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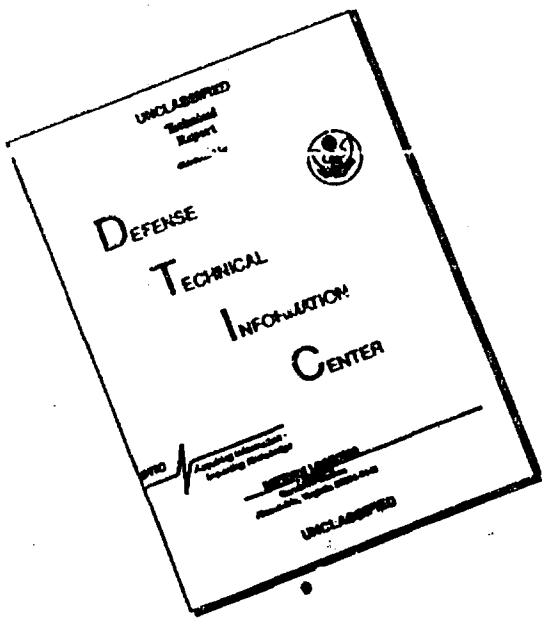
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# TECHNOLOGY INSERTION-ENGINEERING SERVICES
# PROCESS CHARACTERIZATION
# TASK ORDER NO. 1
# (BLOCK II)

## DATABASE DOCUMENTATION BOOK

**OC-ALC**

**MATPCA**

**CONTRACT SUMMARY REPORT**
**11 SEPTEMBER 1989**

A-1 23

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

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*McDonnell Douglas Missile Systems Company*
*St. Louis, Missouri 63166-0516 (314) 232-0232*

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## 1.0 IDENTIFICATION OF RCC

MATPCA is separated into two sections, each having its own workload and personnel. The two sections are physically separated by an eight foot isle which runs between them. The two sections share storage cabinets and some test equipment, but otherwise exist as separate entities, each having its own supervisor. Workloads appear to be divided equitably based on existing staffing.

The first section's workload consists mostly of ignition exciters, temp. probes, electrically actuated valves, and associated electrical accessories. The work area is somewhat crowded with test equipment and work benches, much of which is not being utilized due to the present workload levels. The existing facilities would be capable of processing a much greater workload given the needed staffing. This section contains 6,250 square feet of floor space.

The second section's workload is mostly made up of temperature amplifiers, servo-motors, and power supllies. Again, the area contains several benches and and testing equipment which is not being utilized at their full potential given the present workload. The section contains 2,875 square feet of floor space.

Note that MISTR items are normally delivered to an outside storage area in building 3123. Technicians normally are sent to this area once a week to uncrate accessories and load them onto a transport trailer.

## 2.0 GENERAL INFORMATION

MATPCA is an electrical accessories repair unit within the Accessories Division Production Branch at OC-ALC. This RCC is located in building 3001.

The primary responsibility of MATPCA is to overhaul, repair, and bench test motors, exciters, power supplies, servo-motors, and a variety of aircraft and engine electrical accessories. The primary workload in this RCC consists of MISTR and PDM items, with the PDM accessories being worked mainly as support for the engine overhaul unit at OC-ALC.

The workload of MATPCA has been relatively stable for the last several years, but it should be mentioned that production levels for recent months has been lower due to decreasing demand for certain aircraft parts. MATPCA has historically worked electrical accessory parts for the A-7, F-4, and B-52 aircraft. As these aircraft are phased out of the active Air Force inventory, demand for overhaul and repair work has decreased. We may expect to see production levels increase as new electrical accessories from aircraft such as the F-16 and B-1 enter the depot system. It must be emphasized that MATPCA is in a transition period between the old and new aircraft technologies, and that a definitive workload analysis would need to account for the changing patterns of processed parts.

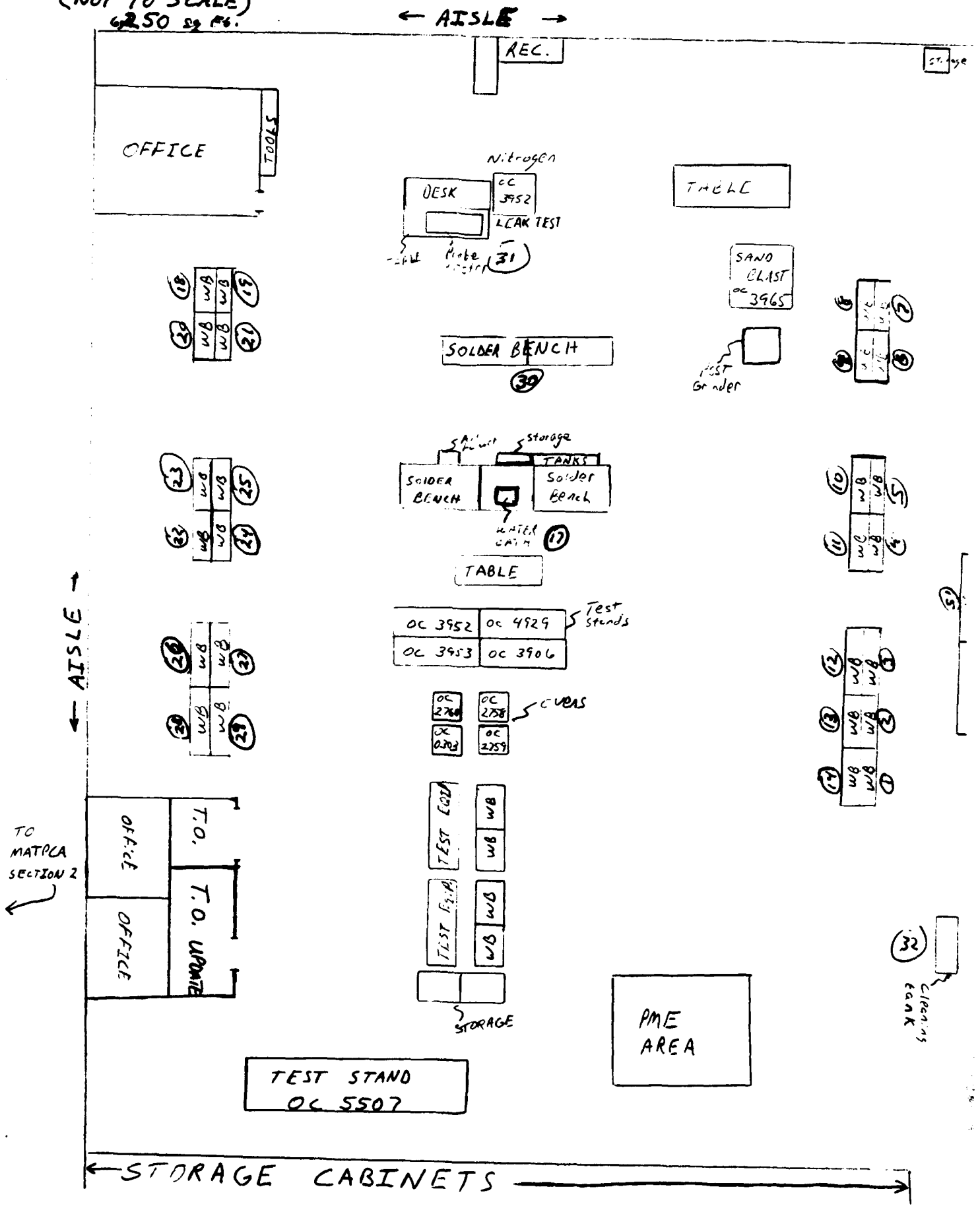
## 2.1 FACILITY LAYOUT DRAWING

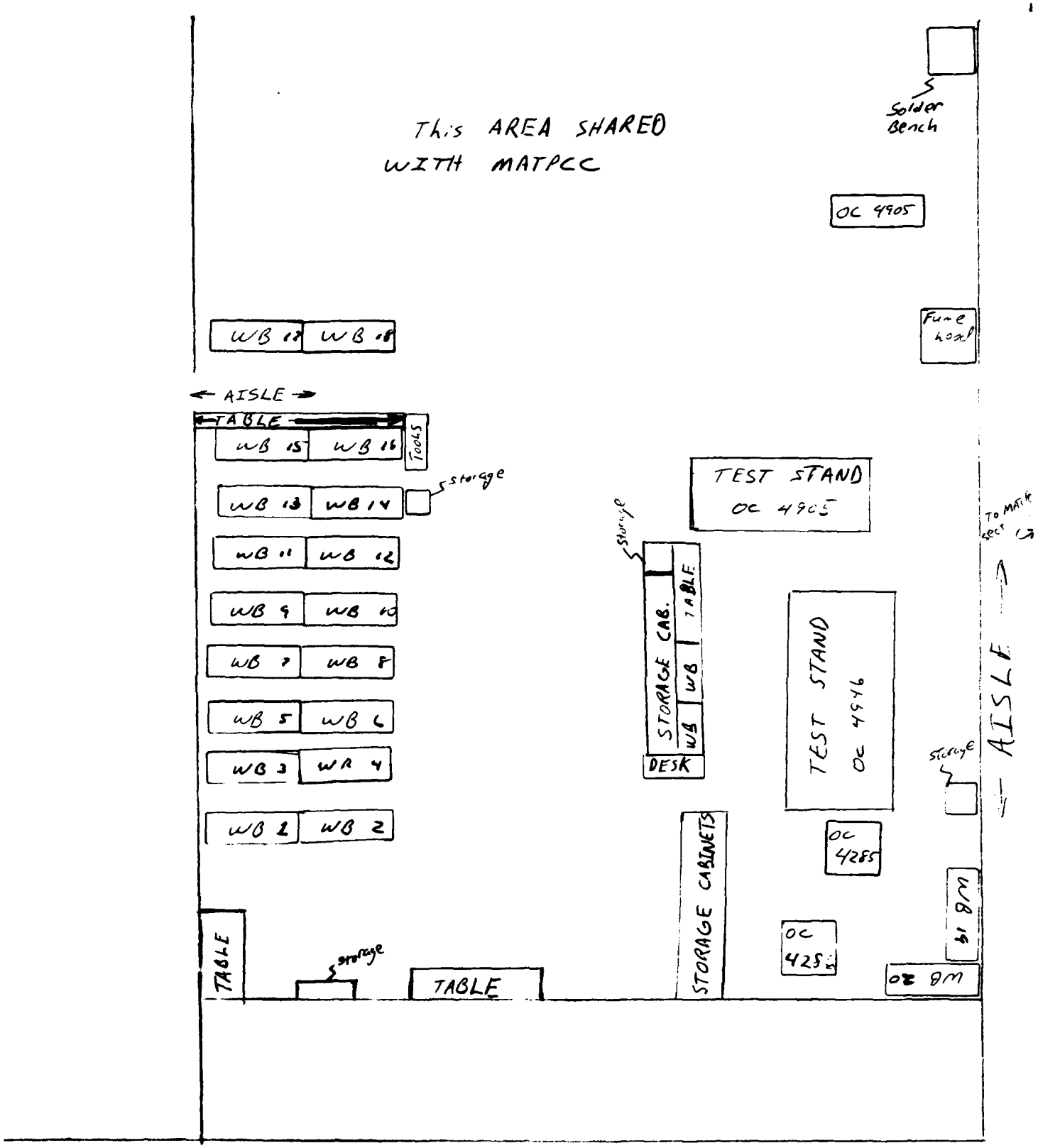
The existing facility layout drawings are not representative of the present conditions. There have been changes to the shop floor as well as a restructuring of the MATPCA RCC. The attached layouts are representative of the present conditions.

2.7 A MATPCA SECTION 1

(NOT TO SCALE)

6250 Sq Ft.






← AISLE →

2,875 Sq Ft.

2.7B MATPCA SECTION 2 (NOT TO SCALE)

## 2.2 EQUIPMENT

Equipment presently used in the MATPCA RCC consists of a variety of electrical test stands, common electrical testing equipment such as oscilloscope, ohmmeters, meggers, etc., and both common and specialized hand tools.

The test stands used in this RCC range from four to thirty years old, with much of the equipment being at least twenty years old. It is somewhat surprising that newer equipment purchased in the last five years to support repair and testing of B-1 and F-16 electrical accessories shows a much higher rate of downtime and repair requests than does the older equipment.

A detailed listing of the equipment used in MATPCA is included in the equipment profile, which is enclosed in this report.

## 2.3 WORKFORCE

MATPCA has a relatively stable workforce with little variance. Workloads are well defined and personnel appear knowledgeable about their tasks. The workforce is comprised of two supervisors, 32 journeyman technicians, a sandblast technician, and a painter. The following is a breakdown of the manpower in the MATPCA RCC.

| SKILL CODE | SKILL LEVEL | QUANTITY | EXPERIENCE |
|---|---|---|---|
| AY | WG-10 | 5 | 12 |
| | WG-9 | 6 | 8 |
| BY | WG-10 | 10 | 7 |
| | WG-9 | 10 | 4 |
| | WG-7 | 2 | 6 |
| B3 | WG-7 | 1 | 2 |

Experience is given as average years at that grade. Note that MATPCA is supported by two backshops, MATPCM machine shop and MATPIW welding shop.

## 2.4 REPAIR PROCESS TECHNOLOGIES

The repair process technology in MATPCA consists of testing and repair of aircraft and aircraft engine electrical accessories.

Accessories are tested for function and specification requirements, and overhaul is performed as required. Modifications are made to existing items as required be tech order changes and to meet the present configuration required for targeted aircraft.

When applicable, repairs are made to internal components of the worked accessories, as well testing,

replacement of defective parts, and inspection of problems requiring backshop support.

## 2.5 WORKLOAD VOLUME AND MIX

The workload within MATPCA consists of both MISTR and PDM. Electrical accessories sent to the engine overhaul facility at OC-ALC is a PDM workload. All other items tested and/or overhauled are MISTR designated.

Workloads are variable and depend on Air Force inventory needs. For more information see the enclosed workload profile.

## 2.6 MATERIAL HANDLING

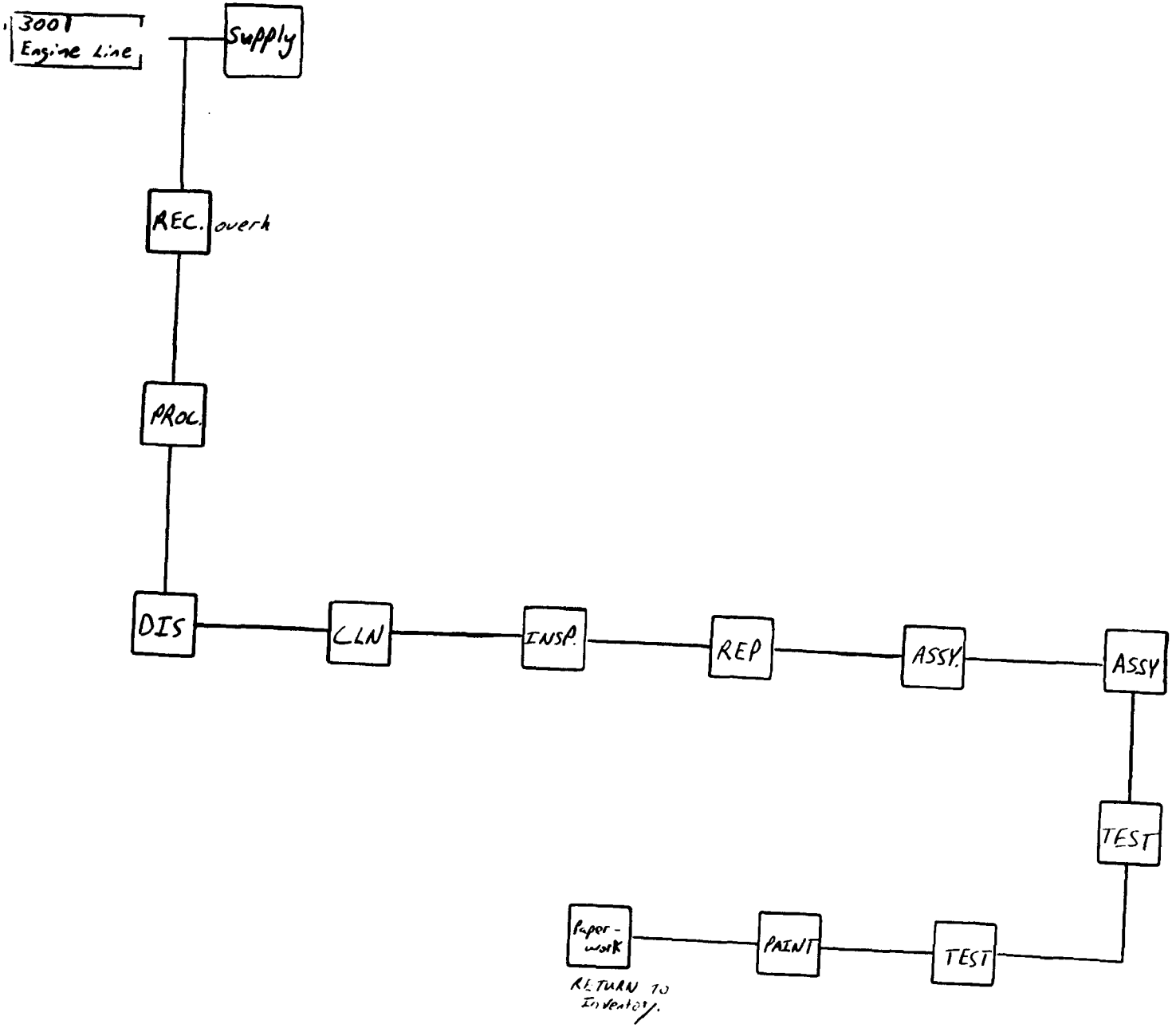
Material handling in MATPCA is mostly by hand. Material is initially received in building 3123. Technicians are sent to this area to uncrate received items and place them on a specially suspended trailer. A tug driver is then called to move the items to Bld. 3001 where they are placed in storage cabinets. This procedure is normally performed once a week and requires approximately four hours of the skilled technician's time.

## 2.7 STORAGE

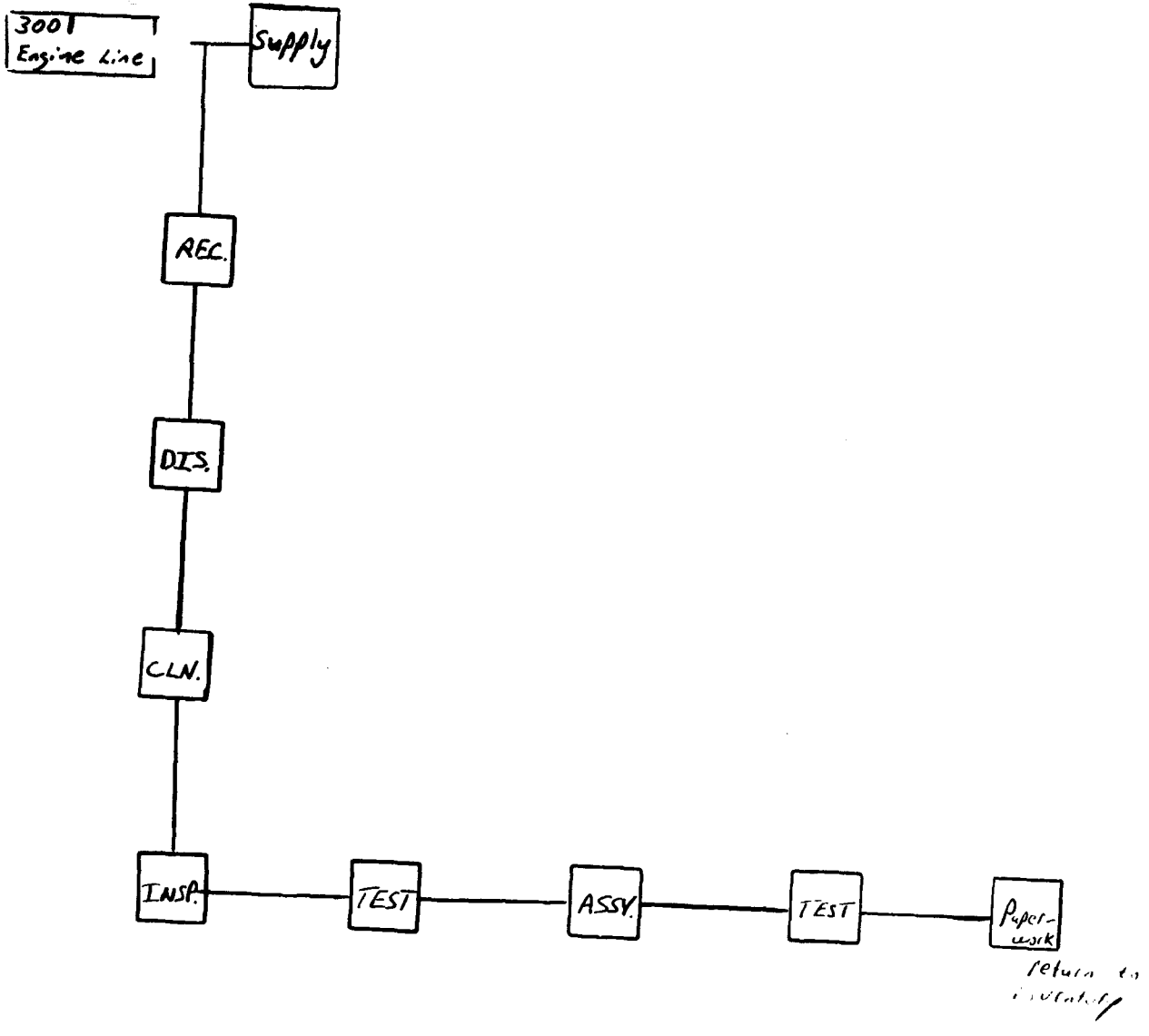
Storage in the MATPCA area consists of 76 cabinets that are 6x3x2 feet in size. These cabinets are located throughout the MATPCA shop area as shown on the facility layout drawing enclosed.

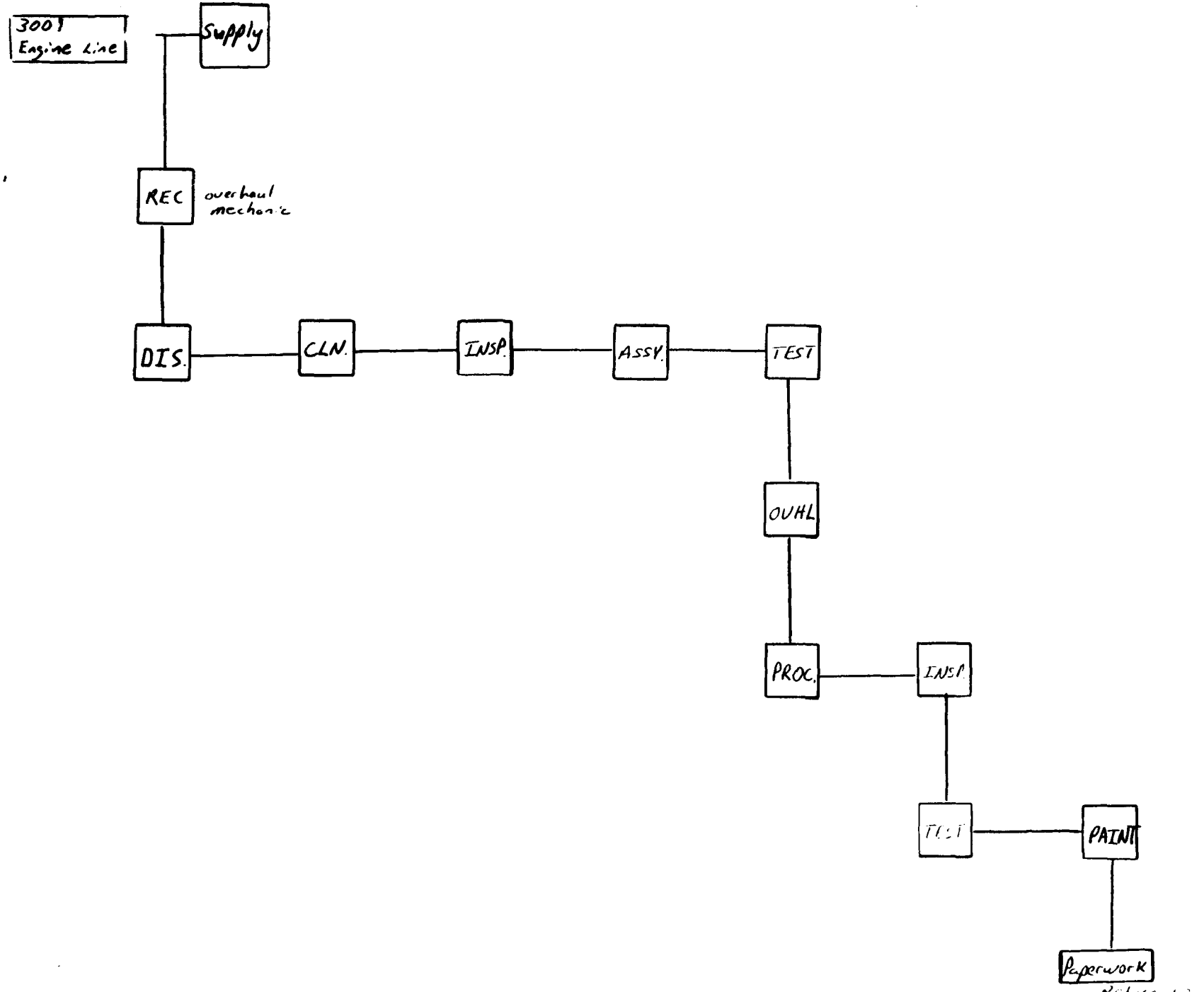
## 2.8 PROCESS FLOW DIAGRAMS

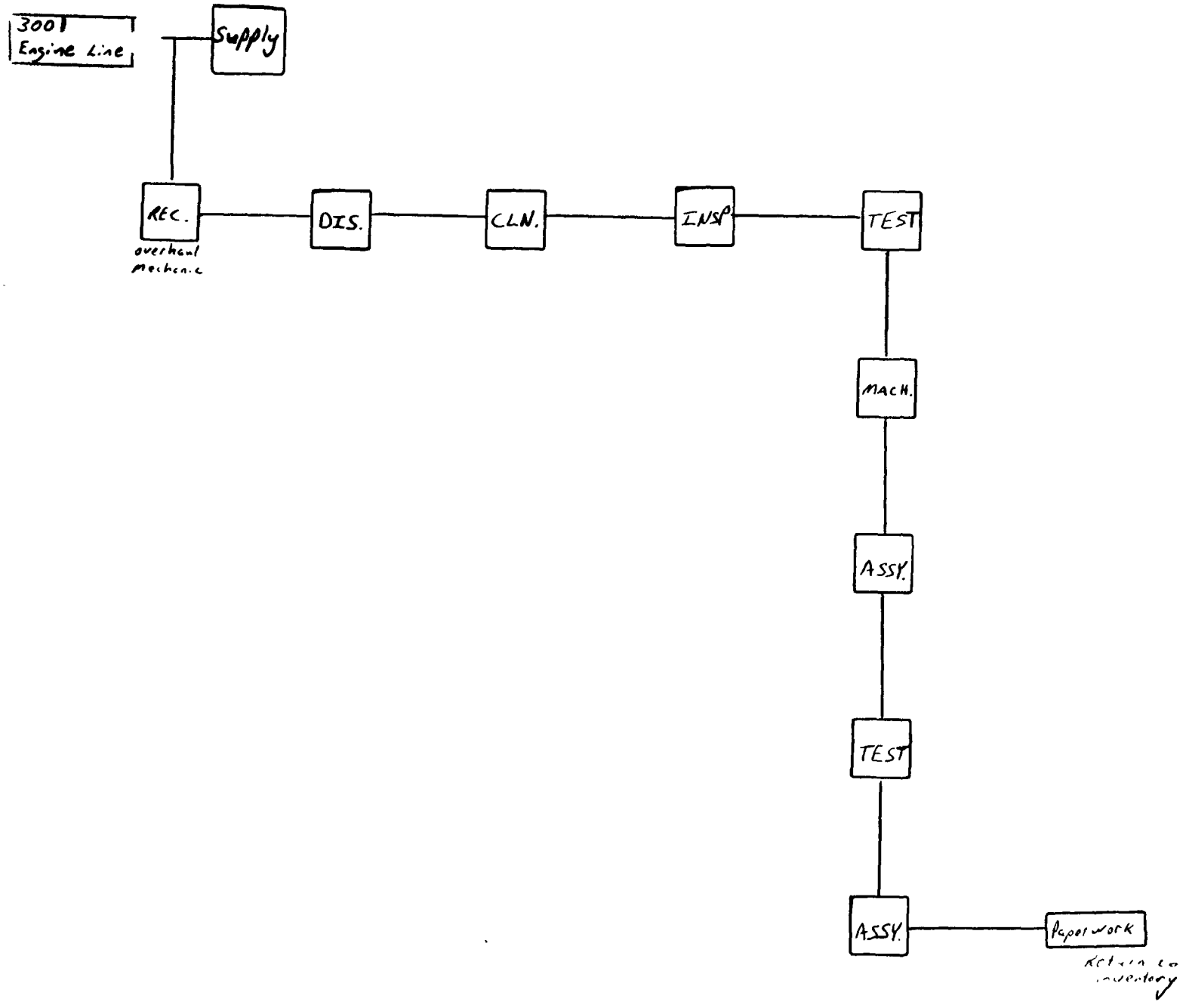
The following process flow diagrams are representative of the operations required to test and/or overhaul the various items worked by the MATPCA Accessories RCC. The items have been divided into family groups (i.e., like items in regard to designation and function). Operations shown often represent a logical combination of similar and related tasks. For more detailed analysis of the processes studied, please refer to the appropriate operation profile packet (enclosed).

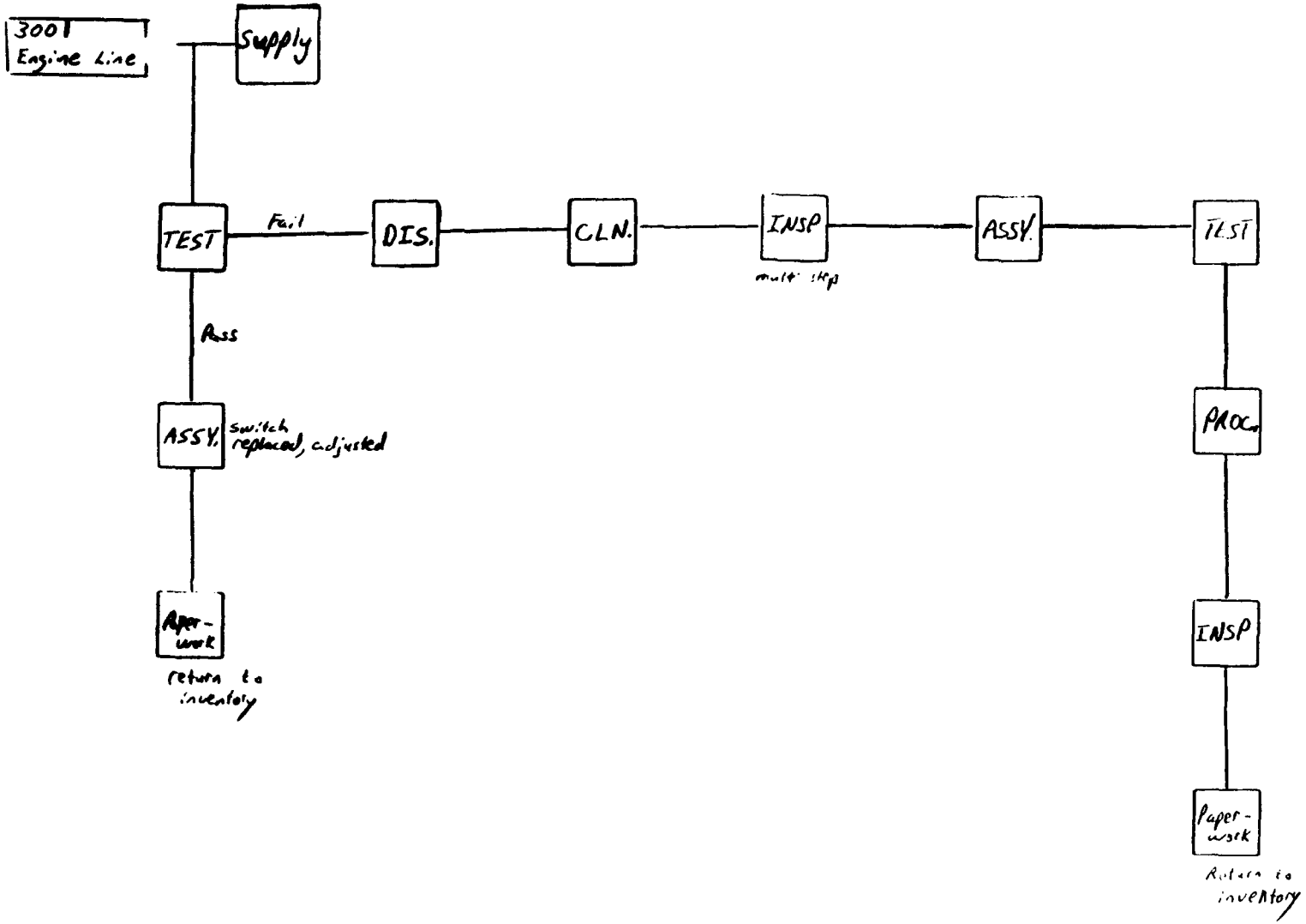

3001
Engine Line
Supply
REC.
overh
PROC.
DIS
CLN
INSP.
REP
ASSY.
ASSY
TEST
TEST
PAINT
Paper-
work
RETURN TO
Inventory.

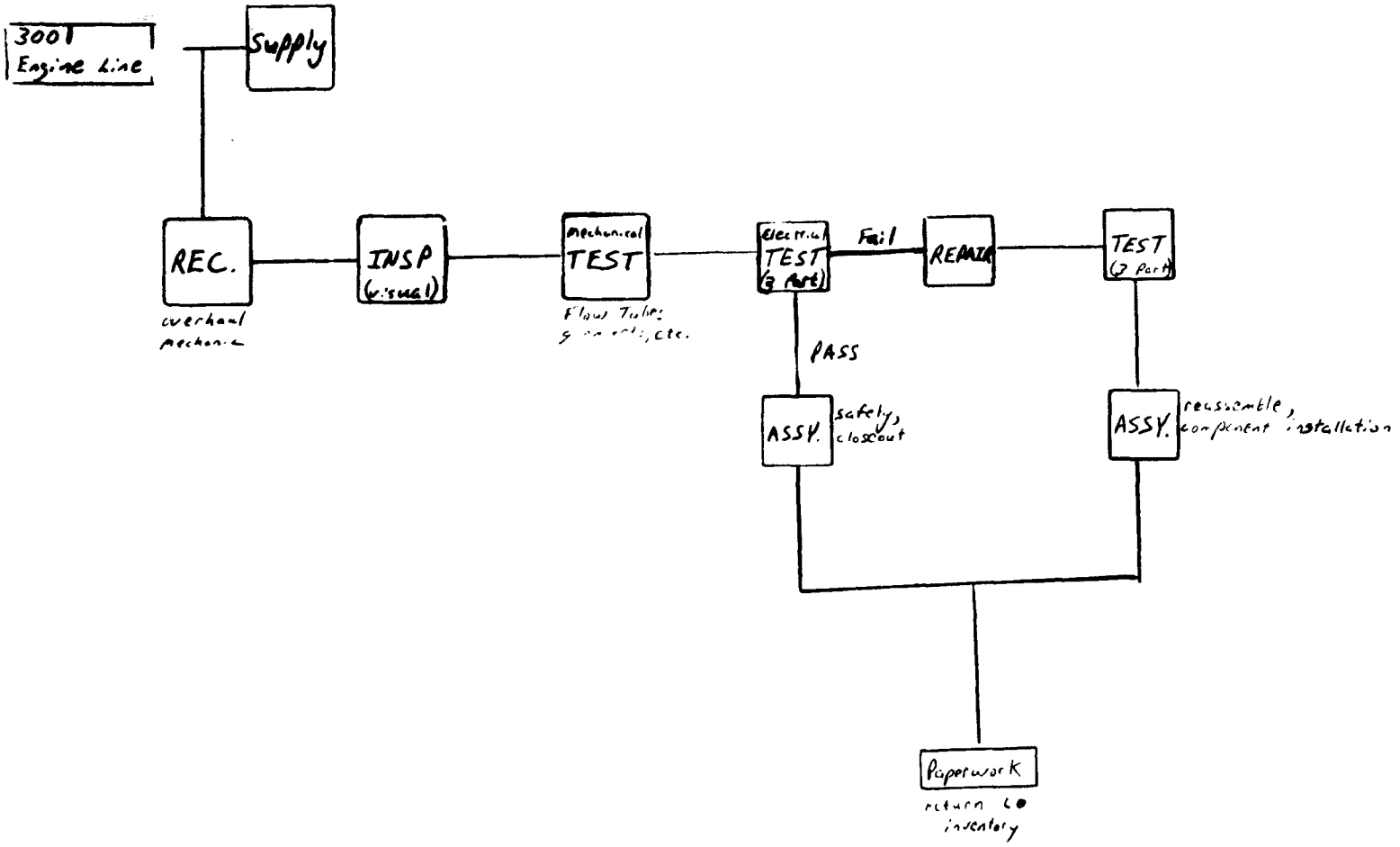
Relay Box

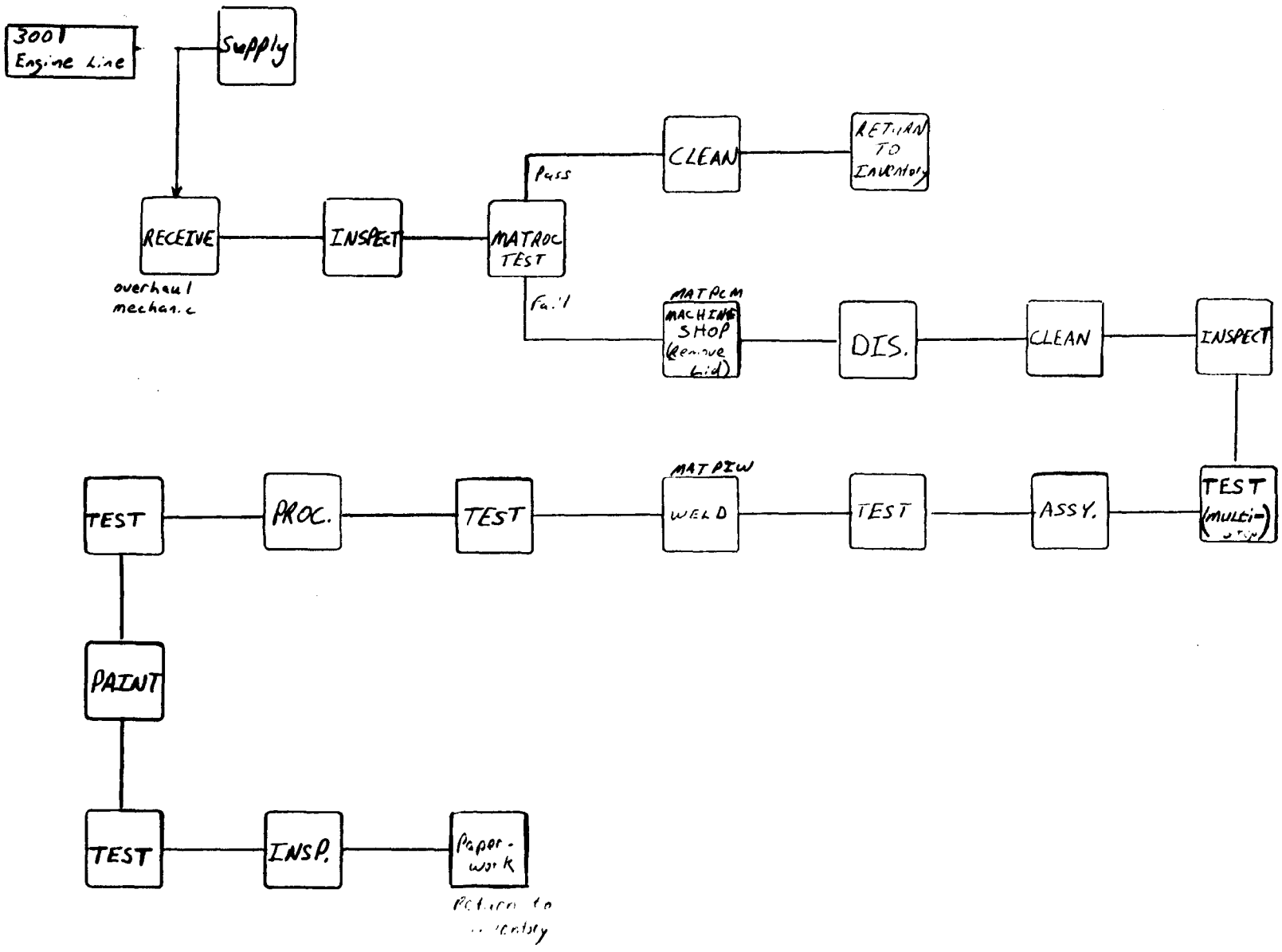

3001
Engine Line
Supply
REC.
DIS.
CLN.
INSP.
TEST
ASSY.
TEST
Paper-
work


3003
Engine Line
Supply
REC
overhaul
mechanic
DIS.
CLN.
INSP.
ASSY.
TEST
OVHL
PROC.
INSP.
TEST
PAINT
Paperwork


300T
Engine Line
Supply
REC.
overhaul
Mechanic
DIS.
CLN.
INSP
TEST
MACH.
ASSY.
TEST
ASSY.
Paperwork
Return to
inventory


