BELLOWS S/N
 MTPET COMPENSATING BELLOWS S/N

080

+80 DEGREE FACTORY ETCHED HEIGHT
 COMPARISON:
 ROTOR BELLOWS COMPENSATING BELLOWS
 ETCHED HEIGHT:
 COMPARISON HEIGHT:
 COMPARISON MUST BE WITHIN .010 IN

T

48 HRS

NOTE
 NO FURTHER TESTING REQUIRED IF ABOVE
 LIMITS ARE MET.

PCN 50191A

15. DISP 16. PDN/

STATION/OP NO. 117. WORK TO BE ACCOMPLISHED

18. RECH 19" P 120" Q

100 RECORD DATA FOR ROTOR & COMPENSATING BELLOW

T

ROTOR-BELLOWS

PROBE TEMP.	BELLOWS TEMP.	LOAD LBS	LIMIT INCH	TRAVEL
-65 DF	-65 DF	11.5	0.0000	0.0000
+80 DF	-65 DF	13.0	.0439	
+510DF	-65 DF	14.0	.1781	
			.1951	
+80 DF	+80 DF	13.0	.0926	
			.1036	
-65 DF	+80 DF	11.0	.0458	
			.0518	
-65 DF	+300DF	10.0	.1282	
			.1438	

COMPENSATING-BELLOWS

PROBE TEMP.	BELLOWS TEMP.	LOAD LBS.	LIMITS INCH	TRAVEL
-65 DF	-65 DF	10.0	0.0000	
+80 DF	-65 DF	10.0	0.0000	
+510DF	-65 DF	10.0	0.0000	
+80 DF	+80 DF	12.0	.0458	
			.0514	
-65 DF	+80 DF	12.0	.0458	
			.0514	
-65 DF	+300DF	10.0	.1273	
			.1421	

110 PLOT READINGS OF LAST CHART LINE FOR ROTOR BELLOWS IAW T.O.

T

120 I CERTIFY THAT THIS COMPONENT HAS BEEN TESTED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.

T

12. ORIG/ROD NR 13. QUANTITY 14. DATE SCHED 15. DATE COMP
50281A 1 891+2

PART NUMBER 19. AREA 20. MATERIAL DATA/ OPTIONAL

81136H

21. TIME DESIGN/SERIALS

22. DISK

23. MISC

24. DISK

25. DISK

26. DISK

27. DISK

28. DISK

29. DISK

30. DISK

31. DISK

32. DISK

33. DISK

34. DISK

35. DISK

36. DISK

37. DISK

38. DISK

39. DISK

40. DISK

41. DISK

42. DISK

43. DISK

44. DISK

45. DISK

46. DISK

47. DISK

48. DISK

49. DISK

50. DISK

51. DISK

52. DISK

53. DISK

54. DISK

55. DISK

56. DISK

57. DISK

58. DISK

59. DISK

60. DISK

61. DISK

62. DISK

63. DISK

64. DISK

65. DISK

66. DISK

67. DISK

68. DISK

69. DISK

70. DISK

040
061
079

CMO.ATIONS

080

081

082

083

084

15. STEP 14. PDN/ STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19 "P" 20 "Q"

090	REF 38, MEAS. SLEEVE TO BEARING .0010-.0025. ACT (S. MIC)	M
100	REF 41, MEAS. SLEEVE TO GUIDE .0015/ .0080. ACT (.7520 SPINDLE, S. MIC)	M
110	REF 43, MEAS. GUIDE TO PISTON .002/ .007. ACT (T. GAGE & MIC)	M
120	REF 44, MEAS. PIN TO ROLLER .0010/ .0040. ACT (S. MIC)	M
130	REF 202, MEAS. SPRING 125768 # 3.200" FOR 11/13 LBS. ACT # 1.700" FOR 25/28 LBS. ACT	M
140	MEAS. SPRING 480729 # 3.200" FOR 8.875/9.125 LBS. ACT # 1.700" FOR 15.062/15.625 LBS. ACT	M
150	REF 203, MEAS. SPRING 418347 # 1.182" FOR 3.750/4.000 LBS. ACT # 20.992" FOR 6.562/ 7.625 LBS. ACT	M
160	REF 204, MEAS. SPRING #0.566" FOR 1.562/1.937 LBS. ACT #0.450" FOR 3.625/4.375 LBS. ACT	M
170	REASSEMBLE.	M
180	TORQUE 12 NUTS (265068) 75-85 LB/IN.	M
190	PLUGS (208831) 260-275 DEG.	M
200	PLUGS (310976) 110-120 LB/IN.	M
210	TEST: VALVE SHOULD OPEN RAPIDLY, LESS THAN 2 SEC. & WITHOUT PERCEPT- IBLE DELAY. CYCLE UNIT 10 TO 15 TIMES. OPERATING PRESS. OPEN 20 TO 22. ACT	M
220	PERFORM DIFFERENTIAL TEST. NOT TO EXCEED 20 PSIG AFTER 30 SEC. ACT	M
230	SAFETYWIRE.	M

PCN 50281A

STATION/OP NO. 117, WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

240 COMPLETE & FORWARD AFID 349 TO DATA PROCESSING.

M

245 I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TOTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.

M

250 OPERATIONS COMPLETE. PAPERWORK PROCESSED.

M

260 COMPLY WITH MAPI 65-35, PARA 13.

M

TYPE WORK PERFORMED

12. DRIC/PROD NR 13 QUANTITY 14. POC 15. DATE SCHED 16. DATE COMP
61138A 1 89135

PART NUMBER 749985 LITER SERIAL NR 3-111 TECH DATA/OPTIONAL SWING 85349L
10. NAME DESIGN/SERIES 11. STOCK NO 12-05 3 SWIFT 87258H
12. POC 13. POC 14. POC 15. POC

13. RISC 14. NOUN/END 15. WASH
FUEL NOZZLES
15. RISC 16. WASH
STATION 17. NO. 18. MECH 19. P 20. Q

NOTE:
NOT A LOW BARREL TYPE - FLAMMABLE
METAL INDICATOR 8" X 10" X 1/4"
PART NO. 4

3061	010	SEAL THE GENEALTY OF CONTACT AREA ONLY	
	HTPCD	ALL OPERATIONS ARE TO BE PERFORMED IN THE AND ALL LABELS AND INSTRUCTIONS. TECH CAUTIONS, WARNINGS, AND NOTES. INSTRUCTIONS MUST BE FOLLOWED.	M
	020	DISASSEMBLE SUBJECT ASSEMBLY TAW PARA 1-9 & 10	M
	030	CLEAN TAW PWA 1-5 IF NECESSARY USE TWO STEP CLEANING PROCEDURE PROCEDURE (ALTERNATE) PARA 4-3	M
	040	USING 8 TO 15X MAGNIFICATION, INSPECT FOR CRACKS.	M
	050	INSPECTION & REPAIR TAW PARA 4-9, IF WELDING REPAIR IS REQUIRED TO REPAIR TAW WORK REFER TO APPROPRIATE PARAS. NOT REQ	M
	060	IF ALL ABOVE STEPS HAVE BEEN COMPLIED WITH, IF REQUIRED: REFER TO BLDG 3108 FOR INTERNAL LEAK TEST. REQ NOT REQ	M
3108	070	PERFORM INTERNAL LEAKAGE CHECK TAW PARA 4-27 (M)	M
		REQ NOT REQ PERFORM THE FOLLOWING LEAK TEST FOR 5 MINUTES.	
		PRIMARY SECONDARY LEAKAGE PSIG VELOCITY CC/MIN ACT. MONITOR ACT.	
		RETURN TO HTPCD	

STATION/OP NO. 117. WERE TO BE REPAIR ICHED 118. NECH 19" P" 20" Q"

3001	088	CONNECTOR CONNECTED BY REPAIR IAW	
	HTPCN	4-19. 110 6.5. 4 2.3 IN2.5 4-3.	M
	070	SEALING	
	HTPCN	4-16. 110 6.5. 4 2.3 IN2.5 4-3.	M
	100	THE	
	HTPCN	4-16. 110 6.5. 4 2.3 IN2.5 4-3.	M
	110		
	HTPCN	4-16. 110 6.5. 4 2.3 IN2.5 4-3.	M
	120		
	HTPCN	4-16. 110 6.5. 4 2.3 IN2.5 4-3.	M
	130		
	HTPCN	4-16. 110 6.5. 4 2.3 IN2.5 4-3.	M
3001	140	NECH 19" P" 20" Q" PARA 4-27(W)	
	HTPCD	IF REPAIR IAW 3.037" 3.037" 3.037"	M
	150	IF STEP 140 IS COMPLETED REPEAT	
		PROCEEDS BY THE END OF STEP 150.	M
	160	ROUTE SUPPORT & REPLY TO BLOC 3108	
	HTPCD	FOR TEST IAW 3.037".	M
	170	FINAL VISUAL INSPECT: IAW	
		NECH 19" P" 20" Q".	M
		INSPECTOR ASSY. RIVET & PIN.	
		LOCK RING	
	180	349 COMPLIANT & PARAGRAPHS IF	
		APPLICABLE	M
	190	OPERATIONS CHECKLIST & PAPERWORK	
		PROCESSED. THAT THIS END	M
		ITER HAS BEEN OVERHAULED IAW T.O.	
		INTO. CURRENT LOGS, SUPPLEMENTS	
		AND APPLICABLE T.O. ORDERS.	
	200	COMPLY WITH 36. PARA 13	
		TYPE WORK PERFORMED	M

12. ORIG/PROD NR 13. QUANTITY 14. 15. DATE SCHED 16. DATE COMP 17. 89131

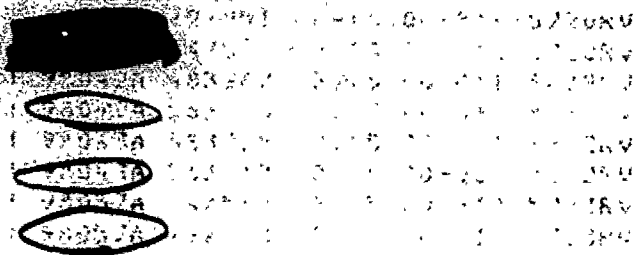
PART NUMBER 18. PART TYPE SERIAL NO. 19. NEW DATA/OPTIONAL 20. 89131 WP 010 00 88336H

21. REGION/SERIES 22. 23. 24. 25. 26. 27. 28. 29. 30. 31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100.

31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100.

41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100.

19. MECH119"P" 20"Q"



3117 010 RECEIVED FROM THE MANUFACTURING DEPARTMENT. ALL PARTS SHALL BE TO THE BASIC T.D. AND APPROVED BY THE DESIGNER. DATA TO BE IN THE DRAWINGS. CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES RELEVANT TO THE PART.

CAUTION: HANDLE MANIFOLD WITH CARE. NEVER TRANSPORT MANIFOLD NOT PROPERLY SUPPORTED IN ORDER TO AVOID STRESSES WILL RESULT IN MANIFOLD DAMAGE.

3001 020 MANIFOLD TO BE STORED IN THE STORAGE AREA. SUPPORT SHALL BE PROVIDED. MANIFOLD SHALL BE STORED WITH THE DIMENSIONS AS SHOWN IN THE DRAWINGS. MANIFOLD SHALL BE STORED WITH THE DIMENSIONS AS SHOWN IN THE DRAWINGS. OF MANIFOLD.

030 DISTORTION CHECK

035 DISTORTION CHECK INLET FLANGE

040 CHECK SHIPPING FOR DISTORTION, NONE ALLOWED

050 CLEAN IAW T.D EXTERIOR HEATSHIELD SHALL BE

115.01SP 14. PDM/ STATION OF NO. 142 WORK TO BE PERFORMED 118. RECH 19"P" 20"Q"

| | | | |
|-----|-------------------------------|--|--|
| 145 | INSPECT AIR INLET | | |
| 150 | FLUSH BURNER | | |
| 155 | INNER AND OUTER BURNER S. LAW | | |
| 160 | REPAIR BURNER | | |
| 165 | INSPECT BURNER | | |
| 170 | REPAIR BURNER | | |
| 210 | DRILL HOLES FOR | | |
| 215 | REFRESH MANIFOLD AT WATER TO | | |
| 220 | INSPECT BURNER | | |
| 230 | INSPECT BURNER | | |
| 250 | INSPECT NOZZLE | | |
| 260 | LEAK NOZZLE | | |
| 270 | FLUSH MANIFOLD | | |
| 280 | PRIOR TO ASSEMBLY | | |

CONTINUED

STATION/OP NO. 117 WORK TO BE ACCOMPLISHED 18 RECH 19 "P" 20 "Q"

NOZZLE BODY 1 2 3

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION

NOZZLE

P/N

SEAL

SELECTED

CLUSTER NO.

NOZZLE
DIMENSION

NOZZLE

P/N

SEAL

SELECTED

CLUSTER NO.

NOZZLE BODY 1 2 3

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION



NOZZLE BODY 4 5 6

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION

NOZZLE
P/N

SEAL

SELECTED

STATION OP NO. 117 WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"

| STATION | DESCRIPTION | UNIT | REMARKS |
|------------|--|------|---------|
| | REJECTED | | |
| 290 | INSTALL SEAL HOLES & TAB LOCKS.
AND TORQUE TO 40 INCH LBS IN/LES | M | |
| 320 | IDENTIFY | M | |
| 330 | TAB HOLES | M | |
| 340 | HOLES | M | |
| 3108 350 | MOVE TO 3 FROM 1ST BLOC 3138. | M | |
| P/0-35 360 | FRONT THERMAL INSUL ASSY. | M | |
| 370 | SEAL TIGHT BLOC TO TAB LOCKS | M | |
| 380 | LAP LEFT ADAPTER BLOC TO MTPCB
MEASURE TIGHT BLOC THICKNESS,
0.240 IN MIN ACT | M | |
| 390 | PERFORM DISTORTION TEST.
CHECK HEATSHIELD AND WELD FOR
CRACKS AND LOGG WELD SHIELDS.
CHECK FLANGE ALIGNMENT. | M | |
| 400 | CAP ALL PORTS & LOGG LUGS TO
FRAME. | M | |
| 410 | INSURE PROPER IDENTIFICATION. | M | |
| 420 | COMPLETE AS
TABLE. | M | |
| 430 | INSPECT, TAG & HOLD FOR WORK.
I CERTIFY THAT THIS UNIT HAS
BEEN OVERHAULED TO MEET ALL
CURRENT REVISIONS AND
APPLICABLE PROCEDURES. | M | |
| 435 | COMPLY WITH 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114, 115, 116, 117, 118, 119, 120, 121, 122, 123, 124, 125, 126, 127, 128, 129, 130, 131, 132, 133, 134, 135, 136, 137, 138, 139, 140, 141, 142, 143, 144, 145, 146, 147, 148, 149, 150, 151, 152, 153, 154, 155, 156, 157, 158, 159, 160, 161, 162, 163, 164, 165, 166, 167, 168, 169, 170, 171, 172, 173, 174, 175, 176, 177, 178, 179, 180, 181, 182, 183, 184, 185, 186, 187, 188, 189, 190, 191, 192, 193, 194, 195, 196, 197, 198, 199, 200, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 218, 219, 220, 221, 222, 223, 224, 225, 226, 227, 228, 229, 230, 231, 232, 233, 234, 235, 236, 237, 238, 239, 240, 241, 242, 243, 244, 245, 246, 247, 248, 249, 250, 251, 252, 253, 254, 255, 256, 257, 258, 259, 260, 261, 262, 263, 264, 265, 266, 267, 268, 269, 270, 271, 272, 273, 274, 275, 276, 277, 278, 279, 280, 281, 282, 283, 284, 285, 286, 287, 288, 289, 290, 291, 292, 293, 294, 295, 296, 297, 298, 299, 300, 301, 302, 303, 304, 305, 306, 307, 308, 309, 310, 311, 312, 313, 314, 315, 316, 317, 318, 319, 320, 321, 322, 323, 324, 325, 326, 327, 328, 329, 330, 331, 332, 333, 334, 335, 336, 337, 338, 339, 340, 341, 342, 343, 344, 345, 346, 347, 348, 349, 350, 351, 352, 353, 354, 355, 356, 357, 358, 359, 360, 361, 362, 363, 364, 365, 366, 367, 368, 369, 370, 371, 372, 373, 374, 375, 376, 377, 378, 379, 380, 381, 382, 383, 384, 385, 386, 387, 388, 389, 390, 391, 392, 393, 394, 395, 396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 783, 784, 785, 786, 787, 788, 789, 790, 791, 792, 793, 794, 795, 796, 797, 798, 799, 800, 801, 802, 803, 804, 805, 806, 807, 808, 809, 810, 811, 812, 813, 814, 815, 816, 817, 818, 819, 820, 821, 822, 823, 824, 825, 826, 827, 828, 829, 830, 831, 832, 833, 834, 835, 836, 837, 838, 839, 840, 841, 842, 843, 844, 845, 846, 847, 848, 849, 850, 851, 852, 853, 854, 855, 856, 857, 858, 859, 860, 861, 862, 863, 864, 865, 866, 867, 868, 869, 870, 871, 872, 873, 874, 875, 876, 877, 878, 879, 880, 881, 882, 883, 884, 885, 886, 887, 888, 889, 890, 891, 892, 893, 894, 895, 896, 897, 898, 899, 900, 901, 902, 903, 904, 905, 906, 907, 908, 909, 910, 911, 912, 913, 914, 915, 916, 917, 918, 919, 920, 921, 922, 923, 924, 925, 926, 927, 928, 929, 930, 931, 932, 933, 934, 935, 936, 937, 938, 939, 940, 941, 942, 943, 944, 945, 946, 947, 948, 949, 950, 951, 952, 953, 954, 955, 956, 957, 958, 959, 960, 961, 962, 963, 964, 965, 966, 967, 968, 969, 970, 971, 972, 973, 974, 975, 976, 977, 978, 979, 980, 981, 982, 983, 984, 985, 986, 987, 988, 989, 990, 991, 992, 993, 994, 995, 996, 997, 998, 999, 1000 | | |
| 440 | MOVE TO PICK-UP | M | |

1. CBE04 WORK CONTROL DOCUMENT - SC 1. DATE 89087 PAGE 1 OF 4 PAGES

12. ORIG/PROD NO 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP
MTPCBE 89131

PART NUMBER 17. ITER SERIAL NR 18/12. TECH DATA/OPTIONAL
2J-TF33-53-11, WP 010 00 88336H
CHG 21

10. MODEL/DESIGN/SERIES 11. STOCK NR
TF33-P7-P9

13. MISC 14. NOUN/END ITEM NOUN
MANIFOLD ASSY, FUEL PAC
SHREVE/RATEAC/65920

15. DISP 16. PDM/
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

| | | |
|------------|--------|--------------------|
| 98034A | 797251 | 2915-00-918-5720RV |
| 98034A | 547512 | 2915-00-918-5720RV |
| 98042A | 483267 | 2915-00-061-8889RV |
| [REDACTED] | 563215 | 2915-00-061-8889RV |
| 98043A | 483268 | 2915-00-061-8892RV |
| 98043A | 563217 | 2915-00-061-8892RV |
| 98057A | 547513 | 2915-00-918-5723RV |
| 98057A | 797263 | 2915-00-918-5723RV |

MTPCB END ITEM CONTAINS PRECIOUS METAL
(GOLD NICKEL) PROCESS IAM MAOI 65-4

| | | | |
|------|--------------|---|---|
| 5117 | 010 | RECEIVE, IDENTIFY & MTC. PAPERWORK
ALL REFERENCES ARE TO THE BASIC T.O.
AND APPLICABLE PROCESS ORDERS. TECH
DATA CONTAINS DETAILED NOTES,
CAUTIONS, WARNINGS, DIMENSIONS AND
TOLERANCES REQUIRING COMPLIANCE.

CAUTION: HANDLE MANIFOLD WITH CARE.
NEVER TRANSPORT MANIFOLDS NOT PROP-
ERLY SUPPORTED IN FIXTURE. STRESSES
WILL RESULT IN MANIFOLD FAILURE. | M |
| 3001 | 020
MTPCB | REMOVE NOZZLES FROM MANIFOLD ASSY. &
STORE IN STORAGE CONTAINERS.
CAUTION: SUPPORT & SECURE NOZZLE
HEADERS WHILE REMOVING FUEL NOZZLES
THIS IS ESSENTIAL SINCE DISTORTION
OF MANIFOLDS WILL REQUIRE SCRAPPING
OF MANIFOLD. | M |
| | 030 | DISTORTION CHECK | M |
| | 035 | DISTORTION CHECK COMPLETED. CHECK
INLET FLANGE THICKNESS.
ACT: | M |
| | 040 | CHECK SHIPPING FIXTURE FOR DISTR-
TION, NONE ALLOWED. | M |
| | 050 | CLEAN IAM T.O.
EXTERIOR HEATSHIELDS MUST BE | M |

(CONTINUED)

IMMEDIATELY CLEANED FOR INSPECTION.

055 NTPIM REMOVE HEATSHIELD AS REQ. M

060 ACID CHECK WELD REQ NOT REQ M

090 NTPCH NOZZLE BODY REPAIR: A. FIG. 12 ITEM 2 ACT: M B. FIG. 12 ITEM 1 ACT: C. FIG. 12 ITEM 3 ACT: D. FIG. 12 ITEM 5 ACT: E. WEAR OF GROOVES IN NOZZLE BODIES, DUE TO HEAT-SHIELD MOTION SHALL NOT EXCEED 0.050 IN. IN GROOVE DEPTH. WEAR ON LANDS IS PERMISSIBLE PROVIDED O D OF LANDS HAS NOT BEEN REDUCED.

100 AS REQUIRED, REMOVE & REPLACE SLEEVES. REQ. NOT REQ. M

110 NPTCH DIMENSIONAL INSPECT LUGS RECORD ACTUAL LUG THICKNESS. M R.H. L.H. CLSTR 1 CLSTR 5 CLSTR 2 CLSTR 6 CLSTR 3 CLSTR 7 CLSTR 4 CLSTR 8

120 NTPIM HEATSHIELDS & LUGS AS REQUIRED. M INSPECT HEATSHIELDS & WELDS FOR T.D.

140 NTPCH REPAIR OR REPLACE THICK LUG BUSHING AS REQUIRED REQ. NOT REQ. M

142 MACHINE THIN LUGS. CK LUG THICKNESS 0.177 TO 0.181 (O.D. MICROMETER) R.H.L.H. CLSTR 1 CLSTR 5 CLSTR 2 CLSTR 6 CLSTR 3 CLSTR 7 CLSTR 4 CLSTR 8

| | | |
|-----|---|---|
| 145 | REPAIR INLET ADAPTER AND BUSHINGS
REQ. NOT REQ. | M |
| 150 | FLUORESCENT PENETRANT INSPECT THE
INNER AND OUTER LUGS FOR CRACKS IAW
T.O. 2J-TF33-53-1, SWP 010 02. | N |
| 155 | PERFORM FLEX MOUNT MOD IAW T.O.
2J-TF33-53-2, SWP 014 04
REQ. NOT REQ.
RECEIVE, IDENTIFY, AND PERFORM
MODIFICATION TO FLEX MOUNT.
MOUNT MANIFOLD & MACHINE OUTER
MOUNTING ADAPTERS TO DIMENSIONS
AS REQUIRED.
DRILL TWO HOLES (0.276-0.286) IN EA.
OUTER MOUNTING ADAPTER IAW FIG. 8.
INSTALL P/N 483260 BRACKETS
P/N 303328 BOLTS, & P/N 454393 NUT
PLATES ON MANIFOLD.
REIDENTIFY TO PROPER PART NUMBER. | M |
| 160 | PERFORM DISTORTION CHECK. COLD
BEND AS REQUIRED. | M |
| 165 | INSPECT HEATSHIELDS WELDS FOR
CRACKS. | M |
| 170 | REPLACE LOOSE OR DAMAGED COMBUSTION
CHAMBER ELBOW
REQ. NOT REQ. | M |
| 210 | DRILL HOLES FOR SILICONE INJECTION.
REQ. NOT REQ. | W |
| 215 | REFLUSH MANIFOLD WITH WATER TO
REMOVE CLEANING SOLUTIONS
REQ. NOT REQ. | M |
| 220 | INSPECT SILICONE. | W |
| 230 | FLUSH MANIFOLD/REMOVE SILICON RESIDUE | W |
| 250 | INSPECT NOZZLE BODY SEATS & THREADS | M |
| 260 | LAP NOZZLE BODY SEATS | M |
| 270 | FLUSH MANIFOLD. | M |
| 280 | PRIOR TO ASSEMBLY, ASSURE CORRECT
SEALS AND NOZZLES ARE SELECTED.
ASSEMBLE MANIFOLD & NOZZLE ASSY | M |

(CONTINUED)

15. DISP-14. PDM/

STATION/OP NO. 117. WORK TO BE ACCOMPLISHED

18. RECH 117 "P" 120 "B"

| | | | |
|-----------------------|---|---|---|
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/M | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/M | | | |
| SEAL SELECTED | | | |
| CLUSTER NO. | | | |
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE | | | |
| SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/M | | | |
| SEAL SELECTED | | | |

(CONTINUED)

| | | | |
|-----------------------|---|---|---|
| CLUSTER NO. | | | |
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| CLUSTER NO. | | | |
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |

| ***** | | | |
|----------|-----------------------|--|---------------------------------|
| CBEC04 | WORK CONTROL DOCUMENT | SC | 1. DATE 59087 PAGE 6 OF 6 PAGES |
| 15. DISP | 16. PDN | | |
| STATION | OP NO. | 17. WORK TO BE ACCOMPLISHED | 18. RECH 19 "P" 20 "Q" |
| | | SEAL
SELECTED | |
| | 290 | INSTALL SEAL, NOZZLES & TAB LOCKS.
AND TORQUE NOZZLES 450 +/- 50 IN/LBS | M |
| | 320 | IDENTIFY: P/N _____ SER # _____ | M |
| | 330 | CAP NOZZLES, PROTECT INLET FLANGE. | M |
| | 340 | OVERHAUL OPERATIONS & PAPERWORK PRO-
CESSED. | M |
| 3108 | 350 | MOVE TO & FROM TEST BLOB 3108.
ATTACH RUN SHEET CTEC04. | M |
| P/O-35 | 360 | PROCESS THROUGH FINAL ASSY. | M |
| | 370 | SLEEVES TIGHT & FLARED, SET TABLOCKS | M |
| | MTPCB | | M |
| | 380 | LAP INLET ADAPTER. MOVE TO MTPCB
MEASURE INLET HEAD THICKNESS,
0.260 IN MIN ACT | M |
| | MTPCB | | M |
| | 390 | PERFORM DISTORTION CHECK.
CHECK HEATSHIELDS AND WELDS FOR
CRACKS AND LOOSE HEAT SHIELDS.
CHECK FLANGE ALIGNMENT. | M |
| | MTPCB | | M |
| | 400 | CAP ALL PORTS & SECURE ALL LUGS TO
FRAME. | M |
| | 410 | ENSURE PROPER IDENTIFICATION. | M |
| | 420 | 349 COMPLETED & FORWARDED AS
APPLICABLE. | M |
| | 430 | INSPECT, TAB & PROCESS PAPERWORK.
I CERTIFY THAT THIS END ITEM HAS
BEEN OVERHAULED IAW T.O., TCLO,
CURRENT REVISIONS, SUPPLEMENTS AND
APPLICABLE PROCESS ORDERS. | M |
| | 435 | COMPLY WITH NAOI 66-36, PARA 13. | M |
| | | TYPE WORK PERFORMED _____ | M |
| | 440 | MOVE TO PICK-UP STATION. | M |

PCN 98043A

CBEC04 * WORK CONTROL DOCUMENT * SC 1. DATE 89087 PAGE 1 OF 6 PAGES

12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP
1 ATPCBE 1 89131 1

PART NUMBER 19. ITER SERIAL NR 18/12. TECH DATA/OPTIONAL
6. 2J-TF33-53-11, WP 010 00 88336H
CHG 21
10. MODEL/DESIGN/SERIES 11. STOCK NR
TF33-P7-P9
13. MISC 14. NOUN/END ITEM NOUN
MANIFOLD ASSY, FUEL FACI
SHREVE/MATEAC/65920

15. DISP-14. PDN/
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

98034A 797251 2915-00-918-5720RV
98034A 547512 2915-00-918-5720RV
98042A 483267 2915-00-061-8889RV
98042A 543215 2915-00-061-8889RV
98042A 483268 2915-00-061-8892RV
543217 2915-00-061-8892RV
98057A 547513 2915-00-918-5723RV
98057A 797263 2915-00-918-5723RV

ATP.C.B

END ITEM CONTAINS PRECIOUS METAL
(BOLD NICKEL) PROCESS IAW MADI 65-4

3117 010 RECEIVE, IDENTIFY & ATTCH. PAPERWORK
ALL REFERENCES ARE TO THE BASIC T.O. M
AND APPLICABLE PROCESS ORDERS. TECH
DATA CONTAINS DETAILED NOTES,
CAUTIONS, WARNINGS, DIMENSIONS AND
TOLERANCES REQUIRING COMPLIANCE.

CAUTION: HANDLE MANIFOLD WITH CARE.
NEVER TRANSPORT MANIFOLDS NOT PROP-
ERLY SUPPORTED IN FIXTURE. STRESSES
WILL RESULT IN MANIFOLD FAILURE.

3001 020 REMOVE NOZZLES FROM MANIFOLD ASSY. &
ATPCBE IN STORAGE CONTAINERS. M
SUPPORT & SECURE NOZZLE
WHILE REMOVING FUEL NOZZLES
IS ESSENTIAL SINCE DISTORTION
OF MANIFOLDS WILL REQUIRE SCRAPPING
OF MANIFOLD.

030 DISTORTION CHECK M

035 DISTORTION CHECK COMPLETED. CHECK
INLET FLANGE THICKNESS. M
ACT:

040 CHECK SHIPPING FIXTURE FOR DISTOR-
TION, NONE ALLOWED. M

050 CLEAN IAW T.O.
EXTERIOR HEATSHIELDS MUST BE M

(CONTINUED)

PCN 98043A

THOROUGHLY CLEANED FOR INSPECTION.

055 REMOVE HEATSHIELD AS REQ. M
NTPIM

060 ACID CHECK WELD M
REQ NOT REQ

090 NOZZLE BODY REPAIR: M
NTPCM A. FIG. 12 ITEM 2
ACT:
B. FIG. 12 ITEM 1
ACT:
C. FIG. 12 ITEM 3
ACT:
D. FIG. 12 ITEM 5
ACT:
E. WEAR OF GROOVES IN NOZZLE BODIES, DUE TO HEAT-SHIELD MOTION SHALL NOT EXCEED 0.050 IN. IN GROOVE DEPTH. WEAR ON LANDS IS PERMISSIBLE PROVIDED O D OF LANDS HAS NOT BEEN REDUCED.

100 AS REQUIRED, REMOVE & REPLACE SLEEVES. M
REQ. NOT REQ.

110 DIMENSIONAL INSPECT LUGS RECORD ACTUAL LUG THICKNESS. M
NPTCM
R.H. L.H.
CLSTR 1 CLSTR 5
CLSTR 2 CLSTR 6
CLSTR 3 CLSTR 7
CLSTR 4 CLSTR 8

120 HEATSHIELDS & LUGS AS REQUIRED. W
NTPIM INSPECT HEATSHIELDS & WELDS FOR IAW T.O.

140 REPAIR OR REPLACE THICK LUG M
NTPCM BUSHING AS REQUIRED
REQ. NOT REQ.

142 MACHINE THIN LUGS. CK LUG THICKNESS 0.177 TO 0.181 (O.D. MICROMETER) M
R.H.L.H.
CLSTR 1 CLSTR 5
CLSTR 2 CLSTR 6
CLSTR 3 CLSTR 7
CLSTR 4 CLSTR 8

| | | |
|--------------|---|---|
| 145 | REPAIR INLET ADAPTER AND BUSHINGS
REQ. NOT REQ. | M |
| 150
ATPIW | FLUORESCENT PENETRANT INSPECT THE
INNER AND OUTER LUGS FOR CRACKS IAW
T.O. 2J-TF33-53-1, SWP 010 02. | N |
| 155
ATPCM | PERFORM FLEX MOUNT MOD IAW T.O.
2J-TF33-53-2, SWP 016 04
REQ. NOT REQ.
RECEIVE, IDENTIFY, AND PERFORM
MODIFICATION TO FLEX MOUNT.
MOUNT MANIFOLD & MACHINE OUTER
MOUNTING ADAPTERS TO DIMENSIONS
AS REQUIRED.
DRILL TWO HOLES (0.276-0.286) IN EA.
OUTER MOUNTING ADAPTER IAW FIG. 8.
INSTALL P/N 483260 BRACKETS
P/N 303328 BOLTS, & P/N 454393 NUT
PLATES ON MANIFOLD.
REIDENTIFY TO PROPER PART NUMBER. | M |
| 160 | PERFORM DISTORTION CHECK. COLD
BEND AS REQUIRED. | M |
| 165
ATPCB | INSPECT HEATSHIELDS WELDS FOR
CRACKS. | M |
| 170
ATPCB | REPLACE LOOSE OR DAMAGED COMBUSTION
CHAMBER ELBOW
REQ. NOT REQ. | M |
| 210
ATPCM | DRILL HOLES FOR SILICONE INJECTION.
REQ. NOT REQ. | W |
| 215
ATPIW | REFLUSH MANIFOLD WITH WATER TO
REMOVE CLEANING SOLUTIONS
REQ. NOT REQ. | M |
| 220
ATPIW | INSPECT SILICONE. | W |
| 230
ATPIW | FLUSH MANIFOLD/REMOVE SILICON RESIDUE | W |
| 250
ATPCB | INSPECT NOZZLE BODY SEATS & THREADS | M |
| 260 | LAP NOZZLE BODY SEATS | M |
| 270 | FLUSH MANIFOLD. | M |
| 280 | PRIOR TO ASSEMBLY, ASSURE CORRECT
SEALS AND NOZZLES ARE SELECTED.
ASSEMBLE MANIFOLD & NOZZLE ASSY | M |

(CONTINUED)

CBEC04 * WORK CONTROL DOCUMENT * SC 1. DATE 89087 PAGE 4 OF 6 PAGES
15. OISP-14. PDM/
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" / 20 "Q"

NOZZLE BODY 1 2 3

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION

NOZZLE
P/M

SEAL
SELECTED

NOZZLE BODY 4 5 6

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION

NOZZLE
P/M

SEAL
SELECTED

CLUSTER NO.