3001
Engine Line
Supply
TEST
Fail
DIS.
CLN.
INSP
multi step
ASSY.
TEST
Ass
ASSY.
switch replaced, adjusted
PROC.
Paper-work
return to inventory
INSP
Paper-work
Return to inventory


3001
Engine Line
Supply
REC.
overhaul
INSP
(visual)
Mechanical
TEST
Flow Tube
Electrical
TEST
(3 Part)
Fail
REPAIR
TEST
(2 Part)
PASS
ASSY.
safety,
closeout
ASSY.
reassemble,
component installation
Paperwork
return to
inventory


3001
Engine Line
Supply
RECEIVE
overhaul
mechanic
INSPECT
MATROC
TEST
Pass
CLEAN
RETURN
TO
INVENTORY
Fail
MATPCM
MACHINE
SHOP
(remove
Lid)
DIS.
CLEAN
INSPECT
TEST
(MULTI-
STEP)
MATPIW
WELD
TEST
ASSY.
TEST
PROC.
TEST
PAINT
TEST
INSP.
Paper-
work
Return to
inventory

## 3.0 80/20 WORKLOAD ANALYSIS

An 80/20 analysis was previously performed for MATPCA using information obtained from AFLC "TOP DOLLAR ITEM" lists. These lists assumedly weighted the items on the basis of earned hours reported for each control number worked. In the case of MATPCA, this list proved dated, with several of the PCNs having been reassigned to other RCCs. An updated list was formed by reviewing the recent history of items processed, and replacing those PCNs that were no longer relevant with presently processed items of equal or greater earned hours. The following is the updated list of those part control numbers identified as representing 80% of MATPCA's present workload:

| CONTROL NUMBER | WCD NAME |
|---|---|
| 35023A | CAEY10 |
| 98093A | CAEC11 |
| 34253A | CAAC24 |
| 37719A | CAA001 |
| 38718A | CAEM02 |
| 38645A | CAEM08 |
| 30241A | CAEB05 |
| 34044A | CAEC04 |
| 49711A | CAEC07 |
| *35111A | CAEZ08 |
| 34128A | CAEY08 |
| 98001A | CAEC07 |

| | |
|---|---|
| 38694A | CAEM09 |
| 50217A | CAEA01 |
| 50078A | CAEZ05 |
| 38669A | CAEM03 |
| 35510A | CAEY12 |
| 31151A | CA2222 |
| 30056A | CAEZ03 |
| *34252A | CAAC02 |
| *34551A | CAEZ04 |
| *35113A | CAEZ02 |
| 38643A | CAEM04 |
| 49315A | CAEY09 |
| 61234A | CAEC05 |
| *35033A | CAEY11 |
| *97133A | CAEB08 |
| 50297A | CAEM22 |

* These are the PCNs that were placed on this list in order to update it to present conditions observed in MATPCA.

## 3.1 VALIDATION

Validation of the 80/20 list was performed as described in the preceding section. The updated list is believed to be representative of the MATPCA workload.

## 4.0 DATA COLLECTION

Of the data profile sheets collected, the following were found to be applicable to the MATPCA RCC:

- Operation Profile
- Manpower Profile
- Equipment Profile

Disassembly/Assembly Profiles and Parallel Process Profiles were not applicable to this RCC due to the nature of the work performed. All information represented on the operation profile sheets was developed primarily from information provided by the interviewed technicians. Manpower availability and equipment profile information was provided by shop supervisors.

### 4.1 DATA COLLECTION PROCESS

Each control number identified on the 80/20 list had an operation profile developed for it. The applicable shop foreman identified the technician most familiar with the item being studied, and an interview was performed to determine the relevant operations and their associated time requirements.

Please note that while a specific WCD (work control document) is the primary paperwork associated with any particular item's control number, this WCD can not be

regarded as an accurate description of the actual operations required for testing and overhaul of that item. The WCD should instead be considered as only a tracking device for the existing PAC certification program.

# WORKLOAD PI FILE

NAME Huggins, Duane ALC Okla City DATE 19 April 89 RCC MATPCA SHEET 1 OF 1

| ITEM NUMBER | AIRCRAFT MODEL | WCD | WORKLOAD TYPE | FLOATING STOCK | ACTUAL PRODUCTION BY QUARTER 1 | 2 | 3 | 4 | NO. OF ENVELOP UNITS | MAXIMUM W.I.P. | STANDARD HOURS |
|---|---|---|---|---|---|---|---|---|---|---|---|
| PCN 34253A<br>NSN 6130007728567<br>PN 17J51GMAC | 135 | CAEC24 | 4 | 0 | 144 | 177 | [illegible] | [illegible] | NA | 20 | 3.8 |
| PCN 37719A<br>NSN 661[illegible]1343<br>PN 6[illegible]12 | 130 | CAAE01 | 4 | | 124 | 121 | 155 | [illegible] | N/A | 30 | 7.2 |
| PCN 38645A<br>NSN 2915001378307PL<br>PN 635E490G01 | F4<br>J79 Eng | CAEM08 | 4 | | [illegible] | 65 | [illegible] | [illegible] | N/A | 15 | 7.9 |
| PCN 35[illegible]12A<br>NSN 661[illegible]0833457<br>PN 3110191[illegible] | F4<br>J79 eng | CAEM04 | 4 | | 47 | 40 | [illegible] | [illegible] | N/A | 10 | 7.5 |
| PCN 35113A<br>NSN 2925001565635CN<br>PN 6869188 | A7<br>TF41 eng | CAEE02 | 4 | | [illegible] | 40 | [illegible] | | N/A | 8 | 3.5 |
| PCN 35111A<br>NSN 2925002285485CN<br>PN 10-382470-3 | A7<br>TF41 RNG | CAEE01 | 4 | | [illegible] | [illegible] | [illegible] | [illegible] | N/A | 10 | 2.5 |
| PCN 34253A<br>NSN 6130007728566<br>PN 8TJ51@AA4 | 135 | CAEC0[illegible] | 4 | | 40 | 15 | [illegible] | | N/A | 20 | [illegible] |
| PCN 31151A<br>NSN 1650[illegible]658 8003<br>PN 632830K | CSD | CAAV01 | 4 | | 90 | 93 | 80 | 76 | N/A | 40 | 1.37 |
| PCN 38694A<br>NSN 2925009637864PL<br>PN | J79 Aft Jet Pipe | CAEM09 | 4 | | 70 | 74 | 82 | 62 | N/A | 10 | 3.8 |
| PCN<br>NSN<br>PN | | | | | | | | | | | |
| PCN<br>NSN<br>PN | | | | | | | | | | | |
| PCN<br>NSN<br>PN | | | | | | | | | | | |
| PCN<br>NSN<br>PN | | | | | | | | | | | |

LSC-20000B

# WORKLOAD PROFILE

NAME Sandra Wilson ALC OC DATE 5/19/89 RCC MATRA SHEET 1 OF 2

| ITEM NUMBER | AIRCRAFT MODEL | WCD | WORKLOAD TYPE | FLOATING STOCK | ACTUAL PRODUCTION BY QUARTER 1 | 2 | 3 | 4 | NO. OF ENVELOP UNITS | MAXIMUM W.I.P. | STANDARD HOURS |
|---|---|---|---|---|---|---|---|---|---|---|---|
| PCN NSN P/N 35023A | TF 33 3-7-9 | CAEY10 | 4 | Ø | 84 | 62 | 50 | 65 | 2 | 15 | 12.0 |
| PCN NSN P/N 98093 A | TF 33 P.7 | CAEC11 | 4 | | 152 | 145 | 124 | 94 | 3 | 30 | 12.4 |
| PCN NSN P/N 38718 A | J79-15 | CAEM02 | 4 | | 97 | 97 | 87 | 84 | 4 | 15 | 9.2 |
| PCN NSN P/N 30241 A | J57-43 | CAEB05 | 4 | | 223 | 144 | 103 | 50 | 2 | 40 | 6.0 |
| PCN NSN P/N 34044 A | TF33-7 | CAEC04 | 4 | | 54 | 38 | 47 | 19 | 3 | 10 | 9.8 |
| PCN NSN P/N 49711A | TF33-3 | CAEC07 | 4 | | 78 | 79 | 48 | 23 | 2 | 15 | 7.2 |
| PCN NSN P/N 34128A | TF33-P111 | CAEY08 | 4 | | 162 | 140 | 170 | 129 | NA | 45 | 4.3 |
| PCN NSN P/N 98001A | TF33-3 | CAEC07 | 4 | | 22 | 26 | 23 | 23 | 2 | 8 | 6.7 |
| PCN NSN P/N 38694A | J79-15-17 | CAEM09 | 4 | | 70 | 81 | 47 | 90 | NA | 10 | 3.8 |
| PCN NSN P/N 50217A | TF33-5 | CAEA01 | 4 | | 1 | 5 | 2 | 5 | 2 | 5 | 10.0 |
| PCN NSN P/N 49315A | TF30-3-9 | CAEY09 | 4 | | 301 | 209 | 215 | 260 | NA | 50 | 4.0 |
| PCN NSN P/N 38669A | J79-15-17 | CAEM03 | 4 | | 37 | 45 | 35 | 30 | 1 | 10 | 4.5 |
| PCN NSN P/N 35510 A | TF30-P100 | CAEY12 | 4 | | 21 | 16 | 26 | 2 | NA | 8 | 5.2 |

# WORKLOAD PROFILE

NAME Sandra Wilson ALC OC DATE 5/19/89 RCC MATPCA SHEET 2 OF 2

| ITEM NUMBER | AIRCRAFT MODEL | WCD | WORKLOAD TYPE | FLOATING STOCK | ACTUAL PRODUCTION BY QUARTER | | | | NO. OF ENVELOP UNITS | MAXIMUM W.I.P. | STANDARD HOURS |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1 | 2 | 3 | 4 | | | |
| PCN NSN P/N 30056A | TF 41 A1-A2 | CAE303 | 4 | Ø | 27 | 16 | 23 | 19 | NA | 10 | 5.2 |
| PCN NSN P/N 50297A | J79-15-17 | CAEM22 | 4 | | 6 | 0 | 0 | 0 | NA | 6 | 4.5 |
| PCN NSN P/N 34551A | TF41-A1 | CAE204 | 4 | | 23 | 30 | 24 | 15 | NA | 5 | 5.2 |
| PCN NSN P/N 97133A | TF33-3 | CAEB08 | 4 | | 39 | 47 | 39 | 12 | NA | 10 | 2.9 |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |
| PCN NSN P/N | | | | | | | | | | | |

LSC-2(X)96B

# EQUIPMENT P' OFILE

Due 27 APR. 1989

NAME Duane Huggins ALC Oklahoma City DATE 15 May 89 RCC MAIPCM SHEET 1 OF 1

| EQUIPMENT CODE | EQUIPMENT TYPE/DESCRIPTION | QUANTITY PER SHIFT | | | DOWNTIME | | | | | PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE) | ENVELOP UNITS | | ALTERNATE EQUIPMENT CODE | SOURCE |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | PREVENTIVE MAINT. | | | UNSCHEDULED BREAKDOWN REPAIR TIME | | | MIN | MAX | | |
| | | 1st | 2nd | 3rd | FREQ. | SHIFT | DOWN TIME | MTBF | MTTR | | | | | |
| OC 4286 | J79 Temp Am | 1 | 0 | 0 | 090 | 1 | 00080 | 365 | 020 | 0% | N | A | A | TMDE Inventory List + Supervision |
| OC 4285 | J79 Temp Am | 1 | | | 090 | 1 | 00080 | 365 | 020 | 0% | N | A | | TMDE Inventory List + Shop Supervision |
| OC 4531 | Kit Test Am | 1 | | | 180 | 1 | 00080 | 730 | 020 | | N | A | CC107C | TMDE Inventory List + Shop Supervision |
| OC 3908 | Timing Tes 30- | 1 | | | NPCR | NA | NA | 365 | 010 In Shop | | N | A | None [illegible] CC B | Shop |
| NA | Poly Bx TST | 1 | | | 365 | NA | NA | never failed | never failed | | N | A | | TMDE Inventory List |
| NA | Auto Sq Tes | 1 | | | NPCR | NA | NA | 365 | In Shop | | N | A | | Shop |
| OC 6585 | Delay Test | 1 | | | 365 | 1 | 00080 | never failed | never failed | | | | | TMDE Inventory List |
| NA | Percent TST 30 Pc | 4 | | | 180 | 1 | 00560 | 1145 | 0050 | 0 | | | | Inventory List |
| | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |

NCR:

# EQUIPMENT PROFILE

Due 27 APR. 1987

NAME Sandra Wishon ALC OC DATE [illegible] RCC MATPCA SHEET ___ OF ___

| EQUIPMENT CODE | EQUIPMENT TYPE/DESCRIPTION | QUANTITY PER SHIFT 1st | 2nd | 3rd | DOWNTIME: PREVENTIVE MAINT. FREQ. | SHIFT | DOWN TIME | UNSCHEDULED BREAKDOWN REPAIR TIME: MTBF | MTTR | PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE) | ENVELOP UNITS MIN / MAX | ALTERNATE EQUIPMENT CODE | SOURCE |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| [illegible] | [illegible] yrs | 3 | | | 1 | 1 | [illegible] | 730 | [illegible] | C | | | TABLE & SMV |
| OC 3952 | IGN TST CON + 20 yr | | | | [illegible] | 1 | NA | 2190 | [illegible] | C | | OC 3953 | |
| OC 4929 | IGN TST [illegible] yrs | | | | [illegible] | 1 | [illegible] | 730 | [illegible] | C | | OC 3906 | |
| | IGN TSTR 20 yr | 2 | | | | 1 | [illegible] | 730 | [illegible] | C | | | |
| OC C805 | ELEC OVEN 20 yr | 1 | | | [illegible] | 1 | [illegible] | 365 | [illegible] | C | | | |
| OC 4060 | IGN Com TST 20 yr | 1 | | | [illegible] | 1 | [illegible] | 180 | [illegible] | C | | | |
| OC 3958 | OVEN 20 yrs | 1 | | | [illegible] | 1 | [illegible] | 365 | [illegible] | C | | OC 3958 OC 3959 | |
| [illegible] | [illegible] 1 yrs | 2 | | | [illegible] | 1 | [illegible] | 2190 | [illegible] | C | | | |
| [illegible] | PK CAP TST 20 yrs | 1 | | | NA | 1 | [illegible] | 180 | [illegible] | C | | | |
| OC 2429 | LEAK DET 20 yrs | 1 | | | [illegible] | 1 | [illegible] | 730 | | C | | | |
| | | | | | | | | | | | | | |
| | | | | | | | | | | | | | |

NCR

LSC-2009-B

Due Tues. APR 25, 1989

# MANPOWER PROFILE

NAME Huggins Duane ALC Okla City DATE 19 Apr 89 RCC 2M MTPC14 SHEET 1 OF 1

| SKILL CODE/LEVEL | JOB DESCRIPTION | QUARTER | QUANTITY AVAILABLE | | | | | | | | | MANPOWER AVAILABLE (HOURS) | | | | | | | | | ALTERNATE SKILL CODE/LEVEL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | WORK WEEK | | | WEEKEND | | | HOLIDAYS | | | WORK WEEK | | | WEEKEND | | | HOLIDAYS | | | |
| | | | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | |
| AY 09 7 | Engine Electrical component Repair/overhaul Misc Aircraft Electronic components Repair/ Overhaul | 1 | 9 | | | 7 | | | 7 | | | 6.0 | | | 6.0 | | | 6.0 | | | |
| | | 2 | 7 | | | 7 | | | 7 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 3 | 6 | | | 6 | | | 6 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 6 | | | 6 | | | 6 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| AY 10 | Engine Electrical component Repair/ Overhaul, Misc Aircraft Electronic component Repair/Overhaul | 1 | 9 | | | 9 | | | 9 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 2 | 7 | | | 2 | | | 7 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 3 | 5 | | | 5 | | | 5 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 5 | | | 5 | | | 5 | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 1 | | | | | | | | | | | | | | | | | | | |
| | | 2 | | | | | | | | | | | | | | | | | | | |
| | | 3 | | | | | | | | | | | | | | | | | | | |
| | | 4 | | | | | | | | | | | | | | | | | | | |
| | | 1 | | | | | | | | | | | | | | | | | | | |
| | | 2 | | | | | | | | | | | | | | | | | | | |
| | | 3 | | | | | | | | | | | | | | | | | | | |
| | | 4 | | | | | | | | | | | | | | | | | | | |
| | | 1 | | | | | | | | | | | | | | | | | | | |
| | | 2 | | | | | | | | | | | | | | | | | | | |
| | | 3 | | | | | | | | | | | | | | | | | | | |
| | | 4 | | | | | | | | | | | | | | | | | | | |

Note: only one shift at present time

LSC-2000

Due Tues Apr 25, 1989

# MANPOWER PROFILE

Sandra Wishon

NAME [redacted] ALC Okla City DATE 19 Apr 89 RCC 211 ATPCH SHEET ___ OF ___

| SKILL CODE/LEVEL | JOB DESCRIPTION | QUARTER | QUANTITY AVAILABLE | | | | | | | | | MANPOWER AVAILABLE (HOURS) | | | | | | | | | ALTERNATE SKILL CODE/LEVEL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | WORK WEEK | | | WEEKEND | | | HOLIDAYS | | | WORK WEEK | | | WEEKEND | | | HOLIDAYS | | | |
| | | | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | 1 | 2 | 3 | |
| BY 10 | overhaul/repair of engine & aircraft electrical & [illegible] assemblies, functional test & troubleshoot special purpose test stands, [illegible] | 1 | 10 | | | | | | | | | 60 | | | 6.0 | | | 6.0 | | | |
| | | 2 | 10 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 3 | 10 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 10 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| BY 09 | overhaul/repair/inspect [illegible] aircraft electrical [illegible] and components | 1 | 10 | | | | | | | | | 60 | | | 6.0 | | | 6.0 | | | |
| 4 yrs | | 2 | 10 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 3 | 10 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 10 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| BY 07 | Train as intermediate position while assisting higher grade in [illegible] overhaul/repair of [illegible] aircraft electrical & [illegible] and accessories | 1 | 1 | | | | | | | | | 60 | | | 6.0 | | | 6.0 | | | |
| Elect Eqp Repr Trainee Grade 09 | | 2 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| 1/1 | | 3 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| B3 07 | Perform [illegible] on the [illegible] of [illegible] aircraft [illegible] and other equipment | 1 | 1 | | | | | | | | | 6.0 | | | 6.0 | | | 6.0 | | | |
| 1 | | 2 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 3 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| BY 07 | [illegible] clean blast & final process) clean aft [illegible] aircraft electrical [illegible], 25% of line - WG2654 work | 1 | 1 | | | | | | | | | 6.0 | | | 6.0 | | | 6.0 | | | |
| DEMASTER 1 | | 2 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 3 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |
| | | 4 | 1 | | | | | | | | | 5.9 | | | 5.9 | | | 5.9 | | | |

LSC-20003

# ENVE P

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

ALC OC RCC MATPCA EQUIPMENT CODE OC 2760 (OC·2758, 2759 - All enclosures)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 10 cu.

| LIST OF PARTS BY ITEM NUMBER | SIZE/VOLUME CU. FT. | UNIT VALUE | MINIMUM | MAXIMUM | REMARKS/SOURCE |
|---|---|---|---|---|---|
| PCN 55[illegible]3<br>NSN 2925 00941 3778PD<br>P/N 42127 | .1cu.FT | 2 | 1 | 6 | EACH CVEN IS LIMITED TO 6 DUE TO FITTINGS |
| PCN 58649<br>NSN 2925 00992 1235PL<br>P/N 10-353975-2 | .09cu.FT. | 1 | 1 | 6 | |
| PCN 98693<br>NSN 2925 00 456 7687RV<br>P/N 43311 | .2cu.FT | 3 | 1 | 6 | |
| PCN 38718<br>NSN 2925 01132 583[illegible]PL<br>P/N 10-3[illegible]625-1 | .3cu.FT. | 4 | 1 | 6 | |
| PCN 50941<br>NSN 2925 00 084 8118 RV<br>P/N 10-106700-1 | .14cu.FT. | 2 | 1 | 6 | |
| PCN 34041<br>NSN 2925 00 986 2155 RV<br>P/N 42590 | .2cu.FT | 3 | 1 | 6 | |
| PCN 49711<br>NSN 2925 01 131 8761RV<br>P/N 10-617860-1 | .1cu.FT | 2 | 1 | 6 | |
| PCN 98001<br>NSN 2925 00 773 7911RV<br>P/N 10-197866-1 | .1cu.Ft | 2 | 1 | 6 | |
| PCN 50317<br>NSN 2925 01 161 5516 RV<br>P/N 44387 | .14cu.FT | 2 | 1 | 6 | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |

# ENVE P

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

ALC OC RCC MATRIX EQUIPMENT CODE OC 0303

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 2 1/2 (1 ea)

| LIST OF PARTS BY ITEM NUMBER | SIZE/VOLUME CU. FT. | UNIT VALUE | MINIMUM | MAXIMUM | REMARKS/SOURCE |
|---|---|---|---|---|---|
| PCN 98093 NSN 2529004567697RD P/N 43317 | .2 cu.FT | 3 | 1 | 18 | This oven does not have fittings inside |
| PCN 34044 NSN 2925009962055RD P/N 42590 | .2 cu.FT | 3 | 1 | 18 | |
| PCN 49711 NSN 2925011318761RD P/N 10-617860-1 | .1 cu.FT | 2 | 1 | 18 | |
| PCN 26011 NSN 5[illegible]00773721[illegible]RD P/N 10-187860-1 | .1 cu.FT | 2 | 1 | 18 | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |
| PCN NSN P/N | | | | | |

LSC-2010GA

# ENVELC
## (For Internal Use, Not a Model Input)

ALC _____ RCC _____ EQUIPMENT CODE _____

TOTAL VOLUME OF EQUIPMENT IN CU. FT. _____

| LIST OF PARTS BY ITEM NUMBER | SIZE/VOLUME CU. FT. | UNIT VALUE | MINIMUM | MAXIMUM | REMARKS/SOURCE |
|---|---|---|---|---|---|
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | note: no batch processes ran on any of this equip. listing. |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |
| PCN<br>NSN<br>P/N | | | | | |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/04/89 RCC MAT PCA [redacted]

(PCN) RSN PMI 30056A WCD CAEZ03 WCD DATE 682003

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

* Note - This sheet for in [redacted] dates

LSC-2(X)92C

# OPERATION PROFILE

NAME Parker, Phillip ALC 00 DATE 05/04/89 RCC MAT PCA SHEET 1 OF 6

PCN / NSN / P/N 30056A WCD CAEZ 03 WCD DATE 882003

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .17 | — | — | — | — | SKill 5-10 |
| 020 | | INFO | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Applicable T.O. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | ~~PROCESS~~ | — | — | | — | — | — | — | — | — | — | SKill range 9-10 |
| 025 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Note: This op'n not listed in w.c.d. Initial function TEST. see Ops 160-22 |
| | | | | ~~SETUP~~ | — | — | | | | | — | — | — | — | Equip - DI = digital indicat SA = Switch Adjust Devic |
| | | | | PROCESS | — | — | | 1 | 1.0 | 2.87 | | | | | SKill range - 9-10 |
| 030 | | DIS | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .18 | BEN 4 | 1 | 1.0 | .18 | SKill range 9-10 |
| 040 | | CIN | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN 4 | 1 | 1.0 | .18 | SKill range 9-10 |

Hawkins

LSC-2(K)92C

# OPERATION PROFILE

NAME Parker, Phillip ALC [illegible] DATE 05/04/89 RCC MAT PCA SHEET 2 OF 6

PCN
NSN
PRI 300564 WCD CAE203 WCD DATE 88 2003

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 050 | MAT PCA | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Note: This is a visual inspection. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | Skill range 9-10 |
| 060 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Micrometer req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | Skill range 9-10 |
| 070 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Micrometer req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | Skill range 9-10 |
| 080 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Micrometer req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | Skill range 9-10 |
| 090 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Micrometer req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | Skill range 9-10 |

# OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 05/04/89 RCC MAT PCA SHEET 3 OF 6

PCN
NSN
P/N 300561 WCD CAE203 WCD DATE 68 20 03

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 100 | MAT PCA | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | micrometer req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .17 | BEN 4 | 1 | 1.0 | .17 | SKILL 9-10 |
| 110 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | micrometer req |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN 4 | 1 | 1.0 | .17 | SKILL 9-10 |
| 120 | | PROC | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | As Required |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN 4 | 1 | 1.0 | .17 | SKILL 9-10 |
| 130 | | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | several steps required |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.52 | BEN 4 | 1 | 1.0 | .17 | SKILL 9-10 |
| 140 | | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Adjustment required. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .1 | BEN 4 | 1 | 1.0 | .1 | SKILL 9-10 |

# OPERATION PROFILE

NAME [illegible] ALC [illegible] DATE 05 [illegible] 89 RCC MAT PCA SHEET 4 OF 6

PCN
NSN
PN 30056A WCD CAE203 WCD DATE 882003

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 150 | MAT PCA | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Adjustment required. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .18 | BEN4 | 1 | 1.0 | .18 | SK'll 9-10 |
| 155 | | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | adjustment required. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | SK'll 9-10 |
| 158 | | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Requires Torque |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | .02 | SK'll 9-10 |
| 160 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | TEST Apparatus: SW. Adjustment Device (SAD) |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.01 | BEN4 | 1 | 1.0 | 1.09 | SK'll 9-10 |
| 170 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Separate test from above. |
| | | | | ~~SETUP~~ | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .12 | BEN4 | 1 | 1.0 | .12 | SK'll 9-10 |

# OPERATION PROFILE

NAME Baker, Phillip ALC OC DATE 05 04 88 RCC MAT PCA SHEET 5 OF 6

PCN NSN PNI 30056A WCD CAE203 WCD DATE 8820 OT

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 220 | MAT PCA | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Test Apparatus: Dial Indicator (DT) |
| | | | | ~~SETUP~~ | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .53 | BEN4 | 1 | 1.0 | .53 | SK:II 9-10 |
| 230 | | PROC | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Special tool required. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN4 | 1 | 1.0 | .03 | SK:II 9-10 |
| 260 | | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | — | — | — | — | SK:II 9-10 |
| 270 | | Insp | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Inspect for Presence of Tightness. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | .02 | SK:II 9-10 |
| 280 | | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | |

# OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 05/04/89 RCC MAT PCA SHEET 6 OF 6

(PCN) NSN PN 30056A WCD CAE203 WCD DATE 882003

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 290 | MAT PCA | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .02 | - | - | - | - | SK.11 9-10 |
| 295 | | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .02 | - | - | - | - | SK.11 9-10 |
| 9999 | MAT PCA | OUT DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 30 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 05/04/89

ITEM CODE
PCN ☑
NSN. ☐ 300536A
P/N ☐

WCD CAEZ303 WCD DATE 88203

CHART BEGINS OPN # 010

CHART ENDS OPN # PREPARED BY RJP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ●◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | 020 | ●◇D□▽ | INFO | | | ○◇D□▽ | |
| 025 | | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 030 | 030 | ●◇D□▽ | DIS | | | ○◇D□▽ | |
| 040 | 040 | ●◇D□▽ | CIN | | | ○◇D□▽ | |
| 050 | 050 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 060 | 060 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 070 | 070 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 080 | 080 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 090 | 090 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 100 | 100 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 110 | 110 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 120 | 120 | ●◇D□▽ | LUB | | | ○◇D□▽ | |
| 130 | 130 | ●◇D□▽ | ASSY | | | ○◇D□▽ | |
| 140 | 140 | ●◇D□▽ | ASSY | | | ○◇D□▽ | |
| 150 | 150 | ●◇D□▽ | ASSY | | | ○◇D□▽ | |
| 155 | 155 | ●◇D□▽ | ASSY | | | ○◇D□▽ | |
| 158 | 158 | ●◇D□▽ | ASSY | | | ○◇D□▽ | |
| 160 | 160 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 170 | 170 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 220 | 220 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 230 | 230 | ●◇D□▽ | ACT | | | ○◇D□▽ | |
| 260 | 260 | ●◇D□▽ | PW | | | ○◇D□▽ | |
| 270 | 270 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 280 | 280 | ●◇D□▽ | PW | | | ○◇D□▽ | |
| 290 | 290 | ●◇D□▽ | PW | | | ○◇D□▽ | |
| 295 | 295 | ●◇D□▽ | PW | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
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| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION OFILE

NAME Parker ALC OC DATE 5/8/89 RCC MATPCA SHEET — OF —

PCN
NSN
P/N 30241A

WCD CAEBOS ✓ WCD DATE 89033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 44.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note: This sheet for IN - OUT DATES

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/[illegible]/88 RCC MAT PCA SHEET 1 OF 5

BCN
NSN
P/N 30241A WCD CAEC05 WCD DATE 88033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| [illegible]10 | MAT PCA | REC | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .08 | — | — | — | — | SK. L 5-10 |
| 05 | | INFO | 1.0 | [illegible] | | | | | | | | | | | Applicable T.O. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | TEST | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .02 | — | — | — | — | [illegible] routed [illegible] [illegible] laboratory. |
| | | | | PROCESS | — | — | | 1 | 1.0 | .07 | CC 4929 | 1 | 1.0 | .09 | [illegible] failure rate 95% |
| 020 | | INSP | 1.0 | [illegible] | | | | | | | | | | | Visual inspection for [illegible] cracks |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN21 | 1 | 1.0 | .17 | SK. [illegible] |
| 030 | MAT ACM | MACH | .95 | [illegible] | | | | | | | | | | | Cover removal, usually only machine assigned for this [illegible] |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.[illegible] | 24.3 | — | — | — | — | — | — | — | — | |

Interference overlaid Strout

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MATPCA SHEET 2 OF 5

PCN NSN PN 30241A WCD CAEBOS ✓ WCD DATE 89 09 07

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | DIS | .95 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | CY 10 | 1 | 1.0 | .42 | BEN21 | 1 | 1.0 | .42 | SK.11 9-10 |
| 045 | | TEST | .95 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .33 | — | — | — | — | |
| | | | | PROCESS | — | | | 1 | 1.0 | .33 | ox 3953 | 1 | 1.0 | .66 | SK.11 9-10 |
| 050 | MAT PCA | WELD | .29 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 310 | MAT PCA | ASSY | .95 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .50 | BEN21 | 1 | 1.0 | .50 | SK.11 9-10 |
| 320 | | ASSY | .95 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BEN21 | 1 | 1.0 | .75 | SK.11 9-10 |

LSC-20092C

# OPERATION OFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 3 OF 5

PCN RSN PN 30241A WCD CAEB05 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 330 | MAT PCA | TEST | .95 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | - | - | BY10 | 1 | 1.0 | .02 | - | - | - | - | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .17 | OC 4929 | 1 | 1.0 | .19 | SK-11 9-10 |
| 360 | MAT PIW | WELD | .95 | [illegible] | | | | | | | | | | | [illegible] welding [illegible] |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | - | - | - | - | - | - | - | - | |
| 365 | MAT PCA | PAINT | 1.0 | [illegible] | | | | | | | | | | | [illegible] flow hours. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | - | - | - | - | SK-11 7 |
| 370 | | PROC | .95 | [illegible] | | | | | | | | | | | [illegible] |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | CY10 | 1 | 1.0 | .05 | OC 2758 | 1 | 1.0 | 1.55 | SK-11 9-10 |
| 380 | | INFO | .95 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | SK-11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MATPCA SHEET 4 OF 5

FSN NSN 30241A WCD CAEBQS WCD DATE 890921

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 440 | MAT PCA | PROC | .95 | [redacted] | | | | | | | | | | | Pressurize unit with dry air. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .07 | BEN21 | 1 | 1.0 | .07 | SK. ... |
| 450 | | PROC | .95 | [redacted] | | | | | | | | | | | ... for leakage water bath |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | BEN 17 | 1 | 1.0 | .05 | SK.II ...10 |
| 460 | | TEST | .95 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .07 | OR 4929 | 1 | 1.0 | .09 | SK.II 5-10 |
| 490 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | — | — | — | — | SK 5-10 |
| 500 | | ASSY | .95 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN21 | 1 | 1.0 | .25 | SK.II 5-10 |

# OPERATION .OFILE

NAME Parker ALC 0C DATE 05/08/89 RCC MATPCA SHEET 5 OF 5

PCN REV 30241A WCD CAEB05 WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 510 | MAT PCA | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .03 | — | — | — | — | SK. [illegible] |
| 520 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | — | — | — | — | CK. [illegible] |
| 590 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | SK 11 9-10 |
| 9999 | MAT RA | Out Date | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 20.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 05/08/89

ITEM CODE
PCN ☒ 30241A
NSN. ☐
P/N ☐

WCD CAEBOS WCD DATE 89094

CHART BEGINS 010

CHART ENDS 590 PREPARED BY MP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | | | ○◇D□▽ | |
| 015 | 015 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 017 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | MACH | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | DIS | | | ○◇D□▽ | |
| 045 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 050 | 050 | ○◇D□▽ | WELD | | | ○◇D□▽ | |
| 310 | 310 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 320 | 310 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 330 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 360 | 360 | ○◇D□▽ | WELD | | | ○◇D□▽ | |
| 365 | 365 | ○◇D□▽ | Paint | | | ○◇D□▽ | |
| 370 | — | ○◇D□▽ | Heat | | | ○◇D□▽ | |
| 380 | 380 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 440 | 440 | ○◇D□▽ | Pressurize | | | ○◇D□▽ | |
| 450 | 450 | ○◇D□▽ | Leak test | | | ○◇D□▽ | |
| 460 | 460 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 490 | 490 | ○◇D□▽ | Paperwork | | | ○◇D□▽ | |
| 500 | 500 | ○◇D□▽ | Safety wire | | | ○◇D□▽ | |
| 510 | 510 | ○◇D□▽ | Paper work | | | ○◇D□▽ | |
| 520 | 520 | ○◇D□▽ | Paper work | | | ○◇D□▽ | |
| 590 | 590 | ○◇D□▽ | Paper work | | | ○◇D□▽ | |
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| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME J Carter ALC OC DATE 4/28/89 RCC MATPCA SHEET — OF —

PCN
NSN 31151A WCD CA2222 WCD DATE 88214

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
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| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE: THIS SHEET FOR IN-OUT DATES

LSC-2[illegible]

# OPERATION PROFILE

NAME J. CARTER ALC OC DATE 4-28-89 RCC MAT PCA SHEET 1 OF 2

NSN 31151A WCD CA2222 WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
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| 010 | MAT PCA | REC | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | AY09 | 1 | 1.0 | .10 | 28 BENCH | 1 | 1.0 | .10 | SKILL 5-10 |
| 020 | MAT PCA | DIS | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | — | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.00 | .75 | 28 BENCH | 1 | 1.0 | .25 | |
| 030 | | CLEAN | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | * NO NO. ON CLEANING TANK |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.00 | .1 | 28 BENCH | 1 | 1.0 | .1 | |
| 040 | | INSP | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.00 | .30 | BENCH | 1 | 1.0 | .30 | |
| 050 | | REP | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.00 | .50 | 28 BENCH | 1 | 1.0 | .50 | |

# OPERATION PROFILE

NAME J. Carter ALC OC DATE 4/28/89 RCC MATPCA SHEET 2 OF 2

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WCD CA2222 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
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| 060 | MAT PCA | ASS | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | AY 09 | 1 | 1.0 | .75 | 28 BENCH | | | | |
| 070 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | * MEM SK1265 |
| | | | | PROCESS | — | — | | 1 | 1.0 | .20 | 28 BENCH | | | | |
| 080 | | PW | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .1 | 28 BENCH | — | — | — | |
| 090 | | PW | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .1 | 28 BENCH | | | | |
| 100 | | PW | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 28 BENCH | | | | |
| 9999 | MAT PCA | out Date | 1.0 | Process | 1.0 | 9.6 | | | | | | | | | |

LSC-2000-2C

# FLOW PROCESS CHART

SUBJECT GEAR BOX ASS'Y DATE 5-1-89

ITEM CODE PCN ☑ 31151A NSN. ☐ P/N ☐

WCD [redacted] WCD DATE 88214

CHART BEGINS OP 010

CHART ENDS OP 100 PREPARED BY J. CARTER

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | — | ●◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | — | ●◇D□▽ | DISASSEMBLE | | | ○◇D□▽ | |
| 030 | — | ●◇D□▽ | CLEAN | | | ○◇D□▽ | |
| 040 | — | ●◇D□▽ | INSPECT | | | ○◇D□▽ | |
| 050 | — | ●◇D□▽ | REPAIR | | | ○◇D□▽ | |
| 060 | — | ●◇D□▽ | ASSEMBLE | | | ○◇D□▽ | |
| 070 | — | ○◇D■▽ | TEST | | | ○◇D□▽ | |
| 080 | — | ●◇D□▽ | P/W | | | ○◇D□▽ | |
| 090 | — | ●◇D□▽ | P/W | | | ○◇D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

NOTE; Added times
Equipment blocks

# OPERATION FILE

NAME J. CARTER ALC OC DATE 4-27-82 RCC MAT PCA SHEET 1 OF

PSN 340444A
NSN [redacted]
P/N

WCD CAECO4 ✓ WCD DATE 82-04-5

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN Date | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.000 | TRANSIT | | | BY.10 | — | — | — | | — | — | — | |
| | | | | SETUP | | | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | — | .10 | 6 BENCH | 1 | 1.0 | .1 | BENCH |
| 015 | | PH | 1.000 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | — | .10 | 6 BENCH | 1 | 1.0 | .1 | BENCH |
| 020 | | DIS | 1.000 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | — | 2.0 | 6 BENCH | 1 | 1.0 | 2.0 | BENCH |
| 030 | | CLN | 1.000 | TRANSIT | — | — | | 1 | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | | — | — | — | — | — | — | CLEANING TANK - NO NUMBER |
| | | | | PROCESS | — | — | BY. 10 | 1 | — | .1 | — | — | — | — | |

LSC-2(X)92C

# OPERATION PROFILE

NAME J. CARTER ALC OC DATE 11-27-89 RCC MAT PCA SHEET 2 OF ___

PCN 346447 NSN [redacted] PN ___ WCD CAEC04 WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | INSP. | 1.000 | TRANSIT | — | — | B4-10 | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 6 [illegible] | 1 | 1.0 | .1 | |
| 060 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .20 | OC 4929 | 1 | 1.0 | .20 | |
| 070 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 070 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 080 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | B4-10 | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME JACK CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 3 OF ___

PCN 34044A
NSN [redacted]
PN ___

WCD CAEC04 ✓ WCD DATE ___

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 090 | MAT PCA | TEST | 1.00 | TRANSIT | — | — | — | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY-10 | 1 | 1.0 | .20 | OC 4929 | — | — | — | |
| 100 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | | | | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | | — | — | — | |
| 110 | | TEST | 1.00 | TRANSIT | — | — | | | | | | — | | | |
| | | | | SETUP | — | — | | | | | | — | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | | — | — | — | |
| 120 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | | | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .10 | OC 4929 | — | — | — | |
| 380 | | REP | | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .42 | 6 BENCH | 1 | 1.0 | .42 | |

# OPERATION FILE

NAME J. CARTER ALC _____ DATE _____ RCC _____ SHEET 4 OF ____

PCN
NSN 34044A
PRI _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 390 | MAT PCA | ASS'Y | | TRANSIT | — | — | — | — | — | — | — | — | — | — | COMBINED WITH OP 440 PER ACT FAB. METHOD. |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | 3.0 | BENCH | 1 | 1.0 | 3.0 | |
| 460 | | TEST | 1:0 | TRANSIT | — | — | | — | — | — | — | — | — | — | TEST BENCH |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .15 | # OC3953 | 1 | 1.0 | .15 | |
| 520 | | BAKE | | TRANSIT | — | — | | | — | — | | — | — | — | EPOXY FILL & OVEN BAKE |
| | | | | SETUP | — | — | | | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | 3.0 | | 1 | 1.0 | .1 | # OC0363 | | 1.0 | .75 | |
| 525 | | ASS'Y. | | TRANSIT | — | — | | | | | | | | | NOTE : CASE IS SOLDER-SEALED AT THIS OPER. |
| | | | | SETUP | — | — | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .30 | SOLDER BENCH 39 | 1 | 1.0 | .3 | |
| 530 | | TEST | | TRANSIT | — | — | | 1 | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .10 | # OC3952 | 1 | 1.0 | .10 | |

# OPERATION FILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 5 OF ___

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NSN
PRI _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
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| 540 | MAT PCA | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | .5 | BY 10 | 1 | 1.0 | .10 | PE OC-3953 | 1 | 1.0 | .5 | |
| 560 | | PROC | 1.00 | TRANSIT | 1.0 | .20 | | | — | — | | | — | — | PAINT BOOTH - RELOCATE FOR LOGISTICS |
| | | | | SETUP | — | — | | — | 1.0 | .2 | | | — | — | |
| | | | | PROCESS | 1.0 | 4.0 | | 1 | 1.0 | .3 | — | | 1.0 | .75 | NO NUMBER PAINT BOOTH |
| 570 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .15 | OC 4929 | 1 | 1.0 | .15 | ELEC TEST BENCH |
| 650 | | PROC | | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | 6 BENCH | 1 | 1.0 | .05 | INSTALL SAFETY WIRE |
| 670 | MAT PCA | PH | 1.00 | TRANSIT | — | — | | | | | | — | — | — | |
| | | | | SETUP | — | — | | | | | | — | — | — | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .1 | 6 BENCH | 1 | 1.0 | .1 | |
| 9999 | ) | OUT Date | 1.0 | Process | 1.0 | 28.0 | | | | | | | | | |

LSC-2(XX)2C

# OPERATION PROFILE

NAME J. CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 6 OF 6

PCN 34044A NSN [redacted] PN

WCD CAECO4 ✓ WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
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| 580 | MAT PCA | PH | 1.0 | TRANSIT | — | — | BY | — | — | — | — | — | — | — | |
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| 9999 | | OUT Date | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 8.0 | | | | | | | | | |
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| | | | | PROCESS | | | | | | | | | | | |

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NSH

PN 30

| OPERATION NUMBER |
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| 040 |
| 045 |
| 050 |
| 310 |
| 320 |

#3044A

FLOW PROCESS CHART

SUBJECT IGNITION EXCITER DATE 5-2-89

ITEM CODE
PCN ☑
MAN. ☐
P/N ☐

WCD CAEC04 WCD DATE 89045

CHART BEGINS OPER # 010

CHART ENDS OPR # 680 PREPARED BY CARTER

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ●◇D□▽ | REC | | | ○◇D□▽ | |
| 015 | 015 | ●◇D□▽ | VERIFY | | | ○◇D□▽ | |
| 020 | 020 | ●◇D□▽ | DISASSEMBLE | | | ○◇D□▽ | |
| 030 | 030 | ●◇D□▽ | CLEAN | | | ○◇D□▽ | |
| 040 | 040 | ●◇D□▽ | VIS INSP. | | | ○◇D□▽ | |
| 050 | 050 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| 060 | 060 | ●◇D□▽ | | | | ○◇D□▽ | |
| 070 | 070 | ●◇D□▽ | | | | ○◇D□▽ | |
| 080 | 080 | ●◇D□▽ | | | | ○◇D□▽ | |
| 090 | 090 | ●◇D□▽ | | | | ○◇D□▽ | |
| 100 | 100 | ●◇D□▽ | | | | ○◇D□▽ | |
| 110 | 110 | ●◇D□▽ | | | | ○◇D□▽ | |
| 120 | 120 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| 380 | 380 | ●◇D□▽ | REPAIR | | | ○◇D□▽ | |
| 390 | 390 | ○◇D□▽<br>●◇D□▽ | RE ASSEMBLE & TORQUE | | | ○◇D□▽<br>○◇D□▽ | |
| | 440 | ○◇D□▽ | COMBINE | | | ○◇D□▽ | |
| 460 | 460 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| 520 | 520 | ●◇D□▽ | POT & BAKE | | | ○◇D□▽ | |
| 525 | 525 | ●◇D□▽ | SOLDER SEAL | | | ○◇D□▽ | |
| 530 | 530 | ●◇D□▽ | LEAK TEST | | | ○◇D□▽ | |
| 540 | 540 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| 560 | 560 | ●◇D□▽ | PAINT | | | ○◇D□▽ | |
| 570 | 570 | ●◇D□▽ | FINAL TEST | | | ○◇D□▽ | |
| 650 | 650 | ●◇D□▽ | SAF WIRE | | | ○◇D□▽ | |
| 660 | 660 | ●◇D□▽ | CERT | | | ○◇D□▽ | |
| 670 | 670 | ●◇D□▽ | COMPLY | | | ○◇D□▽ | |
| 680 | 680 | ●◇D□▽ | COMPLY | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# PROBE ASS'Y OPERATION FILE

NAME J. CARTER ALC OC DATE 5-5-89 RCC MAT PCA SHEET 1 OF 4

NSN 34128A WCD CAEY08 ✓ WCD DATE 88307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 32.0 | | | | | | | | | |
| 010 | MAT PCA | PW | 1.0 | TRANSIT | — | — | BY 09 | — | — | — | | — | — | — | BATCH LOTS OF 6 EA. |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 28 BENCH | 1 | 1.0 | .10 | |
| 015 | | PW | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 28 BENCH | 1 | 1.0 | .10 | |
| 017 | | PROC | 1.0 | TRANSIT | [redacted] | — | BY 09 | 1 | 1.0 | .50 | — | — | — | — | HEAT TREAT |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | 1.0 | 24 | — | — | — | — | — | — | — | — | |
| 020 | MAT PCA | DISASS | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .05 | 28 BENCH | 1 | 1.0 | .05 | |

LSC-20092C

# OPERATION FILE

NAME J. CARTER ALC OC DATE 5/5/89 RCC MATPCA SHEET 2 OF 2

PCN NSN PN 34128A WCD CAEY08 WCD DATE 88 307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 030 | MAT PCA | CLEAN | 1.0 | TRANSIT | 1.0 | .50 | | — | — | — | | — | — | — | HEAT TREAT |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | 24 | | — | — | — | | — | — | — | |
| 035 | | CLEAN | 1.0 | TRANSIT | — | — | BY 07 | — | — | — | | — | — | — | ADDED SAND BLAST |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | BEN 28 | 1 | 1.0 | .05 | |
| 040 | | PROC | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | INSPECT STRAIGHTEN |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | BY 09 | 1 | 1.0 | .10 | BEN 28 | 1 | 1.0 | 1.0 | |
| 045 | MT PIT | INSP | 1.0 | TRANSIT | 1.0 | .25 | | — | — | — | | — | — | — | FPI INSP. NOTE: 3 TO 7 WKS |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1 | 504 | | — | — | — | | — | — | — | |
| 050 | MT PIT | MOVE | 1.0 | TRANSIT | 1 | .25 | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | — | — | — | | — | — | — | |

# OPERATI[illegible] FILE

NAME J Carter ALC OC DATE 5/5/89 RCC MATPCA SHEET 3 OF 4

PCN MSN PMI 34128A WCD CAEY08 WCD DATE 88307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 060 | MAT PCA | REPAIR | 1.0 | TRANSIT | — | — | AY09 | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .20 | 28 BENCH | 1 — | 1.0 — | .20 | |
| 070 | | RE ASS | 1.0 | TRANSIT | 1.0 | .2 | | — | — | — | | — | — | — | NOTE: OVEN BAKE AT U-43 |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | 1.0 | | 1 | 1.0 | .10 | 28 BENCH | 1 — | 1.0 — | .1 — | |
| 080 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 28 BENCH | 1 — | 1.0 — | .1 — | |
| 090 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 28 BENCH | 1 — | 1.0 — | .10 — | |
| 100 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | NOTE: NO NUMBER ON "JET CAL" TEST STAND |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN31 | 1 — | 1.0 — | .5 — | |

LSC-2(X)92C

# OPERATI[illegible]OFILE

NAME J. Carter ALC OC DATE 5/5/89 RCC MAT PCA SHEET 4 OF 4

PCN HSN PN 34128 A WCD CAEY08 WCD DATE 88307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 110 | MAT PCA | PROC | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1 | .05 | 28 BENCH | 1 | 1.0 | .05 | SAFETY WIRE |
| 120 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | 28 BENCH | 1 | 1.0 | .10 | |
| 125 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | 28 BENCH | 1 | 1.0 | .1 | |
| 130 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | 28 BENCH | 1 | .10 | .10 | |
| 145 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | 28 BENCH | 1 | 1.0 | .10 | |
| 9999 | | OUT Rate | 1.0 | | .05 | 24.0 | | | | | | | | | |

LSC-2(X)92C

# FLOW PROCESS CHART

SUBJECT PCN 34128A PROBE ASS'Y. DATE 5-5-82

ITEM CODE PCN ● 34128A NSN. ☐ P/N ☐ WCD CAEY08 WCD DATE 88307

CHART BEGINS OP 010

CHART ENDS OP 130 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ●▷D□▽ | REC | | | ○▷D□▽ | |
| 015 | 015 | ●▷D□▽ | PWI | | | ○▷D□▽ | |
| 017 | | ●▷D□▽ | HEAT TRCAT | | | ○▷D□▽ | |
| 020 | 020 | ●▷D□▽ | DISASSEMBLE | | | ○▷D□▽ | |
| 030 | 030 | ●▷D□▽ | CLEAN | | | ○▷D□▽ | |
| 035 | | ●▷D□▽ | SANDBLAST | | | ○▷D□▽ | |
| 040 | 040 | ●▷D□▽ | STRAIGHTEN | | | ○▷D□▽ | |
| 045 | 045 | ●▷D■▽ | FPI | | | ○▷D□▽ | |
| 050 | 050 | ○▷D□▽ | MOVE | | | ○▷D□▽ | |
| 060 | 060 | ●▷D□▽ | REPAIR | | | ○▷D□▽ | |
| 070 | 070 | ●▷D□▽ | REASSEMBLE | | | ○▷D□▽ | |
| 080 | 020 | ●▷D□▽ | TEST | | | ○▷D□▽ | |
| 090 | 090 | ●▷D□▽ | TEST | | | ○▷D□▽ | |
| 100 | 100 | ●▷D□▽ | TEST | | | ○▷D□▽ | |
| 110 | 110 | ○▷D□▽<br>●▷D□▽ | SAFETY WIRE | | | ○▷D□▽<br>○▷D□▽ | |
| 120 | 120 | ●▷D□▽ | PH | | | ○▷D□▽ | |
| 125 | 125 | ●▷D□▽ | PU | | | ○▷D□▽ | |
| 130 | 130 | ●▷D□▽ | PW | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
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| | | ○▷D□▽ | | | | ○▷D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Chip Carrier ALC [illegible] DATE 5-23-89 RCC MAT PCH SHEET 1 OF 4

PCN
NSN
PN 34252A WCD CHPC02 WCD DATE 89010

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 20.0 | | | | | | | | | |
| 010 | MAT PCH | INSP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY09 | 1 | 1.0 — | .25 | BEN 3 | 1 | 1.0 | .25 | SKILL 9-10 |
| 050 | | DES | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY09 | 1 | — | .25 | BEN 3 | 1 | 1.0 | .25 | SKILL 9-10 |
| 060 | | CLN | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY09 | 1 | — | .08 | BEN 3 | 1 | 1.0 | .08 | SKILL 9-10 |
| 070 | | INSP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY09 | 1 | — | .08 | BEN 3 | 1 | 1.0 | .08 | SKILL 9-10 |

# OPERATION PROFILE

NAME GM Guardian ALC [illegible] DATE 5-22-89 RCC MATPCH SHEET 2 OF 4

PCN
HSN 34352A
PN WCD CMP002 WCD DATE 89 PC

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 100 | MAT PCH | Lub | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .02 | GEN 3 | 1 | 1.0 | .02 | SKILL 9-10 |
| 110 | | ASSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | 1.0 | GEN 3 | 1 | 1.0 | 1.0 | SKILL 9-10 |
| 115 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | Manual - Hydraulic, Testing |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .20 | AC 3908 | 1 | 1.0 | .20 | SKILL 9-10 |
| 120 | | OVHL | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | 1.0 | GEN 3 | 1 | 1.0 | 1.0 | SKILL 9-10 |
| 121 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .33 | GEN 3 | 1 | 1.0 | .33 | SKILL 9-10 |

# OPERATION PROFILE

NAME BM Gun Assy ALC NC DATE 5-22-89 RCC MAT PCA SHEET 3 OF 4

PCN
HSH
PN 240529 WCD CMPCA3 WCD DATE 89010

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 122 | MAT PCA | PROC | 1.0 | TRANSIT | | | | | | | | | | | BAKE 1.0 HR. + COLD .25 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 1.25 | BY09 | 1 | - | .03 | NC.1076 | 1 | 1.0 | 1.0 | SKILL 9-10 |
| 123 | | ENGR | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY09 | 1 | - | .25 | BEN 3 | 1 | 1.0 | .25 | SKILL 9-10 |
| 124 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | FINAL-TEST |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY09 | 1 | - | .20 | BEN 3 | 1 | 1.0 | .20 | SKILL 9-10 |
| 170 | | PW | 1.0 | TRANSIT | | | | | | | | | | | COMPLETE W/ PAPERWORK. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY09 | 1 | - | .02 | BEN 3 | 1 | 1.0 | .02 | SKILL 9-10 |
| 171 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | SAND-BLAST |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY04 | 1 | - | .25 | BEN 3 | 1 | 1.0 | .25 | SKILL 9-10 |

# OPERATION PROFILE

NAME [illegible] ALC [illegible] DATE 5-22-89 RCC MHTPCH SHEET 4 OF 4

PCH
NSN
PN [illegible] WCD [illegible] WCD DATE 89010

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MHT | | | TRANSIT | | | | | | | | | | | |
| 172 | PCH | PAINT | 1.0 | SETUP | | | | | | | | | | | Claim Hour Pivot. |
| | 2 | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | W59 | 1 | 1.0 | .3 | SKILL 5-10 |
| | | | | TRANSIT | | | | | | | | | | | |
| 180 | | PW | 1.0 | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | B409 | 1 | — | .08 | — | — | — | — | SKILL 5-10 |
| | | | | TRANSIT | | | | | | | | | | | |
| 9999 | | OUT | 1.0 | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 8.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5-24-89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

WCD CHAC02 WCD DATE 89010

CHART BEGINS 010 - RMR, Tray

CHART ENDS 160 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ⓞ▷D□▽ | REC | | | ○▷D□▽ | |
| 050 | 050 | ⓞ▷D□▽ | [illegible] | | | ○▷D□▽ | |
| 060 | 060 | ⓞ▷D□▽ | CLN | | | ○▷D□▽ | |
| 070 | 070 | ○▷D[I]▽ | INSP | | | ○▷D□▽ | |
| 100 | 100 | ⓞ▷D□▽ | Hub | | | ○▷D□▽ | |
| 110 | 110 | ○▷D□▽ | [illegible] | | | ○▷D□▽ | |
| 115 | 115 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 120 | 120 | ⓞ▷D□▽ | OVHL | | | ○▷D□▽ | |
| 121 | — | ○▷D□▽ | Shaft | | | ○▷D□▽ | |
| 122 | — | ⓞ▷D□▽ | [illegible] | | | ○▷D□▽ | |
| 130 | — | ○▷D[I]▽ | INSP | | | ○▷D□▽ | |
| 140 | — | ⓞ▷D□▽ | TEST | | | ○▷D□▽ | |
| 170 | 170 | ⓞ▷D□▽ | PWI | | | ○▷D□▽ | |
| 171 | — | ○▷D□▽ | [illegible] | | | ○▷D□▽ | |
| 172 | — | ⓞ▷D□▽ | PRINT | | | ○▷D□▽ | |
| 180 | — | ⓞ▷D□▽ | PWI | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
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ⓞ OPERATION ▽ STORAGE ☐ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME GM Guidance ALC [illegible] DATE 5-17-89 RCC MATPCA SHEET 1 OF 4

ECH
NSN
PN 342 53 [illegible] WCD CMZC24 WCD DATE 89010

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 32.0 | | | | | | | | | |
| 010 | MAT RCA | R-T | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .25 | BEN3 | 1 | 1.0 | .25 | SK:11 9-10 |
| 020 | | DIS | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .25 | BEN3 | 1 | 1.0 | .25 | SK:11 9-10 |
| 030 | | CLN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .08 | BEN3 | 1 | 1.0 | .08 | SK:11 9-10 |
| 040 | | INSP. | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY09 | 1 | — | .08 | BEN3 | 1 | 1.0 | .08 | SK:11 9-10 |

# OPERATION PROFILE

NAME GM Guidry ALC OC DATE 5/17/89 RCC MAT PCA SHEET 2 OF 4

PCN
NSN
PN 3H2537A WCD CAA C 211 WCD DATE 89 210

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 050 | MAT PCA | Lub | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ryog | 1 | — | .02 | BEN3 | 1 | 1.0 | .02 | SK:11 9-10 |
| 060 | " | Assy | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ryog | 1 | — | 1.0 | BEN3 | 1 | 1.0 | 1.0 | SK:11 9-10 |
| 070 | " | Test | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ryog | 1 | — | .20 | OC3908 | 1 | 1.0 | .20 | SK:11 9-10 |
| 080 | " | RFA | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ryog | 1 | — | 1.7 | BEN3 | 1 | 1.0 | 1.7 | SK:11 9-10 |
| 081 | " | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ryog | 1 | — | .33 | BEN3 | 1 | 1.0 | .33 | SK:11 9-10 |

# OPERATION PROFILE

NAME GM Guidry ALC OC DATE 5-17-84 RCC MATRCH SHEET 3 OF 11

PCN NSN PRI WCD CH12C211 WCD DATE 89010

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 082 | MAT PCH | PROC | 1.0 | TRANSIT | | | | | | | | | | | Brake 1.0 Hr. Cold .05 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 1.25 | B1/09 | 1 | — | .03 | OC1076 | 1 | 1.0 | 1.0 | Skill 9-10 |
| 083 | | INSP | 1.0 | TRANSIT | | | | | | | | | | | Leak-Check |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | B1/09 | 1 | — | .25 | BEN3 | 1 | 1.0 | 25 | Skill 9-10 |
| 811 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | Final Test |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | B1/09 | 1 | — | .20 | BEN3 | 1 | 1.0 | .20 | Skill 9-10 |
| 090 | | PW | 1.0 | TRANSIT | | | | | | | | | | | Complete Paperwork |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | B1/09 | 1 | — | .02 | BEN3 | 1 | 1.0 | .02 | Skill 9-10 |
| 091 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | Sand-Blast |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | B1/07 | 1 | — | .25 | BEN3 | 1 | 1.0 | .25 | Skill 7-10 |

# OPERATION .OFILE

NAME GM Gwinny ALC OC DATE 5-17-89 RCC MATPCA SHEET 11 OF 11

PCH
NSN
PRI 34253R WCD CMPC211 WCD DATE 89010

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 092 | MAT PCA | PRINT | 1.0 | TRANSIT | | | | | | | | | | | CLEAN-UP & PRINT. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | WS9 | 1 | 1.0 | .30 | SKILL 9-10 |
| 100 | MAT PCA | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | PW09 | 1 | — | .05 | — | — | — | — | SKILL 9-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/17/88

ITEM CODE
PCN [X] 342534
NON. [ ]
P/N [ ]

WCD CAAC24 WCD DATE CAAC24

CHART BEGINS 010

CHART ENDS 100 PREPARED BY Bill Rutherford

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ●◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | 020 | ●◇D□▽ | DIS | | | ○◇D□▽ | |
| 030 | 030 | ●◇D□▽ | CLN | | | ○◇D□▽ | |
| 040 | 040 | ○◇D■▽ | INSP | | | ○◇D□▽ | |
| 050 | 050 | ●◇D□▽ | Lub. | | | ○◇D□▽ | |
| 060 | 060 | ●◇D□▽ | ASSY | | | ○◇D□▽ | |
| 070 | 070 | ○◇D■▽ | TEST | | | ○◇D□▽ | |
| 080 | 080 | ●◇D□▽ | overhaul | | | ○◇D□▽ | |
| 081 | - | ●◇D□▽ | Seal | | | ○◇D□▽ | |
| 082 | - | ●◇D□▽ | BAKE | | | ○◇D□▽ | |
| 083 | - | ○◇D■▽ | INSP | | | ○◇D□▽ | |
| 084 | - | ○◇D■▽ | TEST | | | ○◇D□▽ | |
| 090 | 090 | ●◇D□▽ | PW | | | ○◇D□▽ | |
| 091 | - | ●◇D□▽ | Weight | | | ○◇D□▽ | |
| 092 | - | ●◇D□▽ | PAINT | | | ○◇D□▽ | |
| 100 | 100 | ●◇D□▽ | PW | | | ○◇D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/85 NCC MATPCA SHEET ___ OF ___

(PCN) NSN PN 34551A WCD CAE204 ✓ WCD DATE 58161

| OPERATION NUMBER | NCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 84.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note - This sheet for IN [redacted] DATES

# OPERATION PROFILE

NAME PARKER ALC OC DATE 5/12/89 RCC MATRCA SHEET 1 OF 3

PCN NSN PN 34551A WCD CAE204 WCD DATE 8816

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT RA | REC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .17 | - | - | - | - | SR:11 9-10 |
| 015 | | INFO | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 020 | | DIS | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1 | 1.0 | | 1 | 1.0 | .5 | BEN4 | 1 | 1.0 | .5 | SR:11 9-10 |
| 030 | | CLN | 1.0 | TRANSIT | | | | | | | | | | | From Trail |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1 | 1.0 | | 1 | 1.0 | .5 | BEN 32 | 1 | 1.0 | .5 | SR:11 9-10 |
| 040 | | INSP | 1.0 | TRANSIT | | | | | | | | | | | Visual - damaged cables or input pins |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1 | 1.0 | | 1 | 1.0 | .17 | BEN 4 | 1 | 1.0 | .17 | SR:11 9-10 |

LSC-2000026

# OPERATION PROFILE

NAME Riker ALC OS DATE 5/15/89 RCC MAT PCA SHEET 2 OF 3

PCII/ISN 345514 WCD CAEZ04 WCD DATE 8886.1

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 065 | MAT PCA | TEST | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .33 | BEN 4 | 1 | 1.0 | .33 | SK:11 5-10 |
| 090 | | ASSY | 1.0 | [illegible] | | | | | | | | | | | K.I. items (replace) |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN 4 | 1 | 1.0 | .25 | SK:11 5-10 |
| 110 | | ASSY | 1.0 | [illegible] | | | | | | | | | | | reassy. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN 4 | 1 | 1.0 | .50 | SK:11 5-10 |
| 155 | | TEST | 1.0 | [illegible] | | | | | | | | | | | sent to 310 & they do test w. their personnel |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 12.0 | — | — | — | — | — | — | — | — | |
| 178 | | TEST | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .33 | BEN 4 | 1 | 1.0 | .33 | SK:N 5-10 |

LSC-[illegible]

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/15/89 RCC MATRA SHEET 3 OF 3

PCN NSN PN 34551A WCD CAE204 WCD DATE 8861

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 239 | MAT RCA | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .08 | - | - | - | - | SKILL 8-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
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| | | | | PROCESS | | | | | | | | | | | |
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| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/19/89

ITEM CODE
PCN X 34551A
NSN. □
P/N □

WCD CAEZ04 WCD DATE 89055

CHART BEGINS 010

CHART ENDS 239 PREPARED BY MP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC. | | | ○◇D□▽ | |
| 015 | 015 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | DIS. | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | CLN. | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 065 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 090 | 090 | ○◇D□▽ | ASSY. | | | ○◇D□▽ | |
| 110 | 110 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 155 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 178 | 178 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 239 | - | ○◇D□▽ | PW | | | ○◇D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATIOI OFILE

NAME J. CARTER ALC OC DATE 5-4-89 RCC MAT PCA SHEET 1 OF 6

NSN P/N 350234 WCD CAEY10 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.0 | TRANSIT | — | — | AY 10 | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .10 | ? BENCH | 1 — | 1.0 — | .10 | |
| 015 | MAT PCA | P W | 1.0 | TRANSIT | | | | — | — | — | | — | — | — | |
| | | | | SETUP | | | | — | — | — | | — | — | — | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | ? BENCH | 1 — | 1.0 — | .10 — | |
| 020 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 030 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 6

PCN
NSN
P/N _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 080 | MAT MCH | PROC | 1.0 | TRANSIT | — | — | | — | — | — | | — | | | |
| | | | | SETUP | — | — | | — | — | — | | — | | | |
| | | | | PROCESS | 1.0 | 24 | | — | — | — | | — | | | |
| 085 | MAT PCA | DISASS | 1.0 | TRANSIT | — | — | | — | — | — | | — | | | |
| | | | | SETUP | — | — | | — | — | — | | — | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BENCH? | 1 | 1.0 | .75 | |
| 090 | MAT PCA | CLEAN | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | + | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BENCH? | 1 | 1.0 | .75 | |
| 100 | | INSPECT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .05 | BENCH? | 1 | 1.0 | .05 | |

# OPERATION PROFILE

NAME J. CARTER ALC _____ DATE _____ RCC _____ SHEET 3 OF 6

PCN
NSN
P/N _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 110 | MAT PIW | WLD | 1.0 | TRANSIT | | | AY 10 | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24 | | | | | | | | | |
| 130 | MAT PCA | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .05 | OC 3953 | 1 | 1.0 | .05 | |
| 140 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .05 | OC 6523 | 1 | 1.0 | .05 | |
| 150 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .05 | OC 6523 | 1 | 1.0 | .05 | |
| 160 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1.0 | 1.0 | .05 | OC 3953 | 1 | 1.0 | .05 | |

# OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 6

PCN
NSN
P/N _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 170 | MAT PCA | TEST | 1.0 | TRANSIT | — | — | AY-10 | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | ? BENCH | 1 | 1.0 | .05 | |
| 180 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | ? BENCH | 1 | 1.0 | .05 | |
| 190 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | COMBINE OP 190, 200 & 210 |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .01 | QC 3952 | 1 | 1.0 | .01 | |
| 220 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | QC 3952 | 1 | 1.0 | .05 | |
| 230 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | QC 3906 | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME J. CARTER ALC _____ DATE _____ RCC _____ SHEET 5 OF 6

PCN
NSN
P/N _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 240 | MAT PCA | TEST | 01 | TRANSIT | — | — | | — | — | — | | — | — | — | COMBINED OP 240, 250, 260, & 270 |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 3906 | 1 | 1.0 | .10 | |
| 280 | | TEST | 01 | TRANSIT | — | — | | — | — | - | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | OC 6523 | 1 | 1.0 | .05 | |
| 290 | | TEST | 01 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | OC 3953 | 1 | 1.0 | .05 | |
| 300 | | REPAIR | 01 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | ? BENCH | 1 | 1.0 | .50 | |
| 310 | | REASS | 01 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | ? BENCH | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME J. CARTER ALC _____ DATE _____ RCC _____ SHEET 6 OF 6

PCN
NSN
P/N _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 320 | MAT PCA | TEST | 1.0 | TRANSIT | — | — | AY 10 | — | — | — | | — | — | — | COMBINE OP 220 & 230 |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 7 BENCH | 1 | 1.0 | .10 | |
| 340 | MT PIW | WELD | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | 24 | | — | — | — | | — | — | — | |
| 350 | MT PIW | WELD | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | 24.0 | | — | — | — | | — | — | — | |
| 360 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | COMBINE OP 360 & 380 |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | 7 BENCH | 1 | 1.0 | .10 | |
| 390 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 9999 | | OUT | 1.0 | PROCESS | 1.0 | 48.0 | | | | | | | | | |

LSC-20092C

# FLOW PROCESS CHART

SUBJECT 35023A DATE 5-4-89

ITEM CODE
PCN ☐
NSN. ☐
P/N ☐

WCD CAEY10 WCD DATE 89094

CHART BEGINS OP 010

CHART ENDS OP 390 PREPARED BY J. CARTER

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | |
|---|---|---|---|---|---|---|---|---|
| 010 | 010 | ●◇D□▽ | REC | 320 | 320 | ●◇D□▽ | TEST | * |
| 015 | 015 | ●◇D□▽ | VERIFY | | 330 | ●◇D□▽ | | * |
| 020 | 020 | ●◇D□▽ | TEST | 340 | 340 | ●◆D□▽ | | |
| 030 | 030 | ●◇D□▽ | TEST | | 350 | ●◆D□▽ | | |
| | 040 | ●◇D□▽ | | 360 | 360 | ●◇D□▽ | TEST | * |
| | 050 | ●◇D□▽ | | | 380 | ●◇D□▽ | | * |
| | 060 | ●◇D□▽ | TEST | 390 | 390 | ●◇D□▽ | TEST | |
| 070 | 070 | ●◇D□▽ | DISASS | | 400 | ●◇D□▽ | | * |
| 080 | 080 | ●◆D□▽ | MACHINE | | 410 | ●◇D□▽ | | |
| 090 | 090 | ●◇D□▽ | CLEAN | 420 | 420 | ●◇D□▽ | PW | |
| 100 | 100 | ●◇D□▽ | INSP | 460 | 460 | ●◇D□▽ | PW | |
| 110 | 110 | ●◆D□▽ | WELD | 470 | 470 | ●◇D□▽ | PW | |
| 130 | 130 | ●◇D□▽ | TEST | 475 | 475 | ●◇D□▽ | PW | |
| 140 | 140 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 150 | 150 | ●◇D□▽<br>●◇D□▽ | TEST | | | ○◇D□▽<br>○◇D□▽ | | |
| 160 | 160 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 180 | 180 | ○◇D□▽ | TEST | | | ○◇D□▽ | | |
| 190 | 190 | ●◇D□▽ | TEST | | | ○◇D□▽ | | * |
| | 200 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| | 210 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 220 | 220 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 230 | 230 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 240 | 240 | ●◇D□▽ | TEST | | | ○◇D□▽ | | * |
| | 250 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| | 260 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| | 270 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 280 | 280 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 290 | 290 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |
| 300 | 300 | ●◇D□▽ | REPAIR | | | ○◇D□▽ | | |
| 310 | 310 | ●◇D□▽ | REASSEMB | | | ○◇D□▽ | | |
| 320 | 320 | ●◇D□▽ | TEST | | | ○◇D□▽ | | |

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

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/23/01 RCC MAT PCA SHEET ___ OF ___

PCN
NSN
PN 35033A WCD CAEY11 ✓ WCD DATE 58307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 19.2 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note: This sheet for IN - OUT DATES

LSC-2(XX)2(

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/22/89 RCC MAT PCA SHEET 1 OF 2

PCN / NSN / PMI 35033A WCD CAEY11 WCD DATE 58307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | PROCESS | — | — | BY10 | 1 | 1.0 | .02 | | — | — | — | SK:11 S-10 |
| 015 | | INFO | 1.0 | PROCESS | | | | | | | | | | | SK:11 S-10 |
| 020 | | DIS | 1.0 | PROCESS | — | — | | 1 | 1.0 | .50 | BEN19 | 1 | 1.0 | .50 | Remove cover. SK:11 S-10 |
| 030 | | CLN | 1.0 | PROCESS | — | — | | 1 | 1.0 | .25 | BEN19 | 1 | 1.0 | .50 | Topical SK:11 S-10 |
| 040 | | INSP | 1.0 | PROCESS | — | — | | 1 | 1.0 | .08 | BEN19 | 1 | 1.0 | .08 | For cracked terminal boards, etc. (Visual) SK:11 S-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/23/89 RCC MAT PCA SHEET 2 OF 2

PCN
NSN
PRI 35033 A WCD CAEY II WCD DATE 88302

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 050 | MAT PCA | TEST | 1.0 | [redacted] | | | | | | | | | | | multimeter req (208 fa.1) |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .05 | Ben 19 | 1 | 1.0 | .05 | SA:11 5-10 |
| 070 | | REP | .20 | [redacted] | | | | | | | | | | | replace terminal board, includes soldering ISE replacement) |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | 1.0 | BEN 19 | 1 | 1.0 | 1.0 | SA:11 5-10 |
| 075 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | functional test |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .10 | BEN 19 | 1 | 1.0 | .10 | SA:4 5-10 |
| 080 | | ASSY | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .07 | BEN 19 | | | | SA:4 5-10 |
| 115 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .05 | – | – | – | – | SA:11 9-10 |
| 9999 | | OUT | 1.0 | | | 0 | | | | | | | | | |