NOZZLE BODY 1 2 3

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION

NOZZLE
P/M

SEAL
SELECTED

NOZZLE BODY 4 5 6

NOZZLE BODY
DIMENSION

NOZZLE
DIMENSION

NOZZLE
P/M

SEAL
SELECTED

(CONTINUED)

| | | | |
|-----------------------|---|---|---|
| CLUSTER NO. | | | |
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| CLUSTER NO. | | | |
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |

(CONTINUED)

| STATION OF NO. | WORK TO BE ACCOMPLISHED | RECH | "P" | "C" |
|----------------|--|------|-----|-----|
| | SELECTED | | | |
| 290 | INSTALL SEAL, NOZZLES & TAB LOCKS.
AND TORQUE NOZZLES 450 +/-50 IN/LBS | M | | |
| 320 | IDENTIFY: P/N _____ SER N _____ | M | | |
| 330 | CAP NOZZLES, PROTECT INLET FLANGE. | M | | |
| 340 | OVERHAUL OPERATIONS & PAPERWORK PROCESSED. | M | | |
| 3108 | 350 MOVE TO & FROM TEST BLOB 3108.
ATTACH RUN SHEET CTEC04. | M | | |
| P/O-35 | 360 PROCESS THROUGH FINAL ASSY. | M | | |
| | 370 SLEEVES TIGHT & FLAKED, SET TABLOCKS
MTPCB | M | | |
| | 380 LAP INLET ADAPTER, MOVE TO MTPCB
MTPCB MEASURE INLET HEAD THICKNESS,
0.260 IN MIN ACT | M | | |
| | 390 PERFORM DISTORTION CHECK.
MTPCB CHECK HEATSHIELDS AND WELDS FOR
CRACKS AND LOOSE HEAT SHIELDS.
CHECK FLANGE ALIGNMENT. | M | | |
| | 400 CAP ALL PORTS & SECURE ALL LUGS TO
FRAME. | M | | |
| | 410 INSURE PROPER IDENTIFICATION. | M | | |
| | 420 249 COMPLETED & FORWARDED AS
APPLICABLE. | M | | |
| | 430 INSPECT, TAG & PROCESS PAPERWORK.
I CERTIFY THAT THIS END ITEM HAS
BEEN OVERHAULED IAW T.O., TCTO,
CURRENT REVISIONS, SUPPLEMENTS AND
APPLICABLE PROCESS ORDERS. | M | | |
| | 435 COMPLY WITH RAOI 46-36, PARA 13.

TYPE WORK PERFORMED _____ | M | | |
| | 440 MOVE TO PICK-UP STATION. | M | | |

CBEC04 * WORK CONTROL DOCUMENT * SC 1. DATE 89087 PAGE 1 OF 6 PAGES

2. ORIG/PROD NR 13. QUANTITY 14. PRUD SECTION/RCC 15. DATE SCHED 16. DATE COMP
1 NTPCBE 1 89131 1

PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL
2J-TF33-53-11, WP 010 00 88336H
CHD 21

10. MODEL/DESIGN/SERIES 11. STOCK NR
TF33-P7-P9

13. MISC 14. NOUN/END ITEM NOUN
MANIFOLD ASSY, FUEL PACI
SHREVE/MATEAC/65920

15. DISP 16. PDN/
STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19 "P" 20 "Q"

| | | | | | |
|--|--|---------------|--------------------|--|--|
| | | 98034A 797251 | 2915-00-918-5720RV | | |
| | | 98034A 547512 | 2915-00-918-5720RV | | |
| | | 98042A 483267 | 2915-00-061-8889RV | | |
| | | 98042A 563215 | 2915-00-061-8889RV | | |
| | | 98043A 483268 | 2915-00-061-8892RV | | |
| | | 98043A 563217 | 2915-00-061-8892RV | | |
| | | 98057A 547513 | 2915-00-918-5723RV | | |
| | | 797263 | 2915-00-918-5723RV | | |

END ITEM CONTAINS PRECIOUS METAL
(BOLD NICKEL) PROCESS IAW MAOI 65-4

| | | | | | |
|------|-----|---|--|--|---|
| 3117 | 010 | RECEIVE, IDENTIFY & MTC. PAPERWORK
ALL REFERENCES ARE TO THE BASIC T.O.
AND APPLICABLE PROCESS ORDERS. TECH
DATA CONTAINS DETAILED NOTES,
CAUTIONS, WARNINGS, DIMENSIONS AND
TOLERANCES REQUIRING COMPLIANCE.

CAUTION: HANDLE MANIFOLD WITH CARE.
NEVER TRANSPORT MANIFOLDS NOT PROP-
ERLY SUPPORTED IN FIXTURE. STRESSES
WILL RESULT IN MANIFOLD FAILURE. | | | M |
|------|-----|---|--|--|---|

| | | | | | |
|------|-----|---|--|--|---|
| 3001 | 020 | REMOVE NOZZLES FROM MANIFOLD ASSY. &
NTPCBE STORE IN STORAGE CONTAINERS.
SUPPORT & SECURE NOZZLE
WHILE REMOVING FUEL NOZZLES
IS ESSENTIAL SINCE DISTORTION
OF MANIFOLDS WILL REQUIRE SCRAPPING
OF MANIFOLD. | | | M |
|------|-----|---|--|--|---|

| | | | | | |
|--|-----|------------------|--|--|---|
| | 030 | DISTORTION CHECK | | | M |
|--|-----|------------------|--|--|---|

| | | | | | |
|--|-----|--|--|--|---|
| | 035 | DISTORTION CHECK COMPLETED. CHECK
INLET FLANGE THICKNESS.
ACT: | | | M |
|--|-----|--|--|--|---|

| | | | | | |
|--|-----|---|--|--|---|
| | 040 | CHECK SHIPPING FIXTURE FOR DISTOR-
TION, NONE ALLOWED. | | | M |
|--|-----|---|--|--|---|

| | | | | | |
|--|-----|--|--|--|---|
| | 050 | CLEAN IAW T.O.
EXTERIOR HEATSHIELDS MUST BE | | | M |
|--|-----|--|--|--|---|

| | | | |
|--------------|--|--|---|
| | | ADEQUATELY CLEANED FOR INSPECTION. | |
| 035
NTPIM | | REMOVE HEATSHIELD AS REQ. | M |
| 040 | | ACID CHECK WELD
REQ. NOT REQ. | M |
| 090
NTPCM | | NOZZLE BODY REPAIR:
A. FIG. 12 ITEM 2
ACT: _____
B. FIG. 12 ITEM 1
ACT: _____
C. FIG. 12 ITEM 3
ACT: _____
D. FIG. 12 ITEM 5
ACT: _____
E. WEAR OF GROOVES IN NOZZLE BODIES,
DUE TO HEAT-SHIELD MOTION SHALL NOT
EXCEED 0.050 IN. IN GROOVE DEPTH.
WEAR ON LANDS IS PERMISSIBLE PRO-
VIDED O.D. OF LANDS HAS NOT BEEN
REDUCED. | M |
| 100 | | AS REQUIRED, REMOVE & REPLACE
SLEEVES.
REQ. NOT REQ. | M |
| 110
NPTCM | | DIMENSIONAL INSPECT LUGS RECORD
ACTUAL LUG THICKNESS.

R.H. L.H.
CLSTR 1 CLSTR 5
CLSTR 2 CLSTR 6
CLSTR 3 CLSTR 7
CLSTR 4 CLSTR 8 | M |
| 120
NTPIM | | REMOVE HEATSHIELDS & LUGS AS REQUIRED.
INSPECT HEATSHIELDS & WELDS FOR
CHECKS IAW T.O. | M |
| 140
NPTCM | | REPAIR OR REPLACE THICK LUG
BUSHING AS REQUIRED
REQ. NOT REQ. | M |
| 142 | | MACHINE THIN LUGS. CK LUG THICKNESS
0.177 TO 0.181 (0.0. MICROMETER)

R.H. L.H.
CLSTR 1 CLSTR 5
CLSTR 2 CLSTR 6
CLSTR 3 CLSTR 7
CLSTR 4 CLSTR 8 | |

CBEC04 * WORK CONTROL DOCUMENT # SC 1. DATE 89087 PAGE 3 OF 6 PAGES
115.DISP-16.PDN/
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.RECH119"P"120"Q"

- 145 AIR INLET ADAPTER AND BUSHINGS
NOT REQ. M
- 150 FLUORESCENT PENETRANT INSPECT THE
ATPIW INNER AND OUTER LUGS FOR CRACKS IAW
T.O. 2J-TF33-53-1, SWP 010 02. M
- 155 PERFORM FLEX MOUNT MOD IAW T.O.
ATPCW 2J-TF33-53-2, SWP 016 04 M
REQ. NOT REQ.
RECEIVE, IDENTIFY, AND PERFORM
MODIFICATION TO FLEX MOUNT.
MOUNT MANIFOLD & MACHINE OUTER
MOUNTING ADAPTERS TO DIMENSIONS
AS REQUIRED.
DRILL TWO HOLES (0.276-0.286) IN EA.
OUTER MOUNTING ADAPTER IAW FIG. 8.
INSTALL P/N 483260 BRACKETS
P/N 303328 BOLTS & P/N 454393 NUT
PLATES ON MANIFOLD.
REIDENTIFY TO PROPER PART NUMBER.
- 160 PERFORM DISTORTION CHECK. COLD
BEND AS REQUIRED. M
- 165 INSPECT HEATSHIELDS WELDS FOR
ATPCB CRACKS. M
- 170 REPLACE LOOSE OR DAMAGED COMBUSTION
ATPCB CHAMBER ELBOW M
REQ. NOT REQ.
- 210 DRILL HOLES FOR SILICONE INJECTION.
ATPCW REQ. NOT REQ. W
- 215 REFLUSH MANIFOLD WITH WATER TO
ATPIW REMOVE CLEANING SOLUTIONS M
REQ. NOT REQ.
- 220 [REDACTED] SILICONE. W
ATPIW
- 230 [REDACTED] MANIFOLD/REMOVE SILICON RESIDUE W
ATPIW
- 250 INSPECT NOZZLE BODY SEATS & THREADS M
ATPCB
- 260 LAP NOZZLE BODY SEATS M
- 270 FLUSH MANIFOLD. M
- 280 PRIOR TO ASSEMBLY, ASSURE CORRECT M
SEALS AND NOZZLES ARE SELECTED.
ASSEMBLE MANIFOLD & NOZZLE ASSY

PCN 921024

CBEC04 * WORK CONTROL DOCUMENT * 9C 1. DATE 89087 PAGE 4 OF 6 PAGES
15. DISP 16. PDN/
STATION/OP NO. 117. WORK TO BE ACCOMPLISHED 18. RECH 19 "P" 20 "Q"

| | | | |
|-----------------------|---|---|---|
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| CLUSTER NO. | | | |
| NOZZLE BODY | 1 | 2 | 3 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |
| NOZZLE BODY | 4 | 5 | 6 |
| NOZZLE BODY DIMENSION | | | |
| NOZZLE DIMENSION | | | |
| NOZZLE P/N | | | |
| SEAL SELECTED | | | |

(CONTINUED)

CLUSTER NO.

| | | | |
|-------------|---|---|---|
| NOZZLE BODY | 1 | 2 | 3 |
|-------------|---|---|---|

NOZZLE BODY
 DIMENSION

NOZZLE
 DIMENSION

NOZZLE
 P/N

SEAL
 SELECTED

| | | | |
|-------------|---|---|---|
| NOZZLE BODY | 4 | 5 | 6 |
|-------------|---|---|---|

NOZZLE BODY
 DIMENSION

NOZZLE
 DIMENSION

NOZZLE
 P/N

SEAL
 SELECTED

CLUSTER NO.

| | | | |
|-------------|---|---|---|
| NOZZLE BODY | 1 | 2 | 3 |
|-------------|---|---|---|

NOZZLE BODY
 DIMENSION

NOZZLE
 DIMENSION

SEAL
 SELECTED

| | | | |
|-------------|---|---|---|
| NOZZLE BODY | 4 | 5 | 6 |
|-------------|---|---|---|

NOZZLE BODY
 DIMENSION

NOZZLE
 DIMENSION

NOZZLE
 P/N

| | | SEAL
SELECTED | | |
|--------|-----|--|---|--|
| | 290 | INSTALL SEAL, NOZZLES & TAB LOCKS.
AND TORQUE NOZZLES 450 +/- 50 IN/LBS | M | |
| | 320 | IDENTIFY: P/N SER N | M | |
| | 330 | CAP NOZZLES, PROTECT INLET FLANGE. | M | |
| | 340 | OVERHAUL OPERATIONS & PAPERWORK PRO-
CESSED. | M | |
| 3108 | 350 | MOVE TO & FROM TEST BLDG 3108.
ATTACH RUN SHEET CTEC04. | M | |
| P/O-35 | 360 | PROCESS THROUGH FINAL ASSY. | M | |
| | 370 | SLEEVES TIGHT & FLARED, SET TABLOCKS
ATPCS | M | |
| | 380 | LAP INLET ADAPTER, MOVE TO ATPCB
ATPCB MEASURE INLET HEAD THICKNESS,
0.260 14 MIN ACT | M | |
| | 390 | PERFORM DISTORTION CHECK.
ATPCB CHECK HEATSHIELDS AND WELDS FOR
CRACKS AND LOOSE HEAT SHIELDS.
CHECK FLANGE ALIGNMENT. | M | |
| | 400 | CAP ALL PORTS & SECURE ALL LUGS TO
FRAME. | M | |
| | 410 | INSURE PROPER IDENTIFICATION. | M | |
| | 420 | 349 COMPLETED & FORWARDED AS
APPLICABLE. | M | |
| | 430 | INSPECT, TAB & PROCESS PAPERWORK.
I CERTIFY THAT THIS END ITEM HAS
BEEN OVERHAULED IAW T.O., TCTO,
CURRENT REVISIONS, SUPPLEMENTS AND
APPLICABLE PROCESS ORDERS. | M | |
| | 435 | COMPLY WITH RAOI 66-36, PARA 13.
TYPE WORK PERFORMED | M | |
| | 440 | MOVE TO PICK-UP STATION. | M | |

 CMEZ03 * WORK CONTROL DOCUMENT * JC 1. DATE 89040 PAGE 1 OF 3 PAGES

 2. DRIB/PROD NR 13. QUANTITY 14. PRDD SECT. UN/RCD 15. DATE SCHED 16. DATE COMP
 MTPCM B9094

PCN 98206A

ART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL
 6310 4-71 3 892141
 610 10
 10. MODEL/DESIGN/SERIES 11. STOCK NR
 11 41 A1/A2
 13. MISC 14. MOUN/END ITEM MOUN
 H.P. PUMP HINGE PLATE PCSI
 WOLFTRON/MATEAC/65920
 P/N NSN C/N
 6897012 2915010778745CN 98206
 6097012 2915010798745RN 61210

15. DISP-16. PON/
 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19. 20. 21.

C/N P/N NSN
 98406 6897012 2915010778745RN

THIS WCD IS FOR REPLACEMENT OF THE
 HMG HINGE PLATE, MAJOR O/H
 (TYPE "A") ONLY. NOT REQUIRED FOR
 MINOR O/H (TYPE "B") JOBS.
 PUMP REMOVED FROM

ACCOMPLISH ALL OPERATIONS IAW T.O.
 TCTD, APPLICABLE PROCESS ORDERS,
 TECH DATA CONTAINS NOTES, CAUTIONS,
 WARNINGS, DIMENSIONS, AND TOLERANCES
 REQUIRING COMPLIANCE.

010 MOVE COMPONENT TO MACHINE SHOP
 MTPCM (MTPCM). USE THIS DOCUMENT FOR
 ROUTING AND REPAIR. UPON RETURN OF
 (CONTINUED)

COMPONENT FROM NTPCM REATTACH THIS WCD TO PUMP WCD PACKAGE.

020
NTPCM

REPAIR HMG GOVERNOR ASSY. IAW PARA 6-6, TABLE 6-1 THRU 6-3, PERFORM THE FOLLOWING OPERATIONS, AND RETURN TO NTPCB O/H SHOP WHEN COMPLETED.

021

A. REMOVE UNSERVICEABLE HINGE PLATE BY MARKING AN X ON THE BOTTOM OF OLD HINGE PLATE. INSTALL LEVER ASSY. ON FIXTURE AND GRIND RIVET HEADS FLUSH TO HINGE PLATE. PRESS OUT OLD RIVETS.

021

B. SET UP RIVETING FIXTURE AND INSTALL NEW HINGE PLATE WITH REPLACEMENT RIVETS. IF REQ, REAM UNDERSIZE HOLES. THE COUNTER SUNK SIDE OF HINGE PLATE SHOULD BE NEXT TO THE RIVET HEADS. RIVET TOGETHER. CHECK THAT HINGE PLATE IS PARALLEL TO DRIFICE PAD TO WITHIN 0.002 TIR, AS SHOWN IN FIG. 6-1.

022

C. REMOVE EXISTING DOWELS FROM MOUNTING PLATE. IF DOWEL HOLES HAVE PREVIOUSLY BEEN DRILLED THROUGH, PUNCH OUT THE EXISTING DOWELS WITH A SUITABLE PIN PUNCH IF NOT, REMOVE DOWELS BY MOUNTING THE OLD HINGE PLATE, ON THE BOTTOM OF MOUNTING PLATE, WHERE THE "X" WILL SHOW. SELECT A SMALL DRILL BIT APPROX. ONE-HALF THE DIAMETER OF THE DOWEL AND DRILL THROUGH THE CENTER OF THE DOWEL HOLE IN THE OLD HINGE PLATE UNTIL BIT HITS DOWEL. USE A SMALL PIN PUNCH TO DRIVE OUT DOWELS. REMOVE DIRT OR CORROSION AROUND HOLES WITH A BRASS BRUSH.