LSC-2XXXXC

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/23/88

ITEM CODE
PCN ☐
MSN. ☐☐
P/N ☐

WCD CAEY11 WCD DATE 87093

CHART BEGINS 010

CHART ENDS 115 PREPARED BY CP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○▷D□▽ | REC | | | ○▷D□▽ | |
| 015 | 015 | ○▷D□▽ | INFO | | | ○▷D□▽ | |
| 020 | 020 | ○▷D□▽ | DIS | | | ○▷D□▽ | |
| 030 | 030 | ○▷D□▽ | GLN. | | | ○▷D□▽ | |
| 040 | 040 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 050 | 050 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 070 | 070 | ○▷D□▽ | REPAIR | | | ○▷D□▽ | |
| 080 | 080 | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 115 | — | ○▷D□▽ | PW | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽<br>○▷D□▽ | | | | ○▷D□▽<br>○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
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| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME GM Gun Assy ALC GC DATE 5-22-89 RCC MPTPCP SHEET 1 OF 6

PCN/NSN/PNI 3511M2-GA WCD CMEZ08 WCD DATE 88227

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY10 | 1 | 1.0 | .17 | GEN 1 | 1 | 1.0 | .17 | Skill-9 |
| 015 | / | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY10 | 1 | " | .25 | GEN 1 | 1 | 1.0 | .25 | |
| 020 | / | DIS | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY10 | 1 | " | .33 | GEN 1 | 1 | 1.0 | .33 | Skill-9 |
| 030 | / | CLN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | HY10 | 1 | " | .33 | GEN 1 | 1 | 1.0 | .33 | Skill-9 |

# OPERATION FILE

NAME GM Grinding ALC QC DATE 5-22-89 RCC MATPCP SHEET 2 OF 6

RCD
NSN
PN 35111B WCD CHEZ C8 WCD DATE 88224

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C40 | MAT PCP | INSP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY10 | 1 | — | .25 | BEN 1 | 1 | 1.0 | .25 | SKILL 9-10 |
| C5C | | INSP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 060 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 070 | | REP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY10 | 1 | — | .25 | BEN 1 | 1 | 1.0 | .25 | SKILL 9-10 |
| 130 | | Lub | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | RY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .25 | SKILL 9-10 |

# OPERATION PROFILE

NAME GNG. Assy ALC QC DATE 5-22-89 NCC MATPCB SHEET 3 OF 6

ECN
IISN
PRI 35111B WCD CA57.00 WCD DATE 88227

| OPERATION NUMBER | NCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 110 | MAT PCB | ASSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | PY10 | 1 | — | .50 | BEN 1 | 1 | 1.0 | .50 | SKILL 9-10 |
| 150 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | PY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 160 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | PY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 170 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | PY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 180 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | PY10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |

# OPERATION PROFILE

NAME GM Guidry ALC QC DATE 5-22-89 RCC MAT PCP SHEET 4 OF 6

PCN
HSH
PRI 3511R WCD CRUZ08 WCD DATE 88227

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 190 | MAT PCP | PSSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | — | .25 | BEN1 | 1 | 1.0 | .25 | SKILL 9-10 |
| 200 | | PSSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | — | .17 | BEN1 | 1 | 1.0 | .17 | SKILL 9-10 |
| 210 | | PSSY | 1.0 | TRANSIT | | | | | | | | | | | THIS OPERATION SHOULD BE MPSH # 180. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | — | .08 | BEN1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 220 | | PSSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | — | .25 | BEN1 | 1 | 1.0 | .25 | SKILL 9-10 |
| 240 | | PSSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | — | .08 | BEN1 | 1 | 1.0 | .08 | SKILL 9-10 |

# OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 5 OF 6

PCN
NSN
PN _____ WCD _____ WCD DATE _____

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 310 | MNT PCM | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | 12/10 | 1 | — | .03 | BEN 1 | 1 | 1.0 | .03 | SK I 11 9-10 |
| 320 | | REP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | 12/10 | 1 | — | .02 | BEN 1 | 1 | 1.0 | .02 | SK II 9-10 |
| 330 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | 12/10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SK II 9-10 |
| 340 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | 12/10 | 1 | — | .10 | BEN 1 | 1 | 1.0 | .10 | SK II 9-10 |
| 350 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | 12/10 | 1 | — | .17 | BEN 1 | 1 | 1.0 | .17 | SK II 9-10 |

# OPERATION PROFILE

NAME BM Bulkley ALC OC DATE 5-22-89 RCC MNT PCH SHEET 6 OF 6

PCH
NSH
PRI U.S. WCD CHEZ08 WCD DATE 85227

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 360 | MNT PCH | ASSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | P4/10 | 1 | — | .25 | BEN 1 | 1 | 1.0 | .25 | SKILL 9-10 |
| 370 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | P4/10 | 1 | — | .02 | BEN 1 | 1 | 1.0 | .02 | SKILL 9-10 |
| 380 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | P4/10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL 9-10 |
| 390 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | P4/10 | 1 | — | .02 | BEN 1 | 1 | 1.0 | .02 | SKILL 9-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 33.6 | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE _____

ITEM CODE
PCN ☐ 351119
NSN ☐
P/N ☐

WCD CAE202 WCD DATE 88227

CHART BEGINS 010 - BM Bushey

CHART ENDS 390 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ⓞ▷D□▽ | Kan. | | | ○▷D□▽ | |
| 015 | 015 | ⓞ▷D□▽ | Pack | | | ○▷D□▽ | |
| 020 | 020 | ⓞ▷D□▽ | [illegible] | | | ○▷D□▽ | |
| 030 | 030 | ○▷D□▽ | [illegible] | | | ○▷D□▽ | |
| 040 | 040 | ○▷D▣▽ | Test | | | ○▷D□▽ | |
| 050 | 050 | ○▷D□▽ | Ok | | | ○▷D□▽ | |
| 060 | 060 | ○▷D□▽ | Label | | | ○▷D□▽ | |
| 070 | 070 | ⓞ▷D□▽ | Bag | | | ○▷D□▽ | |
| 080 | 080 | ○▷D□▽ | Lab | | | ○▷D□▽ | |
| 090 | 090 | ⓞ▷D□▽ | Key | | | ○▷D□▽ | |
| 100 | 100 | ⓞ▷D□▽ | Pick. | | | ○▷D□▽ | |
| 110 | 110 | ⓞ▷D□▽ | Place | | | ○▷D□▽ | |
| 120 | 120 | ⓞ▷D□▽ | Place | | | ○▷D□▽ | |
| 130 | 130 | ⓞ▷D□▽ | Place | | | ○▷D□▽ | |
| 140 | 140 | ⓞ▷D□▽ | Pick. | | | ○▷D□▽ | |
| 150 | 150 | ⓞ▷D□▽ | Pack. | | | ○▷D□▽ | |
| 160 | 160 | ⓞ▷D□▽ | Pack | | | ○▷D□▽ | |
| 170 | 170 | ⓞ▷D□▽ | Pack | | | ○▷D□▽ | |
| 180 | 180 | ⓞ▷D□▽ | Pack. | | | ○▷D□▽ | |
| 190 | 190 | ⓞ▷D□▽ | Pack | | | ○▷D□▽ | |
| 200 | 200 | ⓞ▷D□▽ | Pack | | | ○▷D□▽ | |
| 210 | 210 | ⓞ▷D□▽ | Pack. | | | ○▷D□▽ | |
| 220 | 220 | ○▷D□▽ | Place | | | ○▷D□▽ | |
| 240 | 240 | ○▷D□▽ | Test | | | ○▷D□▽ | |
| 250 | 250 | ⓞ▷D□▽ | Test | | | ○▷D□▽ | |
| 260 | 260 | ⓞ▷D□▽ | Re-work | | | ○▷D□▽ | |
| 330 | 330 | ⓞ▷D□▽ | Test | | | ○▷D□▽ | |
| 340 | 340 | ⓞ▷D□▽ | Place | | | ○▷D□▽ | |
| 350 | 350 | ⓞ▷D□▽ | Place | | | ○▷D□▽ | |
| 360 | 360 | ⓞ▷D□▽ | Wave | | | ○▷D□▽ | |
| 370 | 370 | ⓞ▷D□▽ | Pick | | | ○▷D□▽ | |
| 380 | 380 | ○▷D□▽ | PWI | | | ○▷D□▽ | |
| 390 | 390 | ⓞ▷D□▽ | PWI | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |

ⓞ OPERATION ▽ STORAGE ▣ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME CM Gutierrez ALC QC DATE 5-22-89 RCC MATPCA SHEET 1 OF 11

PCN
NSN
PN 35113A WCD CAEZ02 WCD DATE 88202

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 36.0 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .25 | GEN 1 | 1 | 1.0 | .25 | SKILL-9-10 |
| 015 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | | .50 | GEN 1 | 1 | 1.0 | .50 | SKILL-9-10 |
| 020 | | DEB | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | | .50 | GEN 1 | 1 | 1.0 | .50 | SKILL-9-10 |
| 030 | | CLN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | | .08 | GEN 1 | 1 | 1.0 | .08 | SKILL-9-10 |

# OPERATION PROFILE

NAME CM Rivera ALC QC DATE 5-22-89 NCC MATPCB SHEET 2 OF 4

PCH
NSN
PN 3511 AP WCD CAEZ02 WCD DATE 88202

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | INSP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | AY10 | 1 | - | .17 | BEN 1 | 1 | 1.0 | .17 | SKILL - 9 |
| 050 | | REPL | 1.0 | TRANSIT | | | | | | | | | | | Mechanic, Qa Not have any time for Replacing, only for Replacing. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | AY10 | 1 | - | .50 | BEN 1 | 1 | 1.0 | .50 | |
| 051 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | Potting - Chassis |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | AY10 | 1 | - | .50 | QA 1 | 1 | 1.0 | .50 | SKILL - 9 |
| 060 | | ASSY | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | AY10 | 1 | - | .17 | BEN 1 | 1 | 1.0 | .17 | SKILL - 9 |
| 070 | | ASSY | 1.0 | TRANSIT | | | | | | | | | | | Connecting |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | AY10 | 1 | - | .02 | BEN 1 | 1 | 1.0 | .02 | SKILL - 9 |

# OPERATION PROFILE

NAME OM Guidance ALC CC DATE 5-20-84 RCC MATPCB SHEET 3 OF 4

PCID
HSH
PMI 35113R WCD CMEZ02 WCD DATE 88202

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MAT | | | TRANSIT | | | | | | | | | | | |
| 100 | PCA | ASSY | 1.0 | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | — | .02 | BEN 1 | 1 | 1.0 | .02 | SKILL-9 |
| | | | | TRANSIT | | | | | | | | | | | |
| 110 | | ASSY | 1.0 | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | — | .02 | BEN 1 | 1 | 1.0 | .02 | SKILL-9 |
| | | | | TRANSIT | | | | | | | | | | | |
| 120 | | TEST | 1.0 | SETUP | | | | | | | | | | | Cold Stamp-Test Machine. OR NC, DC Inc. N. Sorensen-Power Supplies |
| | | | | PROCESS | — | — | AY10 | 1 | — | .03 | BEN 1 | 1 | 1.0 | .03 | SKILL-9 |
| | | | | TRANSIT | | | | | | | | | | | |
| 130 | | SWT | 1.0 | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | — | .03 | BEN 1 | 1 | 1.0 | .08 | SKILL-9 |
| | | | | TRANSIT | | | | | | | | | | | |
| 140 | | TEST | 1.0 | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | — | .03 | BEN 1 | 1 | 1.0 | .03 | SKILL-9 |

# OPERATION PROFILE

NAME GM Cruiser ALC DC DATE 5-22-89 RCC MAT PCH SHEET 4 OF 4

PCH / HSH / PH 35113 R WCD CAEZ02 ✓ WCD DATE 88202

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1H1 | MAT PCH | PRINT | 1.0 | TRANSIT | | | | | | | | | | | CLEAN FOR PRINT. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | W59 | 1 | 1.0 | .30 | SKILL-9 |
| 150 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ry10 | 1 | — | .08 | BEN 1 | 1 | 1.0 | .08 | SKILL-9 |
| 160 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ry10 | 1 | — | .02 | BEN 1 | 1 | 1.0 | .02 | SKILL-9 |
| 170 | | PW | 1.0 | TRANSIT | | | | | | | | | | | Completed Inspection. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ry10 | 1 | — | .08 | BEN 1 | 1 | 1.3 | .08 | SKILL-9 |
| 175 | | REP | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | Ry10 | 1 | — | 3.50 | BEN 1 | 1 | 1.0 | 3.5 | SKILL-9 |
| 9999 | | OUT | 1.0 | TRANSIT | 1.0 | 19.2 | | | | | | | | | |

## FLOW PROCESS CHART

SUBJECT _____ DATE 88202

ITEM CODE
PCN ☒ 351134
NSN. ☐
P/N ☐

WCD CAE202 WCD DATE 89135

CHART BEGINS 010 —

CHART ENDS 175 PREPARED BY CMC...

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ●▷D□▽ | REC | | | ○▷D□▽ | |
| 015 | 015 | ●▷D□▽ | PROC | | | ○▷D□▽ | |
| 020 | 020 | ●▷D□▽ | DISC | | | ○▷D□▽ | |
| 030 | 030 | ●▷D□▽ | CLN | | | ○▷D□▽ | |
| 040 | 040 | ○▷D■▽ | INSP | | | ○▷D□▽ | |
| 050 | 050 | ●▷D□▽ | REPL | | | ○▷D□▽ | |
| 051 | — | ●▷D□▽ | POT | | | ○▷D□▽ | |
| 060 | 060 | ●▷D□▽ | ASSY | | | ○▷D□▽ | |
| 070 | 070 | ●▷D□▽ | CONNT | | | ○▷D□▽ | |
| 100 | 100 | ●▷D□▽ | CONNT | | | ○▷D□▽ | |
| 110 | 110 | ●▷D□▽ | CONNT | | | ○▷D□▽ | |
| 120 | 120 | ○▷D■▽ | TEST | | | ○▷D□▽ | |
| 130 | 130 | ●▷D□▽ | SET | | | ○▷D□▽ | |
| 140 | 140 | ●▷D□▽ | SET | | | ○▷D□▽ | |
| 141 | — | ●▷D□▽ | PRINT | | | ○▷D□▽ | |
| 150 | 150 | ●▷D□▽ | PROC | | | ○▷D□▽ | |
| 160 | 160 | ●▷D□▽ | PROC | | | ○▷D□▽ | |
| 170 | 170 | ●▷D□▽ | PW | | | ○▷D□▽ | |
| 175 | 175 | ●▷D□▽ | REP | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
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| | | ○▷D□▽ | | | | ○▷D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Ricker ALC OC DATE 5/9/89 RCC MAT PCA SHEET — OF —

PCN/NSN/P/N 35510 A WCD CAEV 12 ✓ WCD DATE 88037

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 36.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE: THIS SHEET FOR IN-OUT DATES

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/9/89 RCC MAT PCA SHEET 1 OF 8

PCB NSN PIN 35510 A.. WCD CAEY12 ✓ WCD DATE 88037

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .08 | - | | | - | SK# 7-10 |
| 015 | | INFO | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | SK.# 7-10 |
| 017 | | TEST | 1.0 | TRANSIT | - | - | | 1 | 1.0 | .25 | - | | - | - | 7-10 ... d input ... of delay ... of 10 ...ol unit |
| | | | | SETUP | - | - | | 1 | 1.0 | .50 | - | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .17 | OC 1944 | 1 | 1.0 | .67 | |
| 018 | | TEST | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | - | - | | 1 | 1.0 | .08 | - | | - | - | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .17 | 3906 | 1 | 1.0 | .25 | SK.# 5-3 |
| 019 | | TEST | 1.0 | [redacted] | | | | | | | | | | | spark gap tester |
| | | | | SETUP | - | - | | 1 | 1.0 | .08 | - | - | - | - | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .17 | 4060 | 1 | 1.0 | .25 | SK.# 7-10 |

LSC-20092C

# OPERATIO. .ROFILE

NAME PARKER ALC [redacted] DATE 05/9/[redacted] RCC MAT PCA SHEET 2 OF 8

PCN NSN P/N 35510 A.. WCD CAEY12 ✓ WCD DATE 8803 J

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 020 | MAT PCM | MACH | .50 | [redacted] | | | | | | | | | | | one machine computed for [illegible] work. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 10 | 24.0 | – | | | | – | | | | SK: 7-13 |
| 030 | MAT PCA | DIS | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | CY10 | 1 | 1.0 | .67 | BEN 4 | 1 | 1.0 | .67 | SK: 11 9-13 |
| 040 | MAT PIW | WELD | .08 | [redacted] | | | | | | | | | | | per unit, |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | – | – | | – | – | |
| 050 | MAT PCA | CLN | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | | | CY10 | 1 | 1.0 | .33 | BEN 4 | 1 | 1.0 | .33 | SK: 7-13 |
| 060 | | INSP | .50 | [redacted] | | | | | | | | | | | visual insp. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .17 | BEN 4 | 1 | 1.0 | .17 | SK: 11 9 |

# OPERATION PROFILE

NAME Baker ALC [illegible] DATE 05/[illegible] RCC MAT PCA SHEET [illegible] OF 8

PCN
NSN
PIN 35510 A WCD CAEY12 WCD DATE 58097

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 070 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | BX10 | 1 | 1.0 | .17 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN15 | 1 | 1.0 | .67 | SK:11 9-10 |
| 080 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .05 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | OC 4060 | 1 | 1.0 | .07 | SK 9-10 |
| 090 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | | | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | | | 1 | 1.0 | .03 | OC 3906 | 1 | 1.0 | .05 | SK 9-10 |
| 100 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | | | 1 | | .03 | | | | | |
| | | | | PROCESS | | | | 1 | | .02 | OC 3906 | 1 | 1.0 | .05 | SK:11 9-10 |
| 110 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | | .05 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | OC 4060 | 1 | 1.0 | .07 | SK:11 9-10 |

LSC-2000-2C

# OPERATION PROFILE

NAME Parker ALC OC DATE [redacted] RCC [redacted] SHEET 1 OF 8

PCN
NSN
P/N 35510A WCD CAEY12 WCD DATE 8 3

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 120 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | .02 | SK:11 5-10 |
| 130 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | .02 | SK:11 5-10 |
| 140 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 0 | .02 | BEN4 | 1 | 1.0 | .02 | SK:11 5-10 |
| 150 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | .02 | SK:11 5-10 |
| 160 | | TEST | .5 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | .02 | SK:11 5-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/01/89 RCC MAT PCA SHEET 5 OF 8

PCN RSN PN 35870A WCD CAEY12 WCD DATE 8B03

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 170 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | | BY10 | 1 | | .02 | BEN4 | 1 | 1.0 | .02 | SK:11 S-10 |
| 180 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | – | | 1 | 1.0 | .03 | – | – | – | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .07 | 4060 | 1 | 1.0 | .10 | SK:11 S-10 |
| 190 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | – | | 1 | 1.0 | .03 | – | – | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .07 | 4060 | 1 | 1.0 | .10 | SK:11 S-10 |
| 200 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | BEN4 | 1 | 1.0 | .03 | SK:11 S-10 |
| 210 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | BEN4 | 1 | 1.0 | .03 | SK:1 S-10 |

LSC-2(X)92C

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/09/89 RCC MAT PCA SHEET 5 OF 8

PCN NSN 35510A WCD SAEY17 WCD DATE 8803R

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 220 | MAT RCA | TEST | .50 | [redacted] | | | | | | | | | | | SK. 11 9-10 |
| | | | | SETUP | — | — | BY10 | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 4060 | 1 | 1.0 | .05 | |
| 230 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN4 | | 1.0 | .03 | SK. 11 9-10 |
| 240 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 3906 | 1 | 1.0 | .05 | SK. 11 9-10 |
| 245 | | PROC | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .33 | BEN 4 | 1 | 1.0 | .33 | SK. 11 9-10 |
| 250 | | ASSY | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .67 | BEN 4 | 1 | 1.0 | .67 | SK. 11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/09/85 RCC MAT PCA SHEET 7 OF 8

PCN
NSN 35510A
P/N

WCD CAEY12 ✓ WCD DATE 8[illegible]037

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 255 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | | CY10 | 1 | 1.0 | .03 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .05 | OC 3906 | 1 | 1.0 | .08 | SK.11 9-10 |
| 260 | MAT PTW | WELD | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | – | – | – | | – | | | – | SK.11 9-10 |
| 290 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | (280,290 [illegible]) |
| | | | | [redacted] | | | | | | | | | | | SK. 9-10 |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .12 | BEN4 | | | .12 | CO2 (11y) c 6 |
| 300 | | INSP | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | BEN17 | 1 | 1.0 | .03 | SK.11 9-10 |
| 310 | | TEST | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | – | – | | 1 | 1.0 | .03 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .05 | OC 4060 | 1 | 1.0 | .08 | SK.11 9-10 |

# OPERATION PROFILE

NAME Rocket ALC OC DATE 05/9/89 RCC MATPCA SHEET 8 OF 8

PCN NSN PIN 35510 A WCD CAE12 WCD DATE 88037

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 320 | MAT RA | TEST | 50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | BY10 | 1 | 1.0 | .03 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | CX 3906 | 1 | 1.0 | .08 | SKILL 8-10 |
| 330 | | PW | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | — | — | — | — | SK.11 8-10 |
| 350 | | PW | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | SK. 8-10 |
| 360 | | PW | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | SK. 11 8-10 |
| 3 | | PW | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | SK. 8-10 |
| 9999 | | OUT | 1.0 | PROCESS | 10 | 28.8 | | | | | | | | | |

LSC-20092C

# FLOW PROCESS CHART

SUBJECT _____ DATE 05/09/89

ITEM CODE PCN [X] 35510A NSN. [ ] P/N [ ]

WCD CAEV12 WCD DATE 88087

CHART BEGINS 010

CHART ENDS 365 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○▷D□▽ | REC. | 290 | 290 | ○▷D□▽ | TEST |
| 015 | 015 | ○▷D□▽ | INFO | 300 | 300 | ○▷D□▽ | INSP |
| 017 | - | ○▷D□▽ | TEST | 310 | 310 | ○▷D□▽ | TEST |
| 018 | - | ○▷D□▽ | TEST | 320 | 320 | ○▷D□▽ | TEST |
| 019 | - | ○▷D□▽ | TEST | 330 | 330 | ○▷D□▽ | PW |
| 020 | 020 | ○▷D□▽ | MACH | 350 | 350 | ○▷D□▽ | PW |
| 030 | 030 | ○▷D□▽ | DIS | 360 | 360 | ○▷D□▽ | PW |
| 040 | 040 | ○▷D□▽ | WELD | 365 | 365 | ○▷D□▽ | PW |
| 050 | 050 | ○▷D□▽ | CIN | | | ○▷D□▽ | |
| 060 | 060 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 070 | 070 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 080 | 080 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 090 | 090 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 100 | 100 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 110 | 110 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 120 | 120 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 130 | 130 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 140 | 140 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 150 | 150 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 160 | 160 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 170 | 170 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 180 | 180 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 190 | 190 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 200 | 200 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 210 | 210 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 220 | 220 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 230 | 230 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 240 | 240 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 245 | 245 | ○▷D□▽ | AROC | | | ○▷D□▽ | |
| 250 | 250 | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 255 | - | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 260 | 260 | ○▷D□▽ | WELD | | | ○▷D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

5.3 ALO

# OPERATION PROFILE

29 12/1-1K

NAME J. CARTER ALC OK CA DATE 5-4-89 RCC MAT PCA SHEET 1 OF 3

PCN/RSN PIN 37719 A WCD CAA001 WCD DATE 86291

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 32.0 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | AY10 | 1.0 | 1.0 | .1 | — | — | — | — | |
| 020 | | DIS | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .5 | BEN 7 | 1 | 1.0 | .5 | |
| 030 | | CLEAN | 1.0 | TRANSIT | | | | — | — | — | | | | | |
| | | | | SETUP | | | | — | — | — | | | | | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .5 | BEN 7 | 1 | 1.0 | .50 | |
| 040 | | INSP | 1.0 | TRANSIT | | | | — | — | — | | | | | 180 DAY CAL. 10% TO MCI SHOP (COMUTAT[illegible]) |
| | | | | SETUP | | | | — | — | — | | | | | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | 2.0 | BEN 7 | 1 | 1.0 | 20 | |

# OPERATION PROFILE

NAME Carter ALC 0C DATE 5/4/89 RCC MATPCA SHEET 2 OF 3

NSN PN 3221SA WCD CAA0Ø1 WCD DATE 86291

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 050 | MAT PCA | REP. | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | - | |
| | | | | SETUP | — | — | | — | — | — | | — | — | - | |
| | | | | PROCESS | — | — | AY10 | 1 | 1.0 | .75 | BEN 7 | 1 | 1.0 | .75 | |
| 060 | | ASSY | 1.0 | TRANSIT | | | | | | | | | | | ARBOR PRESS |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | 1.3 | BEN 7 | 1 | 1.0 | 1.3 | |
| 070 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 3.0 | | 1 | 1.0 | .75 | BEN 7 | 1 | 1.0 | .75 | (4) TEST STANDS MULTI GAGE |
| 080 | | PH | 1.0 | TRANSIT | — | — | | | | | | | | | |
| | | | | SETUP | — | — | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BEN 7 | 1 | 1.0 | .75 | |
| 090 | | PH | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | BEN 7 | 1 | 1.0 | .20 | |

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/4/82 RCC MAT ACA SHEET 3 OF 3

PCN NSN PN 37715A WCD CARO81 WCD DATE 86291

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 160 | MAT ACA | PH | 1.0 | [redacted] | — | — | | | | | | | | | |
| | | | | [redacted] | — | — | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | 1.0 | .10 | — | — | — | — | |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 20.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/4/88

ITEM CODE
PCN [X] 377194
NON. [ ]
P/N [ ]

WCD CAA001 WCD DATE 86251

CHART BEGINS 010

CHART ENDS 100 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○▷D□▽ | REC | | | ○▷D□▽ | |
| 020 | 020 | ○▷D□▽ | DIS | | | ○▷D□▽ | |
| 030 | 030 | ○▷D□▽ | CLN. | | | ○▷D□▽ | |
| 040 | 040 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 050 | 050 | ○▷D□▽ | REP. | | | ○▷D□▽ | |
| 060 | 060 | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 070 | 070 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 080 | 080 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 090 | 090 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 100 | 100 | ○▷D□▽ | PW | | | ○▷D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET — OF —

PCN/NSN/PNI 38643A WCD CAEM04 ✓ WCD DATE 88259

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 36.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
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| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note : This sheet for IN - OUT DATES

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATPCA SHEET 1 OF 5

PCN
NSN 3864 3A
PN

WCD CAEM04 WCD DATE 8[illegible]89

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT RCA | REC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | – | – | AY 10 | 1 | 1.0 | .02 | – | – | – | – | SKILL 5-10 |
| 020 | | INFO | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | SKILL 5-10 |
| 030 | | INSP | 1.0 | [redacted] | | | | | | | | | | | Visual |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | | | .03 | BEN 19 | 1 | 1.0 | .03 | SKILL 5-10 |
| 035 | | INSP | 1.0 | [redacted] | | | | | | | | | | | Flow bench work done in old 3108 by MATPCA tech. |
| | | | | SETUP | – | – | | 1 | 1.0 | .17 | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .12 | OC 1135 | 1 | 1.0 | .29 | SKILL 5-10 |
| 040 | | TEST | 1.0 | [redacted] | | | | | | | | | | | Minimum time of 20 min for machine. Visual at |
| | | | | SETUP | | | | 1 | 1.0 | .07 | – | – | – | – | |
| | | | | PROCESS | 1.0 | .33 | | 1 | 1.0 | 1.0 | OC 4285 | 1 | 1.0 | 1.40 | SKILL 5-10 |

wall-co wyle

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATPCA SHEET 2 OF 5

PCN NSN PN 38643A WCD CAEM04 WCD DATE 8[illegible]89

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 045 | MAT PCA | TEST | 1.0 | [illegible] | | | | | | | | | | | M.T test 45 min [illegible] |
| | | | | SETUP | — | — | — | 1 | 1.0 | .03 | — | — | — | — | (note: combined ATE, several steps) |
| | | | | PROCESS | 1.0 | .25 | AY10 | 1 | 1.0 | 1.0 | OC 4285 | 1 | 1.0 | 1.78 | SK-11 9-10 |
| 120 | | INFO | 1.0 | [illegible] | | | | | | | | | | | 80% pass all tests, routed to inventory |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| 130 | | DIS | .20 | [illegible] | | | | | | | | | | | includes removal of potting compound. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BEN 19 | 1 | 1.0 | .75 | |
| 140 | | CLN | .20 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .33 | BEN 19 | 1 | 1.0 | .33 | |
| 150 | | INSP | .20 | [illegible] | | | | | | | | | | | Visual |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN 19 | 1 | 1.0 | .17 | |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/88 RCC MAT RCA SHEET 3 OF 5

ECN
NSN
P/N 38643A WCD CAEM04 WCD DATE 58284

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 151 | MAT RCA | REP | .15 | [redacted] | | | | | | | | | | | 75% of all failures involve M3 module & require its removal and replacement |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | AV10 | 1 | 1.0 | .50 | BEN19 | 1 | 1.0 | .50 | |
| 152 | | REP | .04 | [redacted] | | | | | | | | | | | Both the M4 and M1 modules fail 10% of the time and require removal & replacement |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.0 | BEN19 | 1 | 1.0 | 1.0 | SKILL 5-10 |
| 153 | | REP | .01 | [redacted] | | | | | | | | | | | The M5 module fails approx. 5% of the time and requires replacement. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 2.0 | BEN19 | 1 | 1.0 | 2.0 | SKILL 5-10 |
| 160 | | INSP | .20 | [redacted] | | | | | | | | | | | inspect potentiometer |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN19 | 1 | 1.0 | .08 | SKILL 5-10 |
| 170 | | ASSY | .20 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BEN19 | 1 | 1.0 | .75 | SKILL 5-10 |

(Note: All failures will at ambient temperatures)

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 4 OF 5

PCN
NSN
P/N 38643A

WCD CAEM04 WCD DATE 88289

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 185 | MAT PCA | ASSY | .20 | [illegible] | | | | | | | | | | | several steps including drying time. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 1.0 | AV 10 | 1 | 1.0 | .67 | OC # 4285 | 1 | 1.0 | 1.67 | SK. 11 7-10 |
| 270 | | TEST | .20 | [illegible] | | | | | | | | | | | several steps involved. "Hot" test |
| | | | | SETUP | — | — | | 1 | 1.0 | .03 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.0 | OC # 4285 | 1 | 1.0 | 1.03 | SK. 11 5-10 |
| 340 | | TEST | .20 | [illegible] | | | | | | | | | | | short cert |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN 19 | 1 | 1.0 | .17 | SK. 11 5-10 |
| 350 | | TEST | 1.0 | [illegible] | | | | | | | | | | | mechanical pressure test |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN 19 | 1 | 1.0 | .17 | SK. 11 5-10 |
| 360 | | TEST | 1.0 | [illegible] | | | | | | | | | | | vibration test |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN 19 | 1 | 1.0 | .50 | SK. 11 5-10 |

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/88 RCC MATPCA SHEET 5 OF 5

PCN
NSN
P/N 38643A WCD CAEM04 WCD DATE 88299

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 399 | MAT ACA | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | AY 10 | 1 | 1.0 | .22 | – | – | – | – | SK: 11 810 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/16/89

ITEM CODE PCN [X] 38643A NSN. [ ] P/N [ ]

WCD CAEM04 WCD DATE 89094

CHART BEGINS 010

CHART ENDS 399 PREPARED BY MP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 035 | 035 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 120 | 120 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 130 | 130 | ○◇D□▽ | OIS | | | ○◇D□▽ | |
| 140 | 140 | ○◇D□▽ | CLN | | | ○◇D□▽ | |
| 150 | 150 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 151 | - | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 152 | - | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 153 | - | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 160 | 160 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 170 | 170 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 185 | - | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 220 | 220 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 340 | 340 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 350 | 350 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 360 | 360 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 399 | - | ○◇D□▽ | PW | | | ○◇D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/16/89

ITEM CODE PCN NSN. P/N

WCD CAE401 WCD DATE 86128

CHART BEGINS 010

CHART ENDS 547 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○⇨D□▽ | REC | | | ○⇨D□▽ | |
| 015 | 015 | ○⇨D□▽ | INFO | | | ○⇨D□▽ | |
| 017 | – | ○⇨D□▽ | Sandblast | | | ○⇨D□▽ | |
| 018 | – | ○⇨D□▽ | TEST | | | ○⇨D□▽ | |
| 020 | 020 | ○⇨D□▽ | REP. | | | ○⇨D□▽ | |
| 021 | – | ○⇨D□▽ | TEST | | | ○⇨D□▽ | |
| 022 | – | ○⇨D□▽ | REP | | | ○⇨D□▽ | |
| 023 | – | ○⇨D□▽ | REP | | | ○⇨D□▽ | |
| 024 | – | ○⇨D□▽ | REP | | | ○⇨D□▽ | |
| 025 | – | ○⇨D□▽ | REP | | | ○⇨D□▽ | |
| 040 | 040 | ○⇨D□▽ | INSP | | | ○⇨D□▽ | |
| 085 | – | ○⇨D□▽ | TEST | | | ○⇨D□▽ | |
| 360 | 360 | ○⇨D□▽ | ASSY | | | ○⇨D□▽ | |
| 405 | – | ○⇨D□▽ | INSP | | | ○⇨D□▽ | |
| 435 | – | ○⇨D□▽ | AROC | | | ○⇨D□▽ | |
| 460 | 460 | ○⇨D□▽ | TEST | | | ○⇨D□▽ | |
| 470 | 470 | ○⇨D□▽ | TEST | | | ○⇨D□▽ | |
| 490 | 490 | ○⇨D□▽ | TEST | | | ○⇨D□▽ | |
| 455 | 459 | ○⇨D□▽ | PAINT | | | ○⇨D□▽ | |
| 547 | 547 | ○⇨D□▽ | PW | | | ○⇨D□▽ | |
| | | ○⇨D□▽ | | | | ○⇨D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION

⇨ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC QC DATE 5/19/89 RCC MAT PCA SHEET 1 OF 4

PCN RSN PN 50292A WCD CAEM22 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .02 | BEN4 | 1 | 1.0 | | SK.11 9-10 |
| 020 | | INFO | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| 030 | | INSP | 1.0 | TRANSIT | | | | | | | | | | | SK.11 9-10 |
| | | | | SETUP | | | | | | | | | | | Visual insp. for d[illegible], scratches depth, insul., mounts |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | BEN4 | 1 | 1.0 | .03 | CK.11 9-10 |
| 035 | | TEST | 1.0 | [redacted] | | | | | | | | | | | 5% Fa.1) |
| | | | | SETUP | – | – | | 1 | 1.0 | .07 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .07 | QC 3906 | 1 | 1.0 | .14 | SK.11 9-10 |
| 040 | MAT PCM | MACH | .05 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | – | – | – | – | | – | | – | |

4.5

LSC-2XXXXX

# OPERATION PROFILE

NAME Parker ALC 2C DATE 5/19/89 RCC MAT RCA SHEET — OF —

PCN
NSN
PN 50297A WCD CAE M22 ✓ WCD DATE 88 239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 19.2 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note: This sheet For IN-OUT Data's

LSC-2000[illegible]

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MAT PCA SHEET 1 OF 4

ECN
NSN 38645A
PIN
WCD CAEM08 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 28.0 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | 1.0 | .02 | — | — | — | — | SKILL 5-10 |
| 020 | | INFO | 1.0 | [illegible] | | | | | | | | | | | Applicable TO |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| 030 | | INSP | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN 20 | 1 | 1.0 | .03 | SKILL 5-10 |
| 040 | | TEST | 1.0 | [illegible] | | | | | | | | | | | Flow tube test performed in 310F by MAT PCA technician (Note: appr SS, ful. see pn 217) |
| | | | | SETUP | — | — | | 1 | 1.0 | .17 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .12 | OC 1135 | 1 | 1.0 | .29 | SKILL 5-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MATRCA SHEET 2 OF 4

ECN
NSN
PIN 38645A WCD CAEM08 ✓ WCD DATE 890504

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 050 | MAT RCA | TEST | 1.0 | TRANSMIT | | | | | | | | | | | megger used several steps. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | – | – | AY 10 | 1 | 1.0 | 1.0 | BEN 20 | 1 | 1.0 | 1.0 | SKILL 5-10 |
| 059 | | TEST | 1.0 | TRANSMIT | | | | | | | | | | | Ambient test, warm-up time for machine required. several steps |
| | | | | SETUP | – | – | | 1 | 1.0 | .07 | – | – | – | – | |
| | | | | PROCESS | 1.0 | 1.0 | | 1 | 1.0 | 1.0 | OC # 4286 | 1 | 1.0 | 2.07 | SKILL 5-10 |
| 205 | | TEST | 1.0 | TRANSMIT | | | | | | | | | | | adjustment of temperature required, 1 to flow rate. (cold test) - must fail at this temp- |
| | | | | SETUP | – | – | | 1 | 1.0 | .03 | – | – | – | – | |
| | | | | PROCESS | 1.0 | 1.0 | | 1 | 1.0 | 1.0 | OC # 4286 | 1 | 1.0 | 2.03 | SKILL 5-10 |
| 215 | | TEST | 1.0 | TRANSMIT | | | | | | | | | | | (Hot test) |
| | | | | SETUP | – | – | | 1 | 1.0 | .03 | – | – | ± | – | |
| | | | | PROCESS | 1.0 | 1.0 | | 1 | 1.0 | 1.0 | OC # 4286 | 1 | 1.0 | 2.03 | SKILL 5-10 |
| 216 | | INFO | 1.0 | TRANSMIT | | | | | | | | | | | Note - 60% pass all tests and are routed to inventory. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note: A module failure at any point in the testing

LSC-2(XX)2C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MATPCA SHEET 3 OF 4

PCN/NSN/PIN 38645 A WCD CAEM08 WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 217 | MAT PCA | REP | .02 | TRANSIT | | | | | | | | | | | 5% of all failed items require repair or replacement of fueling tube, grommets, connectors, etc. Found upon visual inspection. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY 10 | 1 | 1.0 | 1.0 | BEN 20 | 1 | 1.0 | 2.0 | |
| 218 | | TEST | .38 | TRANSIT | | | | | | | | | | | -All other failures than above involve modules (95%). This is a troubleshooting test, use oscilloscope, multimeter, etc. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.0 | BEN 20 | 1 | 1.0 | 1.0 | |
| 221 | | REP | .10 | TRANSIT | | | | | | | | | | | Replacement of module A1 (25% failure) |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 2.0 | BEN 20 | 1 | 1.0 | 2.0 | Time includes testing |
| 222 | | REP | .08 | TRANSIT | | | | | | | | | | | Replacement of Module A2 (20% failure) |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 2.5 | BEN 20 | 1 | 1.0 | 2.5 | Time includes testing |
| 223 | | REP | .11 | TRANSIT | | | | | | | | | | | Replacement of module A3 (30% failure rate) |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 9.0 | BEN 20 | 1 | 1.0 | 9.0 | Note: this is a select F.I. part. (See note) |

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MAT RCA SHEET 4 OF 4

PCN NSN PN 38645A1 WCD CAEMO8 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 224 | MAT RCA | REP | .08 | [redacted] | | | | | | | | | | | Replacement of # 4 module, includes test time. (20% failure) SR.# 5-10 |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | AV10 | 1 | 1.0 | 3.0 | BEN 20 | 1 | 1.0 | 3.0 | |
| 225 | | REP | .02 | [redacted] | | | | | | | | | | | Replacement of module # 5, including test time (5% failure) SR.# 5-10 |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 3.0 | BEN 20 | 1 | 1.0 | 3.0 | |
| 310 | | ASSY | .40 | [redacted] | | | | | | | | | | | Final assy., including RTV and oven time, plus 1.0 hr cooling time SR.# 5-10 |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.17 | | 1 | 1.0 | 1.25 | OC 4286 | 1 | 1.0 | 1.17 | |
| 320 | | TEST | .40 | [redacted] | | | | | | | | | | | Final Testing, same as ops 059, 205, 215 combined. SR.# 5-10 |
| | | | | SETUP | | | | 1 | 1.0 | .13 | — | — | — | — | |
| | | | | PROCESS | 1.0 | 3.0 | | 1 | 1.0 | 3.0 | OC 4286 | 1 | 1.0 | 6.13 | |
| 330 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | — | — | — | — | |
| 9999 | | OUT | 1.0 | PROCESS | | 16.0 | | | | | | | | | |

LSC-20092C

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/10/89

ITEM CODE
PCN [X] 38645A
NSN. [ ]
P/N [ ]

WCD CAEM08 WCD DATE FS 0S4

CHART BEGINS 010

CHART ENDS _____ PREPARED BY MP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 050 | 050 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 055 | – | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 205 | – | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 215 | – | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 216 | – | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 217 | – | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 218 | – | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 221 | – | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 222 | – | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 223 | – | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 224 | – | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 225 | | ○◇D□▽ | REP | | | ○◇D□▽ | |
| 310 | 310 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 320 | 320 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 330 | 330 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/5/89 RCC MATRCA SH[redacted]

PCN
NSN 38669A
PNI

WCD CAEM03 ✓ WCD DATE 56239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

* Note: This sheet for in-out dates

LSC-2(X)92C

# OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 5[illegible]/89 RCC MAT PCA SHEET 1 OF 2

PCN
NSN
PN 38669A WCD CAEM03 WCD DATE 882389

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .03 | | | | | SR 9-10 |
| 020 | | INFO | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Reference T.O. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | ~~PROCESS~~ | | | | | | | | | | | |
| 025 | | INFO | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | MAOI 65-4 |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | ~~PROCESS~~ | | | | | | | | | | | |
| 027 | | CLN | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Add'l pers. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | BEN 2 | 1 | 1.0 | .17 | |
| 030 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN 2 | 1 | 1.0 | .03 | |

LSC-20092C

# OPERATION . . IOFILE

NAME Ricker, Phillip ALC OC DATE 5/5/98 RCC MAT PCA SHEET 2 OF 7

PCN
NSN
PN 36664A WCD CAEM03 WCD DATE 88299

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 035 | MAT PCA | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Continuously observed test, 3 parts. |
| | | | | SETUP | - | - | BY 10 | 1 | 1.0 | .10 | - | - | - | - | |
| | | | | PROCESS | - | - | BY 10 | 1 | 1.0 | .08 | OC 4929 | 1 | 1.0 | .07 | SK-11 9-13 |
| 040 | MAT PEM | MACH | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Sent to machine shop. Normally only one machine designated. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | - | - | - | - | - | - | - | - | SK-11 |
| 045 | MAT PCA | DIS | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | replace parts as needed |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY 10 | 1 | 1.0 | .15 | BEN 2 | 1 | 1.0 | .15 | SK-11 9-12 |
| 050 | MAT PCA | CLN | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | cleaning tank CT 1301 |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .07 | BEN 32 | 1 | 1.0 | .07 | |
| 055 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | ... cracker req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .12 | BEN 2 | 1 | 1.0 | .12 | SK-11 |

# OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 5/5/89 RCC MATPCA SHEET 3 OF 7

PCN RSN PIN 38669A WCD CAEM03 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 060 | MAT PCA | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | test stand: Tube assy. (TT 100) |
| | | | | SETUP | — | — | BY10 | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN 15 | 1 | 1.0 | .02 | SK. 11 7-10 |
| 065 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .17 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 3952 | 1 | 1.0 | .03 | SK 11 7-10 |
| 070 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Vale Illm valve assy |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN 2 | 1 | 1.0 | .08 | SK. 11 7-10 |
| 075 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .42 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | OC 3952 | 1 | 1.0 | .05 | SK 11 7-10 |
| 080 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Cycle the actuator w. 1 |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC 4060 | 1 | 1.0 | .08 | SK 11 9-10 |

# OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 5/5/89 RCC MATPCA SHEET 4 OF 7

NSN PIN 3866 9A WCD CAE M03 WCD DATE 88899

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 085 | MAT PCA | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | capacitor analyzer and MEGGAR (500 V) req. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .17 | OC4060 | 1 | 1.0 | .08 | SK. 1 9-10 |
| 090 | | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | As required, removed and replaced. |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN2 | 1 | 1.0 | .25 | SK |
| 095 | | ASSY | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .33 | BEN2 | 1 | 1.0 | .33 | SK 9-10 |
| 100 | | INFO | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | ~~PROCESS~~ | | | | | | | | | | | |
| 105 | | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | as applicable |
| | | | | SETUP | — | — | | 1 | 1.0 | .1 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC4929 | 1 | 1.0 | .07 | SK 9-10 |

# OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 5/5/89 RCC MAT PCA SHEET 5 OF 7

PCN NSN PIN 38669A WCD CAE M03 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 110 | MAT PIW | WEID | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 115 | MAT PCA | TEST | 1.0 | TRANSIT | | | | | | | | | | | press. $N_2$. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .10 | BEN | 1 | 10 | .10 | SK |
| 120 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | Placed in oven. |
| | | | | SETUP | — | — | | 1 | 1.0 | .05 | — | — | — | — | |
| | | | | PROCESS | 1.0 | 4.75 | | 1 | 1.0 | .10 | OC 2258 | 1 | 1.0 | 4.75 | SK |
| 123 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | water bath used. if bath below test temp., must be raised. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | .50 | .35 | WB 140 | 1 | .50 | .35 | K. |
| 125 | | PAINT | 1.0 | [redacted] | | | | | | | | | | | Parts [illegible] fully loaded in this shop. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .3 | W59 | 1 | 1.0 | .30 | two hour drying time. |

# OPERATION PROFILE

NAME PARKER, PHILIP ALC OC DATE 5/5/89 RCC MAT PCA SHEET 6 OF 7

RSN PIN 38669A WCD CAEM03 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 130 | MAT PCA | TEST | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | SETUP | — | — | BY10 | 1 | 1.0 | .10 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC4929 | 1 | 1.0 | .07 | SK/L 7-10 |
| 145 | | INSP | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | Insp for correct ID on system |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN2 | 1 | 1.0 | .08 | SK/L 7-10 |
| 150 | | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .17 | — | — | — | — | SK/L 7-10 |
| 155 | | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | SK/L 9-10 |
| 160 | | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | — | — | — | — | SK/L 9-10 |

# OPERATION PROFILE

NAME Parker, Alvin ALC OC DATE 5/5/89 RCC MAT PCA SHEET 2 OF 2

PCN MSN PIN 38669A WCD CAE M03 ✓ WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 165 | MAT PCA | PW | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY 10 | 1 | 1.0 | .08 | - | - | - | - | SKILL 9-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

## FLOW PROCESS CHART

SUBJECT _____ DATE 05/05/89

ITEM CODE PCN ☑ NSN ☐ P/N ☐ 38669A

WCD CAEM03 WCD DATE 89289

CHART BEGINS Opn # 010

CHART ENDS Opn # PREPARED BY RJP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 025 | 025 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 027 | | ○◇D□▽ | CLN | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 035 | 035 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | MACH | | | ○◇D□▽ | |
| 045 | 045 | ○◇D□▽ | DIS | | | ○◇D□▽ | |
| 050 | 050 | ○◇D□▽ | CLN | | | ○◇D□▽ | |
| 055 | 055 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 060 | 060 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 065 | 065 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 070 | 070 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 075 | 075 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 080 | 080 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 085 | 085 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 090 | 090 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 095 | 095 | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 100 | 100 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 105 | 105 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 110 | 110 | ○◇D□▽ | WELD | | | ○◇D□▽ | |
| 115 | 115 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 120 | 120 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 123 | 123 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 125 | 125 | ○◇D□▽ | PAINT | | | ○◇D□▽ | |
| 130 | 130 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 145 | 145 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 150 | 150 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 155 | 155 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 160 | 160 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 165 | 165 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-30147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 1 OF 3

PCN/NSN/PN 38694A WCD CAEM09 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| 010 | MAT RA | REC | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | AY10 | 1 | 1.0 | .12 | — | — | — | — | SK:11 9-10 |
| 020 | | INFO | 1.0 | [redacted] | | | | | | | | | | | Applicable Technical Order |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| 025 | | INSP | 1.0 | [redacted] | | | | | | | | | | | remove cover, Visual insp. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN4 | 1 | 1.0 | .25 | SK:11 9-10 |
| 040 | | ASSY | 1.0 | [redacted] | | | | | | | | | | | replace valve assy. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .25 | BEN4 | 1 | 1.0 | .25 | SK:11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 2 OF 3

PCN/NSN/PIN 38694A WCD CAEM09 ✓ WCD DATE 88289

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 045 | MAT PCA | DIS | .80 | [redacted] | | | | | | | | | | | 80% of all armitures are dished out and must be replaced. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | AY10 | 1 | 1.0 | .5 | BEN4 | 1 | 1.0 | .5 | SK:11 5-10 |
| 055 | MAT PIW | WELD | .80 | [redacted] | | | | | | | | | | | must be sent to welding if armiture removed. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 72.0 | – | – | – | – | – | – | – | – | |
| 065 | MAT PCA | ASSY | .80 | [redacted] | | | | | | | | | | | Rebuild armiture and related assy. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | AY10 | 1 | 1.0 | 1.0 | BEN4 | 1 | 1.0 | 1.0 | SK:11 5-10 |
| 075 | | TEST | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | – | | 1 | 1.0 | .07 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .25 | OC 6585 | 1 | 1.0 | .82 | SK:11 5-10 |
| 085 | | ASSY | 1.0 | [redacted] | | | | | | | | | | | reassemble solenoid assembly. This includes safety wiring. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .25 | BEN4 | 1 | 1.0 | .25 | SK:11 5-10 |

# OPERATION PROFILE

NAME Packer ALC OC DATE 5/19/89 RCC MATPCA SHEET 3 OF 3

NSN PIN 38694A WCD CAEM09 WCD DATE 89

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 095 | MAT PCA | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | AY10 | 1 | 1.0 | .25 | - | - | - | - | OP 11 5-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/19/89

ITEM CODE
PCN X 38694A
MSN. ☐
PN ☐

WCD CAFM09 WCD DATE 8/29/89

CHART BEGINS 010 —

CHART ENDS 095 PREPARED BY JP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○▷D□▽ | REC. | | | ○▷D□▽ | |
| 020 | 020 | ○▷D□▽ | INFO | | | ○▷D□▽ | |
| 025 | — | ○▷D□▽ | INSP. | | | ○▷D□▽ | |
| 040 | 040 | ○▷D□▽ | ASSY. | | | ○▷D□▽ | |
| 045 | — | ○▷D□▽ | DIS. | | | ○▷D□▽ | |
| 055 | — | ○▷D□▽ | WELD. | | | ○▷D□▽ | |
| 065 | — | ○▷D□▽ | ASSY. | | | ○▷D□▽ | |
| 075 | — | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 085 | — | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 095 | — | ○▷D□▽ | PW | | | ○▷D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME J Carter ALC OC DATE 5/3/89 NCC MAT RCA SHEET — OF —

PCII/NSN/PII 38718A WCD CAEM02 WCD DATE 88239

| OPERATION NUMBER | NCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
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| | | | | PROCESS | | | | | | | | | | | |

Note: This sheet for IN-OUT Dates

# OPERATION PROFILE

NAME CARTER ALC OC PCT DATE 5-3-87 RCC MAT PCA SHEET 1 OF 2

PCN/NSN/PIN 3871E4 WCD CAEM02 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC PIN | 1.00 | TRANSIT | — | — | B4 07 | — | — | .10 | — | | | | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | — | — | .10 | BENCH | 1 | 1.0 | .1 | |
| 020 | | PIN | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | — | — | .10 | BENCH | 1 | 1.0 | .10 | |
| 025 | | PIN | 1.00 | TRANSIT | — | — | | — | — | | | 1 | — | — | |
| | | | | SETUP | | | | | | | | — | — | — | |
| | | | | PROCESS | | | | | | .10 | BENCH | 1 | 1.0 | .10 | |
| 030 | | PROC | 1.00 | TRANSIT | — | — | | | | | | | | | MACHINE SHOP |
| | | | | SETUP | — | — | | | | | | | 1 | | |
| | | | | PROCESS | 1.0 | 24.0 | | — | — | — | — | — | — | — | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

LSC-2000/2C

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MATPCA SHEET 2 OF 2

PCN
NSN
PIN 38718A WCD CAEM02 ✓ WCD DATE 88235

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 035 | MAT PCA | CLEAN | 1.0 | TRANSIT | — | — | | | | | | | | | |
| | | | | SETUP | — | — | — | | | | | | | | |
| | | | | PROCESS | — | — | BH10 | 1 | 1.0 | .50 | BENCH | 1 | 1.0 | .50 | DEGREASE & SAND BLAST |
| 040 | | DIS | 1.0 | TRANSIT | — | — | | — | — | — | | | | | |
| | | | | SETUP | — | — | | — | — | — | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .3 | BENCH? | 1 | 1.0 | .30 | COMPONENT TEAR DOWN |
| 050 | | INSP | 1.0 | TRANSIT | | | | | | | | — | — | — | |
| | | | | SETUP | | | | | | | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | BENCH? | 1 | 1.0 | .10 | MICKES |
| 060 | MAT AM | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24 | — | — | — | — | — | — | — | — | MACHINE SHOP |
| 070 | MAT AM | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24 | — | — | — | — | — | — | — | — | HELD |

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MATPCA SHEET 3 OF 7

(CN) NSN PIN 38718A WCD CAEM02 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 090 | MAT PCM | PROC | 1.0 | TRANSIT | — | — | — | — | — | — | — | — | — | — | visual, disp. micrometer req. |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .10 | BENCH | 1 | 1.0 | .10 | |
| 100 | MAT PCA | TEST | 1.0 | TRANSIT | — | — | — | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | — | — | 1.0 | .10 | BENCH | 1 | 1.0 | .10 | |
| 110 | | TEST | 1.0 | TRANSIT | — | — | — | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | — | — | 1.0 | .05 | BENCH | 1 | 1.0 | .05 | |
| 120 | | PROC | 1.0 | TRANSIT | — | — | — | — | — | — | — | — | — | — | |
| | | | | SETUP | — | | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | — | 1 | 1.0 | .02 | BENCH | 1 | 1.0 | .02 | |
| 130 | | TORQUE | 1.0 | TRANSIT | — | — | — | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | — | 1 | 1.0 | .10 | BENCH | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT ACA SHEET 4 OF 7

PCN
NSN
P/N 38718A WCD CAEM02 WCD DATE 68239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 140 | MAT ACA | PROC | 1.0 | TRANSIT | — | — | | | — | — | | | | | |
| | | | | SETUP | — | — | | - | — | — | | | | | |
| | | | | PROCESS | - | - | AK10 | — | 1.0 | .10 | BENCH | 1 | 1.0 | .10 | ARBOR PRESS |
| 145 | MAT Acm | PROC | 1.0 | TRANSIT | — | — | | — | — | — | | - | - | - | |
| | | | | SETUP | — | — | | — | — | — | | — | - | - | MACHINE SHOP |
| | | | | PROCESS | 1.0 | 4.0 | — | — | — | - | - | - | — | — | |
| 150 | MAT PEW | PROC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | IN FLD SHOP |
| | | | | PROCESS | 1.0 | 2.0 | | | | | | | | | |
| 155 | MAT ACA | ASS | 1.0 | TRANSIT | — | | | — | — | — | | — | — | — | ADDED OPER |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | - | AK10 | 1 | 1.0 | 1.25 | BENCH | 1 — | 1.0 — | 1.25 — | |
| 160 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 3906 | 1 — | 1.0 — | .10 — | |

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MATRCA SHEET 5 OF 7

PCN / NSN / PIN 38718A WCD CAEM02 ✓ WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 170 | MAT RCA | TEST | 1.0 | TRANSIT | | | | | | | | | | | COMBINE WITH 160 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 180 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | ADD OP 175 .1 HR |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | WELD |
| 190 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .05 | | — | — | — | LEAK & |
| | | | | PROCESS | 1.0 | 4.75 | BX10 | 1 | 1.0 | .10 | OC 2756 | 1 | 1.0 | 4.75 | PURGE |
| 195 | | PROC | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .05 | BENZ | 1 | 1.0 | .05 | TORQUE |
| 200 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .1 | OC 3906 | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT PCA SHEET 6 OF 7

PCN/REN/PIN 38718A WCD CAEM02 ✓ WCD DATE 88234

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 210 | MAT PCA | TEST | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | SPARK GAP |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | TEST |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .05 | OC 4060 | — | — | — | NO # |
| 220 | | CLEAN | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1 | .05 | BENCH | 1 | 1.0 | .05 | |
| 230 | | PAINT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24 | — | — | — | — | — | — | — | — | IN 59 |
| 240 | | PROC | 1.0 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1 | .2 | BENCH | 1 | 1.0 | .20 | |
| 250 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1 | .05 | BENCH | 1 | 1.0 | .05 | |

# OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/85 RCC MAT PCA SHEET 1 OF 2

FCN
NSN
PIN 38718A WCD CAEM02 WCD DATE 88235

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 210 | MAT PCA | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .10 | BENCH | 1 | 1.0 | .10 | |
| 270 | | PW | 1.0 | TRANSIT | - | - | | | - | - | | - | - | - | |
| | | | | SETUP | - | - | | - | - | - | | - | - | - | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .05 | BENCH | 1 | 1.0 | .05 | |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 320 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

LSC-20092C

## FLOW PROCESS CHART

SUBJECT _____ DATE 5/3/88

ITEM CODE
PCN [X]
NSN. [ ] 38718A
P/N [ ]

WCD CAEM02 WCD DATE 88239

CHART BEGINS 010

CHART ENDS _____ PREPARED BY RC

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 025 | — | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 035 | — | ○◇D□▽ | CLN | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | LTC | | | ○◇D□▽ | |
| 050 | 050 | ○◇D□▽ | INSP | | | ○◇D□▽ | |
| 060 | 060 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 070 | 070 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 090 | 090 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 100 | 100 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 110 | 110 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 120 | 120 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 130 | 130 | ○◇D□▽ | TORQUE | | | ○◇D□▽ | |
| 140<br>145 | 140<br>145 | ○◇D□▽<br>○◇D□▽ | PROC<br>PROC | | | ○◇D□▽<br>○◇D□▽ | |
| 150 | 150 | ○◇D□▽ | Proc | | | ○◇D□▽ | |
| 155 | — | ○◇D□▽ | ASSY | | | ○◇D□▽ | |
| 160 | 160 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 170 | 170 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 180 | 180 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 190 | 190 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 195 | 195 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 200 | 200 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 210 | 210 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 220 | 220 | ○◇D□▽ | CLN | | | ○◇D□▽ | |
| 230 | 230 | ○◇D□▽ | PAINT | | | ○◇D□▽ | |
| 240 | 240 | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 250 | 250 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 260 | 260 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| 270 | 270 | ○◇D□▽ | PW | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Packer ALC OC DATE 5/E/89 RCC MAT PCA SHEET — OF —

PCN/MSN/PIN 49711A WCD CAECQ7 WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.0 | MAT PCA | IN | 1.0 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE: This sheet for IN-OUT DATES

LSC-2(X)92C

# OPERATION PROFILE

NAME Packer ALC OC DATE 5/8/89 RCC MAT PCA SHEET 1 OF 10

PCN / NSN / PN 49711A WCD CAEC07 WCD DATE 89095

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | PROCESS | — | — | BY 10 | 1 | 1.0 | .03 | BEN2 | 1 | 1.0 | .03 | SKILL 9-10 |
| 015 | | INFO | 1.0 | PROCESS | | | | | | | | | | | SKILL 9-10 |
| 018 | | TEST | 1.0 | SETUP | — | — | | 1 | 1.0 | .03 | — | — | — | — | as per T.O.: [illegible] |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 4929 | 1 | 1.0 | 4 | SOS [illegible] |
| 020 | MAT PCM | MACH | .50 | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | See MAT PCM notes for info on this oper. (not removal) SKILL 9-10 |
| 030 | MAT PCA | INS | .50 | PROCESS | — | — | BY 10 | 1 | 1.0 | .15 | BEN2 | 1 | 1.0 | .15 | SKILL 9-10 |

LSC-2(XX)2C

# OPERATION PROFILE

NAME Parker ALC QC DATE 5/18/89 RCC MAT PCA SHEET 2 OF 10

PCN
HSN
PIN 49711A WCD CAEC07 WCD DATE 89095

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | CLN | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .08 | BEN32 | 1 | 1.0 | .08 | SK:11 S-10 |
| 050 | | INSP | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .03 | BEN2 | 1 | 1.0 | .03 | SK:11 S-10 |
| 051 | | INSP | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .03 | BEN 2 | 1 | 1.0 | .03 | SK:11 S-10 |
| 053 | | ASSY | .50 | TRANSIT | | | | | | | | | | | Added - Stand offs |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .07 | BEN 2 | 1 | 1.0 | .07 | SK:11 S-10 |
| 055 | MAT PIW | WELD | .50 | TRANSIT | | | | | | | | | | | Housing to welding for add. of extension steps. Note: IT housing must be extra must remove coat for. (Problem with fumes). |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | - | - | - | - | - | - | - | - | |

LSC-2XXXXC

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MATPCA SHEET 3 OF 10

NSN/PN 49711A WCD CAFC07 WCD DATE 5 0895

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 060 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .02 | BEN2 | 1 | 1.0 | .02 | SK:11 9-10 |
| 065 | MAT PCA | MACH | .50 | [illegible] | | | | | | | | | | | This opn required only 5% of the time dependent on results of opns 80 & 90 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 070 | MAT PCW | WELD | .03 | [illegible] | | | | | | | | | | | this opn required only 5% of the time dependent on results of opns 80 & 90 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 080 | MAT PCA | TEST | .03 | [illegible] | | | | | | | | | | | capacitor analyzer OC # 4060 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | OC # 4060 | 1 | 1.0 | .08 | SK:11 9-10 |
| 090 | | TEST | .50 | [illegible] | | | | | | | | | | | Req 400 V Megger. Not available. Must use test stand. |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC # 5507 | 1 | 1.0 | .16 | SK:11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 4 OF 10

PCN MRN PN 49711A WCD CAECO7 ✓ WCD DATE 890911

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 100 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | use char meter |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .02 | BEN 2 | 1 — | 1.0 | .02 | SK:11 5-10 |
| 110 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN 2 | 1 — | 1.0 | .02 | SK:11 5-10 |
| 120 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC 4060 | 1 | 1.0 | .16 | SK:11 5-10 |
| 130 | | TEST | .50 | [illegible] | | | | | | | | | | | 50% run 2 min |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN 2 | 1 — | 1.0 — | .08 — | SK:11 5-10 70% failure |
| 140 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN 2 | 1 — | 1.0 — | .08 — | SK:11 5-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 5 OF 10

PCN/RSN/Prt 49711A WCD CAEC07 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 150 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | BEN2 | 1 | 1.0 | .08 | SK:11 9-10 |
| 160 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN2 | 1 | 1.0 | .08 | SK:11 9-10 |
| 170 | | DIS | .50 | [redacted] | | | | | | | | | | | capacitor repaired in unit. must be placed in rack. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | | 1 | 1.0 | .80 | OC 2758 | 1 | 1.0 | 11.5 | SK:11 9-10 |
| 175 | | TEST | .50 | [redacted] | | | | | | | | | | | SK:11 9-10 |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC # 4060 | 1 | 1.0 | .16 | Test Stand OC #: 4060 |
| 180 | | TEST | .50 | [redacted] | | | | | | | | | | | Test Stand: OC # 4060 |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .12 | OC # 4060 | 1 | 1.0 | .20 | SK:11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 6 OF 10

PCN NSN PN 49711A WCD CAEC07 WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 190 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | Spark gap OC# 3506 |
| | | | | SETUP | — | — | B410 | 1 | 1.0 | .03 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | OC 3906 | 1 | 1.0 | .05 | SK:11 9-10 |
| 195 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | | | | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN15 [redacted] | 1 | 1.0 | .04 | SK:11 9-10 |
| 200 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN2 | 1 | 1.0 | .02 | SK:11 9-10 |
| 203 | | TEST | .50 | [redacted] | | | | | | | | | | | Adapter test fixture to lock at 7.0 special equip. |
| | | | | SETUP | — | — | | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC# 3953 | 1 | 1.0 | .10 | SK:11 9-10 |
| 205 | MAT PCM | MACH | .35 | [redacted] | | | | | | | | | | | all elec Bench test for mech. 70% Failure rate. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |

LSC-2000/2C

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/8/89 RCC MAT PCA SHEET 2 OF 10

FCN
NSN
PIN 49711A WCD CAFC07 WCD DATE 89095

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 207 | MAT PCA | PROC | .35 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .07 | BEN2 | 1 | 1.0 | .07 | SK:11 9-10 |
| 208 | MAT PIW | WELD | .35 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 209 | MAT PCA | Test | .50 | [illegible] | | | | | | | | | | | Tested d.c to sign. fabric info |
| | | | | SETUP | — | — | BY10 | 1 | 1.0 | .05 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC#4060 | 1 | 1.0 | .08 | SK:11 9-10 |
| 210 | | ASSY | .50 | [illegible] | | | | | | | | | | | Repair and replace as Afc. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN2 | 1 — | 1.0 — | .50 — | SK:11 9-10 |
| 230 | | ASSY | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN2 | 1 — | 1.0 — | .50 — | SK:11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 8 OF 10

CN
NSN
PN 4971IA WCD CAEC07 WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 240 | MAT PCA | PROC | .50 | [illegible] | | | | | | | | | | | Drying in oven |
| | | | | SETUP | — | — | BV10 | 1 | 1.0 | .05 | — | — | — | — | |
| | | | | PROCESS | 1.0 | 4.75 | | 1 | 1.0 | .10 | OC # 2758 | 1 | 1.0 | 4.75 | SK:11 9-10 |
| 250 | | PROC | .50 | [illegible] | | | | | | | | | | | Fill with res.in |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .18 | BEN2 | 1 — | 1.0 — | .18 — | SK:11 9-10 |
| 260 | | PROC | .50 | [illegible] | | | | | | | | | | | Baking in oven |
| | | | | SETUP | — | — | | 1 | 1.0 | .05 | — | — | — | — | |
| | | | | PROCESS | 1.0 | 4.75 | | 1 | 1.0 | .10 | OC # 2758 | 1 | 1.0 | 4.75 | SK:11 9-10 |
| 265 | | Test | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .03 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC # 3906 | 1 | 1.0 | .06 | SK:11 9-10 |
| 270 | MAT PIW | WELD | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |

LSC-2000-92C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 9 OF 10

PCN
NSN
PN 49711A WCD CAEC02 WCD DATE 890[illegible]

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 295 | MAT PCA | PROC | .50 | [illegible] | | | | | | | | | | | oven apply vacuum and heat. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | .5 | BY10 | 1 | 1.0 | .02 | OC# 2758 | 1 | 1.0 | .5 | SK:II 9-10 |
| 300 | | PROC | .50 | [illegible] | | | | | | | | | | | w/ 555 pressurized and continue to heat |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 3.0 | | 1 | 1.0 | .02 | OC# 2758 | 1 | 1.0 | 3.0 | SK:II 9-10 |
| 305 | | TEST | .50 | [illegible] | | | | | | | | | | | Test before paint. If done after cure test fails, must strip flash paint off. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN 17 [illegible] | 1 | 1.0 | .03 | SK:II 9-10 |
| 310 | | PAINT | .50 | [illegible] | | | | | | | | | | | Paint plus primer. 2 hr. drying time |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | WB52 | 1 | 1.0 — | .30 — | SK:II WG-2 |
| 340 | | TEST | .50 | [illegible] | | | | | | | | | | | Ohmmeter req. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .03 | BEN | 1 — | 1.0 — | .03 — | SK:II 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 10 OF 10

PCN NSN PN 49711A WCD CAEC07 WCD DATE 89085

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 350 | MAT PCA | TEST | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | – | BY10 | 1 | 1.0 | .03 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | OC # 3906 | 1 | 1.0 | .06 | SK.11 5-10 |
| 360 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .17 | – | – | – | – | SK.11 9-10 |
| 370 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .02 | – | – | – | – | SK.11 9-10 |
| 380 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .02 | – | – | – | – | SK.11 9-10 |
| 385 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .02 | – | – | – | – | SK.11 9-10 |
| 9999 | | Out | 1.0 | Process | 1.0 | 48.0 | | | | | | | | | |

LSC-2(XX)2C

## FLOW PROCESS CHART

SUBJECT _____ DATE 05/02/88

ITEM CODE PCN [X] 49711A NSN. [ ] P/N [ ]

WCD CAEC07 WCD DATE 89095

CHART BEGINS 010

CHART ENDS 385 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | 209 | — | ○◇D□▽ | TEST |
| 015 | 015 | ○◇D□▽ | INFO | 210 | 210 | ○◇D□▽ | ASSY |
| 018 | — | ○◇D□▽ | TEST | 230 | 230 | ○◇D□▽ | ASSY |
| 020 | 020 | ○◇D□▽ | MACH | 240 | 240 | ○◇D□▽ | PROC |
| 030 | 030 | ○◇D□▽ | QIS | 250 | 250 | ○◇D□▽ | PROC |
| 040 | 040 | ○◇D□▽ | CIN | 260 | 260 | ○◇D□▽ | PROC |
| 050 | 050 | ○◇D□▽ | INSP | 265 | — | ○◇D□▽ | TEST |
| 051 | 051 | ○◇D□▽ | INSP | 270 | 270 | ○◇D□▽ | WELD |
| 053 | — | ○◇D□▽ | ASSY | 275 | — | ○◇D□▽ | PROC |
| 055 | 055 | ○◇D□▽ | WELD | 300 | 300 | ○◇D□▽ | PROC |
| 060 | 060 | ○◇D□▽ | TEST | 305 | — | ○◇D□▽ | TEST |
| 065 | — | ○◇D□▽ | MACH | 310 | 310 | ○◇D□▽ | Paint |
| 070 | 070 | ○◇D□▽ | WELD | 340 | 340 | ○◇D□▽ | TEST |
| 080 | 080 | ○◇D□▽ | TEST | 350 | 350 | ○◇D□▽ | TEST |
| 090 | 090 | ○◇D□▽ | TEST | 360 | 360 | ○◇D□▽ | PW |
| 100 | 100 | ○◇D□▽ | TEST | 370 | 370 | ○◇D□▽ | PW |
| 110 | 110 | ○◇D□▽ | TEST | 390 | 380 | ○◇D□▽ | PW |
| 120 | 120 | ○◇D□▽ | TEST | 385 | 385 | ○◇D□▽ | PW |
| 130 | 130 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 140 | 140 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 150 | 150 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 160 | 160 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 170 | 170 | ○◇D□▽ | QIS | | | ○◇D□▽ | |
| 175 | — | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 180 | 180 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 190 | 190 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 195 | 195 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 200 | 200 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 203 | — | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 205 | — | ○◇D□▽ | MACH | | | ○◇D□▽ | |
| 207 | — | ○◇D□▽ | PROC | | | ○◇D□▽ | |
| 208 | — | ○◇D□▽ | INFO | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/09/89 RCC MAT PCA SHEET — OF —

PCN / NSN / PIN 50078 A WCD CAE205 ✓ WCD DATE 88204

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 1.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE : THIS SHEET FOR IN- OUT DATES

LSC-20092C

# OPERATION PROFILE

NAME [illegible] ALC [illegible] DATE [illegible] RCC [illegible] SHEET 1 OF 6

PCN
RSN
PWA 50078A

WCD [illegible] ✓ WCD DATE 820

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 003 | MAT PAC | PROC | 1.0 | [illegible] | | | | | | | | | | | sandblast ... trolly |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 07 | 1 | 1.0 | .25 | OC3965 | 1 | 1.0 | .25 | SA. 4-6-7 |
| 005 | | PW | 1.0 | [illegible] | | | | | | | | | | | Do ... a computer. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | EY 0 | 1 | 1.0 | .08 | — | — | — | — | SA. 1 1-3 |
| 010 | | REC | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN4 | 1 | 1.0 | .25 | SA.4 9-10 |
| 015 | | INTO | 1 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | SK.4 9-10 |
| 020 | | TEST | 1.0 | [illegible] | | | | | | | | | | | SA.11 9-10 |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | | | 1 | 1.0 | .17 | OC 3906 | 1 | 1.0 | .25 | |

LSC-20092C

# OPERATIO.. PROFILE

NAME [illegible] ALC [illegible] DATE [illegible] RCC [illegible] SHEET 1 OF 6

PCN
NSN 500728A
PIN

WCD CY10 ✓ WCD DATE 8820

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 030 | MAT RCA | INFO | .10 | [redacted] | | | | | | | | | | | Repair as necessary see T.O. reference |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| [illegible] | | DIS | .10 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | CY10 | 1 | 1.0 | .25 | BEN4 | - | - | - | SK. 11 5-13 |
| 050 | | CLN. | .10 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | 1.0 | BEN4 | 1 | 1.0 | 1.0 | SK. [illegible] 5-13 |
| 060 | | INSP | .10 | TRANSIT | | | | | | | | | | | Visual |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | .25 | BEN4 | 1 | 1.0 | .25 | SK. 11 5-13 |
| 070 | | TEST | .10 | TRANSIT | | | | | | | | | | | Also use the portable capacitance analyzer. |
| | | | | SETUP | | | | 1 | 1.0 | .25 | - | - | - | - | |
| | | | | PROCESS | | | | 1 | 1.0 | .25 | OC 3952 | 1 | 1.0 | 1.0 | SK. 11 5-10 |

# OPERATIOI.. ROFILE

NAME Parker ALC CC DATE 02/[illegible]/89 RCC MAT PCA SHEET 3 OF 6

PCN
NSN
PIN 50078A WCD CAEZ05 WCD DATE 6820 1

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 250 | MAT PCA | ASSY | .10 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .25 | BEN4 | 1 | 1.0 | .25 | SKILL 9-10 |
| 281 | | INSP | .10 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN4 | 1 | 1.0 | .03 | SKILL 9-10 |
| 282 | | PROC | .10 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.[illegible] | 30 | | — | — | | | | | | SKILL 9-10 |
| 290 | | ASSY | .10 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.0 | BEN4 | 1 | 1.0 | 1.0 | SKILL 9-10 |
| 295 | | PROC | .10 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN4 | 1 | 1.0 | .50 | SKILL 9-10 |

LSC-2(XX)2C

# OPERATIO.. PROFILE

NAME [redacted] ALC 2C DATE [redacted] RCC [redacted] SHEET 1 OF 6

PCN
NSN
PIN [redacted] WCD CAT 2 ✓ WCD DATE 8820

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 310 | MAT HEA | INSP | .10 | [redacted] | | | | | | | | | | | SKILL 5-10 |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BV10 | 1 | 1.0 | .03 | BEN 17 | 1 | 1.0 | .05 | h. |
| 370 | | PROC | .1 | [redacted] | | | | | | | | | | | (HEAT) |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | .50 | | 1 | 1. | .05 | OC 2758 | 1 | 1.0 | .55 | SKILL 5-10 |
| 380 | | PROC | .1 | [redacted] | | | | | | | | | | | (HEAT) |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 4.0 | | | | .02 | OC 2758 | 1 | 1.0 | 4.2 | SKILL 5-10 |
| 390 | | PROC | .1 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN 4 | 1 | 1.0 | .03 | SKILL 5-10 |
| 400 | | PROC | .10 | [redacted] | | | | | | | | | | | HEAT, COOL |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | | 8.0 | | 1 | 1.0 | .02 | BEN 4 | 1 | 1.0 | .02 | SKILL 5-10 |