023

D. SELECT APPROPRIATE DRILL ACCORDING TO DOWEL HOLE SIZE (DIAMETER) TABLE 6-1A. USING ORIGINAL DOWEL HOLES FOR GUIDES DRILL THROUGH THE MOUNTING PLATE ASSEMBLE THE HINGE PLATE & LEVER ASSY. TO MOUNTING PLATE, USING SLAVE BOLTS AND SUPPORT PLATE. ENSURE LEVER DRIFICE PAD IS CENTRALLY LOCATED OVER MOUNTING PLATE DRIFICE.

024

E. INSTALL MOUNTING PLATE IN HOLDING FIXTURE; FLAT SIDE UP, LEVER DOWN (CONTINUED)

USE THE THROUGH HOLES AS GUIDES &
 DRILL THROUGH THE HINGE PLATE.
 REAM DRILLED HOLE AS REQUIRED.
 CHECK DIAMETER "D" WITH PLUG GAGE

025

REMOVE HINGE AND LEVER ASSEMBLY
 FROM MOUNTING PLATE. SELECT
 APPROPRIATE REAMER AND REAM HINGE
 PLATE DIAM. "C".
 REMOVE BURRS FROM HOLES IN MOUNT-
 ING PLATE AND HINGE PLATE. WASH
 PARTS IN SOLVENT PD 600 AND DRY
 IN A MOISTURE FREE AIR BLAST.

026

INSTALL MOUNTING PLATE IN HOLDING
 FIXTURE, FLAT SIDE DOWN.
 ASSEMBLE HINGE LOOSELY TO MOUNTING
 PLATE. INSTALL AND SEAT DOWEL AS
 SHOWN IN FIG. 6-3. DOWELS TO BE
 FLUSH WITH HINGE PLATE SURFACE OR
 NOT MORE THAN 0.002 BELOW IT. DOWEL
 PROTRUSION NOT TO EXCEED 0.020
 BEYOND MOUNTING PLATE BOTTOM
 SURFACE. REMOVE AND REINSTALL HINGE
 PLATE SEVERAL TIMES TO ASSURE
 CLEARANCE BETWEEN HINGE PLATE DOWEL
 HOLES & DOWELS. REREAM HINGE PLATE
 DOWEL HOLES IF REQUIRED.

CAUTION:

THE MATCHED SET SHOULD BE STORED
 CAREFULLY TO PREVENT THE MIXING OF
 PARTS AND TO EXCLUDE THE POSSIBILITY
 OF DAMAGE. SCRATCHES ON THE HINGE
 CAN DEVELOPE INTO CRACKS.

030
 MTPCB

FORM FLUORESCENT PENETRANT
 SECTION IAW MIL I 3086.
 LEVER
 OK _____ REP _____
 HINGE PLATE
 OK _____ REP _____

040

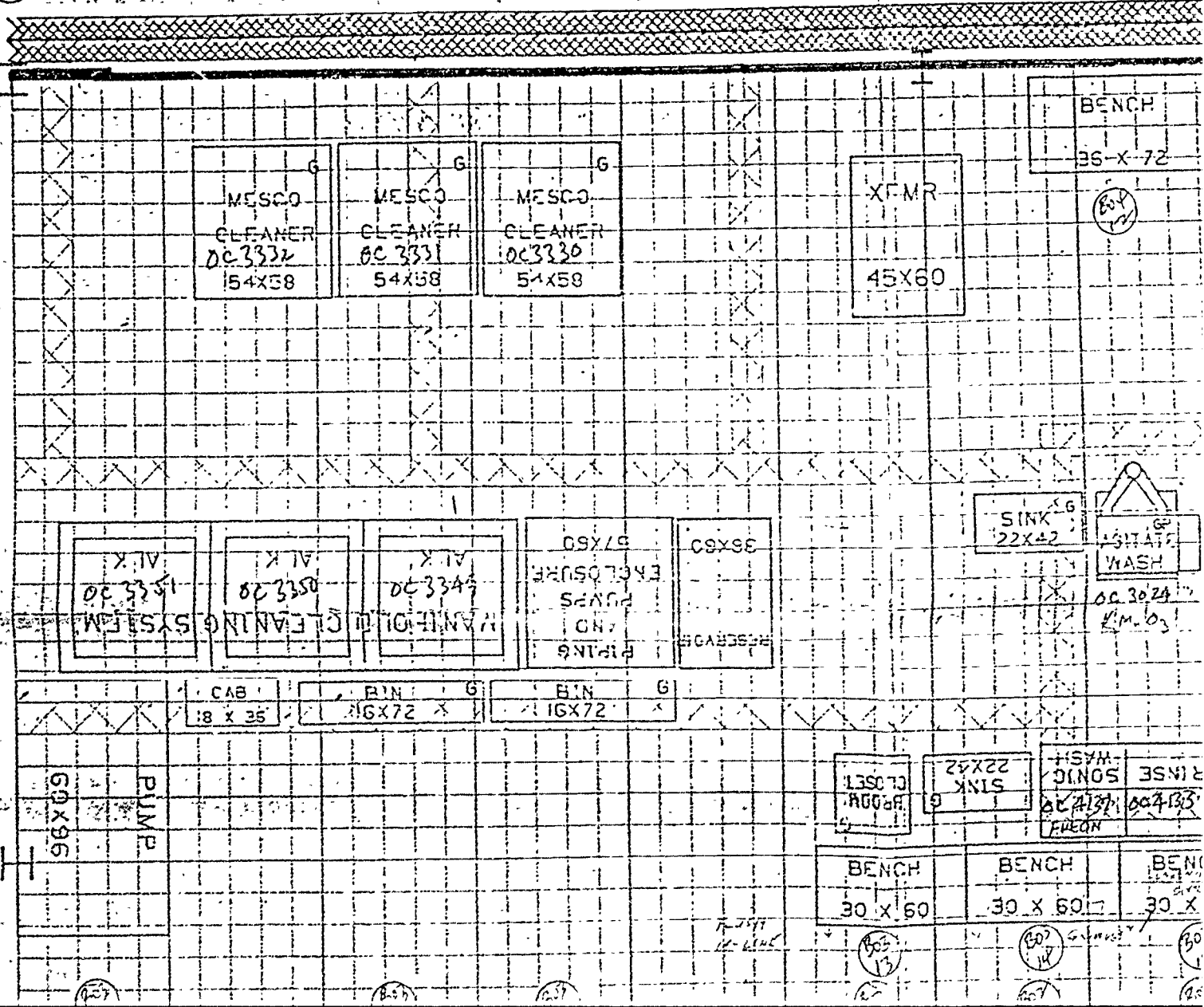
ALL OPERATIONS COMPLETE & PAPERWORK
 PROCESSED. I CERTIFY THAT THIS END
 ITEM HAS BEEN WORKED IAW APPLICABLE
 TECH DATA AND PROCESS ORDERS.

050

RECEIVE AND ATTACH THIS WCD TO ITEM
 PACKAGE.

35

M



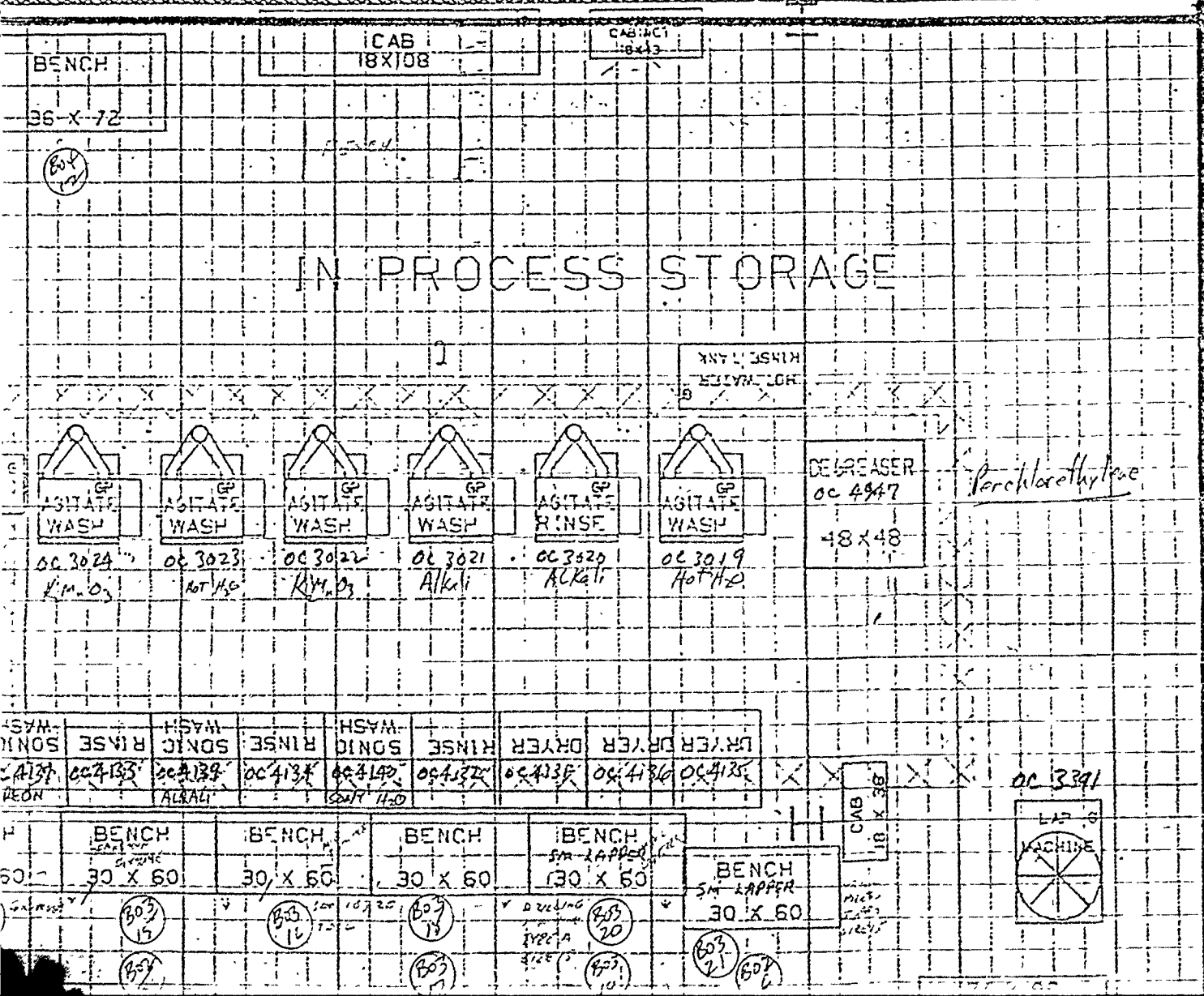
N

50
 73

 3650
 204

 3446 SF

(37)



S.H.O.P.

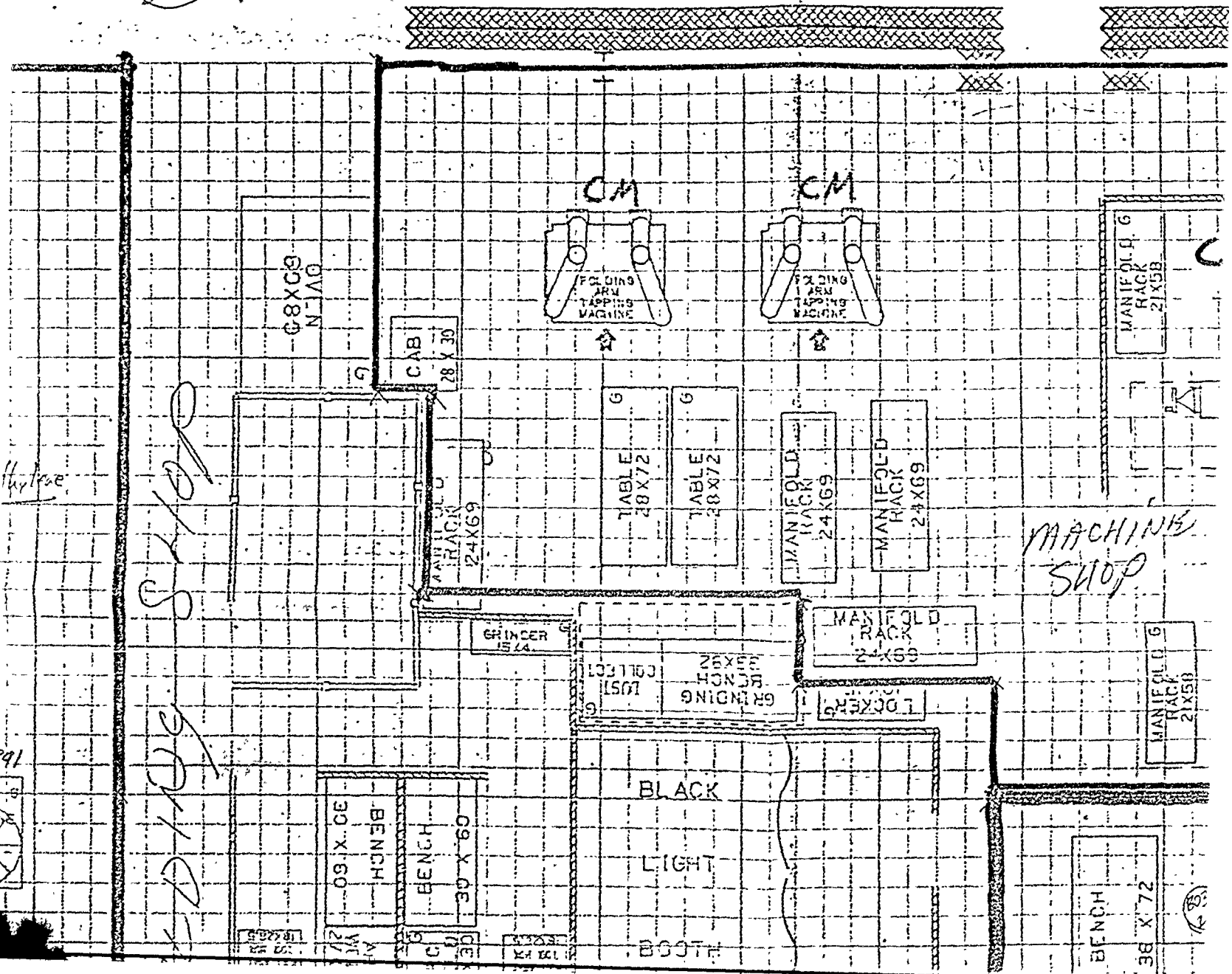
50
73

3650
204

3446 SP. P.

67084

3446
298
3744



Hypose

SLIP

MACHINE SHOP

191

67117

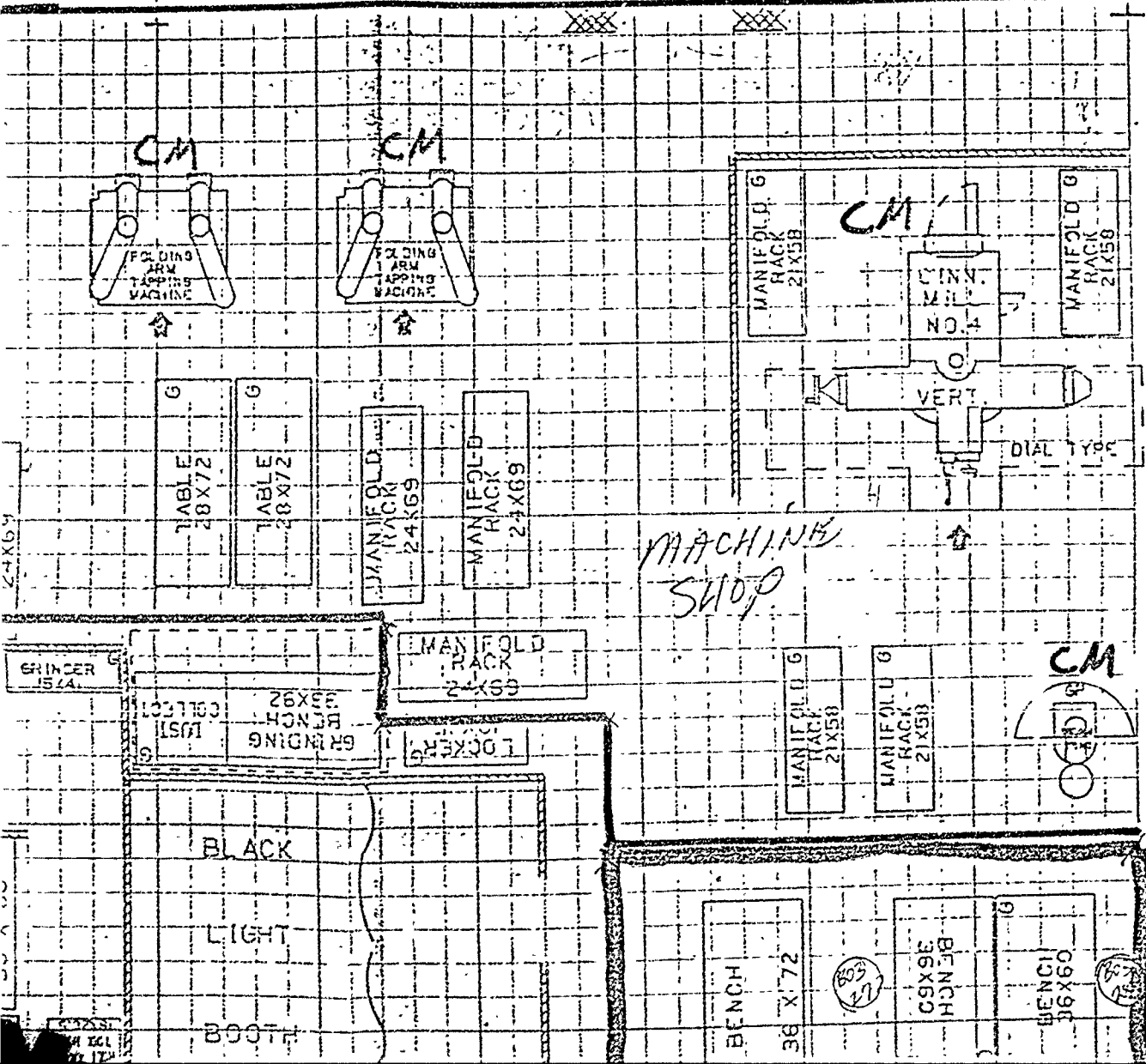
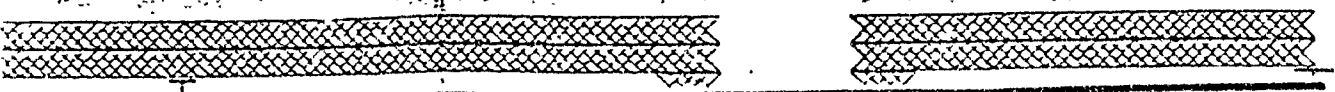
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3444
298
3744