# OPERATION PROFILE

NAME Parker ALC CC DATE 05/[illegible]/89 RCC [illegible] SHEET 5 OF 6

PGM
NSN
PN 500284 WCD CAF205 ✓ WCD DATE [illegible]

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 410 | MAT PCA | INSP | .10 | [illegible] | | | | | | | | | | | solder |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | – | – | B[illegible]0 | [illegible] | [illegible].0 | .08 | BEN4 | 1 | 1.0 | .08 | SK:11 5-13 |
| 420 | | TEST | .10 | [illegible] | | | | | | | | | | | Final Functional test. |
| | | | | SETUP | – | – | | 1 | 1.0 | .08 | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .17 | OC 3906 | 1 | 1.0 | .25 | SK:11 5-10 |
| 425 | | PAINT | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | W59 | 1 | 1.0 | .30 | SK:11 WG-7 |
| 430 | | PW | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .08 | – | – | – | – | SK:11 5-10 |
| 440 | | PW | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | – | – | – | – | SK:11 5-10 |

# OPERATIO.. PROFILE

NAME Parker ALC OC DATE 051 RCC MATPCA SHEET 2 OF 6

PCN
RSN
PIN 50028A

WCD CAE205 ✓ WCD DATE 89094

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 450 | MAT PCA | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .08 | - | - | - | - | SK:11 5-10 |
| 460 | | PW | 1.0 | [redacted] | | | | | | | | | | | Specification of tasks on P4.3 thru |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .08 | - | - | - | - | SK:11 5-10 |
| 485 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .02 | - | | - | - | SK:11 5-10 |
| 490 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 10 | .08 | - | | - | - | SK:11 5-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 6.0 | | | | | | | | | |

LSC-20092C

## FLOW PROCESS CHART

SUBJECT _____ DATE 5/5/89

ITEM CODE
PCN ☒ 500784
NSN. ☐
PN ☐

WCD CAEZ05 WCD DATE 89094

CHART BEGINS 003

CHART ENDS 490 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 003 | — | ○▷D□▽ | Sandblast | | | ○▷D□▽ | |
| 005 | 005 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 010 | 010 | ○▷D□▽ | REC | | | ○▷D□▽ | |
| 015 | 015 | ○▷D□▽ | INFO | | | ○▷D□▽ | |
| 020 | 020 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 030 | 030 | ○▷D□▽ | INFO | | | ○▷D□▽ | |
| 040 | 040 | ○▷D□▽ | DIS | | | ○▷D□▽ | |
| 050 | 050 | ○▷D□▽ | CLN | | | ○▷D□▽ | |
| 060 | 060 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 070 | 070 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 250 | 250 | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 281 | 281 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 282 | 282 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 290 | 290 | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 295 | 295 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 310 | 310 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 320 | 320 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 380 | 380 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 390 | 390 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 400 | 400 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 410 | 410 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 420 | 420 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 425 | 425 | ○▷D□▽ | PAINT | | | ○▷D□▽ | |
| 430 | 430 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 440 | 440 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 450 | 450 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 460 | 460 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 485 | 485 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| 490 | 490 | ○▷D□▽ | PW | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC 0- DATE 5/16/89 RCC MAT PCA SHEET - OF -

PCN
NSN
PN 50217A-- WCD CAEA01 WCD DATE 86121

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 36.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE: This sheet is for IN-OUT Sheet

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/1/87 RCC MAT PCA SHEET 1 OF 4

PCN
ASN 50217A
PRI

WCD CAEA01 ✓ WCD DATE 8612

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .08 | BEN 6 | 1 | 1.0 | .08 | Skill 9-10 |
| 015 | | INFO | 1.0 | [redacted] | | | | | | | | | | | Applicable T.O. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| 017 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | Sandblast |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 07 | 1 | 1.0 | .12 | ∝ 3965 | 1 | 1.0 | .12 | ∝ work |
| 018 | | TEST | 1.0 | [redacted] | | | | | | | | | | | 60% failure rate. |
| | | | | SETUP | — | — | | 1 | 1.0 | .12 | | | — | — | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .08 | OC 3906 | 1 | 1.0 | .20 | Skill 9-10 |
| 020 | | REP | .30 | [redacted] | | | | | | | | | | | Transformer fails 50% of tests (visual and/or electrical). Time includes remove and replace. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 4.5 | BEN 6 | 1 | 1.0 | 4.5 | Skill 9-10 |

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATRA SHEET 2 OF 4

PCN NSN P/N 5021DA WCD CAEA01 WCD DATE 86198

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 021 | MAT PCA | TEST | .60 | [redacted] | | | | | | | | | | | Tube assy. are defective in approx. 50% of all items failing test. |
| | | | | SETUP | – | – | | 1 | 1.0 | .33 | – | – | – | – | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .10 | BEN 15 | 1 | 1.0 | .43 | SK:11 9-10 |
| 022 | | REP | .30 | [redacted] | | | | | | | | | | | [illegible] replace tube assy. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .75 | BEN 1 | 1 | 1.0 | .75 | SK:11 9-10 |
| 023 | | REP | .12 | [redacted] | | | | | | | | | | | Rectifier defective in ~ 20% of all items failing test, (Tube assy. must be removed). |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .50 | BEN 6 | 1 | 1.0 | .50 | SK:11 9-10 |
| 024 | | REP | .03 | [redacted] | | | | | | | | | | | Capacitor No. one defective ~5% of all failed items. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | 1.0 | BEN 6 | 1 | 1.0 | 1.0 | SK:11 9-10 |
| 025 | | REP | .03 | [redacted] | | | | | | | | | | | capacitor assy #2 defective in ~ 5% of all failed items |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | 2.0 | BEN 6 | 1 | 1.0 | 2.0 | SK:11 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 3 OF 4

PCN
IISN
PRI 50217A WCD CAEA01 WCD DATE 86/28

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | INSP | .60 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | GEN 6 | 1 | 1.0 | .08 | [illegible] |
| 085 | | TEST | .60 | [redacted] | | | | | | | | | | | before sealing |
| | | | | SETUP | — | — | | 1 | 1.0 | .12 | — | — | — | — | See Sym Ofc |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC 5206 | 1 | 1.0 | .20 | |
| 360 | | ASSY | .60 | [redacted] | | | | | | | | | | | [illegible] and closed. [illegible] der |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1 | 1.0 | | 1 | 1.0 | 1.0 | GEN 6 | 1 | 1.0 | 1.0 | [illegible] |
| 405 | | Insp | .60 | [redacted] | | | | | | | | | | | Lock ck [illegible] |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN 17 | 1 | 1.0 | .03 | [illegible] |
| 435 | | PROC | .60 | [redacted] | | | | | | | | | | | includes [illegible] cooling [illegible] |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.5 | | 1 | 1.0 | .02 | OC 2258 | 1 | 1.0 | 2.52 | [illegible] |

LSC-20002C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATRA SHEET 4 OF 4

PCH
RSN
PN 5021A WCD CAEA01 ✓ WCD DATE 86/98

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 460 | MAT PCA | TEST | .60 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .03 | | | | | Yard gap machine |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .05 | OC 4060 | 1 | 1.0 | .08 | SK.11 9-10 |
| 470 | | TEST | .60 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .12 | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC 3906 | 1 | 1.0 | .20 | SK.11 9-10 |
| 490 | | TEST | .60 | TRANSIT | | | | | | | | | | | Second part of test |
| | | | | SETUP | | | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 3906 | 1 | 1.0 | .11 | SK.11 9-10 |
| 499 | | PAINT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | W55 | 1 | 1.0 | .30 | SK.4 9-10 |
| 547 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .11 | — | — | — | — | SK.11 9-10 |
| 9999 | | OUT | 1.0 | Process | 1.0 | 0 | | | | | | | | | |

# OPERATION PROFILE

NAME Packer ALC OC DATE 5/19/89 RCC MATPCA SHEET 2 OF 4

PCN/ASN/PN 50297A WCD CAEM22 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 045 | MAT PCA | DIS | .05 | [redacted] | | | | | | | | | | | deburr, d.s. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | BV 10 | 1 | 1.0 | .58 | BEN 4 | 1 | 1.0 | .58 | SK. 11 5-10 |
| 060 | | TEST | .05 | [redacted] | | | | | | | | | | | Tube tester |
| | | | | SETUP | - | - | | 1 | 1.0 | .03 | - | - | - | - | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .03 | BEN 15 | 1 | 1.0 | .06 | SK. 11 5-10 |
| 079 | | TEST | .05 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .17 | BEN 4 | 1 | 1.0 | .17 | SK. 11 5-10 |
| 090 | | ASSY | .05 | [redacted] | | | | | | | | | | | remove and replaced as necessary. Reassy. ) torque |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | 1.17 | BEN 4 | 1 | 1.0 | 1.17 | SK. 11 5-10 |
| 105 | | TEST | .05 | [redacted] | | | | | | | | | | | Identical to opn # 035. |
| | | | | SETUP | - | - | | 1 | 1.0 | .07 | - | - | - | - | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .07 | ∝ # 3906 | 1 | 1.0 | .14 | SK. 11 5-10 |

LSC-20XX2C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 3 OF 4

PCN/NSN/PN 50297A WCD CAEM22 ✓ WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 110 | MAT PIW | WELD | .05 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | – | – | – | – | – | – | – | – | |
| 115 | MAT RA | INSP | .05 | [redacted] | | | | | | | | | | | Fill dry $N_2$ water bath |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .03 | BEN4 | 1 | 1.0 | .03 | SK:11 S-10 |
| 120 | | PROC | .05 | [redacted] | | | | | | | | | | | Bake in oven, Vacume (Ary). |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 4.25 | | | | .03 | BEN 4 | 1 | 1.0 | .03 | SK:11 S-10 |
| 121 | | INSP | .05 | [redacted] | | | | | | | | | | | water bath |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1 | 1.0 | | 1 | 1.0 | .05 | BEN 4 | 1 | 1.0 | .05 | SK:11 S-10 |
| 122 | | TEST | .05 | [redacted] | | | | | | | | | | | Same as opn # 35 |
| | | | | SETUP | – | – | | 1 | 1.0 | .07 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .07 | or # 3906 | 1 | 1.0 | .14 | SK:11 S-10 |

ISC-2(XXD)C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/15/85 RCC MAT PCA SHEET 4 OF 4

PCN / RSN / PRI 50297A WCD CAEM22 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 123 | MAT PCA | PROC | .05 | [redacted] | | | | | | | | | | | Sandblast |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY07 | 1 | 1.0 | .25 | BEN 4 | 1 | 1.0 | .25 | SK:11 WG-07 |
| 125 | | PAINT | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | W59 | 1 | 1.0 | .30 | SK:11 WG-07 |
| 147 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY10 | 1 | 1.0 | .17 | - | - | - | - | SK:11 9-10 |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 9.6 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

ISC-21XXXX

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/19/89

ITEM CODE
PCN ☒ 502972A
NSN. ☐
P/N ☐

WCD CAEM22 WCD DATE 88239

CHART BEGINS 010

CHART ENDS 147 PREPARED BY GJP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○▷D□▽ | REC. | | | ○▷D□▽ | |
| 020 | 020 | ○▷D□▽ | INFO | | | ○▷D□▽ | |
| 030 | 030 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 035 | 035 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 040 | 040 | ○▷D□▽ | MACH. | | | ○▷D□▽ | |
| 045 | 045 | ○▷D□▽ | DIS | | | ○▷D□▽ | |
| 060 | 060 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 079 | — | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 090 | 090 | ○▷D□▽ | ASSY. | | | ○▷D□▽ | |
| 105 | 105 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 110 | 110 | ○▷D□▽ | WELD. | | | ○▷D□▽ | |
| 115 | 115 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 120 | 120 | ○▷D□▽ | PROC | | | ○▷D□▽ | |
| 121 | — | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 122 | — | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 123 | — | ○▷D□▽ | Proc. | | | ○▷D□▽ | |
| 125 | 125 | ○▷D□▽ | Paint | | | ○▷D□▽ | |
| 147 | — | ○▷D□▽ | PW | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
| | | ○▷D□▽ | | | | ○▷D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATIO' ROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET — OF —

PCN
NSN
PN 61234A WCD CAECOS ✓ WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 206 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
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| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE: This sheet for IN-OUT DATES

LSC-2(X)92C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 1 OF 4

PCN/REV/PN 61234A WCD CAEC05 WCD DATE 8502.5

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | BEN 4 | 1 | 1.0 | .08 | Skill 5-10 |
| 015 | | INFO | 1.0 | TRANSIT | | | | | | | | | | | Applicable T.O. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 017 | | PROC | 1.0 | TRANSIT | | | | | | | | | | | Sandblast |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY07 | 1 | 1.0 | .12 | OC3965 | 1 | 1.0 | .12 | Skill WG-7 |
| 018 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | 60% failure rate. |
| | | | | SETUP | — | — | | 1 | 1.0 | .12 | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | OC 3906 | 1 | 1.0 | .20 | Skill 9-10 |
| 020 | | REP | .30 | TRANSIT | | | | | | | | | | | Transformer fails 50% of tests visual and/or electr. Time includes remove and replace. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 4.5 | BEN 4 | 1 | 1.0 | 4.5 | Skill 5-10 |

ISC-20000

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATRCA SHEET 2 OF 4

PCN
NSN 61234A
PIN

WCD CAECOS ✓ WCD DATE 8[illegible]8

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 021 | MAT PCA | TEST | .30 | [illegible] | | | | | | | | | | | Tube assy. are defective in approx. 50% of all items fail test. |
| | | | | SETUP | — | — | | 1 | 1.0 | .33 | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .10 | GEN15 [illegible] | 1 | 1.0 | .43 | SKILL 9-10 |
| 022 | | REP | .30 | [illegible] | | | | | | | | | | | Remove and replace tube assy. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .75 | BEN4 | 1 | 1.0 | .75 | SKILL 9-10 |
| 023 | | REP | .12 | [illegible] | | | | | | | | | | | Rectifier defective in ~ 20 % of all items failing test, (Tube assy. must be rem |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN4 | 1 | 1.0 | .50 | SKILL 9-10 |
| 024 | | REP | .03 | [illegible] | | | | | | | | | | | Capacitor No. one defective ~ 5% of all failed items. |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 1.0 | BEN4 | 1 | 1.0 | 1.0 | SKILL 9-10 |
| 025 | | REP | .03 | [illegible] | | | | | | | | | | | capacitor assy #2 defective in ~ 5% of all failed items |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | 2.0 | BEN4 | 1 | 1.0 | 2.0 | SKILL 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 3 OF 4

PCN
NSN
PN 61234A WCD CAECOS ✓ WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | INSP | .60 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | BEN4 | 1 | 1.0 | .08 | SK'N 5-13 |
| 085 | | TEST | .60 | ~~TRANSIT~~ | | | | | | | | | | | before sealing |
| | | | | SETUP | — | — | | 1 | 1.0 | .12 | — | — | — | — | see 040 |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC 3906 | 1 | 1.0 | .20 | 018 |
| 360 | | ASSY | .60 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | case press. and closed. solder |
| | | | | PROCESS | 1 | 1.0 | | 1 | 1.0 | 1.0 | BEN4 | 1 | 1.0 | 1.0 | SK'N 5-13 |
| 405 | | INSP | .60 | ~~TRANSIT~~ | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | Leak ck water |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN17 [illegible] | 1 | 1.0 | .03 | SK'N 5-13 |
| 435 | | PROC | .60 | TRANSIT | | | | | | | | | | | |
| | | | | ~~SETUP~~ | | | | | | | | | | | includes sealing |
| | | | | PROCESS | 1.0 | 2.5 | | 1 | 1.0 | .02 | OC 2358 | 1 | 1.0 | 2.52 | SK II 5-13 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATRA SHEET 4 OF 4

PCN/RSN/PRI 61234A WCD CAECOS WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 460 | MAT PCA | TEST | .60 | TRANSIT | | | | | | | | | | | spark gap machine |
| | | | | SETUP | — | — | | 1 | 1.0 | .03 | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .05 | OC 4060 | 1 | 1.0 | .08 | SK:II 9-10 |
| 470 | | TEST | .60 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .12 | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC 3906 | 1 | 1.0 | .20 | SK:II 9-10 |
| 490 | | TEST | .60 | TRANSIT | | | | | | | | | | | second part of test |
| | | | | SETUP | | | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 3906 | 1 | 1.0 | .11 | SK:II 9-10 |
| 499 | | PAINT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .30 | W59 | 1 | 1.0 | .30 | SK:II 9-10 |
| 547 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .11 | — | — | — | — | SK:II 9-10 |
| 9999 | | OUT | 1.0 | Process | 1.0 | 6.9 | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/16/89

ITEM CODE
PCN
NSN.
P/N

WCD CAECO5 WCD DATE 89085

CHART BEGINS 010

CHART ENDS _____ PREPARED BY _____

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○▷D□▽ | REC | | | ○▷D□▽ | |
| 015 | 015 | ○▷D□▽ | INFO | | | ○▷D□▽ | |
| 017 | — | ○▷D□▽ | Sandblast | | | ○▷D□▽ | |
| 018 | — | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 020 | 020 | ○▷D□▽ | REP. | | | ○▷D□▽ | |
| 021 | — | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 022 | — | ○▷D□▽ | REP | | | ○▷D□▽ | |
| 023 | — | ○▷D□▽ | REP | | | ○▷D□▽ | |
| 024 | — | ○▷D□▽ | REP | | | ○▷D□▽ | |
| 025 | — | ○▷D□▽ | REP | | | ○▷D□▽ | |
| 040 | 040 | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 085 | — | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 360 | 360 | ○▷D□▽ | ASSY | | | ○▷D□▽ | |
| 405 | — | ○▷D□▽ | INSP | | | ○▷D□▽ | |
| 435 | — | ○▷D□▽ | AROC | | | ○▷D□▽ | |
| 460 | 460 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 470 | 470 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 490 | 490 | ○▷D□▽ | TEST | | | ○▷D□▽ | |
| 495 | 459 | ○▷D□▽ | PAINT | | | ○▷D□▽ | |
| 547 | 547 | ○▷D□▽ | PW | | | ○▷D□▽ | |
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○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PCN SHEET — OF —

PCN
NSN
PN 97133A WCD CAEB08 WCD DATE 89033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 480 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
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| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

Note: This sheet for in-out dates.

LSC-2000226

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 1 OF 3

Wendel Hawkins

FCH
ISN 97133A
PRI

WCD CAEB08 WCD DATE 89038

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MAT PCA | REC | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | BEN4 | 1 | 1.0 | .08 | SK'll 5-10 |
| 015 | | INFO | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | SKill 5-10 |
| 020 | | DIS | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .25 | BEN4 | 1 | 1.0 | .25 | SK'll 5-10 |
| 030 | | CLN | 1.0 | [redacted] | | | | | | | | | | | Recon Tank Remove carbon etc. Hand brush. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .8 | BEN4 | 1 | 1.0 | .25 | SK'll 5-10 |
| 040 | | INSP | 1.0 | [redacted] | | | | | | | | | | | visual insp. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .05 | BEN4 | 1 | 1.0 | .05 | SK'll 5-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/19/89 RCC MAT PCA SHEET 2 OF 3

PCH NSN PN 97133A WCD CAEB08 WCD DATE 89033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 070 | MAT PCA | TEST | 1.0 | [redacted] | | | | | | | | | | | Coil tested Dielectric tester |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .17 | BEN 4 | 1 | 1.0 | .17 | Skill 9-10 |
| 090 | MAT PCM | MACH | .15 | [redacted] | | | | | | | | | | | Housing cracked. (1st occurrence) |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | – | – | – | – | – | – | – | – | |
| 155 | MAT PCA | ASSY | 1.0 | [redacted] | | | | | | | | | | | This delayed by about 1 if above occurs, otherwise 100% |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY 10 | 1 | 1.0 | 1.0 | BEN4 | 1 | 1.0 | 1.0 | Skill 9-10 |
| 205 | | TEST | 1.0 | [redacted] | | | | | | | | | | | Added Test - Apply air to check for leaks. Important procedure. Needed to avoid delays. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .08 | BEN4 | 1 | 1.0 | .08 | |
| 255 | | TEST | 1.0 | [redacted] | | | | | | | | | | | Tested in Bldg. 3108. by technician doing overhaul. |
| | | | | SETUP | – | – | | 1 | 1.0 | .50 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .50 | OC 1135- | 1 | 1.0 | 1.0 | Skill 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 3 OF 3

PCN WSH PN 97133A WCD CAEA08 WCD DATE 88033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 285 | MAT PCA | ASSY | 1.0 | [redacted] | | | | | | | | | | | includes safety wiring |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .17 | BEN4 | 1 | 1.0 | .17 | SK-11 5-10 |
| 305 | | PW | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | — | — | — | — | SK-11 5-10 |
| 4999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 9.6 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT _____ DATE 5/18/89

ITEM CODE
PCN 97133A
NSN.
P/N

WCD CAEB08 WCD DATE 89033

CHART BEGINS 010

CHART ENDS _____ PREPARED BY CP

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○◇D□▽ | REC | | | ○◇D□▽ | |
| 015 | 015 | ○◇D□▽ | INFO | | | ○◇D□▽ | |
| 020 | 020 | ○◇D□▽ | DIS | | | ○◇D□▽ | |
| 030 | 030 | ○◇D□▽ | CLEAN | | | ○◇D□▽ | |
| 040 | 040 | ○◇D□▽ | INSP. | | | ○◇D□▽ | |
| 070 | 070 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 090 | 090 | ○◇D□▽ | MACH | | | ○◇D□▽ | |
| 155 | - | ○◇D□▽ | ASSY. | | | ○◇D□▽ | |
| 205 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 255 | - | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 285 | - | ○◇D□▽ | ASSY. | | | ○◇D□▽ | |
| 305 | - | ○◇D□▽ | PW. | | | ○◇D□▽ | |
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| | | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MATRCA SHEET — OF —

PCN / NSN / PMI 98001A WCD CAEC07A WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT RCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 28.0 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

NOTE: This sheet FOR IN-OUT DATES

LSC-2(XX)2C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/6/8[illegible] RCC [illegible] SHEET 1 OF 10

PCN
NSN
PIN 58001A WCD CAEC07A WCD DATE 89MAY

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 010 | MA PCA | REC | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .03 | BEN 2 | 1 | 1.0 | .03 | [illegible] 9-10 |
| [illegible] | | [illegible] | 1.0 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| 018 | | TEST | 1.0 | TRANSIT | | | | | | | | | | | [illegible] |
| | | | | SETUP | — | — | | 1 | 1.0 | .03 | — | — | — | — | [illegible] |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | OC 4979 | 1 | 1.0 | 4 | [illegible] |
| 020 | MAT PCM | MACH | .50 | TRANSIT | | | | | | | | | | | [illegible] |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | .1 | 24.0 | — | — | — | — | — | — | — | — | [illegible] |
| 021 | MAT PCA | [illegible] | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY 10 | 1 | 1.0 | .15 | BEN 2 | 1 | 1.0 | .15 | [illegible] |

LSC-20092C

# OPERATION PROFILE

NAME Parker ALC QC DATE 5/18/89 RCC MAT PCA SHEET 1 OF 10

PCN NSN PN 98001A WCD CAEC07A WCD DATE 8-08-89

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | CLN | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | BY 10 | 1 | 1.0 | .08 | BEN2 | 1 | 10 | .08 | SK.11 5-10 |
| 050 | | INSP | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .03 | BEN2 | 1 | 1.0 | .03 | SK.11 5-10 |
| 051 | | INSP | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .03 | BEN2 | 1 | 1.0 | .03 | SK.11 5-10 |
| 053 | | ASSY | .50 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | - | - | | 1 | 1.0 | .07 | BEN2 | 1 | 10 | .07 | SK.11 5-10 |
| 055 | MAT PIW | WELD | .50 | TRANSIT | | | | | | | | | | | Housing & welding for add. of extension strips. Note: If housings must be extended must remove expan. for. (problem with frames). |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | - | - | - | - | - | | | - | |

LSC-2(X)92C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MATPCA SHEET 5 OF 10

PCN
NSN
P/N 98001A WCD CAEC07A WCD DATE 890418

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 060 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .02 | BEN2 | 1 | 1.0 | .02 | SK # 9-10 |
| 065 | MAT PCM | MACH | .50 | [illegible] | | | | | | | | | | | This opn required only 5% of the time. Dependent on results of opns 80 & 90 |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 070 | MAT PIW | WELD | .03 | [illegible] | | | | | | | | | | | This opn required only 5% of the time. Dependent on results of opns 80 & 90 |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | — | — | — | — | — | — | — | — | |
| 080 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | capacitor analyzer OC # 4060 |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .08 | OC # 4060 | 1 | 1.0 | .08 | SK # 9-10 |
| 090 | | TEST | .50 | [illegible] | | | | | | | | | | | Req 400 V megger. Not available. Must use test stand. |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC # 5507 | 1 | 1.0 | .16 | SK # 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 4 OF 10

PCN RSN PN 98001A WCD CAECO7A WCD DATE 8 [illegible]

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 100 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | use ohm meter |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .02 | BEN2 | 1 | 1.0 | .02 | SK.11 5-10 |
| 110 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN2 | 1 | 1.0 | .02 | SK.11 5-10 |
| 120 | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | — | — | | 1 | 1.0 | .08 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC# 4060 | 1 | 1.0 | .16 | SK.11 5-10 |
| [illegible] | | TEST | .15 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN | 1 | 1.0 | .08 | SK. [illegible] |
| [illegible] | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | BEN2 | 1 | 1.0 | .08 | SK. [illegible] |

LSC-2(XX)2C

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/84 RCC MAT PCA SHEET 5 OF 10

(PCN) RSN PIN 98001A WCD CAECO7A ✓ WCD DATE 8 C 1982

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 150 | MAT PCA | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | – | – | BY10 | 1 | 1.0 | .08 | BEN2 | 1 | 1.0 | .08 | SK. [illegible] |
| [illegible] | | TEST | .50 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .08 | BEN2 | 1 | 1.0 | .08 | SK. [illegible] |
| 170 | | DIS | .50 | [illegible] | | | | | | | | | | | |
| | | | | [illegible] | | | | | | | | | | | |
| | | | | PROCESS | | .10 | | 1 | 1.0 | .80 | [illegible] | 1 | 1.0 | 11.5 | [illegible] |
| 175 | | TEST | .50 | [illegible] | | | | | | | | | | | SK. [illegible] |
| | | | | SETUP | – | – | | 1 | 1.0 | .08 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .08 | OC # 4060 | 1 | 1.0 | .16 | OC # 4060 |
| 180 | | TEST | .50 | [illegible] | | | | | | | | | | | TEST Stand : 4060 |
| | | | | SETUP | – | – | | 1 | 1.0 | .08 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .12 | OC # 4060 | 1 | 1.0 | .20 | SK. [illegible] |

# OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 6 OF 10

PCN NSN 98001A PN

WCD CAECO7A WCD DATE 89 [illegible] 5

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 197 | MAT PCA | TEST | .50 | [redacted] | | | | | | | | | | | [illegible] 3906 |
| | | | | SETUP | — | — | 8410 | 1 | 1.0 | .03 | — | — | — | — | |
| | | | | PROCESS | | | | 1 | 1.0 | .02 | OC 3906 | 1 | [illegible] | .05 | SK [illegible] |
| 195 | | TEST | .5 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | | | | 1 | 1.0 | .02 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN15 | 1 | 1.0 | .04 | SK: II 9-10 |
| 200 | | TEST | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .02 | BEN2 | 1 | 1.0 | .02 | SK: II 9-10 |
| 203 | | TEST | .50 | [redacted] | | | | | | | | | | | [illegible] |
| | | | | SETUP | — | — | | 1 | [illegible] | .02 | | | [illegible] | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .08 | OC # 3953 | 1 | 1.0 | .10 | SK: II 9-10 |
| 205 | MAT FCM | MACH | .35 | [redacted] | | | | | | | | | | | [illegible] |
| | | | | [redacted] | | | | | | | | | | | 70% [illegible] rate |
| | | | | PROCESS | 1.0 | [illegible] | — | — | — | — | — | — | — | — | |

LSC-2(X)92C

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/18/89 RCC MAT PCA SHEET 2 OF 10

PCN NSN P/N 98001A WCD CAECO7A WCD DATE 8[illegible]

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 207 | MAT PCA | PROC | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .07 | BEN2 | 1 | 1.0 | .07 | SK.11 9-10 |
| 208 | MAT PIW | WELD | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 240 | — | — | — | — | — | — | — | — | |
| 209 | MAT PCA | Test | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | — | — | BY10 | 1 | 1.0 | .05 | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | 4060 | 1 | 1.0 | .08 | SK.11 9-10 |
| 210 | | ASSY | .50 | [redacted] | | | | | | | | | | | Acquire and replace |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN2 | 1 | 1.0 | .50 | SK.11 9-10 |
| 230 | | ASSY | .50 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .50 | BEN2 | 2 | 1.0 | .50 | SK.11 9-10 |

# OPERATION . .IOFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 8 OF 10

PCN
NSN
P/N 98001A WCD CAEC07A ✓ WCD DATE 89085

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 240 | MAT PCA | PROC | .50 | [redacted] | | | | | | | | | | | Drying in oven |
| | | | | SETUP | – | – | BY10 | 1 | | .05 | – | – | – | – | |
| | | | | PROCESS | 1.0 | 4.75 | | 1 | 1.0 | .10 | OC # 2758 | 1 | 1.0 | 4.75 | SK:11 9-10 |
| 250 | | PROC | .50 | [redacted] | | | | | | | | | | | Fill with resin |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .18 | BEN2 | 1 | 1.0 | .18 | SK:11 9-10 |
| 260 | | PROC | .50 | [redacted] | | | | | | | | | | | Baking in oven |
| | | | | SETUP | – | – | | 1 | 1.0 | .05 | – | – | – | – | |
| | | | | PROCESS | 1.0 | 4.75 | | 1 | 1.0 | .10 | OC # 2758 | 1 | 1.0 | 4.75 | SK:11 9-10 |
| 265 | | Test | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | – | | 1 | 1.0 | .03 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | OC 3906 | 1 | 1.0 | .06 | SK:11 9-10 |
| 270 | MAT PIW | WELD | .50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 24.0 | – | – | – | – | – | | – | – | |

# OPERATION . .ROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PC A SHEET 9 OF 10

PCN
NSN
P/N 98001A WCD CAECO2A WCD DATE 89 [illegible]

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 275 | MAT PCA | PROC | .50 | [redacted] | | | | | | | | | | | apply vacuum and heat. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | .5 | BY10 | 1 | 1.0 | .02 | OC# 2758 | 1 | 1.0 | .5 | SK:11 9-10 |
| 300 | | PROC | .50 | [redacted] | | | | | | | | | | | pressurization and continue to heat |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 3.0 | | 1 | 1.0 | .02 | OC# 2758 | 1 | 1.0 | 3.0 | SK:11 9-10 |
| 305 | | TEST | .50 | [redacted] | | | | | | | | | | | Test before paint. If done after and test fails, must sand/flash paint off. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .03 | BEN17 | 1 | 1.0 | .03 | SK 9-10 |
| 310 | | PAINT | 1.0 | [redacted] | | | | | | | | | | | Paint plus primer. 2 hr. drying time |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 2.0 | B307 | 1 | 1.0 | .3 | W59 | 1 | 1.0 | .30 | SK:11 WG-2 |
| 340 | | TEST | .50 | [redacted] | | | | | | | | | | | Ohmmeter req. |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .03 | BEN2 | 1 | 1.0 | .03 | SK 9-10 |

# OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 10 OF 10

PCN
NSN
PRI 98001A WCD CAEC07A WCD DATE 890825

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 350 | MAT PCA | TEST | 50 | [redacted] | | | | | | | | | | | |
| | | | | SETUP | – | – | BY10 | 1 | 1.0 | .03 | – | – | – | – | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .03 | OC # 3906 | 1 | 1.0 | .06 | SK:11 5-10 |
| 360 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .17 | – | – | – | – | SK:11 9-10 |
| 370 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .02 | – | – | | – | SK:11 9-10 |
| 380 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .02 | – | – | – | – | SK:11 9-10 |
| 385 | | PW | 1.0 | [redacted] | | | | | | | | | | | |
| | | | | [redacted] | | | | | | | | | | | |
| | | | | PROCESS | – | – | | 1 | 1.0 | .02 | – | – | – | – | SK:11 9-10 |
| 9999 | | out | 1.0 | Hours | 1.0 | 20.9 | | | | | | | | | |

LSC-2(X)92C

# FLOW PROCESS CHART

SUBJECT _____ DATE 05/05/89

ITEM CODE PCN [X] NSN. [ ] P/N [ ] 98001A WCD CAEC07A WCD DATE 8 [illegible] 8 —

CHART BEGINS 010 —

CHART ENDS 385 PREPARED BY _____

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ○⇨D□▽ | REC | 209 | — | ○⇨D▣▽ | TEST |
| 015 | 015 | ○⇨D□▽ | INFO | 210 | 210 | ○⇨D□▽ | ASSY |
| 018 | — | ○⇨D▣▽ | TEST | 230 | 230 | ○⇨D□▽ | ASSY |
| 020 | 020 | ○⇨D□▽ | MACH | 240 | 240 | ○⇨D□▽ | PROC |
| 030 | 030 | ○⇨D□▽ | DIS | 250 | 250 | ○⇨D□▽ | PROC |
| 040 | 040 | ○⇨D□▽ | CIN | 260 | 260 | ○⇨D□▽ | PROC |
| 050 | 050 | ○⇨D□▽ | INSP | 265 | — | ○⇨D▣▽ | TEST |
| 051 | 051 | ○⇨D▣▽ | INSP | 270 | 270 | ○⇨D□▽ | WELD |
| 053 | — | ○⇨D□▽ | ASSY | 275 | — | ○⇨D□▽ | PROC |
| 055 | 055 | ○⇨D□▽ | WELD | 300 | 300 | ○⇨D□▽ | PROC |
| 060 | 060 | ○⇨D▣▽ | TEST | 305 | — | ○⇨D▣▽ | TEST |
| 065 | — | ○⇨D□▽ | MACH | 310 | 310 | ○⇨D□▽ | Paint |
| 070 | 070 | ○⇨D□▽ | WELD | 340 | 340 | ○⇨D▣▽ | TEST |
| 080 | 080 | ○⇨D▣▽ | TEST | 350 | 350 | ○⇨D▣▽ | TEST |
| 090 | 090 | ○⇨D▣▽ | TEST | 360 | 360 | ○⇨D□▽ | PW |
| 100 | 100 | ○⇨D▣▽ | TEST | 370 | 370 | ○⇨D□▽ | PW |
| 110 | 110 | ○⇨D▣▽ | TEST | 380 | 380 | ○⇨D□▽ | PW |
| 120 | 120 | ○⇨D▣▽ | TEST | 385 | 385 | ○⇨D□▽ | PW |
| 130 | 130 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 140 | 140 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 150 | 150 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 160 | 160 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 170 | 170 | ○⇨D□▽ | DIS | | | ○⇨D□▽ | |
| 175 | — | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 180 | 180 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 190 | 190 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 195 | 195 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 200 | 200 | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 203 | — | ○⇨D▣▽ | TEST | | | ○⇨D□▽ | |
| 205 | — | ○⇨D□▽ | MACH | | | ○⇨D□▽ | |
| 207 | — | ○⇨D□▽ | PROC | | | ○⇨D□▽ | |
| 208 | — | ○⇨D□▽ | WELD | | | ○⇨D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION

⇨ TRANSPORTATION D DELAY

LSC-20147

# OPERATIC.. PROFILE

NAME J. CARTER ALC OC DATE 4-27-82 RCC MAT PCA SHEET 1 OF 6

PCN
NSN 98093A
P/N

WCD CAEC II ✓ WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 00 | MAT PCA | IN | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 30.9 | | | | | | | | | |
| 010 | MAT PCA | REC | 1.000 | TRANSIT | | | BY-10 | — | — | — | | — | — | — | |
| | | | | SETUP | | | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | — | .10 | BENCH ? | 1 | 1.0 — | .10 — | BENCH |
| 015 | | PH | 1.000 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | — | .10 | BENCH ? | 1 | 1.0 — | .10 — | BENCH |
| 020 | | DIS | 1.000 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | — | 2.0 | BENCH ? | 1 | 1.0 | 2.0 | BENCH |
| 030 | | CLN | 1.000 | TRANSIT | — | — | | 1 | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | | — | — | — | — | — | — | CLEALING TANK - NO NUMBER |
| | | | | PROCESS | — | — | BY. 10 | 1 | — | .1 | BENZ | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME J. CARTER ALC OC DATE 11-27-89 RCC MAT PCA SHEET 2 OF 6

PCN
NSN
PIN 98093A

WCD CAEC 11 ✓ WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 040 | MAT PCA | INSP. | 1.000 | TRANSIT | — | — | BY-10 | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 060 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .20 | OC 4929 | 1 | 1.0 | .20 | |
| 070 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 070 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | T | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |
| 080 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY-10 | 1 | 1.0 | .10 | OC 4929 | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME JACK CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 3 OF 6

PCN
NSN
P/N 98093A WCD CAEC11 WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 090 | MAT PCA | TEST | 1.00 | TRANSIT | — | — | — | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY-10 | 1 | 1.0 | .20 | OC 4929 | 1 | 1.0 | .20 | |
| 100 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | | | | |
| | | | | SETUP | — | — | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | | | | | |
| 110 | | TEST | 1.00 | TRANSIT | — | — | | | | | | | | | |
| | | | | SETUP | — | — | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .10 | | | | | |
| 120 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | | | | |
| | | | | SETUP | — | — | | — | — | — | | | | | |
| | | | | PROCESS | — | — | | 1.0 | 1.0 | .10 | OC 4929 | | | | |
| 380 | | REP | 1.00 | TRANSIT | — | — | | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .42 | BENCH 2 | 1 | 1.0 | .42 | |