67054

39

M

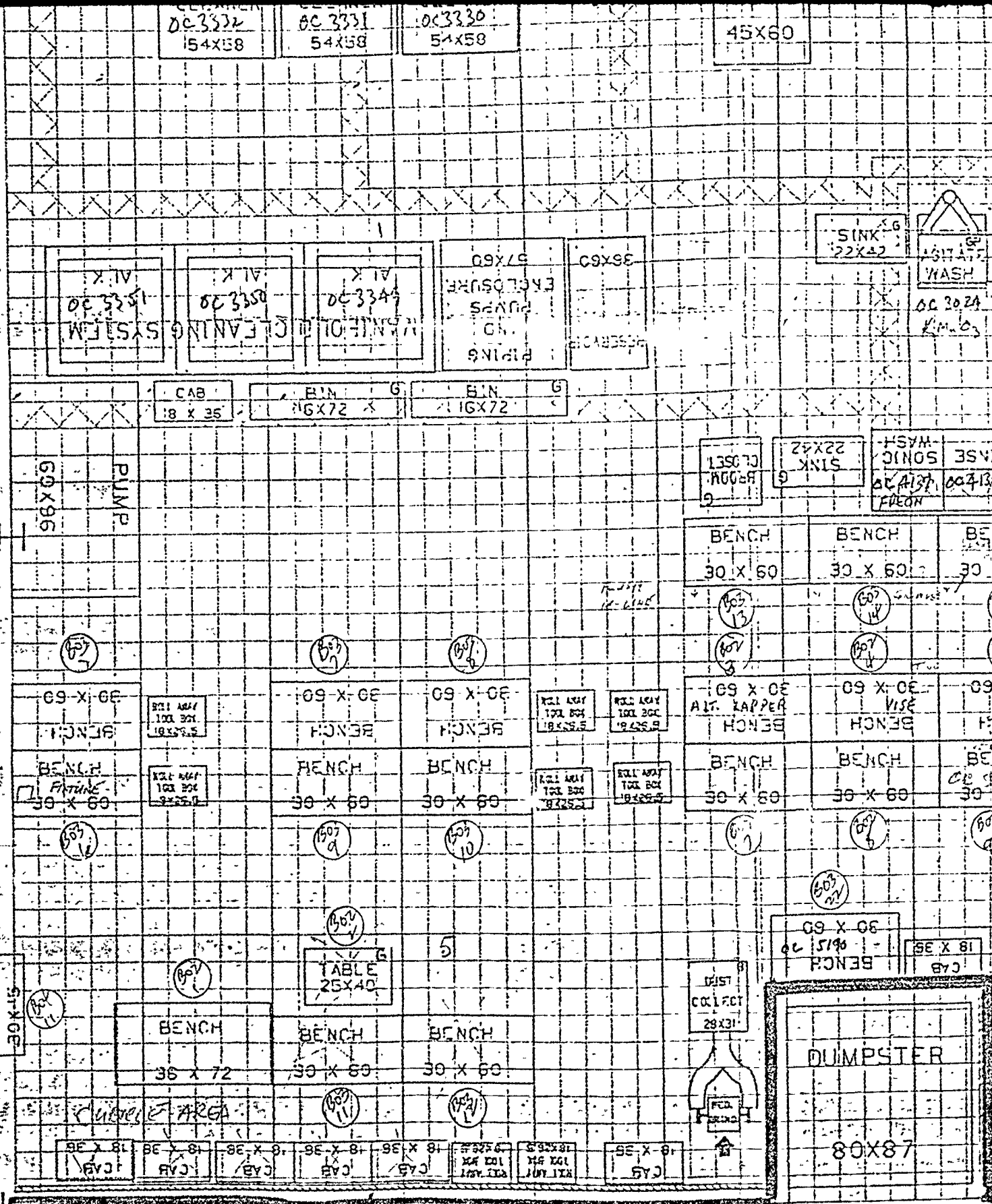


N

16
216
252

202

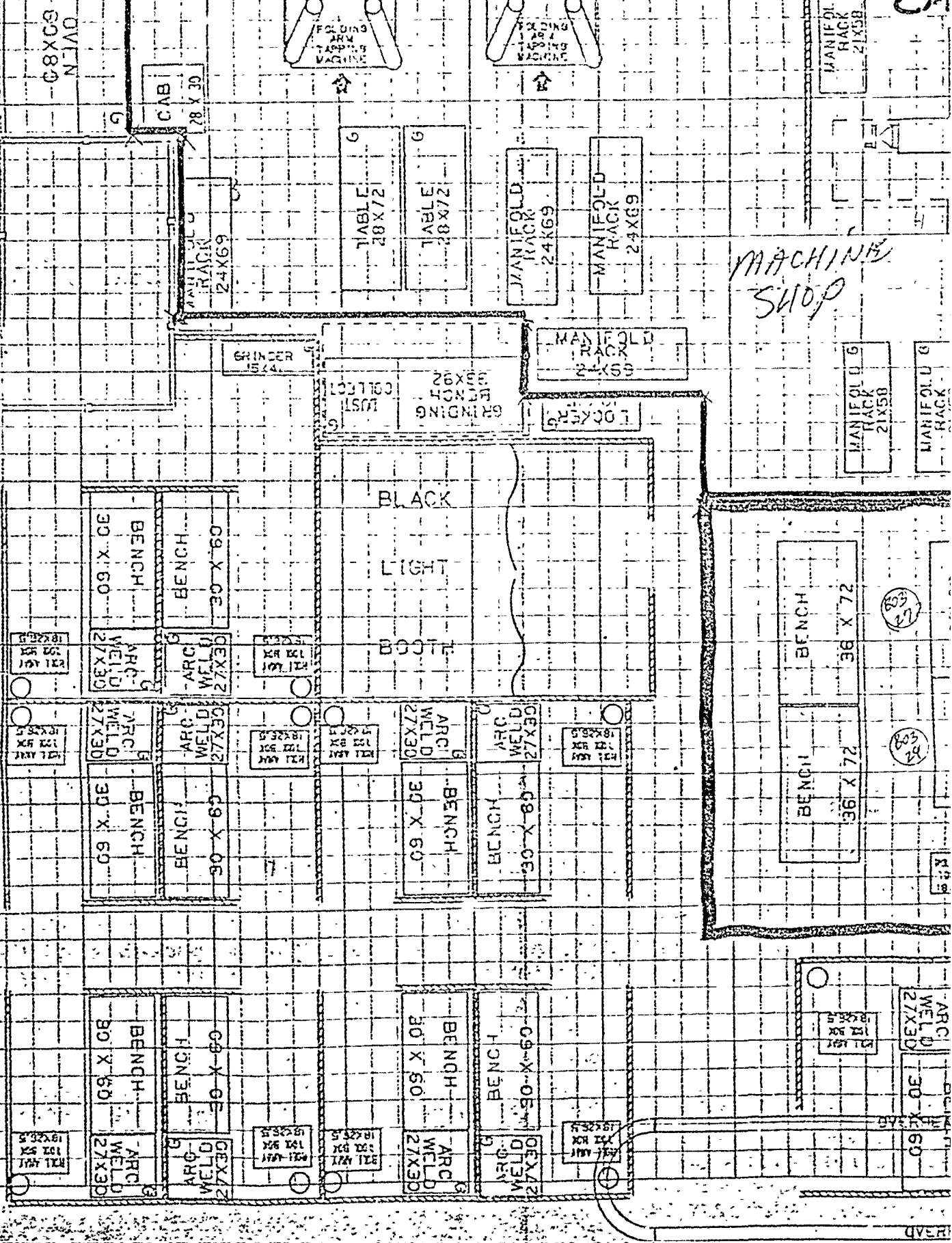
202



296 pws 3446 = 3744 Sq. Ft. PRODUCTION
 330 SQ. FT. SUPPORT
 M. Tompkins. 6-11-87
 9-9-88
 TINKER AFB BLDG 3001

Welding Shop

MACHINE SHOP



OC/MAT PCM

12
132

53
27

53
27

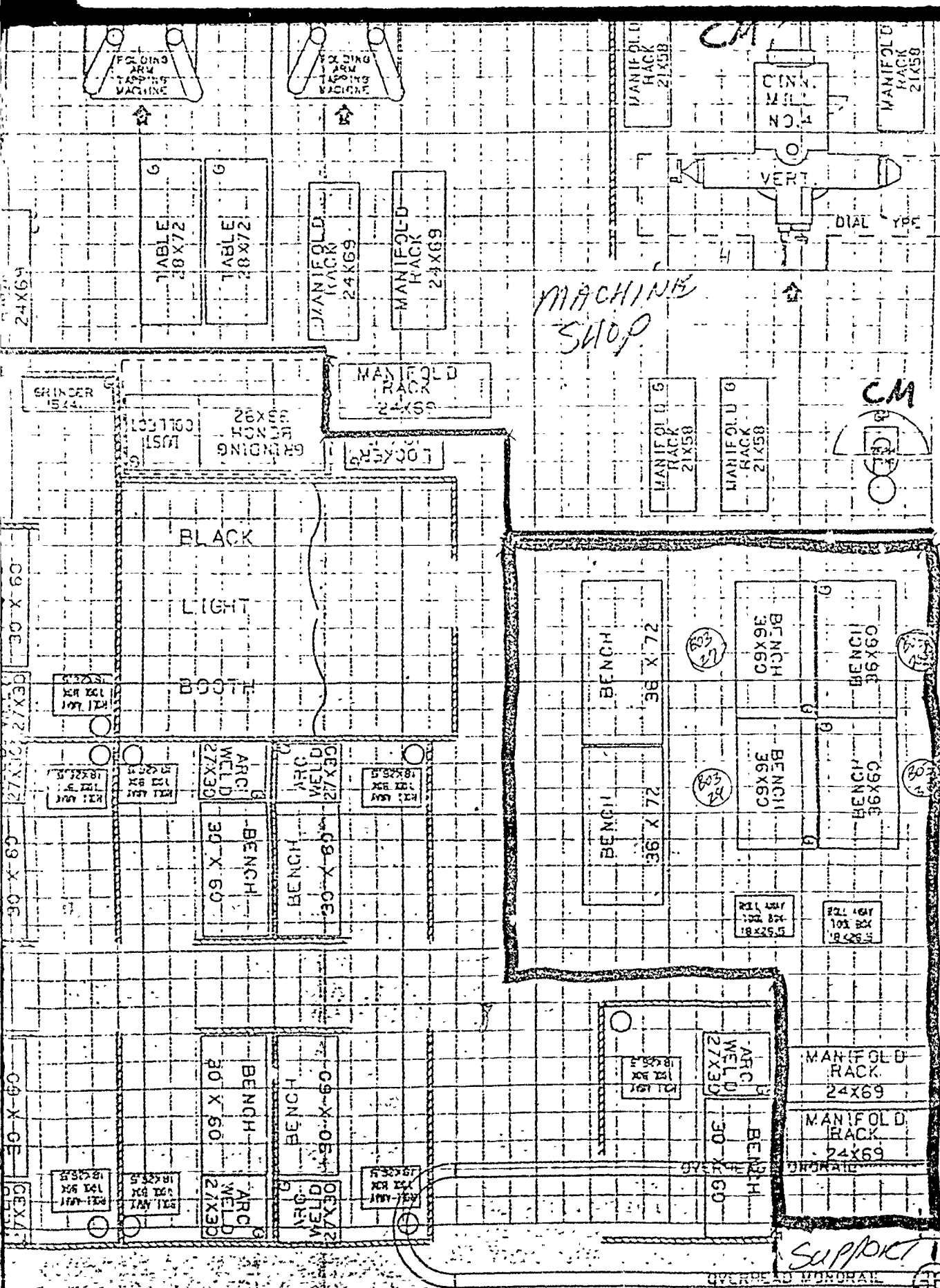
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53
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53
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53
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53
27



MACHINE SHOP

CM

N 16
 $\frac{716}{256}$

6
 $\frac{47}{42}$

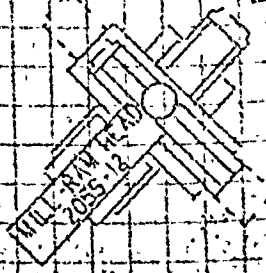
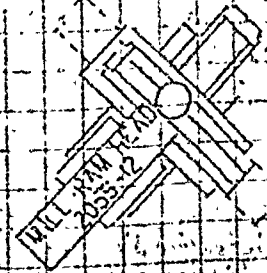
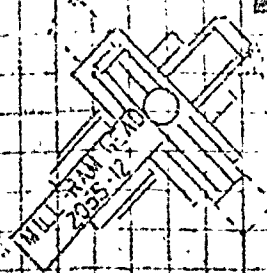
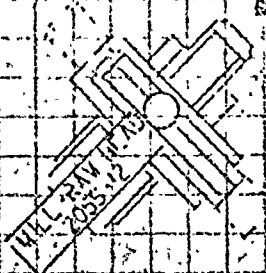
256
 $\frac{472}{298}$ SQ FT

SUPPLIER

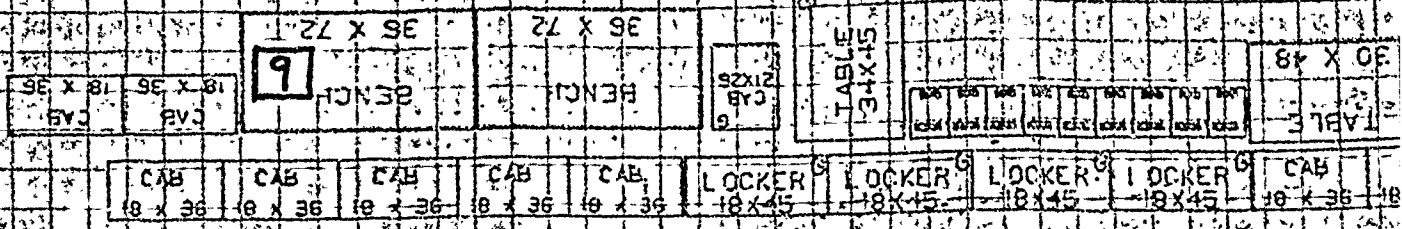
AT PCM

8 TABLE 26 X 90

5' 11" 36 X 96

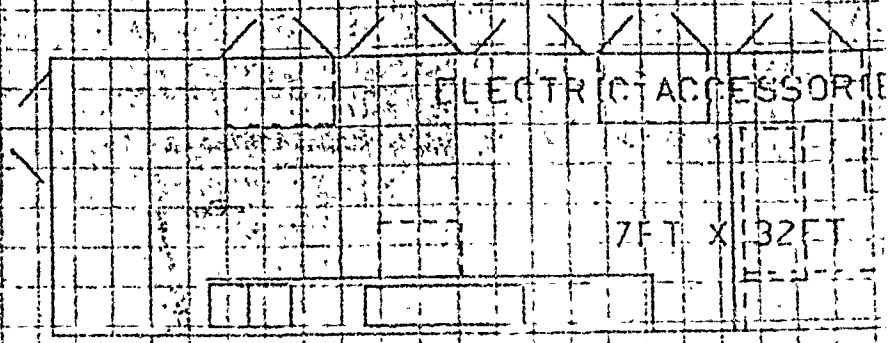
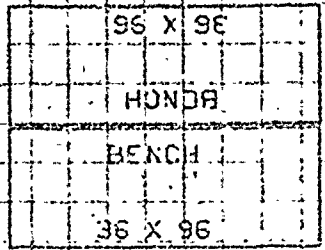


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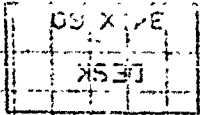
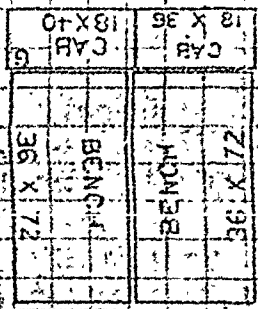


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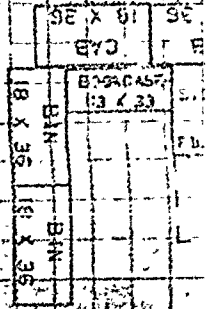
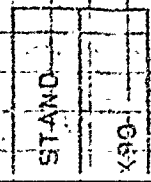
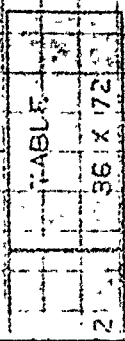
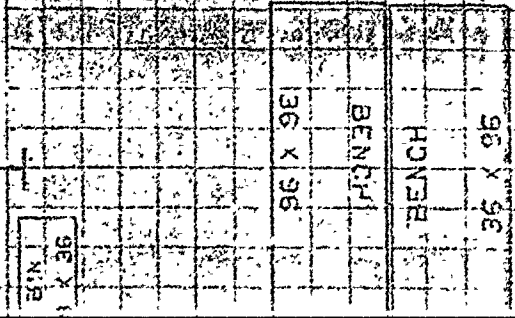
WASHER 22 X 44