# OPERATIC PROFILE

NAME J. CARTER ALC OC DATE 4/24/89 RCC MAT PCA SHEET 4 OF 6

PCN
NSN 98093A WCD CAEC II WCD DATE 88045
PIN

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 390 | MAT PCA | ASS'Y | 1.0 | TRANSIT | — | — | — | — | — | — | — | — | — | — | COMBINED WITH OP 440 PER ACT FAB. METHOD. |
| | | | | SETUP | — | — | — | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | 3.0 | BENCH | — | — | — | |
| 460 | | TEST | 1.0 | TRANSIT | — | — | | — | — | — | — | — | — | — | TEST BENCH |
| | | | | SETUP | — | — | | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .15 | # OC3953 | 1 | 1.0 | .15 | |
| 520 | | BAKE | 1.0 | TRANSIT | — | — | | | — | — | | — | — | — | EPOXY FILL & OVEN BAKE |
| | | | | SETUP | — | — | | | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | 3.0 | | 1 | 1.0 | .1 | # OC0363 | | 1.0 | .75 | |
| 525 | | ASS'Y. | 1.0 | TRANSIT | — | — | | | | | | | | | NOTE: CASE IS SOLDER SEALED AT THIS OPER. |
| | | | | SETUP | — | — | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 1.0 | .30 | SOLDER 30 BENCH | 1 | 1.0 | .30 | |
| 530 | | TEST | 1.0 | TRANSIT | — | — | | 1 | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .10 | # OC3952 | 1 | 1.0 | .10 | |

# OPERATION PROFILE

NAME Carter ALC OC DATE 4/24/89 RCC MAT PCA SHEET 5 OF 6

NSN 5805-93A WCD CAEC II WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 540 | MAT PCA | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | 1.0 | .5 | BY 10 | 1 | 1.0 | .10 | OC-3953 | 1 | 1.0 | .5 | |
| 560 | | PROC | 1.00 | TRANSIT | 1.0 | .20 | | | — | — | | | — | — | PAINT BOOTH - RELOCATE FOR LOGISTICS |
| | | | | SETUP | — | — | | — | 1.0 | .2 | | | — | — | |
| | | | | PROCESS | 1.0 | 4.0 | | 1 | 1.0 | .3 | W53 | 1 | 1.0 | .75 | NO NUMBER PAINT BOOTH |
| 570 | | TEST | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .15 | OC 4929 | 1 | 1.0 | .15 | ELEC TEST BENCH |
| 650 | | PROC | 1.00 | TRANSIT | — | — | | — | — | — | | — | — | — | |
| | | | | SETUP | — | — | | — | — | — | | — | — | — | |
| | | | | PROCESS | — | — | | 1 | 1.0 | .05 | BENCH ? | 1 | 1.0 | .05 | INSTALL SAFETY WIRE |
| 670 | MAT PCA | PH | 1.00 | TRANSIT | — | — | | | | | | — | — | — | |
| | | | | SETUP | — | — | | | | | | — | — | — | |
| | | | | PROCESS | — | — | BY10 | 1 | 1.0 | .1 | BENCH ? | 1 | 1.0 | .10 | |

LSC-2(XX)2C

# OPERATION PROFILE

NAME J. CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 6 OF 6

CN
NSN
PN 98093A WCD CAEC11 ✓ WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 580 | MAT PCA | PH | 1.0 | TRANSIT | — | — | BY | — | — | — | — | — | — | — | |
| | | | | SETUP | — | — | 10 | — | — | — | — | — | — | — | |
| | | | | PROCESS | — | — | — | 1.0 | 1.0 | .10 | 2 BENCH | 1 | 1.0 | .10 | |
| 9999 | | OUT | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | 1.0 | 20.6 | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

# FLOW PROCESS CHART

SUBJECT 98093A DATE 5-6-89

ITEM CODE
PCN ☐
MSN. ☐
P/N ☐

WCD CAEC11 WCD DATE 89045

CHART BEGINS OP 010

CHART ENDS OP 680 PREPARED BY

| OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION | OP. PROFILE OP. NO. | WCD OP. NO. | SYMBOLS | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 010 | 010 | ●◇D□▽ | REC | 530 | 570 | ●◇D□▽ | TEST |
| 015 | 015 | ●◇D□▽ | PW | 540 | 580 | ●◇D□▽ | |
| 020 | 020 | ●◇D□▽ | DISASSEMB | 560 | 590 | ●◇D□▽ | PAINT |
| | 025 | ○◇D□▽ | REPAIR* | | 595 | ●◇D□▽ | |
| 030 | 030 | ●◇D□▽ | CLEAN | 570 | 610 | ●◇D□▽ | TEST |
| | 040 | ●◇D□▽ | INSP | 670 | 670 | ●◇D□▽ | PW |
| 060 | 060 | ○◇D□▽ | TEST | 650 | 680 | ●◇D□▽ | SAF WIRE |
| | 100 | ○◇D□▽ | TEST | 660 | 690 | ●◇D□▽ | PW |
| 070 | 160 | ○◇D□▽ | TEST | - | 700 | ●◇D□▽ | |
| 080 | 210 | ○◇D□▽ | TEST | 680 | 710 | ●◇D□▽ | PW |
| | 220 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| | 270 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| 090 | 290 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| | 300 | ○◇D□▽ | TEST | | | ○◇D□▽ | |
| | 310 | ○◇D□▽<br>○◇D□▽ | TEST | | | ○◇D□▽<br>○◇D□▽ | |
| 100 | 320 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| | 330 | ○◇D□▽ | | | | ○◇D□▽ | |
| | 350 | ○◇D□▽ | | | | ○◇D□▽ | |
| | 360 | ○◇D□▽ | | | | ○◇D□▽ | |
| 120 | 380 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| 380 | 400 | ●◇D□▽ | REPAIR | | | ○◇D□▽ | |
| | 415 | ○◇D□▽ | | | | ○◇D□▽ | |
| | 450 | ○◇D□▽ | | | | ○◇D□▽ | |
| 390 | 480 | ●◇D□▽ | REASS | | | ○◇D□▽ | |
| | 490 | ○◇D□▽ | | | | ○◇D□▽ | |
| 460 | 500 | ●◇D□▽ | TEST | | | ○◇D□▽ | |
| 520 | 590 | ●◇D□▽ | Port BAKE | | | ○◇D□▽ | |
| | 550 | ○◇D□▽ | | | | ○◇D□▽ | |
| 525 | 560 | ●◇D□▽ | SOLDER CASE | | | ○◇D□▽ | |
| | 565 | ○◇D□▽ | | | | ○◇D□▽ | |
| | | ○◇D□▽ | | | | ○◇D□▽ | |

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

## 5.1 PROFILE DATA FILES

The profile data files for RCC MATPCA were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

## 5.2 MODEL INPUT FILES

The model input files for RCC MATPCA were previously submitted under memo number NKE-E016-7643, dated August 28, 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 MATPCA.

## 7.0 COMPUTER SIMULATION ANALYSIS OF RCC

The computer simulation analysis for RCC MATPCA was previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

## 8.0 VALIDATION OF SIMULATION ANALYSIS

The validation of simulation analysis for RCC MATPCA was previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

## 9.0 BRAINSTORMING

The minutes for RCC MATPCA brainstorming were previously submitted under memo number NKE-E016-7643, dated August 28, 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: ~~that~~ 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:

$L_n(J^k)$ ← capital J

Where N = number of experimental runs.

J = 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.

A note on noise: Control factors are those factors easily adjusted during product design and process design. Noise factors are ~~those~~ 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 MATPCA 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 and 10-2. 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 10-3. It lists the factors and levels which will form the experimental design. The use of this array reduces the number of experimental runs from 81 to nine. 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 10-4 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 | D |
|---|---|---|---|---|
| LEVEL: | 1 | 3 | 1 | 1 |

This configuration is interpreted as the following: (1) Add one OC 3906 Jet Ignition Tester on first shift, (2) Add two welders on first and second shifts, (3) Add one OC 4286 Temperature Amplifier Test Stand on first shift, and (4) Add one BY09 skill code position to first shift. Note that the average savings in flow time is a (simulated) 243.64 vs.

302.16 hours for the AS-IS condition. This savings in flow time would need to be compared against the cost of implementing these changes. The justification of expenditures for these changes might be more applicable if applied to surge conditions, when this reduction in flow time might prove more valuable.

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 MATPCA is a robust production area, well able to meet 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, and any change to personnel or equipment needs could have an effect on surge capability.

# MATPCA ELECTRICAL ACCESSORIES
# THROUGHPUT STATISTICAL ANALYSIS
TABLE [redacted] 10-1

| PART CONTROL NUMBER (PCN) | SIMULATED | FY 88 ACTUALS | % VARIANCE (SIM /ACTUALS) |
|---|---|---|---|
| 30056A | 86 | 87 | -1% |
| 30241A | 574 | 523 | 9% |
| 31151A | 326 | 327 | -.31% |
| 34044A | 159 | 158 | 1% |
| 34126A | 590 | 586 | 1% |
| 34252A | 126 | 126 | 0% |
| 34253A | 755 | 758 | -.40% |
| 34551A | 105 | 103 | 2% |
| 35023A | 258 | 255 | 1% |
| 35111A | 114 | 114 | 0% |
| 35113A | 137 | 136 | 1% |
| 35510A | 68 | 65 | 4% |
| 37719A | 493 | 488 | 1% |
| 38643A | 143 | 136 | 5% |
| 38645A | 299 | 268 | 10% |
| 38669A | 147 | 148 | -1% |
| 38694A | 287 | 289 | -1% |
| 38718A | 371 | 369 | 1% |
| 49315A | 1016 | 1000 | 2% |
| 49711A | 236 | 231 | 2% |
| 50217A | 14 | 14 | 0% |
| 50078A | 161 | 160 | 1% |
| 97133A | 141 | 141 | 0% |
| 98001A | 94 | 92 | 2% |
| 98093A | 504 | 501 | 1% |
| 61234A | 104 | 105 | -1% |
| SHOP AVERAGE | 7,308 | 7,180 | 2% |

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# MATPCA ELECTRICAL ACCESSORIES
# FLOW HOURS STATISTICAL ANALYSIS
## TABLE ~~6-19-2~~ 10-2

| PART CONTROL NUMBER (PCN) | SIMULATED | G-019-C | % VARIANCE (SIM /ACTUALS) |
|---|---|---|---|
| 30056A | 78.81 | 408 | -81% |
| 30241A | 269.95 | 264 | 2% |
| 31151A | 51.72 | 264 | -80% |
| 34044A | 172.72 | 216 | -20% |
| 34128A | 1204.78 | 240 | 80% |
| 34252A | 91.75 | 168 | -45% |
| 34253A | 163.91 | 168 | -2% |
| 34551A | 318.92 | 312 | 2% |
| 35023A | 298.99 | 360 | -17% |
| 35111A | 75.22 | 192 | -61% |
| 35113A | 131.44 | 192 | -32% |
| 35510A | 163.08 | 312 | -48% |
| 37719A | 125.24 | 192 | -35% |
| 38643A | 187.46 | 192 | -2% |
| 38645A | 1191.08 | 192 | 84% |
| 38669A | 154.79 | 312 | -50% |
| 38694A | 108.86 | 216 | -50% |
| 38718A | 281.85 | 336 | -16% |
| 49315A | 1115.23 | 240 | 78% |
| 49711A | 445.84 | 216 | 52% |
| 50217A | 318.84 | 192 | 40% |
| 50078A | 115.02 | 192 | -40% |
| 97133A | 86.84 | 288 | -70% |
| 98001A | 338.63 | 360 | 6% |
| 98093A | 193.42 | 336 | -42% |
| 61234A | 126.77 | 192 | -34% |
| SHOP AVERAGE | 302.16 | 252.0 | 17% |

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# MATPCA $L_9(3^4)$ TAGUCHI ORTHOGONAL ARRAY
# THROUGHPUT EXPERIMENTAL RESULTS - FY 90

TABLE [redacted] 10-3

| EXP # | EQUIPMENT QUANTITY | BACKSHOP | EQUIPMENT QUANTITY | MANPOWER ASSIGNED | NORMAL WORKLOAD | | |
|---|---|---|---|---|---|---|---|
| | | | | | AVG | BEST | WORST |
| 1 | ADD 1 OC 3906 | 3 WELDERS ON 1ST SHIFT | ADD 1 OC 4286 ON 1ST SHIFT | ADD 1 CODE BY ON 1ST SHIFT | 100% | 38128A / 107% | 40711A / 94% |
| 2 | ADD 1 OC 3906 | 4 WELDERS ON 1ST SHIFT | ADD 2 OC 4286 ON 1ST SHIFT | ADD 2 CODE BY ON 1ST SHIFT | 100% | 40818A / 100% | 40711A / 99% |
| 3 | ADD 1 OC 3906 | 2 WELDERS ON 1ST SHIFT and 2ND SHIFT | USE OC 4286 ON 2ND SHIFT | ADD 4 CODE BY ON 1ST SHIFT | 100% | 40818A / 100% | 40711A / 91% |
| 4 | ADD 2 OC 3906 | 3 WELDERS ON 1ST SHIFT | ADD 2 OC 4286 ON 1ST SHIFT | ADD 4 CODE BY ON 1ST SHIFT | 99% | 38043A / 100% | 40711A / 99% |
| 5 | ADD 2 OC 3906 | 4 WELDERS ON 1ST SHIFT | USE OC 4286 ON 2ND SHIFT | ADD 1 CODE BY ON 1ST SHIFT | 100% | 40818A / 100% | 40711A / 99% |
| 6 | ADD 2 OC 3906 | 2 WELDERS ON 1ST SHIFT and 2ND SHIFT | ADD 1 OC 4286 ON 1ST SHIFT | ADD 2 CODE BY ON 1ST SHIFT | 100% | 40818A / 107% | 40711A / 99% |
| 7 | 1 OC 3906 WITH 1/2 TIME | 3 WELDERS ON 1ST SHIFT | USE OC 4286 ON 2ND SHIFT | ADD 2 CODE BY ON 1ST SHIFT | 100% | 40818A / 100% | 40711A / 99% |
| 8 | 1 OC 3906 WITH 1/2 TIME | 4 WELDERS ON 1ST SHIFT | ADD 1 OC 4286 ON 1ST SHIFT | ADD 4 CODE BY ON 1ST SHIFT | 100% | 40818A / 100% | 40711A / 100% |
| 9 | 1 OC 3906 WITH 1/2 TIME | 2 WELDERS ON 1ST SHIFT and 2ND SHIFT | ADD 2 OC 4286 ON 1ST SHIFT | ADD 1 CODE BY ON 1ST SHIFT | 100% | 40818A / 100% | 40711A / 99% |

LSC-20497

# ANALYSIS OF EXPERIMENTAL FLOW TIME AVERAGES USING TAGUCHI METHOD ($L_9$)

TABLE [redacted] 10-4

## EXPERIMENTAL FLOW TIME AVERAGES -

| | |
|---|---|
| EXP. 1 | 251.22 |
| EXP. 2 | 239.08 |
| EXP. 3 | 238.65 |
| EXP. 4 | 275.43 |
| EXP. 5 | 237.96 |
| EXP. 6 | 232.85 |
| EXP. 7 | 276.63 |
| EXP. 8 | 247.76 |
| EXP. 9 | 251.12 |

$L_9(3^4)$

| NO | 1 | 2 | 3 | 4 |
|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 |
| 2 | 1 | 2 | 2 | 2 |
| 3 | 1 | 3 | 3 | 3 |
| 1 | 2 | 1 | 2 | 3 |
| 2 | 2 | 2 | 3 | 1 |
| 3 | 2 | 3 | 1 | 2 |
| 1 | 3 | 1 | 3 | 2 |
| 2 | 3 | 2 | 1 | 3 |
| 3 | 3 | 3 | 2 | 1 |

| FACTOR | LEVEL | |
|---|---|---|
| 1 | 1 | 242.96 |
| | 2 | 284.75 |
| | 3 | 256.50 |
| 2 | 1 | 267.76 |
| | 2 | 241.69 |
| | 3 | 240.87 |
| 3 | 1 | 243.94 |
| | 2 | 255.21 |
| | 3 | 251.06 |
| 4 | 1 | 246.77 |
| | 2 | 249.52 |
| | 3 | 253.95 |

# APPENDIX A

# TAGUCHI ANALYSIS BY PCN

# FOR EXPERIMENTAL RUNS

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 0C — RCC : RATPCA — PCN: 61234A — PCA61234

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 110.95 | 95.83333 |
| 2 | 1 | 2 | 2 | 2 | 125.98 | 91.22807 |
| 3 | 1 | 3 | 3 | 3 | 112.71 | 91.22807 |
| 4 | 2 | 1 | 2 | 3 | 119.72 | 89.47368 |
| 5 | 2 | 2 | 3 | 1 | 121.15 | 92.98245 |
| 6 | 2 | 3 | 1 | 2 | 110.95 | 100 |
| 7 | 3 | 1 | 3 | 2 | 125.88 | 91.22807 |
| 8 | 3 | 2 | 1 | 3 | 121.52 | 89.47368 |
| 9 | 3 | 3 | 2 | 1 | 130.8 | 92.98245 |
| | | | | | | |
| | | | TOTAL | | 1088 | 834 |
| | | | AVERAGE | | 120.9 | 92.7 |
| | | | MAXIMUM | | 130.8 | 100 |
| | | | MINIMUM | | 110.95 | 89.47368 |

| | FLOW TIME | | THRU PUT | | INRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 119.2 | 1.36 | 92.8 | 0.05 | 72 | 69 |
| A 2 | 117.3 | 2.96 | 94.2 | 1.55 | 57 | 52 |
| A 3 | 126.1 | -4.32 | 91.2 | -1.60 | 57 | 52 |
| B 1 | 121.5 | -0.55 | 92.2 | -0.58 | 57 | 51 |
| B 2 | 122.9 | -1.68 | 91.2 | -1.60 | 57 | 53 |
| B 3 | 118.2 | 2.23 | 94.7 | 2.18 | 55 | 55 |
| C 1 | 117.1 | 3.07 | 95.1 | 2.58 | 57 | 52 |
| C 2 | 125.5 | -3.85 | 91.2 | -1.60 | 57 | 51 |
| C 3 | 119.9 | 0.78 | 91.8 | -0.97 | 57 | 53 |
| D 1 | 123.6 | -2.30 | 93.9 | 1.31 | 0 | 0 |
| D 2 | 120.9 | -0.07 | 94.2 | 1.55 | 0 | 0 |
| D 3 | 118.0 | 2.37 | 90.1 | -2.86 | 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : OC — RCC : HATPCA — PCN: 90093A — PCA90893

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 171.43 | 100.5952 |
| 2 | 1 | 2 | 2 | 2 | 179.79 | 98.38187 |
| 3 | 1 | 3 | 3 | 3 | 178.3 | 98.38187 |
| 4 | 2 | 1 | 2 | 3 | 182.93 | 98.38187 |
| 5 | 2 | 2 | 3 | 1 | 177.5 | 98.38187 |
| 6 | 2 | 3 | 1 | 2 | 174.45 | 100.3460 |
| 7 | 3 | 1 | 3 | 2 | 183.17 | 98.38187 |
| 8 | 3 | 2 | 1 | 3 | 192.56 | 98.05825 |
| 9 | 3 | 3 | 2 | 1 | 192.46 | 98.38187 |
| | | | | | | |
| | | | TOTAL | | 1633 | 889 |
| | | | AVERAGE | | 181.4 | 98.8 |
| | | | MAXIMUM | | 192.56 | 100.5952 |
| | | | MINIMUM | | 171.43 | 98.05825 |

| | FLOW TIME | | THRU PUT | |
|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT |
| A 1 | 176.5 | 2.70 | 99.1 | 0.31 |
| A 2 | 178.3 | 1.71 | 99.0 | 0.23 |
| A 3 | 189.4 | -4.41 | 98.3 | -0.54 |
| B 1 | 179.2 | 1.23 | 99.1 | 0.31 |
| B 2 | 183.3 | -1.04 | 98.3 | -0.54 |
| B 3 | 181.7 | -0.19 | 99.0 | 0.23 |
| C 1 | 179.5 | 1.06 | 99.7 | 0.87 |
| C 2 | 185.1 | -2.02 | 98.4 | -0.43 |
| C 3 | 179.7 | 0.96 | 98.4 | -0.43 |
| D 1 | 180.5 | 0.52 | 99.1 | 0.31 |
| D 2 | 179.1 | 1.25 | 99.0 | 0.23 |
| D 3 | 184.6 | -1.76 | 98.3 | -0.54 |

| THRUPUT | |
|---|---|
| INDUCTIONS | SAMPLES |
| 168 | 169 |
| 309 | 304 |
| 309 | 304 |
| 309 | 304 |
| 309 | 304 |
| 289 | 290 |
| 309 | 304 |
| 309 | 303 |
| 309 | 304 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 0C — RCC : MATPCA — PCN: 98001A — PCA98001

QUARTERS =

INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 404.85 | 101.7241 |
| 2 | 1 | 2 | 2 | 2 | 299.05 | 102.1276 |
| 3 | 1 | 3 | 3 | 3 | 313.79 | 97.87234 |
| 4 | 2 | 1 | 2 | 3 | 483.56 | 100 |
| 5 | 2 | 2 | 3 | 1 | 290.76 | 97.87234 |
| 6 | 2 | 3 | 1 | 2 | 294.13 | 102 |
| 7 | 3 | 1 | 3 | 2 | 492.28 | 102.1276 |
| 8 | 3 | 2 | 1 | 3 | 364.75 | 100 |
| 9 | 3 | 3 | 2 | 1 | 376.26 | 95.74468 |
| | | | | | | |
| | | | TOTAL | | 3319 | 899 |
| | | | AVERAGE | | 368.8 | 99.9 |
| | | | MAXIMUM | | 492.28 | 102.1276 |
| | | | MINIMUM | | 290.76 | 95.74468 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 339.2 | 8.02 | 100.6 | 0.63 |
| A 2 | 356.2 | 3.44 | 100.0 | 0.02 |
| A 3 | 411.1 | -11.46 | 99.3 | -0.65 |
| B 1 | 460.2 | -24.78 | 101.3 | 1.34 |
| B 2 | 318.2 | 13.73 | 100.0 | 0.06 |
| B 3 | 328.1 | 11.05 | 98.5 | -1.40 |
| C 1 | 354.6 | 3.86 | 101.2 | 1.30 |
| C 2 | 386.3 | -4.74 | 99.3 | -0.65 |
| C 3 | 365.6 | 0.87 | 99.3 | -0.65 |
| D 1 | 357.3 | 3.13 | 98.4 | -1.49 |
| D 2 | 361.8 | 1.90 | 102.1 | 2.15 |
| D 3 | 387.4 | -5.03 | 99.3 | -0.65 |

| THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|
| 58 | 59 |
| 47 | 48 |
| 47 | 46 |
| 47 | 47 |
| 47 | 46 |
| 50 | 51 |
| 47 | 48 |
| 47 | 47 |
| 47 | 45 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 8C — RCC : MA7PCA — PCN: 971330 — PCa97133

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 90.2 | 102 |
| 2 | 1 | 2 | 2 | 2 | 84.07 | 98.83720 |
| 3 | 1 | 3 | 3 | 3 | 84.69 | 98.83720 |
| 4 | 2 | 1 | 2 | 3 | 83.65 | 98.83720 |
| 5 | 2 | 2 | 3 | 1 | 87.96 | 98.83720 |
| 6 | 2 | 3 | 1 | 2 | 84.54 | 98.92473 |
| 7 | 3 | 1 | 3 | 2 | 85.82 | 98.83720 |
| 8 | 3 | 2 | 1 | 3 | 85.01 | 98.83720 |
| 9 | 3 | 3 | 2 | 1 | 83.9 | 98.83720 |
| TOTAL | | | | | 770 | 893 |
| AVERAGE | | | | | 85.5 | 99.2 |
| MAXIMUM | | | | | 90.2 | 102 |
| MINIMUM | | | | | 83.65 | 98.83720 |

| FACTOR | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 86.3 | -0.91 | 99.9 | 0.70 |
| A 2 | 85.4 | 0.18 | 98.9 | -0.33 |
| A 3 | 84.9 | 0.73 | 98.8 | -0.36 |
| B 1 | 86.6 | -1.19 | 99.9 | 0.70 |
| B 2 | 85.7 | -0.17 | 98.8 | -0.36 |
| B 3 | 84.4 | 1.36 | 98.9 | -0.33 |
| C 1 | 86.6 | -1.22 | 99.9 | 0.73 |
| C 2 | 83.9 | 1.95 | 98.8 | -0.36 |
| C 3 | 86.2 | -0.72 | 98.8 | -0.36 |
| D 1 | 87.4 | -2.12 | 99.9 | 0.70 |
| D 2 | 84.8 | 0.85 | 98.9 | -0.33 |
| D 3 | 84.5 | 1.27 | 98.8 | -0.36 |

| THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|
| 50 | 51 |
| 86 | 85 |
| 86 | 85 |
| 86 | 85 |
| 86 | 85 |
| 86 | 85 |
| 93 | 92 |
| 86 | 85 |
| 86 | 85 |
| 86 | 85 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

GLC : QC — RCC : MATPCA — PCN: 50078 — PCA50078

QUARTERS =

INDUCTIONS =

| ROW NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 104.4 | 97.72727 |
| 2 | 1 | 2 | 2 | 2 | 100.24 | 98.63013 |
| 3 | 1 | 3 | 3 | 3 | 97.03 | 97.26027 |
| 4 | 2 | 1 | 2 | 3 | 104.06 | 94.52054 |
| 5 | 2 | 2 | 3 | 1 | 101.84 | 97.26027 |
| 6 | 2 | 3 | 1 | 2 | 97.19 | 100 |
| 7 | 3 | 1 | 3 | 2 | 101.55 | 97.26027 |
| 8 | 3 | 2 | 1 | 3 | 109.89 | 94.52054 |
| 9 | 3 | 3 | 2 | 1 | 115.42 | 98.63013 |
| | | | TOTAL | | 940 | 876 |
| | | | AVERAGE | | 104.4 | 97.3 |
| | | | MAXIMUM | | 115.42 | 100 |
| | | | MINIMUM | | 97.03 | 94.52054 |

| | FLOW TIME | | THRU PUT | | THRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 103.2 | 1.13 | 97.9 | 0.58 | 88 | 86 |
| A 2 | 101.8 | 3.23 | 97.3 | -0.05 | 73 | 72 |
| A 3 | 109.0 | -4.36 | 96.8 | -0.52 | 73 | 71 |
| B 1 | 103.3 | 1.02 | 96.5 | -0.83 | 73 | 69 |
| B 2 | 106.7 | -2.16 | 96.8 | -0.52 | 73 | 71 |
| B 3 | 103.2 | 1.14 | 98.6 | 1.35 | 75 | 75 |
| C 1 | 103.8 | 0.55 | 97.4 | 0.11 | 73 | 71 |
| C 2 | 109.2 | -4.63 | 97.3 | -0.05 | 73 | 69 |
| C 3 | 100.1 | 4.08 | 97.3 | -0.05 | 73 | 72 |
| D 1 | 107.2 | -2.70 | 97.9 | 0.58 | 0 | 0 |
| D 2 | 102.3 | 1.99 | 98.6 | 1.35 | 0 | 0 |
| D 3 | 103.7 | 0.71 | 95.4 | -1.93 | 0 | 0 |
| | 104.4 | -0.00 | 97.3 | -0.00 | | |
| | 109.2 | 4.08 | 98.6 | 1.35 | | |
| | 100.1 | -4.63 | 95.4 | -1.93 | | |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 8C — RCC : HATPCA — PCN: 50217A — PCA50217

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 244.69 | 99.29577 |
| 2 | 1 | 2 | 2 | 2 | 323.39 | 90 |
| 3 | 1 | 3 | 3 | 3 | 280.42 | 90 |
| 4 | 2 | 1 | 2 | 3 | 281.41 | 90 |
| 5 | 2 | 2 | 3 | 1 | 300.71 | 90 |
| 6 | 2 | 3 | 1 | 2 | 209.02 | 66.66666 |
| 7 | 3 | 1 | 3 | 2 | 282.59 | 90 |
| 8 | 3 | 2 | 1 | 3 | 330.3 | 90 |
| 9 | 3 | 3 | 2 | 1 | 319.9 | 90 |
| | | | | | | |
| | | | TOTAL | | 2592 | 796 |
| | | | AVERAGE | | 288.0 | 88.4 |
| | | | MAXIMUM | | 330.3 | 99.29577 |
| | | | MINIMUM | | 209.02 | 66.66666 |

| | FLOW TIME | | THRU PUT | | THRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 289.5 | -0.50 | 93.1 | 5.27 | 142 | 141 |
| A 2 | 263.7 | 8.45 | 82.2 | -7.03 | 10 | 9 |
| A 3 | 310.9 | -7.94 | 90.0 | 1.76 | 10 | 9 |
| B 1 | 276.2 | 4.10 | 93.1 | 5.27 | 10 | 9 |
| B 2 | 318.1 | -10.44 | 90.0 | 1.76 | 10 | 9 |
| B 3 | 269.8 | 6.34 | 82.2 | -7.03 | 3 | 2 |
| C 1 | 268.0 | 6.96 | 85.3 | -3.53 | 10 | 9 |
| C 2 | 308.2 | -7.01 | 90.0 | 1.76 | 10 | 9 |
| C 3 | 287.9 | 0.05 | 90.0 | 1.76 | 10 | 9 |
| D 1 | 295.1 | -2.45 | 93.1 | 5.27 | 0 | 0 |
| D 2 | 271.7 | 5.69 | 82.2 | -7.03 | 0 | 0 |
| D 3 | 297.4 | -3.24 | 90.0 | 1.76 | 0 | 0 |
| AVERAGE | 288.0 | 0.00 | 88.4 | -0.00 | | |
| MAXIMUM | 310.1 | 8.45 | 93.1 | 5.27 | | |
| MINIMUM | 263.7 | -10.44 | 82.2 | -7.03 | | |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : OC — RCC : HATPCA — PCN: 49711A — PCA49711

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 469.93 | 94.01709 |
| 2 | 1 | 2 | 2 | 2 | 332.59 | 96.07843 |
| 3 | 1 | 3 | 3 | 3 | 346.01 | 90.84967 |
| 4 | 2 | 1 | 2 | 3 | 560.66 | 90.19607 |
| 5 | 2 | 2 | 3 | 1 | 313.76 | 92.81045 |
| 6 | 2 | 3 | 1 | 2 | 316.9 | 97.41935 |
| 7 | 3 | 1 | 3 | 2 | 561.71 | 91.50326 |
| 8 | 3 | 2 | 1 | 3 | 403.67 | 92.81045 |
| 9 | 3 | 3 | 2 | 1 | 416.6 | 92.15686 |
| TOTAL | | | | | 3722 | 838 |
| AVERAGE | | | | | 413.5 | 93.1 |
| MAXIMUM | | | | | 561.71 | 97.41935 |
| MINIMUM | | | | | 313.76 | 90.19607 |

| FACTOR | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 382.8 | 7.42 | 93.6 | 0.60 |
| A 2 | 397.1 | 3.97 | 93.5 | 0.41 |
| A 3 | 460.7 | -11.40 | 92.2 | -1.01 |
| B 1 | 530.8 | -28.35 | 91.9 | -1.28 |
| B 2 | 350.0 | 15.36 | 93.9 | 0.87 |
| B 3 | 359.8 | 12.99 | 93.5 | 0.41 |
| C 1 | 396.8 | 4.04 | 94.7 | 1.78 |
| C 2 | 436.6 | -5.58 | 92.8 | -0.30 |
| C 3 | 407.2 | 1.54 | 91.7 | -1.47 |
| D 1 | 400.1 | 3.25 | 93.0 | -0.11 |
| D 2 | 403.7 | 2.37 | 95.0 | 2.05 |
| D 3 | 436.8 | -5.62 | 91.3 | -1.94 |

| THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|
| 117 | 110 |
| 153 | 147 |
| 153 | 139 |
| 153 | 138 |
| 153 | 142 |
| 155 | 151 |
| 153 | 140 |
| 155 | 142 |
| 153 | 141 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : BC — RCC : MATPCA — PCN: 49315A — PCA49315A

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 1237.48 | 95.95238 |
| 2 | 1 | 2 | 2 | 2 | 1129.3 | 109.5238 |
| 3 | 1 | 3 | 3 | 3 | 1136.16 | 109.7142 |
| 4 | 2 | 1 | 2 | 3 | 1560.13 | 102.8571 |
| 5 | 2 | 2 | 3 | 1 | 1124.56 | 109.5238 |
| 6 | 2 | 3 | 1 | 2 | 1137.2 | 107.4003 |
| 7 | 3 | 1 | 3 | 2 | 1565.33 | 103.2380 |
| 8 | 3 | 2 | 1 | 3 | 1125.97 | 109.5238 |
| 9 | 3 | 3 | 2 | 1 | 1141.55 | 109.1428 |
| | | | | | | |
| | | | TOTAL | | 11162 | 957 |
| | | | AVERAGE | | 1240.2 | 106.3 |
| | | | MAXIMUM | | 1560.13 | 109.7142 |
| | | | MINIMUM | | 1124.56 | 95.95238 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 1166.3 | 5.96 | 105.1 | -1.18 |
| A 2 | 1276.6 | -2.94 | 106.6 | 0.26 |
| A 3 | 1277.6 | -3.02 | 107.3 | 0.92 |
| B 1 | 1457.0 | -17.48 | 100.7 | -5.30 |
| B 2 | 1125.3 | 9.27 | 109.5 | 3.01 |
| B 3 | 1138.3 | 8.22 | 100.8 | 2.29 |
| C 1 | 1166.9 | 5.91 | 104.3 | -1.91 |
| C 2 | 1278.3 | -3.08 | 107.2 | 0.80 |
| C 3 | 1275.4 | -2.84 | 107.5 | 1.10 |
| D 1 | 1167.9 | 5.83 | 104.9 | -1.36 |
| D 2 | 1275.9 | -2.88 | 106.7 | 0.38 |
| D 3 | 1276.8 | -2.95 | 107.4 | 0.98 |

| | INPUT INDUCTIONS | INPUT SAMPLES |
|---|---|---|
| | 420 | 403 |
| | 525 | 575 |
| | 525 | 576 |
| | 525 | 540 |
| | 525 | 575 |
| | 527 | 566 |
| | 525 | 542 |
| | 525 | 575 |
| | 525 | 573 |
| | 0 | 0 |
| | 0 | 0 |
| | 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 0C — RCC : MATPCA — PCN: 38718A — PCA38718

QUARTERS =

INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 279.34 | 97.70992 |
| 2 | 1 | 2 | 2 | 2 | 281.83 | 97.34042 |
| 3 | 1 | 3 | 3 | 3 | 281.71 | 97.34042 |
| 4 | 2 | 1 | 2 | 3 | 281.54 | 97.34042 |
| 5 | 2 | 2 | 3 | 1 | 281.49 | 97.34042 |
| 6 | 2 | 3 | 1 | 2 | 280.56 | 104.3956 |
| 7 | 3 | 1 | 3 | 2 | 281.71 | 97.34042 |
| 8 | 3 | 2 | 1 | 3 | 282.96 | 97.34042 |
| 9 | 3 | 3 | 2 | 1 | 282.74 | 97.34042 |
| TOTAL | | | | | 2534 | 883 |
| AVERAGE | | | | | 281.5 | 98.2 |
| MAXIMUM | | | | | 282.96 | 104.3956 |
| MINIMUM | | | | | 279.34 | 97.34042 |

| FACTOR | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 281.0 | 0.21 | 97.5 | -0.71 |
| A 2 | 281.2 | 0.12 | 99.7 | 1.56 |
| A 3 | 282.5 | -0.33 | 97.3 | -0.84 |
| B 1 | 280.9 | 0.24 | 97.5 | -0.71 |
| B 2 | 282.1 | -0.20 | 97.3 | -0.84 |
| B 3 | 281.7 | -0.05 | 99.7 | 1.56 |
| C 1 | 281.0 | 0.21 | 99.8 | 1.68 |
| C 2 | 282.0 | -0.18 | 97.3 | -0.84 |
| C 3 | 281.6 | -0.03 | 97.3 | -0.84 |
| D 1 | 281.2 | 0.13 | 97.5 | -0.71 |
| D 2 | 281.4 | 0.06 | 99.7 | 1.56 |
| D 3 | 282.1 | -0.19 | 97.3 | -0.84 |

| THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|
| 151 | 120 |
| 188 | 183 |
| 188 | 183 |
| 188 | 183 |
| 188 | 183 |
| 182 | 190 |
| 188 | 183 |
| 188 | 183 |
| 188 | 183 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 8C — RCC : MATPCA — PCN: 38694A — PCA38694

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 117.32 | 97.98737 |
| 2 | 1 | 2 | 2 | 2 | 109.51 | 98.78787 |
| 3 | 1 | 3 | 3 | 3 | 110.44 | 99.39393 |
| 4 | 2 | 1 | 2 | 3 | 119.48 | 99.39393 |
| 5 | 2 | 2 | 3 | 1 | 114.69 | 100.6060 |
| 6 | 2 | 3 | 1 | 2 | 109.45 | 100 |
| 7 | 3 | 1 | 3 | 2 | 119.47 | 100 |
| 8 | 3 | 2 | 1 | 3 | 112.28 | 99.39393 |
| 9 | 3 | 3 | 2 | 1 | 109.75 | 98.78787 |
| | | | | | TOTAL | 1022 | 893 |
| | | | | | AVERAGE | 113.6 | 99.3 |
| | | | | | MAXIMUM | 119.48 | 100.6060 |
| | | | | | MINIMUM | 109.45 | 97.98737 |

| | FLOW TIME | | THRU PUT | |
|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT |
| A 1 | 112.4 | 1.03 | 98.4 | -0.86 |
| A 2 | 114.5 | -0.83 | 100.0 | 0.73 |
| A 3 | 113.8 | -0.21 | 99.4 | 0.12 |
| B 1 | 118.8 | -4.54 | 98.8 | -0.45 |
| B 2 | 112.2 | 1.27 | 99.6 | 0.33 |
| B 3 | 109.9 | 3.27 | 99.4 | 0.12 |
| C 1 | 113.0 | 0.51 | 98.8 | -0.45 |
| C 2 | 112.9 | 0.60 | 99.0 | -0.28 |
| C 3 | 114.9 | -1.12 | 100.0 | 0.73 |
| D 1 | 113.9 | -0.28 | 98.8 | -0.45 |
| D 2 | 112.8 | 0.69 | 99.6 | 0.33 |
| D 3 | 114.1 | -0.41 | 99.4 | 0.12 |
| | 113.6 | 0.00 | 99.3 | -0.00 |
| | 118.8 | 3.27 | 100.0 | 0.73 |
| | 109.9 | -4.54 | 98.4 | -0.86 |

| THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|
| 163 | 100 |
| 165 | 163 |
| 165 | 164 |
| 165 | 164 |
| 165 | 166 |
| 156 | 156 |
| 165 | 165 |
| 165 | 164 |
| 165 | 163 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 38669A PCA38669