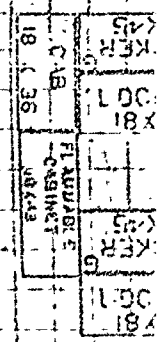
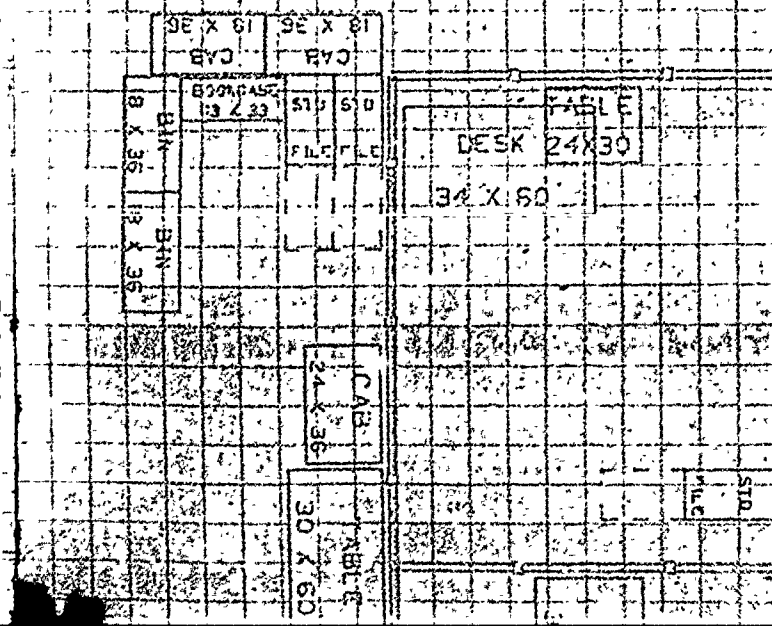
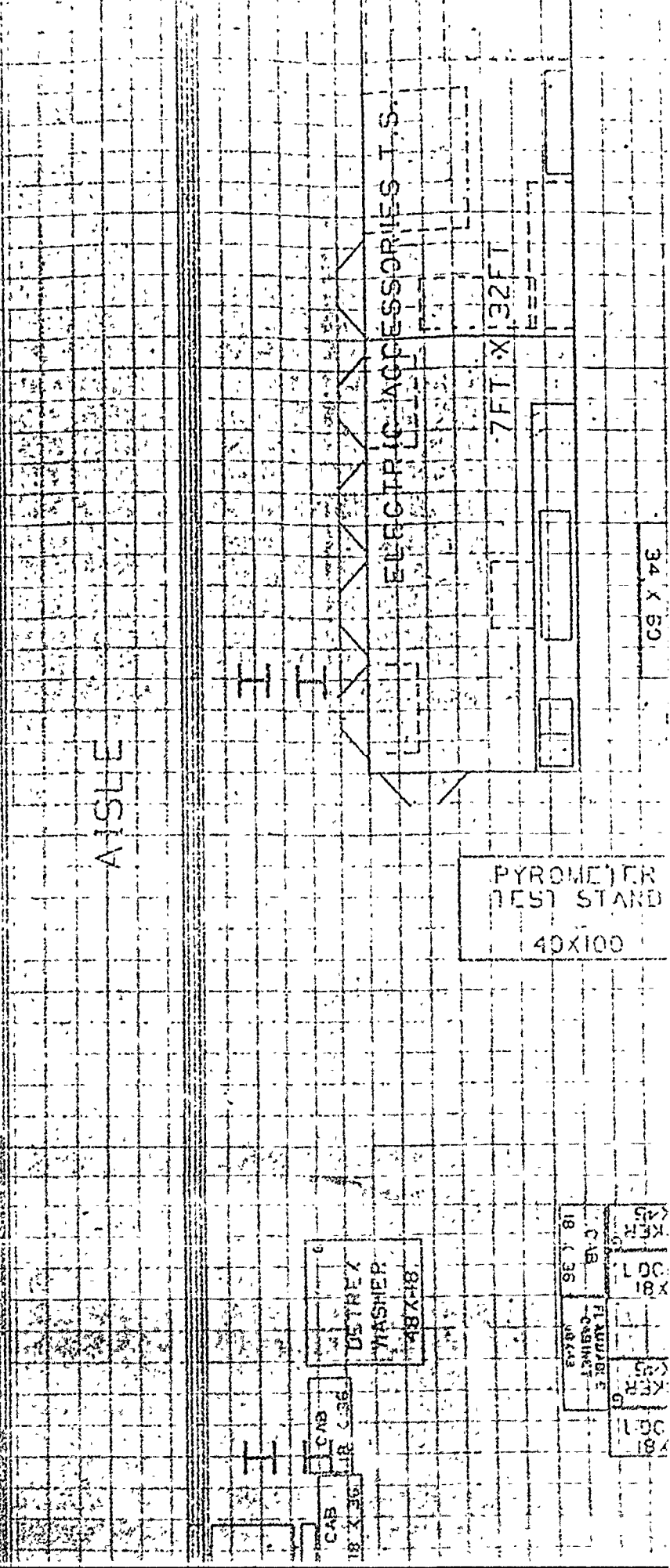
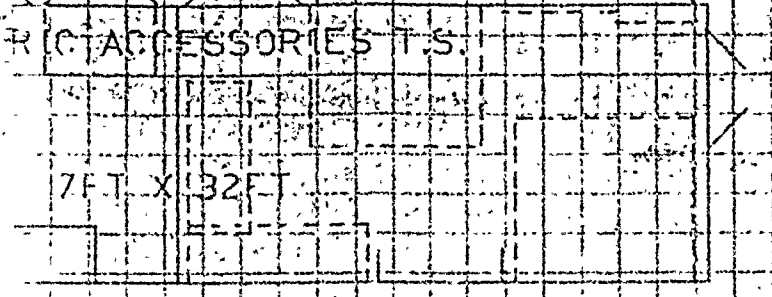
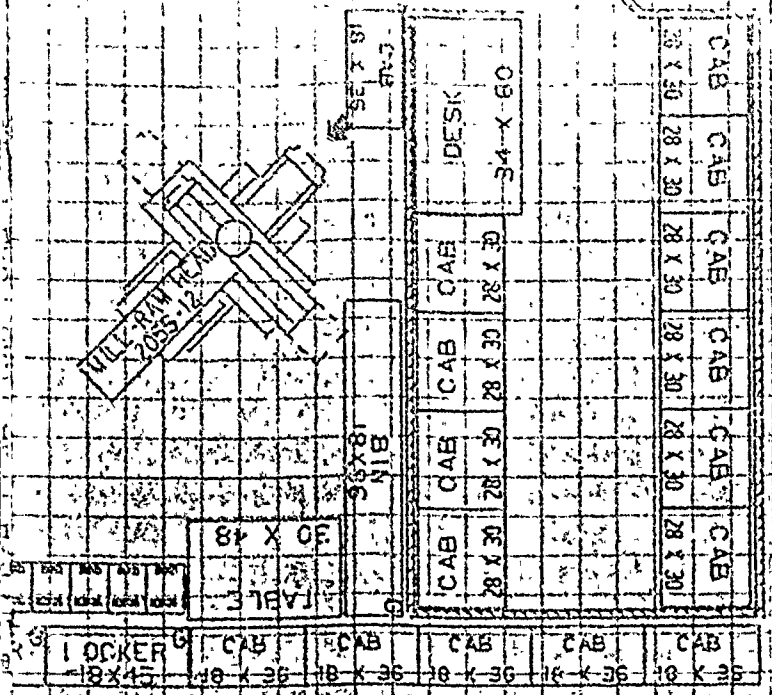
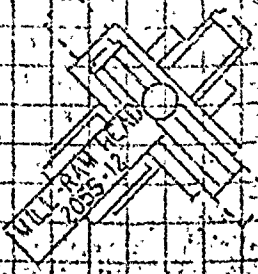
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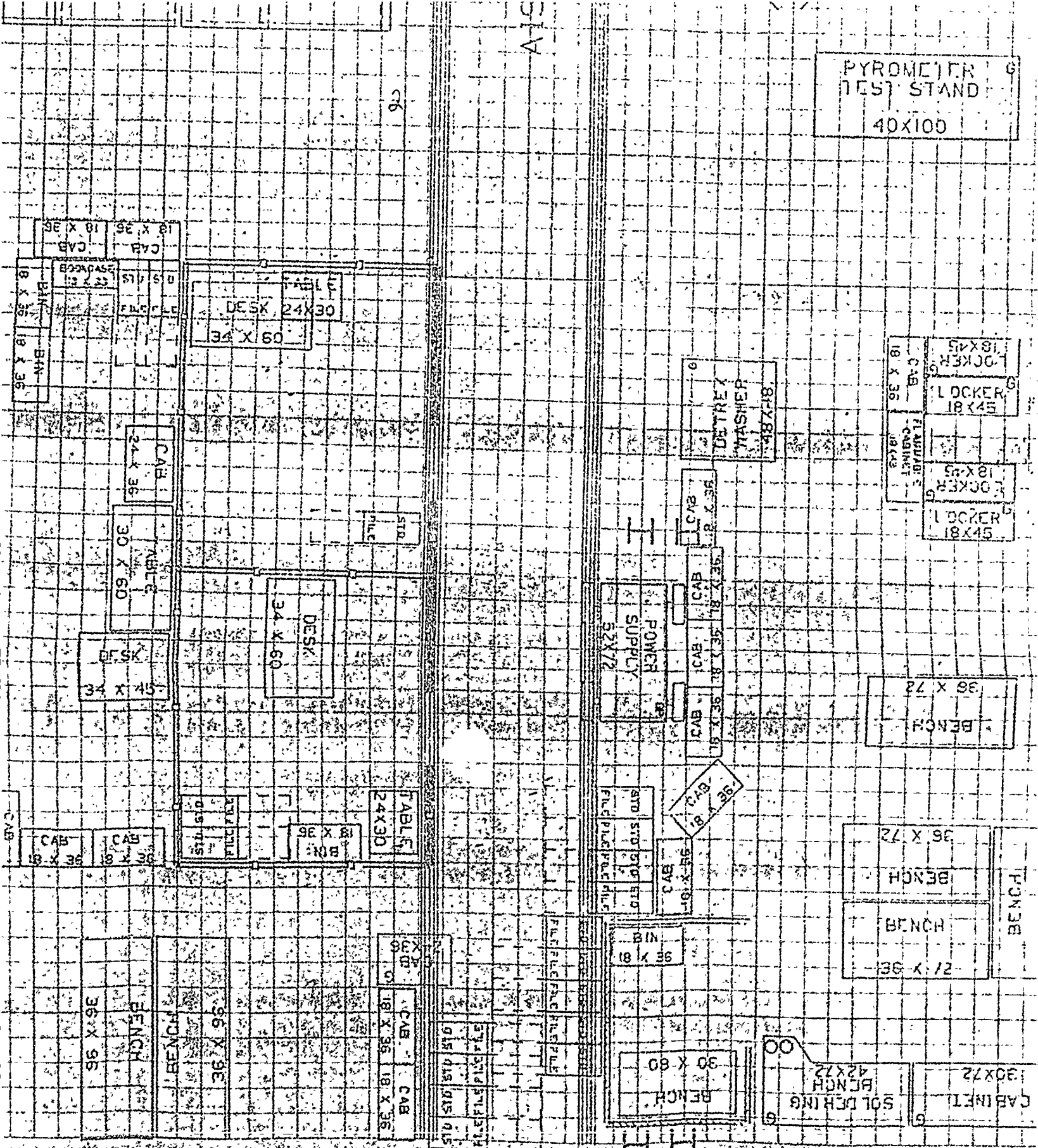


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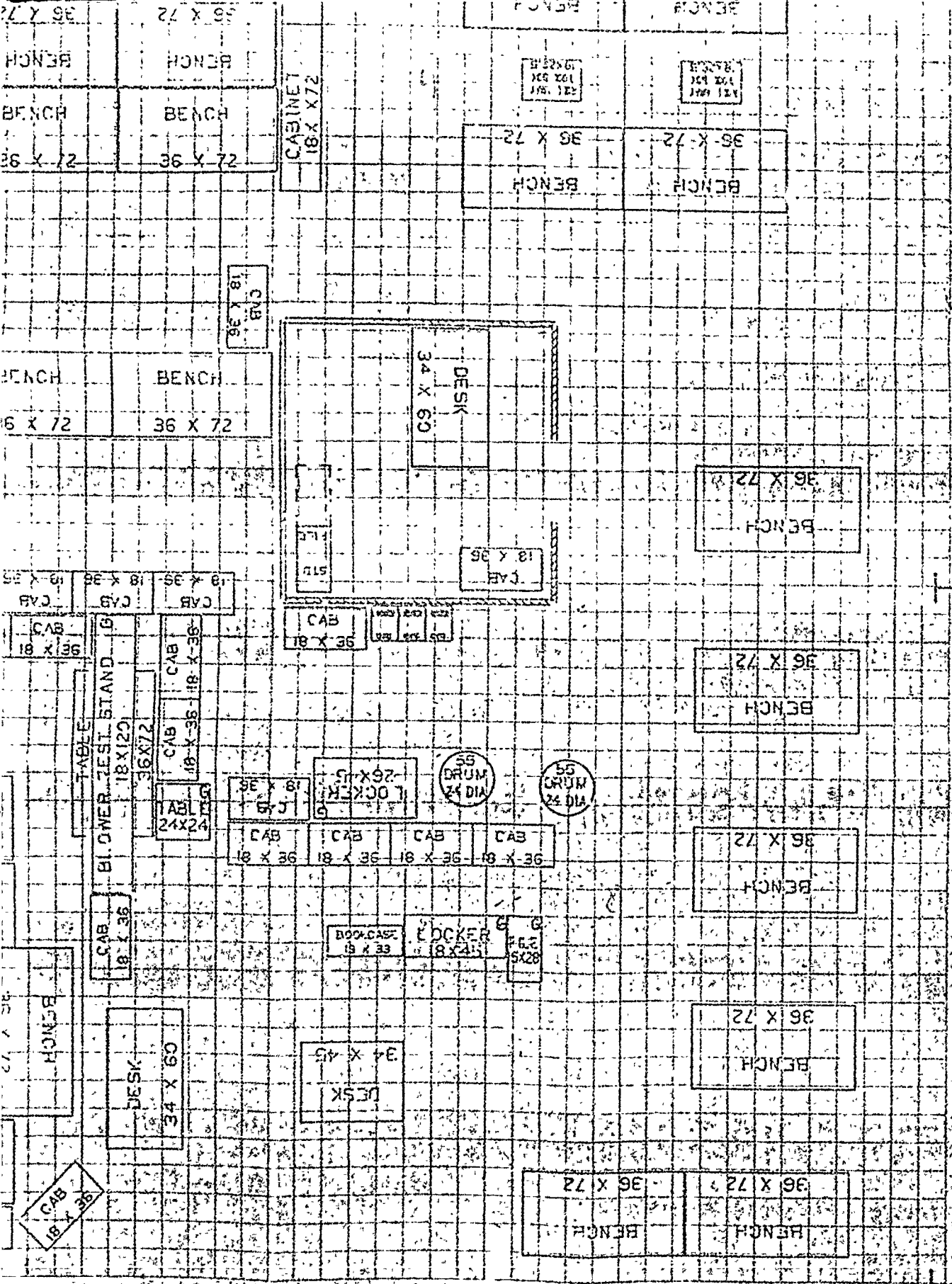
36 X 96





OC/MAT PCM

41



(T)

(43) (U)

OH

aisle

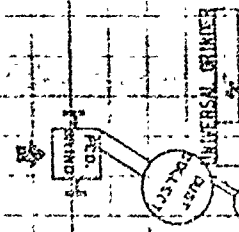
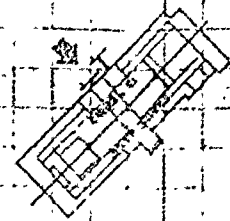
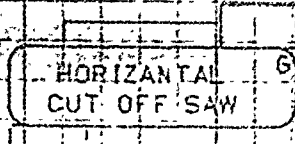
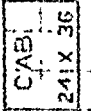
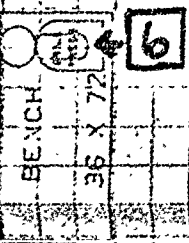
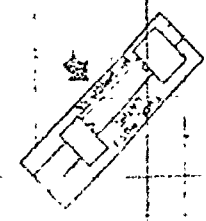
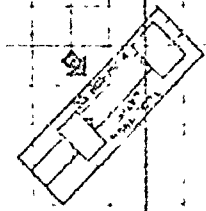
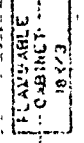
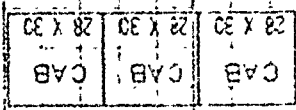
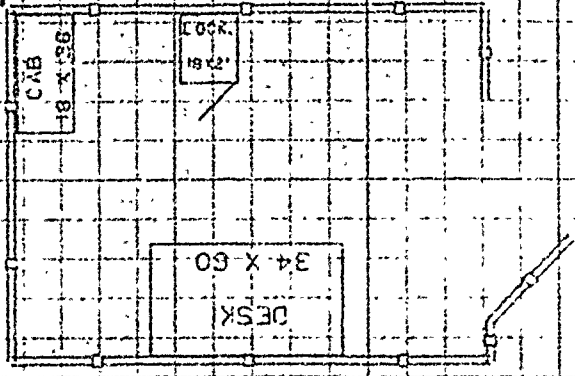
DESK
34 X 60

BENCH
36 X 72

BENCH
36 X 72

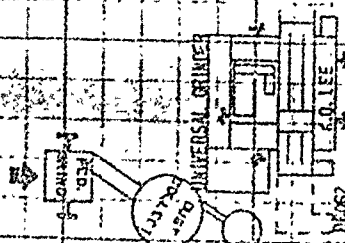
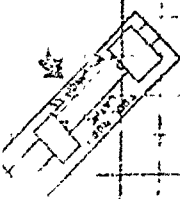
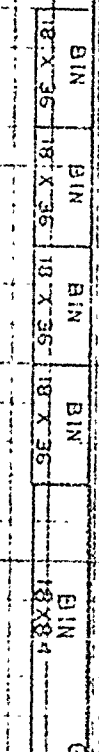
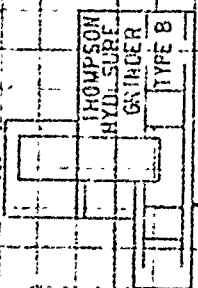
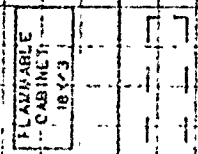
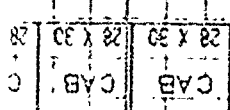
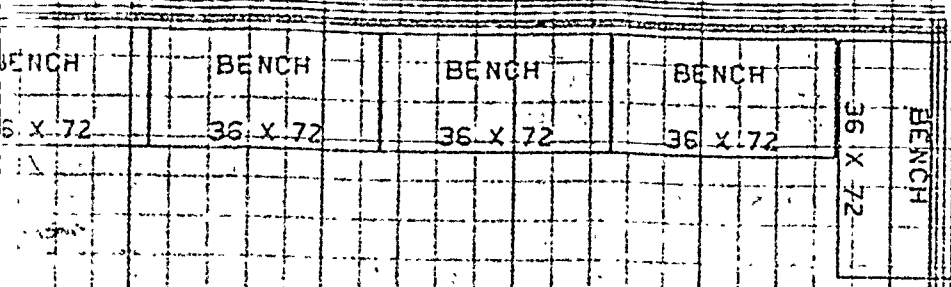
BENCH
36 X 72

P

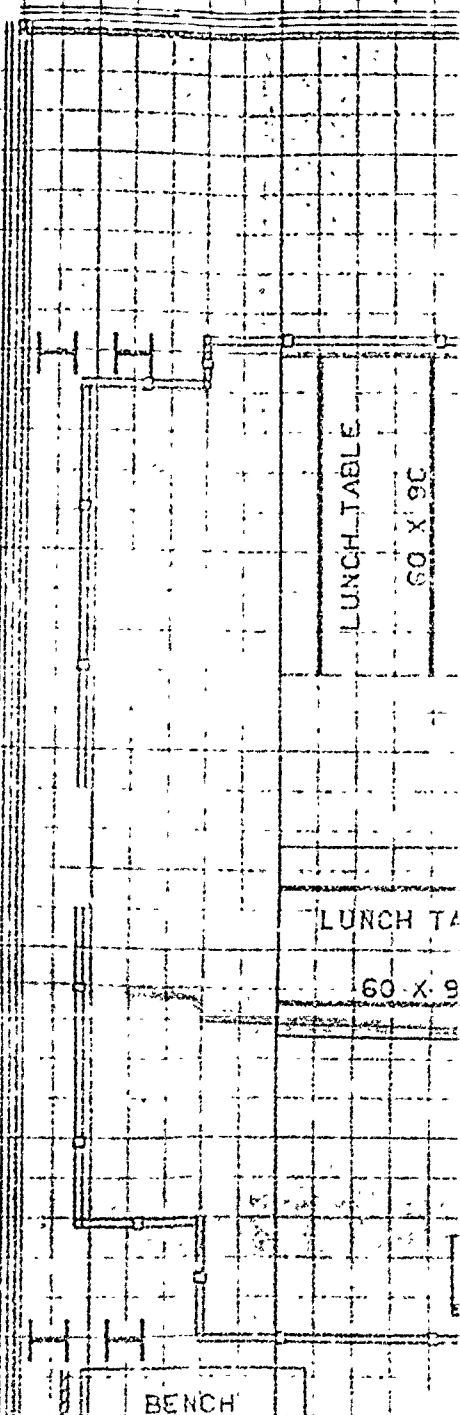


Q

SLE



aisle



aisle

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

BENCH

TABLE

36 X 72

CAB 6
18 X 40

36 X

TAB

AB

S
E

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

LUNCH TABLE

60 X 96

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

VENDING MACHINE
24X36

TABLE

6 X 72

CAB 6
18 X 40

36

36

36

36

LOCKER
18 X 72

LOCKER
18 X 72

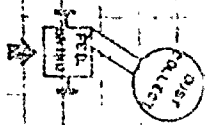
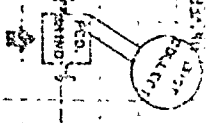
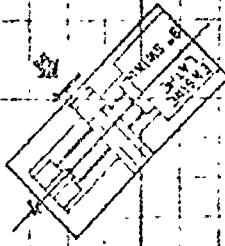
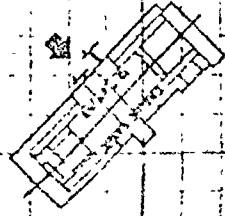
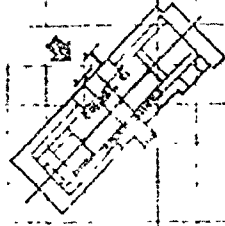
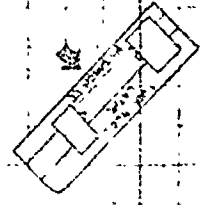
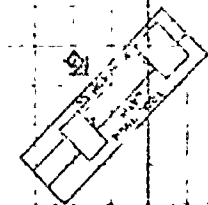
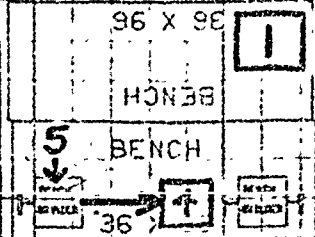
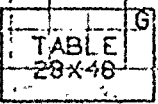
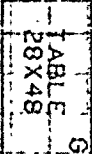
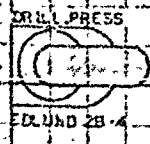
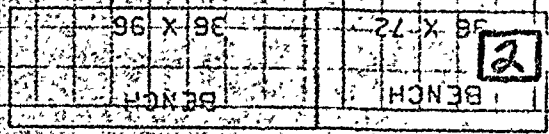
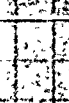
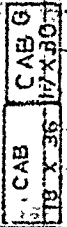
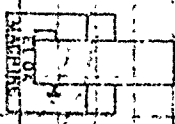
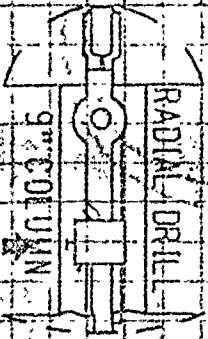
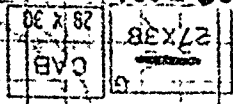
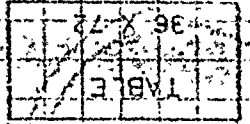
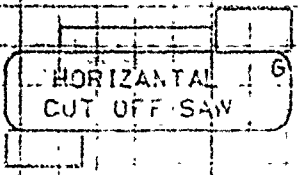
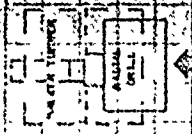
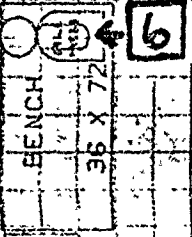
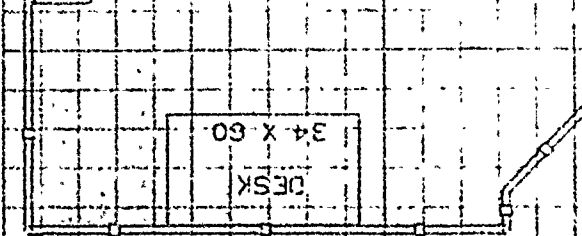
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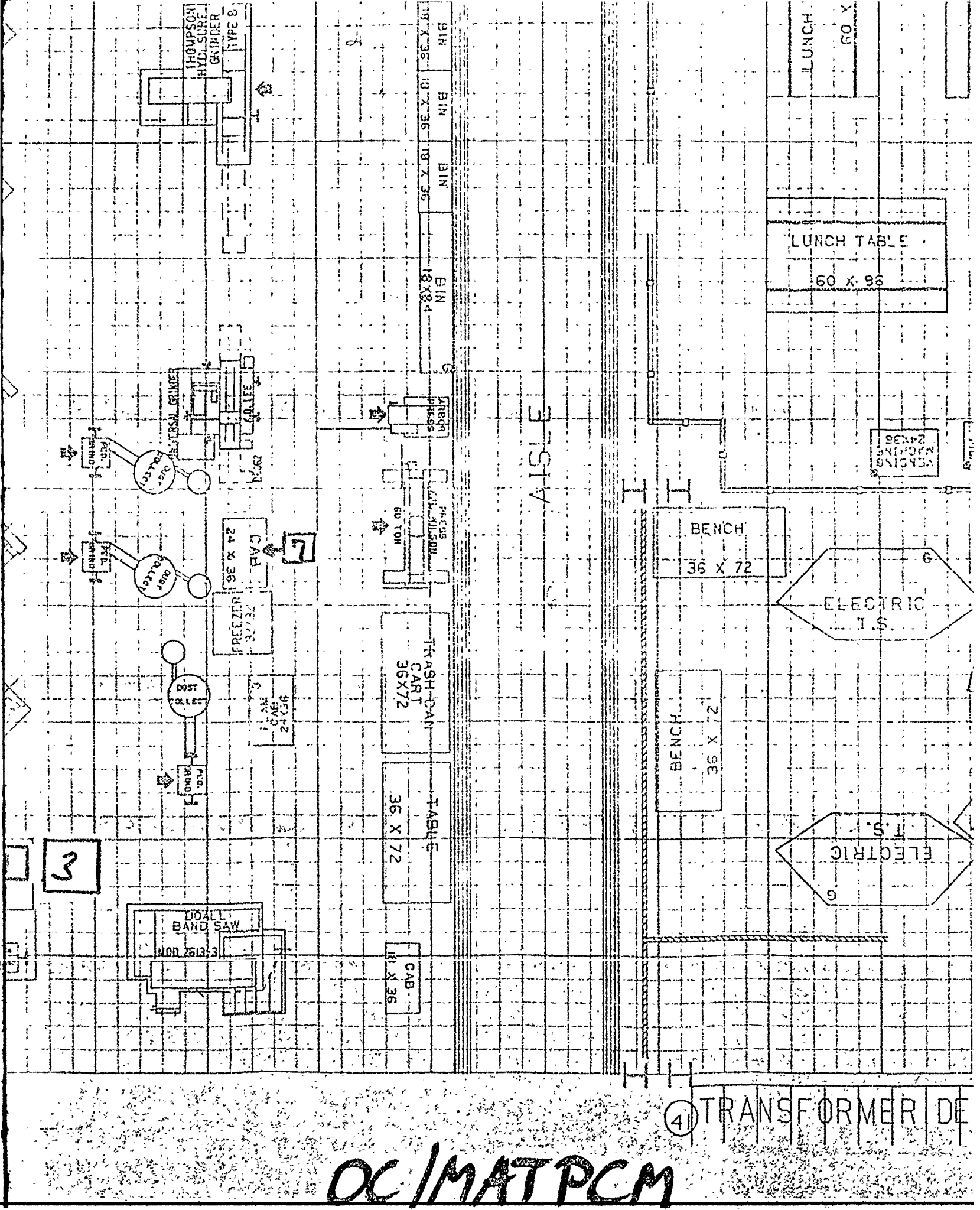
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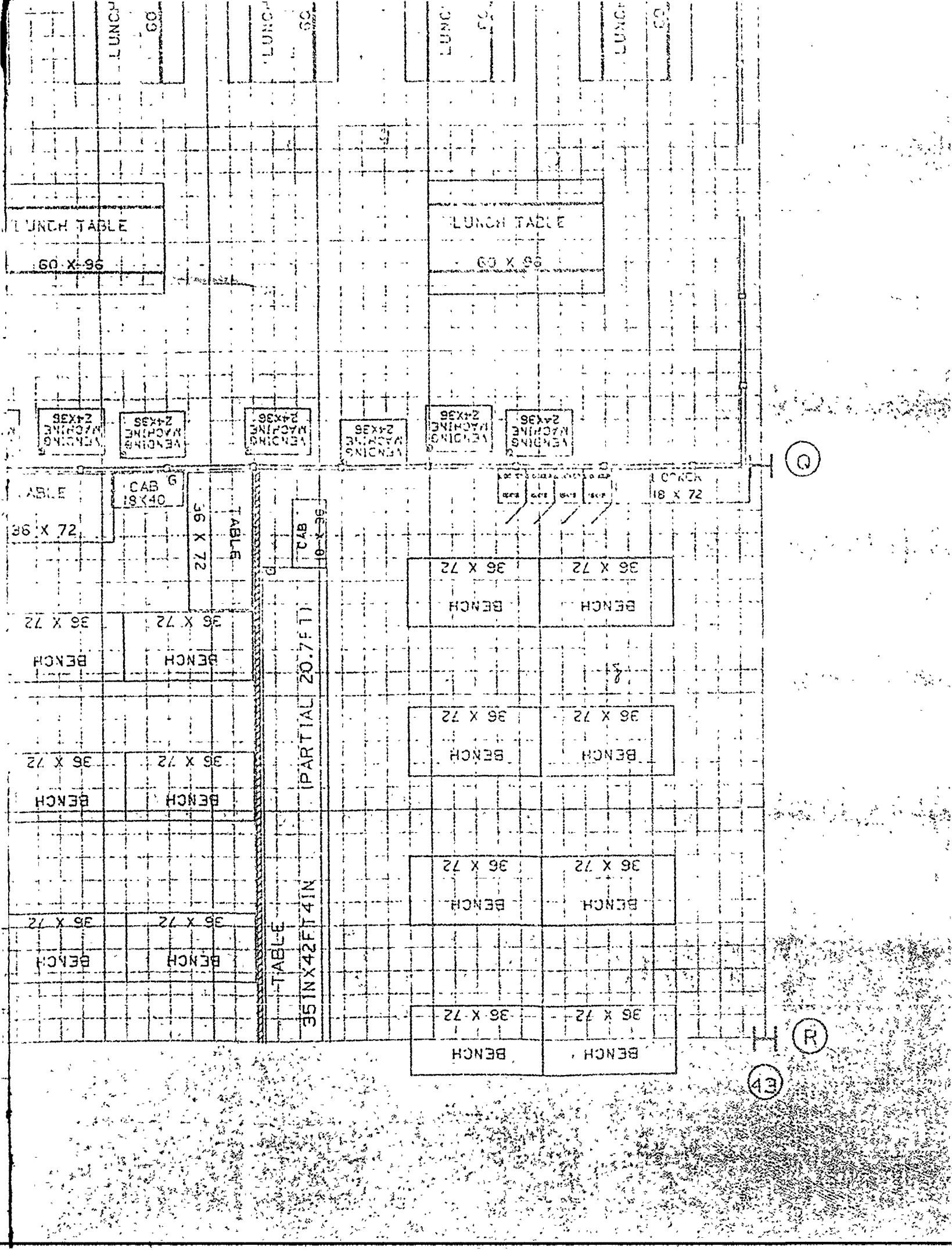


DRY CLEAN PRESS

DRY CLEAN PRESS

DRY CLEAN PRESS





39
M

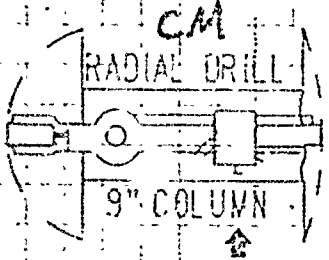


SU

RACK
21X58

CM

CAB
18X30



MANIFOLD
RACK
24X69

MANIFOLD
RACK
24X69

MANIFOLD RACK
24X69



BENCH
W/DRY CRACK
FUTURE
36 X 72

MANIFOLD
RACK
24X69

BENCH
30X120

CM



BENCH
30 X 48

BENCH
29X88

N

CAB
16X12

G

41

Support

MANIFOLD RACK

18 X 36
INDUST.
WASTE
LIFT
STATION

BENCH
36 X 72

BENCH
36 X 72

16
8 X 6

12
50

MANIFOLD
RACK
24 X 69

18 X 72
BIN

MANIFOLD
STAND

Bol 3

Bol 5

BENCH
36 X 72

BENCH
29 X 88

BENCH
36 X 72

BENCH
36 X 72

MANIFOLD
STAND

Bol 4

Bol 6

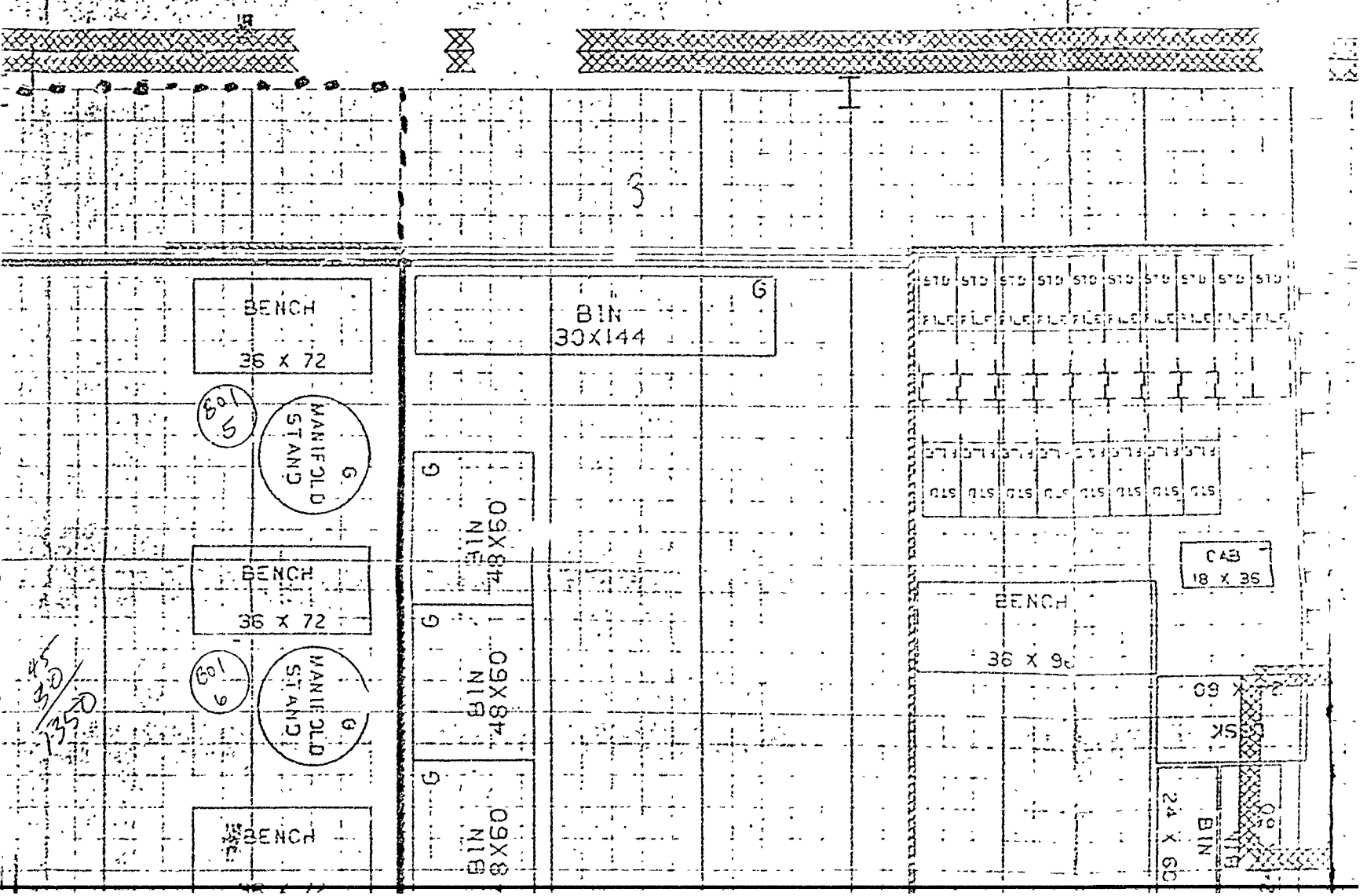
12
30
35

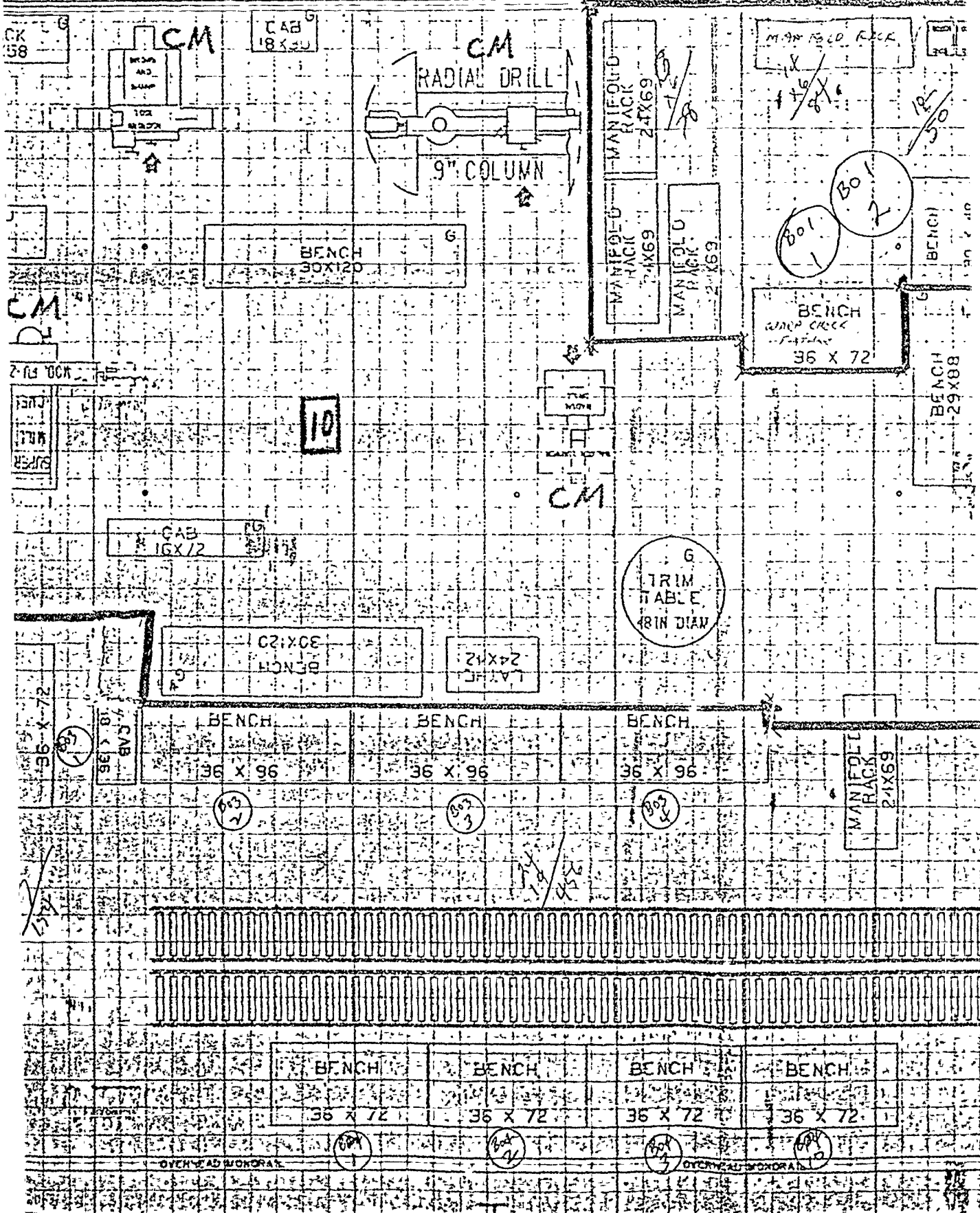
MANIFOLD RACK

BENCH

78
 64
 50
 72
 1350
 252
 456
 154

2496

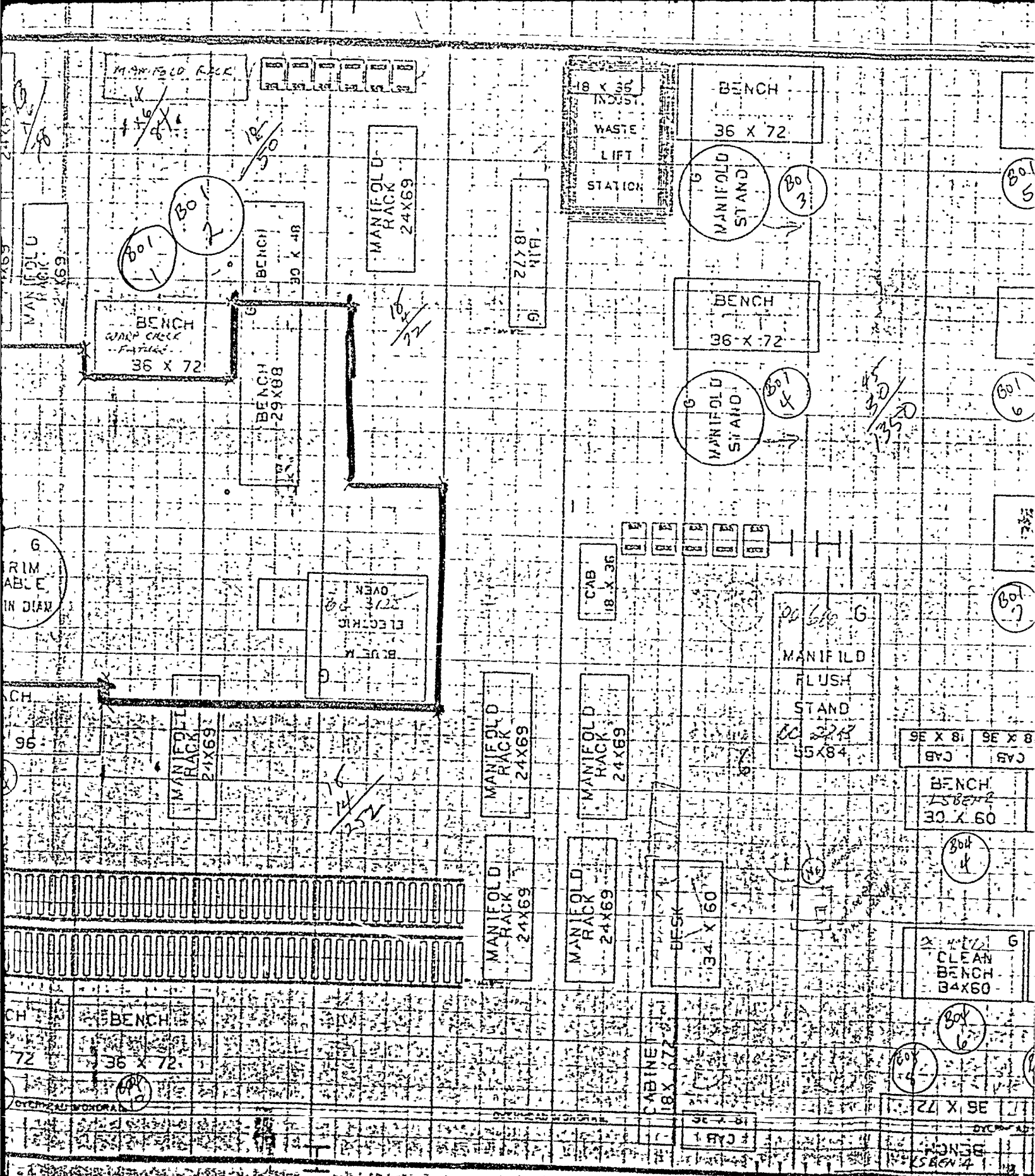




MONORAIL VERTICAL CLEARANCE 5'9"

OVERHEAD MONORAIL

10/21/88
 9/16/88
 S. P. P.



MANIFOLD RACK

18 X 36
WASTE
LIFT
STATION

BENCH
36 X 72

MANIFOLD RACK
24 X 69

Boil 1

Boil 2

BENCH
30 X 48

MANIFOLD RACK
24 X 69

BIN
18 X 22

MANIFOLD STAND

Boil 3

BENCH
WARP CRACK
FUTURE
36 X 72

BENCH
36 X 72

BENCH
29 X 88

MANIFOLD STAND

Boil 4

6
RIM
ABLE
IN DIAM

ELECTRIC
OVEN

CAB
18 X 36

MANIFOLD
FLUSH
STAND
55 X 84

CAB
96 X 81

MANIFOLD RACK
24 X 69

MANIFOLD RACK
24 X 69

MANIFOLD RACK
24 X 69

BENCH
30 X 60

MANIFOLD RACK
24 X 69

MANIFOLD RACK
24 X 69

DESK
34 X 60

CLEAN
BENCH
84 X 60

BENCH
36 X 72

CABINET
18 X 42

BENCH
36 X 72

OVERHEAD MONORAIL

OVERHEAD MONORAIL

OVERHEAD MONORAIL

Handwritten note: 7-21-80

(41)

→ N

OC/MAT/PCM

END

BENCH
36 x 72

Box 5

MANIFOLD
STAND
G

BENCH
36 x 72

Box 6

MANIFOLD
STAND
G

BENCH
36 x 72

Box 5

MANIFOLD
STAND
G

CAB
18 x 36

CAB
18 x 36

BENCH
30 x 60

BENCH
30 x 60

Box 4

Box 5

CLEAN
BENCH
34 x 60

CLEAN
BENCH
34 x 60

Box 6

Box 7

BENCH
36 x 72

BENCH
36 x 72

BIN
30 x 144
G

BIN
48 x 60
G

BIN
48 x 60
G

BIN
48 x 60
G

BIN
24 x 60

BENCH
34 x 60

36 x 60

STD STD STD STD STD STD STD STD STD STD
FILE FILE FILE FILE FILE FILE FILE FILE FILE FILE

CAB
18 x 36

BENCH
36 x 96

96 x 60
SY
BIN
24 x 60
09
110
2

BENCH
36 x 96

TABLE
30 x 86
BIN
24 x 60

CAB
36 x 36

DESK
34 x 60

DESK
34 x 60

OVERHEAD MONORAIL

OVERHEAD MONORAIL

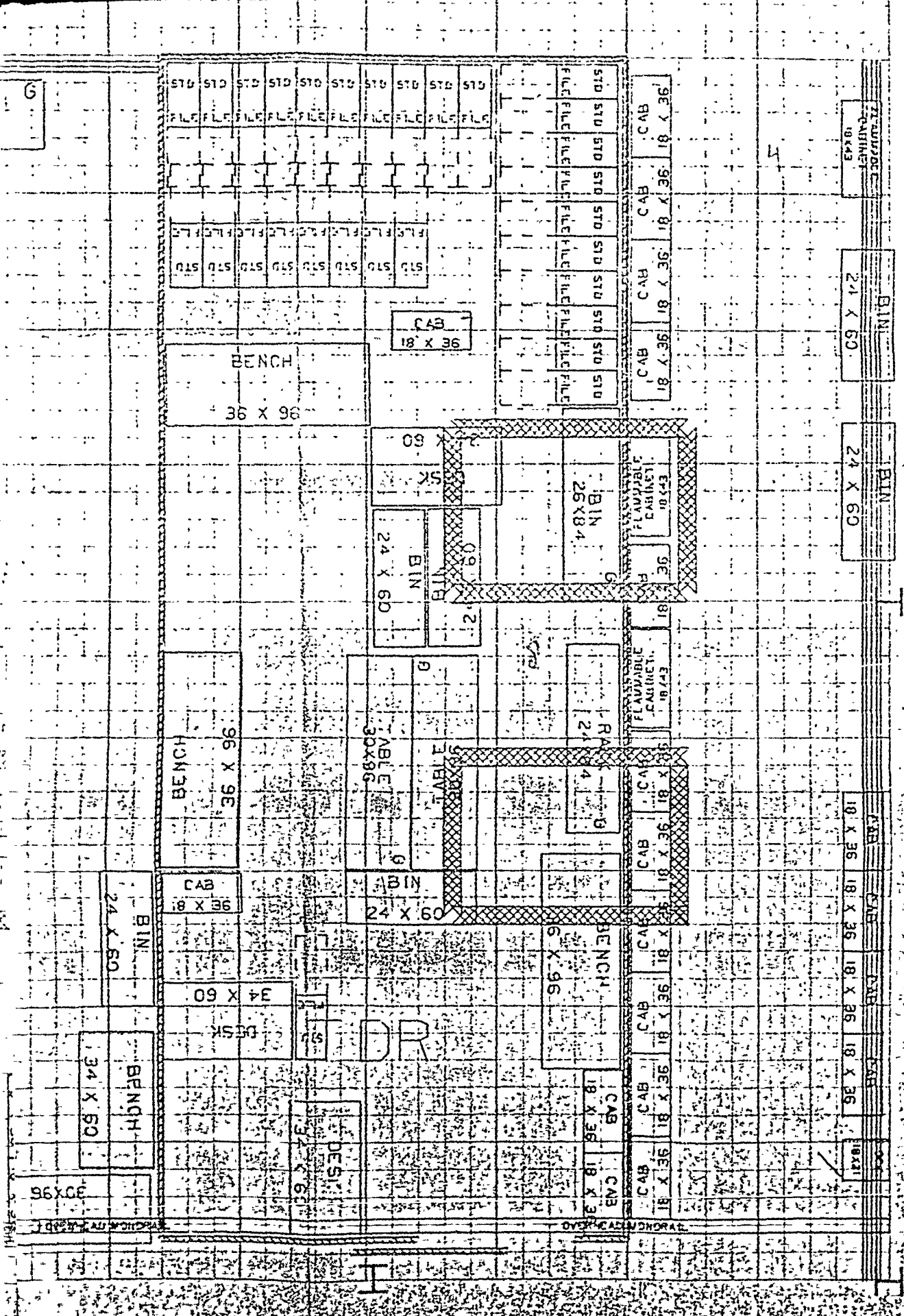
75
375

50
250

250
375
625

35
30
1350

1710



(N)

(C)

(43)

MANIPULATOR SHOP

250
375
625

OVERHEAD MONORAIL