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 142.64 | 100 |
| 2 | 1 | 2 | 2 | 2 | 142.32 | 101.3698 |
| 3 | 1 | 3 | 3 | 3 | 142.05 | 100 |
| 4 | 2 | 1 | 2 | 3 | 139.04 | 100 |
| 5 | 2 | 2 | 3 | 1 | 138.8 | 100 |
| 6 | 2 | 3 | 1 | 2 | 139.01 | 100 |
| 7 | 3 | 1 | 3 | 2 | 141.59 | 100 |
| 8 | 3 | 2 | 1 | 3 | 147.06 | 100 |
| 9 | 3 | 3 | 2 | 1 | 150.85 | 100 |
| | | | TOTAL | | 1283 | 901 |
| | | | AVERAGE | | 142.6 | 100.2 |
| | | | MAXIMUM | | 150.85 | 101.3698 |
| | | | MINIMUM | | 138.8 | 100 |

| | FLOW TIME | | THRU PUT | | INPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 142.3 | 0.18 | 100.5 | 0.30 | 50 | 50 |
| A 2 | 139.0 | 2.55 | 100.0 | -0.15 | 73 | 74 |
| A 3 | 146.5 | -2.74 | 100.0 | -0.15 | 73 | 73 |
| B 1 | 141.1 | 1.05 | 100.0 | -0.15 | 73 | 73 |
| B 2 | 142.7 | -0.09 | 100.5 | 0.30 | 73 | 73 |
| B 3 | 144.0 | -0.96 | 100.0 | -0.15 | 76 | 76 |
| C 1 | 142.9 | -0.21 | 100.0 | -0.15 | 73 | 73 |
| C 2 | 144.1 | -1.04 | 100.5 | 0.30 | 73 | 73 |
| C 3 | 140.0 | 1.25 | 100.0 | -0.15 | 73 | 73 |
| D 1 | 144.1 | -1.05 | 100.0 | -0.15 | 0 | 0 |
| D 2 | 141.0 | 1.14 | 100.5 | 0.30 | 0 | 0 |
| D 3 | 142.7 | -0.09 | 100.0 | -0.15 | 0 | 0 |
| | 142.6 | -0.00 | 100.2 | 0.00 | | |
| | 146.5 | 2.55 | 100.5 | 0.30 | | |
| | 139.0 | -2.74 | 100.0 | -0.15 | | |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 0C — RCC : MATPCA — PCN: 30643A — PCA38643

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 106.04 | 99.04761 |
| 2 | 1 | 2 | 2 | 2 | 75.96 | 99.33774 |
| 3 | 1 | 3 | 3 | 3 | 101.75 | 98.67549 |
| 4 | 2 | 1 | 2 | 3 | 116.03 | 98.67549 |
| 5 | 2 | 2 | 3 | 1 | 119.55 | 101.3245 |
| 6 | 2 | 3 | 1 | 2 | 109.95 | 102.0134 |
| 7 | 3 | 1 | 3 | 2 | 101.17 | 100 |
| 8 | 3 | 2 | 1 | 3 | 79.35 | 99.33774 |
| 9 | 3 | 3 | 2 | 1 | 75.97 | 99.33774 |
| | | | | | | |
| | | | TOTAL | | 886 | 898 |
| | | | AVERAGE | | 98.4 | 99.7 |
| | | | MAXIMUM | | 119.55 | 102.0134 |
| | | | MINIMUM | | 75.96 | 98.67549 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 94.6 | 3.90 | 99.0 | -0.73 |
| A 2 | 115.2 | -17.03 | 100.7 | 0.92 |
| A 3 | 85.5 | 13.13 | 99.6 | -0.19 |
| B 1 | 107.7 | -9.40 | 99.2 | -0.51 |
| B 2 | 91.6 | 6.91 | 100.0 | 0.25 |
| B 3 | 95.9 | 2.57 | 100.0 | 0.26 |
| C 1 | 98.4 | -0.03 | 100.1 | 0.38 |
| C 2 | 89.3 | 9.25 | 99.1 | -0.63 |
| C 3 | 107.5 | -9.22 | 100.0 | 0.25 |
| D 1 | 100.5 | -2.13 | 99.9 | 0.15 |
| D 2 | 95.7 | 2.77 | 100.5 | 0.70 |
| D 3 | 99.0 | -0.63 | 98.9 | -0.86 |
| | 98.4 | 0.00 | 99.7 | -0.00 |
| | 115.2 | 13.13 | 100.7 | 0.92 |
| | 85.5 | -17.03 | 98.9 | -0.86 |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALE : BC RCC : MAIPCA PCN: 38643A PCA38643

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 93.18 | 101.7543 |
| 2 | 1 | 2 | 2 | 2 | 107.96 | 104.3478 |
| 3 | 1 | 3 | 3 | 3 | 125.21 | 104.3478 |
| 4 | 2 | 1 | 2 | 3 | 102.75 | 104.3478 |
| 5 | 2 | 2 | 3 | 1 | 115.18 | 104.3478 |
| 6 | 2 | 3 | 1 | 2 | 117.53 | 95.78947 |
| 7 | 3 | 1 | 3 | 2 | 123.5 | 102.1739 |
| 8 | 3 | 2 | 1 | 3 | 104.12 | 104.3478 |
| 9 | 3 | 3 | 2 | 1 | 99.85 | 104.3478 |
| TOTAL | | | | | 989 | 926 |
| AVERAGE | | | | | 109.9 | 102.9 |
| MAXIMUM | | | | | 125.21 | 104.3478 |
| MINIMUM | | | | | 93.18 | 95.78947 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 108.8 | 1.03 | 103.5 | 0.60 |
| A 2 | 111.8 | -1.73 | 101.5 | -1.33 |
| A 3 | 109.2 | 0.69 | 103.6 | 0.73 |
| B 1 | 106.5 | 3.13 | 102.8 | -0.11 |
| B 2 | 109.1 | 0.76 | 104.3 | 1.44 |
| B 3 | 114.2 | -3.89 | 101.5 | -1.33 |
| C 1 | 104.9 | 4.53 | 100.6 | -2.17 |
| C 2 | 103.5 | 5.82 | 104.3 | 1.44 |
| C 3 | 121.3 | -10.35 | 103.6 | 0.73 |
| D 1 | 102.7 | 6.54 | 103.5 | 0.60 |
| D 2 | 116.3 | -5.83 | 100.8 | -2.04 |
| D 3 | 110.7 | -0.70 | 104.3 | 1.44 |
| | 109.9 | 0.00 | 102.9 | 0.00 |
| | 121.3 | 6.54 | 104.3 | 1.44 |
| | 102.7 | -10.35 | 100.6 | -2.17 |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : DC RCC : RATPCA PCN: 37719A PCA37719

QUARTERS =

INJECTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 119.50 | 98.61751 |
| 2 | 1 | 2 | 2 | 2 | 120.13 | 101.1952 |
| 3 | 1 | 3 | 3 | 3 | 121.35 | 101.1952 |
| 4 | 2 | 1 | 2 | 3 | 120.0 | 101.1952 |
| 5 | 2 | 2 | 3 | 1 | 120.88 | 101.1952 |
| 6 | 2 | 3 | 1 | 2 | 121.09 | 101.6129 |
| 7 | 3 | 1 | 3 | 2 | 120.01 | 101.1952 |
| 8 | 3 | 2 | 1 | 3 | 121.57 | 101.1952 |
| 9 | 3 | 3 | 2 | 1 | 121.05 | 101.1952 |
| | | | | | | |
| | | | TOTAL | | 1087 | 909 |
| | | | AVERAGE | | 120.8 | 101.0 |
| | | | MAXIMUM | | 121.57 | 101.6129 |
| | | | MINIMUM | | 119.50 | 98.61751 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 120.4 | -0.69 | 100.3 | -0.61 |
| A 2 | 0.0 | 100.00 | 101.3 | 0.38 |
| A 3 | 121.1 | -9.40 | 101.2 | 0.24 |
| B 1 | 120.4 | -0.73 | 100.3 | -0.61 |
| B 2 | 120.9 | -9.15 | 101.2 | 0.24 |
| B 3 | 121.2 | -9.42 | 101.3 | 0.38 |
| C 1 | 120.7 | -9.05 | 100.5 | -0.48 |
| C 2 | 120.7 | -8.97 | 101.2 | 0.24 |
| C 3 | 121.0 | -9.29 | 101.2 | 0.24 |
| D 1 | 120.5 | -8.83 | 100.3 | -0.61 |
| D 2 | 120.7 | -8.98 | 101.3 | 0.38 |
| D 3 | 121.2 | -9.49 | 101.2 | 0.24 |
| | 110.7 | 0.00 | 101.0 | 0.00 |
| | 121.2 | 100.00 | 101.3 | 0.38 |
| | 0.0 | -9.49 | 100.3 | -0.61 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 0C — ACC : MATPCA — PCN: 35510A — PCA35510A

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 140.02 | 100 |
| 2 | 1 | 2 | 2 | 2 | 152.66 | 106.25 |
| 3 | 1 | 3 | 3 | 3 | 139.00 | 100 |
| 4 | 2 | 1 | 2 | 3 | 141.04 | 103.125 |
| 5 | 2 | 2 | 3 | 1 | 148.4 | 106.25 |
| 6 | 2 | 3 | 1 | 2 | 126.43 | 138.2352 |
| 7 | 3 | 1 | 3 | 2 | 153.57 | 106.25 |
| 8 | 3 | 2 | 1 | 3 | 157.87 | 109.375 |
| 9 | 3 | 3 | 2 | 1 | 169.85 | 100 |
| | | | | | | |
| | | | TOTAL | | 1329 | 969 |
| | | | AVERAGE | | 147.7 | 107.7 |
| | | | MAXIMUM | | 169.85 | 138.2352 |
| | | | MINIMUM | | 126.43 | 100 |

| | FLOW TIME | | THRU PUT | | THRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 143.9 | 2.53 | 102.1 | -5.23 | 44 | 44 |
| A 2 | 138.6 | 6.12 | 115.9 | 7.57 | 32 | 34 |
| A 3 | 160.4 | -8.65 | 105.2 | -2.33 | 32 | 32 |
| B 1 | 144.9 | 1.88 | 103.1 | -4.27 | 32 | 33 |
| B 2 | 153.0 | -3.60 | 107.3 | -0.40 | 32 | 34 |
| B 3 | 145.1 | 1.72 | 112.7 | 4.66 | 34 | 47 |
| C 1 | 141.4 | 4.21 | 115.9 | 7.57 | 32 | 34 |
| C 2 | 154.5 | -4.65 | 103.1 | -4.27 | 32 | 35 |
| C 3 | 147.0 | 0.43 | 104.2 | -3.30 | 32 | 32 |
| D 1 | 152.8 | -3.45 | 102.1 | -5.23 | 0 | 0 |
| D 2 | 144.2 | 2.33 | 116.9 | 8.53 | 0 | 0 |
| D 3 | 146.0 | 1.12 | 104.2 | -3.30 | 0 | 0 |
| | 147.7 | -0.00 | 107.7 | 0.00 | | |
| | 160.4 | 6.12 | 116.9 | 8.53 | | |
| | 138.6 | -8.65 | 102.1 | -5.23 | | |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : BC BCC : MATPCA PCN: 35113A PCA35113A

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 122.65 | 100 |
| 2 | 1 | 2 | 2 | 2 | 129.34 | 94.20289 |
| 3 | 1 | 3 | 3 | 3 | 126.72 | 92.75362 |
| 4 | 2 | 1 | 2 | 3 | 135.22 | 92.75362 |
| 5 | 2 | 2 | 3 | 1 | 129.07 | 92.75362 |
| 6 | 2 | 3 | 1 | 2 | 129.03 | 101.0101 |
| 7 | 3 | 1 | 3 | 2 | 131.92 | 92.75362 |
| 8 | 3 | 2 | 1 | 3 | 133.5 | 92.75362 |
| 9 | 3 | 3 | 2 | 1 | 130.87 | 94.20289 |
| | | | | | | |
| | | | TOTAL | | 1160 | 854 |
| | | | AVERAGE | | 129.8 | 94.9 |
| | | | MAXIMUM | | 135.22 | 101.0101 |
| | | | MINIMUM | | 122.65 | 92.75362 |

| | FLOW TIME | | THRU PUT | | INPUT | |
|---|---|---|---|---|---|---|
| | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 126.2 | 2.76 | 95.7 | 0.81 | 62 | 62 |
| A 2 | 131.1 | -1.00 | 95.8 | 0.93 | 69 | 65 |
| A 3 | 132.1 | -1.76 | 93.2 | -1.74 | 69 | 64 |
| B 1 | 129.9 | -0.09 | 95.2 | 0.30 | 69 | 64 |
| B 2 | 130.6 | -0.63 | 93.2 | -1.74 | 69 | 64 |
| B 3 | 128.9 | 0.72 | 96.3 | 1.44 | 55 | 56 |
| C 1 | 128.4 | 1.09 | 98.2 | 3.48 | 69 | 64 |
| C 2 | 131.8 | -1.54 | 93.7 | -1.23 | 69 | 64 |
| C 3 | 129.2 | 0.44 | 92.8 | -2.25 | 69 | 65 |
| D 1 | 127.5 | 1.76 | 95.7 | 0.81 | 0 | 0 |
| D 2 | 130.1 | -0.22 | 96.3 | 1.44 | 0 | 0 |
| D 3 | 131.8 | -1.54 | 92.8 | -2.25 | 0 | 0 |
| | | | | | | |
| | 129.8 | 0.00 | 94.9 | 0.00 | | |
| | 132.1 | 2.76 | 98.2 | 3.48 | | |
| | 126.2 | -1.76 | 92.8 | -2.25 | | |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : HATPCA PCN: 35111A PCA35111A

QUARTERS =

INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 73.12 | 94.11764 |
| 2 | 1 | 2 | 2 | 2 | 72.66 | 98.38709 |
| 3 | 1 | 3 | 3 | 3 | 73.11 | 98.38709 |
| 4 | 2 | 1 | 2 | 3 | 72.03 | 98.38709 |
| 5 | 2 | 2 | 3 | 1 | 72.09 | 98.38709 |
| 6 | 2 | 3 | 1 | 2 | 74 | 101.8867 |
| 7 | 3 | 1 | 3 | 2 | 72.81 | 98.38709 |
| 8 | 3 | 2 | 1 | 3 | 72.07 | 98.38709 |
| 9 | 3 | 3 | 2 | 1 | 71.98 | 98.38709 |
| | | | | | | |
| | | | TOTAL | | 653 | 885 |
| | | | AVERAGE | | 72.6 | 98.3 |
| | | | MAXIMUM | | 74 | 101.8867 |
| | | | MINIMUM | | 71.98 | 94.11764 |

| | FLOW TIME | | THRU PUT | | THRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 72.8 | -0.24 | 97.0 | -1.36 | 51 | 49 |
| A 2 | 72.7 | -0.17 | 99.6 | 1.27 | 62 | 61 |
| A 3 | 72.3 | 0.41 | 98.4 | 0.09 | 62 | 61 |
| B 1 | 72.7 | -0.09 | 97.0 | -1.36 | 62 | 61 |
| B 2 | 72.1 | 0.71 | 98.4 | 0.09 | 62 | 61 |
| B 3 | 73.0 | -0.61 | 99.6 | 1.27 | 53 | 54 |
| C 1 | 73.1 | -0.66 | 98.1 | -0.17 | 62 | 61 |
| C 2 | 72.0 | 0.77 | 98.4 | 0.09 | 62 | 61 |
| C 3 | 72.7 | -0.12 | 98.4 | 0.09 | 62 | 61 |
| D 1 | 72.4 | 0.26 | 97.0 | -1.36 | 0 | 0 |
| D 2 | 73.0 | -0.51 | 99.6 | 1.27 | 0 | 0 |
| D 3 | 72.4 | 0.25 | 98.4 | 0.09 | 0 | 0 |
| | 72.6 | 0.00 | 98.3 | -0.00 | | |
| | 73.1 | 0.77 | 99.6 | 1.27 | | |
| | 72.0 | -0.66 | 97.0 | -1.36 | | |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : 0C — RCC : HATPCA — PCN: 35023A — PCA35023A

QUARTERS =

INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 200.54 | 102.0979 |
| 2 | 1 | 2 | 2 | 2 | 194.07 | 101.2345 |
| 3 | 1 | 3 | 3 | 3 | 192.07 | 100.6172 |
| 4 | 2 | 1 | 2 | 3 | 216.47 | 101.8518 |
| 5 | 2 | 2 | 3 | 1 | 184.72 | 100.6172 |
| 6 | 2 | 3 | 1 | 2 | 184.56 | 97.56097 |
| 7 | 3 | 1 | 3 | 2 | 219.72 | 101.8518 |
| 8 | 3 | 2 | 1 | 3 | 211.67 | 101.8518 |
| 9 | 3 | 3 | 2 | 1 | 231.15 | 101.8518 |
| | | | | | | |
| | | | TOTAL | | 1843 | 910 |
| | | | AVERAGE | | 204.8 | 101.1 |
| | | | MAXIMUM | | 231.15 | 102.0979 |
| | | | MINIMUM | | 184.56 | 97.56097 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 198.2 | 3.20 | 101.3 | 0.25 |
| A 2 | 195.3 | 4.65 | 100.0 | -1.04 |
| A 3 | 220.8 | -7.85 | 101.9 | 0.78 |
| B 1 | 214.9 | -4.95 | 101.9 | 0.87 |
| B 2 | 196.8 | 3.88 | 101.2 | 0.17 |
| B 3 | 202.6 | 1.07 | 100.0 | -1.04 |
| C 1 | 201.6 | 1.56 | 100.5 | -0.55 |
| C 2 | 213.9 | -4.45 | 101.6 | 0.58 |
| C 3 | 198.8 | 2.90 | 101.0 | -0.03 |
| D 1 | 208.1 | -1.64 | 101.5 | 0.46 |
| D 2 | 199.5 | 2.60 | 100.2 | -0.83 |
| D 3 | 206.7 | -0.96 | 101.4 | 0.38 |
| | 204.8 | -0.00 | 101.1 | -0.00 |
| | 220.8 | 4.65 | 101.9 | 0.87 |
| | 195.3 | -7.85 | 100.0 | -1.04 |

| | THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|---|
| | 163 | 166 |
| | 162 | 164 |
| | 162 | 163 |
| | 162 | 165 |
| | 162 | 163 |
| | 164 | 160 |
| | 162 | 165 |
| | 162 | 165 |
| | 162 | 165 |
| | 0 | 0 |
| | 0 | 0 |
| | 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : 0C ACC : MATPCA PCN: 34551A PCA34551

QUARTERS =

INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 315.57 | 102.1276 |
| 2 | 1 | 2 | 2 | 2 | 315.98 | 105.4545 |
| 3 | 1 | 3 | 3 | 3 | 315.9 | 105.4545 |
| 4 | 2 | 1 | 2 | 3 | 315.91 | 105.4545 |
| 5 | 2 | 2 | 3 | 1 | 316.38 | 105.4545 |
| 6 | 2 | 3 | 1 | 2 | 316.34 | 103.7037 |
| 7 | 3 | 1 | 3 | 2 | 316.36 | 105.4545 |
| 8 | 3 | 2 | 1 | 3 | 315.91 | 105.4545 |
| 9 | 3 | 3 | 2 | 1 | 316.46 | 105.4545 |
| | | | | | | |
| | | | TOTAL | | 2845 | 944 |
| | | | AVERAGE | | 316.1 | 104.9 |
| | | | MAXIMUM | | 316.46 | 105.4545 |
| | | | MINIMUM | | 315.57 | 102.1276 |

| FACTOR | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT | INPUT INDUCTIONS | INPUT SAMPLES |
|---|---|---|---|---|---|---|
| A 1 | 315.8 | 0.09 | 104.3 | -0.52 | 47 | 48 |
| A 2 | 316.2 | -0.04 | 104.9 | -0.02 | 55 | 58 |
| A 3 | 316.2 | -0.05 | 105.5 | 0.54 | 55 | 58 |
| B 1 | 315.9 | 0.05 | 104.3 | -0.52 | 55 | 58 |
| B 2 | 316.1 | -0.00 | 105.5 | 0.54 | 55 | 58 |
| B 3 | 316.2 | -0.05 | 104.9 | -0.02 | 54 | 56 |
| C 1 | 315.9 | 0.05 | 103.8 | -1.08 | 55 | 58 |
| C 2 | 316.1 | -0.01 | 105.5 | 0.54 | 55 | 58 |
| C 3 | 316.2 | -0.04 | 105.5 | 0.54 | 55 | 58 |
| D 1 | 316.1 | -0.01 | 104.3 | -0.52 | 0 | 0 |
| D 2 | 316.2 | -0.04 | 104.9 | -0.02 | 0 | 0 |
| D 3 | 315.9 | 0.06 | 105.5 | 0.54 | 0 | 0 |
| | 316.1 | -0.00 | 104.9 | 0.00 | | |
| | 316.2 | 0.09 | 105.5 | 0.54 | | |
| | 315.8 | -0.05 | 103.8 | -1.08 | | |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : QC — RCC : MATPCA — PCN: 34253A — PCA34253

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 148.67 | 100.0049 |
| 2 | 1 | 2 | 2 | 2 | 151.32 | 99.34426 |
| 3 | 1 | 3 | 3 | 3 | 142.34 | 99.34426 |
| 4 | 2 | 1 | 2 | 3 | 153.46 | 98.68852 |
| 5 | 2 | 2 | 3 | 1 | 150.5 | 99.67213 |
| 6 | 2 | 3 | 1 | 2 | 141.59 | 99.36305 |
| 7 | 3 | 1 | 3 | 2 | 144.69 | 99.01639 |
| 8 | 3 | 2 | 1 | 3 | 150.05 | 99.34426 |
| 9 | 3 | 3 | 2 | 1 | 150.12 | 99.34426 |
| | | | | | | |
| | | | TOTAL | | 1333 | 895 |
| | | | AVERAGE | | 148.1 | 99.4 |
| | | | MAXIMUM | | 153.46 | 100.0049 |
| | | | MINIMUM | | 141.59 | 98.68852 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 147.4 | 0.43 | 99.9 | 0.42 |
| A 2 | 148.5 | -0.29 | 99.2 | -0.20 |
| A 3 | 148.3 | -0.14 | 99.2 | -0.21 |
| B 1 | 148.9 | -0.58 | 99.5 | 0.09 |
| B 2 | 150.6 | -1.72 | 99.5 | 0.01 |
| B 3 | 144.7 | 2.30 | 99.4 | -0.09 |
| C 1 | 146.8 | 0.89 | 99.9 | 0.42 |
| C 2 | 151.6 | -2.90 | 99.1 | -0.32 |
| C 3 | 145.8 | 1.51 | 99.3 | -0.10 |
| D 1 | 149.8 | -1.14 | 100.0 | 0.53 |
| D 2 | 145.9 | 1.50 | 99.2 | -0.20 |
| D 3 | 148.6 | -0.36 | 99.1 | -0.32 |
| | 148.1 | -0.00 | 99.4 | 0.00 |
| | 151.6 | 2.30 | 100.0 | 0.53 |
| | 144.7 | -2.40 | 99.1 | -0.32 |

| THRUPUT INDUCTIONS | THRUPUT SAMPLES |
|---|---|
| 452 | 456 |
| 305 | 303 |
| 305 | 303 |
| 305 | 301 |
| 305 | 304 |
| 314 | 312 |
| 305 | 302 |
| 305 | 303 |
| 305 | 303 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : QC — RCC : MATPCA — PCN: 342526 — PCA34252

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 77.7 | 95.77464 |
| 2 | 1 | 2 | 2 | 2 | 79.51 | 101.9230 |
| 3 | 1 | 3 | 3 | 3 | 74.54 | 101.9230 |
| 4 | 2 | 1 | 2 | 3 | 80.73 | 100 |
| 5 | 2 | 2 | 3 | 1 | 80.26 | 101.9230 |
| 6 | 2 | 3 | 1 | 2 | 80.81 | 101.9607 |
| 7 | 3 | 1 | 3 | 2 | 75.82 | 100 |
| 8 | 3 | 2 | 1 | 3 | 83.69 | 100 |
| 9 | 3 | 3 | 2 | 1 | 80.36 | 101.9230 |
| TOTAL | | | | | 713 | 905 |
| AVERAGE | | | | | 79.3 | 100.6 |
| MAXIMUM | | | | | 83.69 | 101.9607 |
| MINIMUM | | | | | 74.54 | 95.77464 |

| FACTOR | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 77.3 | 2.55 | 99.9 | -0.73 |
| A 2 | 80.6 | -1.60 | 101.3 | 0.69 |
| A 3 | 80.0 | -0.87 | 100.6 | 0.04 |
| B 1 | 78.1 | 1.50 | 98.6 | -2.00 |
| B 2 | 81.2 | -2.38 | 101.3 | 0.67 |
| B 3 | 78.6 | 0.88 | 101.9 | 1.32 |
| C 1 | 80.7 | -1.85 | 99.2 | -1.35 |
| C 2 | 80.2 | -1.17 | 101.3 | 0.67 |
| C 3 | 76.9 | 3.02 | 101.3 | 0.67 |
| D 1 | 79.4 | -0.22 | 99.9 | -0.73 |
| D 2 | 78.7 | 0.70 | 101.3 | 0.69 |
| D 3 | 79.7 | -0.48 | 100.6 | 0.04 |

| INPUT INDUCTIONS | INPUT SAMPLES |
|---|---|
| 71 | 68 |
| 52 | 53 |
| 52 | 53 |
| 52 | 52 |
| 52 | 53 |
| 51 | 52 |
| 52 | 52 |
| 52 | 52 |
| 52 | 53 |
| 0 | 0 |
| 0 | 0 |
| 0 | 0 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| AVERAGE | 79.3 | 0.00 | 100.6 | -0.00 |
| MAXIMUM | 81.2 | 3.02 | 101.9 | 1.32 |
| MINIMUM | 76.9 | -2.38 | 98.6 | -2.00 |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 34120A PCA34120

QUARTERS =

INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 1202.93 | 107.0270 |
| 2 | 1 | 2 | 2 | 2 | 1203.93 | 99.04153 |
| 3 | 1 | 3 | 3 | 3 | 1202.53 | 99.04153 |
| 4 | 2 | 1 | 2 | 3 | 1201.83 | 99.04153 |
| 5 | 2 | 2 | 3 | 1 | 1204.02 | 99.04153 |
| 6 | 2 | 3 | 1 | 2 | 1203.07 | 97.36842 |
| 7 | 3 | 1 | 3 | 2 | 1202.05 | 99.04153 |
| 8 | 3 | 2 | 1 | 3 | 1202.29 | 99.04153 |
| 9 | 3 | 3 | 2 | 1 | 1204.25 | 99.04153 |
| | | | | | | |
| | | | TOTAL | | 10820 | 898 |
| | | | AVERAGE | | 1203.1 | 99.7 |
| | | | MAXIMUM | | 1204.25 | 107.0270 |
| | | | MINIMUM | | 1201.83 | 97.36842 |

| | FLOW TIME | | THRU PUT | | THRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 1203.1 | -0.00 | 101.7 | 1.97 | 370 | 396 |
| A 2 | 1203.0 | 0.01 | 98.5 | -1.26 | 313 | 310 |
| A 3 | 1203.1 | -0.00 | 99.0 | -0.70 | 313 | 310 |
| B 1 | 1202.5 | 0.04 | 101.7 | 1.97 | 313 | 310 |
| B 2 | 1203.4 | -0.03 | 99.0 | -0.70 | 313 | 310 |
| B 3 | 1203.3 | -0.02 | 98.5 | -1.26 | 304 | 296 |
| C 1 | 1202.8 | 0.03 | 101.1 | 1.41 | 315 | 310 |
| C 2 | 1203.3 | -0.02 | 99.0 | -0.70 | 313 | 310 |
| C 3 | .1 | -0.00 | 99.0 | -0.70 | 515 | 510 |
| D 1 | 1203.7 | -0.05 | 101.7 | 1.97 | 0 | 0 |
| D 2 | 1203.3 | -0.02 | 98.5 | -1.26 | 0 | 0 |
| D 3 | 1202.2 | 0.07 | 99.0 | -0.70 | 0 | 0 |
| | 1203.1 | 0.00 | 99.7 | 0.00 | | |
| | 1203.7 | 0.07 | 101.7 | 1.97 | | |
| | 1202.2 | -0.05 | 98.5 | -1.26 | | |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : BC — RCC : HATPCA — PCN: 31151A — PCA31151

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 49.42 | 99.48453 |
| 2 | 1 | 2 | 2 | 2 | 48.07 | 99.46808 |
| 3 | 1 | 3 | 3 | 3 | 48.4 | 99.46808 |
| 4 | 2 | 1 | 2 | 3 | 47.98 | 99.46808 |
| 5 | 2 | 2 | 3 | 1 | 48.24 | 99.46808 |
| 6 | 2 | 3 | 1 | 2 | 46.51 | 101.1363 |
| 7 | 3 | 1 | 3 | 2 | 48.41 | 99.46808 |
| 8 | 3 | 2 | 1 | 3 | 48.11 | 99.46808 |
| 9 | 3 | 3 | 2 | 1 | 47.96 | 99.46808 |
| | TOTAL | | | | 433 | 897 |
| | AVERAGE | | | | 48.1 | 99.7 |
| | MAXIMUM | | | | 49.42 | 101.1363 |
| | MINIMUM | | | | 46.51 | 99.46808 |

| | FLOW TIME | | THRU PUT | | THRUPUT | |
|---|---|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT | INDUCTIONS | SAMPLES |
| A 1 | 48.6 | -1.06 | 99.5 | -0.18 | 194 | 193 |
| A 2 | 47.6 | 1.13 | 100.0 | 0.37 | 188 | 187 |
| A 3 | 48.2 | -0.08 | 99.5 | -0.19 | 188 | 187 |
| B 1 | 48.6 | -1.08 | 99.5 | -0.18 | 188 | 187 |
| B 2 | 48.1 | -0.04 | 99.5 | 0.19 | 188 | 187 |
| B 3 | 47.6 | 1.04 | 100.0 | 0.37 | 176 | 178 |
| C 1 | 48.0 | 0.23 | 100.0 | 0.38 | 188 | 187 |
| C 2 | 48.0 | 0.25 | 99.5 | -0.19 | 188 | 187 |
| C 3 | 48.4 | -0.47 | 99.5 | -0.19 | 188 | 187 |
| D 1 | 48.5 | -0.87 | 99.5 | -0.18 | 0 | 0 |
| D 2 | 47.7 | 0.95 | 100.0 | 0.37 | 0 | 0 |
| D 3 | 48.2 | -0.09 | 99.5 | -0.19 | 0 | 0 |

TAGUCHI EXPERIMENT ANALYSIS — L9 ARRAY — 05-Sep-89

ALC : BC — RCC : MATPCA — PCN: 30241A — PCA30241

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 244.04 | 102.7777 |
| 2 | 1 | 2 | 2 | 2 | 217.68 | 101.6438 |
| 3 | 1 | 3 | 3 | 3 | 225 | 101.3698 |
| 4 | 2 | 1 | 2 | 3 | 298 | 100.2739 |
| 5 | 2 | 2 | 3 | 1 | 210.72 | 101.9178 |
| 6 | 2 | 3 | 1 | 2 | 221.26 | 101.4005 |
| 7 | 3 | 1 | 3 | 2 | 300.48 | 100 |
| 8 | 3 | 2 | 1 | 3 | 238.39 | 100.8219 |
| 9 | 3 | 3 | 2 | 1 | 266.24 | 99.72602 |
| | | | | | | |
| | | | TOTAL | | 2222 | 910 |
| | | | AVERAGE | | 246.9 | 101.1 |
| | | | MAXIMUM | | 300.48 | 102.7777 |
| | | | MINIMUM | | 210.72 | 99.72602 |

| | FLOW TIME | | THRU PUT | |
|---|---|---|---|---|
| FACTOR | EFFECT | PERCENT | EFFECT | PERCENT |
| A 1 | 228.9 | 7.28 | 101.9 | 0.82 |
| A 2 | 243.3 | 1.43 | 101.2 | 0.09 |
| A 3 | 268.4 | -8.71 | 100.2 | -0.91 |
| B 1 | 280.8 | -13.76 | 101.0 | -0.09 |
| B 2 | 222.3 | 9.97 | 101.5 | 0.35 |
| B 3 | 237.5 | 3.79 | 100.8 | -0.27 |
| C 1 | 234.6 | 4.98 | 101.7 | 0.56 |
| C 2 | 260.6 | -5.58 | 100.5 | -0.55 |
| C 3 | 245.4 | 0.59 | 101.1 | -0.01 |
| D 1 | 240.3 | 2.65 | 101.5 | 0.37 |
| D 2 | 246.5 | 0.16 | 101.0 | -0.09 |
| D 3 | 253.8 | -2.81 | 100.8 | -0.28 |
| | 246.9 | -0.00 | 101.1 | 0.00 |
| | 280.8 | 9.97 | 101.9 | 0.82 |
| | 222.3 | -13.76 | 100.2 | -0.91 |

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 30056A PCA30056

QUARTERS =
INDUCTIONS =

| RUN NO. | FACTOR A LEVEL | FACTOR B LEVEL | FACTOR C LEVEL | FACTOR D LEVEL | FLOW TIME RESULT | THRU PUT RESULT |
|---|---|---|---|---|---|---|
| 1 | 1 | 1 | 1 | 1 | 73.77 | 101.6949 |
| 2 | 1 | 2 | 2 | 2 | 75.69 | 100 |
| 3 | 1 | 3 | 3 | 3 | 75.67 | 100 |
| 4 | 2 | 1 | 2 | 3 | 75.66 | 100 |
| 5 | 2 | 2 | 3 | 1 | 75.83 | 100 |
| 6 | 2 | 3 | 1 | 2 | 69.04 | 97.56097 |
| 7 | 3 | 1 | 3 | 2 | 75.69 | 100 |
| 8 | 3 | 2 | 1 | 3 | 75.63 | 100 |
| 9 | 3 | 3 | 2 | 1 | 75.73 | 100 |
| | | | | | | |
| | | | TOTAL | | 673 | 899 |
| | | | AVERAGE | | 74.7 | 99.9 |
| | | | MAXIMUM | | 75.83 | 101.6949 |
| | | | MINIMUM | | 69.04 | 97.56097 |

| | FLOW TIME EFFECT | FLOW TIME PERCENT | THRU PUT EFFECT | THRU PUT PERCENT |
|---|---|---|---|---|
| A 1 | 75.0 | -0.40 | 100.6 | 0.65 |
| A 2 | 73.5 | 1.65 | 99.2 | -0.73 |
| A 3 | 75.7 | -1.25 | 100.0 | 0.08 |
| B 1 | 75.0 | -0.39 | 100.6 | 0.65 |
| B 2 | 75.7 | -1.30 | 100.0 | 0.08 |
| B 3 | 73.5 | 1.69 | 99.2 | -0.73 |
| C 1 | 72.8 | 2.59 | 99.8 | -0.17 |
| C 2 | 75.7 | -1.27 | 100.0 | 0.08 |
| C 3 | 75.7 | -1.32 | 100.0 | 0.08 |
| D 1 | 75.1 | -0.49 | 100.6 | 0.65 |
| D 2 | 73.5 | 1.70 | 99.2 | -0.73 |
| D 3 | 75.7 | -1.21 | 100.0 | 0.08 |

# OPERATION PROFILE

NAME P HUNT ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 2

ITEM NSN 30241A PSC WCD CAEB05 WCD DATE 89033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME RECORDED % | EQUIPMENT TIME RECORDED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MATPCA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | NO BATCHING. DELIVERED IN GAUGE OF 2 TO 15. LEFT ON TABLE, NO PAPERWORK. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 50 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | ALT. OC NO'S ARE: 5720, 5718, 5719, 5721, 5722, 4906, 4647, 5802, 5801, 4908 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG 10 | 1 | 100 | .50 | OC4907 | 1 | 100 | .50 | |
| 55 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | NOTE ALT. OC NO'S IN OP 50. |
| | | | | SETUP | | | | | | | | | | | REPLACE COILS ON CAPACITORS (COILS) |
| | | | | PROCESS | — | — | | 1 | 100 | .25 | OC4907 | 1 | 100 | .25 | |
| 56 | | CHK | 1.0 | TRANSIT | | | | | | | | | | | TANK IS WATER, PRELIMINARY CHECK WITH NITROGEN. NO OC NO. ON TANK. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 100 | .17 | TANK | 1 | 100 | .25 | LEAK TEST |
| 360 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE ALT. OC NO'S IN OP. 50 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | 1 | 100 | .50 | OC4907 | 1 | 100 | .50 | |

LSC-20092C

AUG 15 '89 8:59 FROM AFLC TINKER OK

PAGE.008

# OPERATION PROFILE

NAME P HUNT ALC OKS DATE 8-10-89 RCC MATRCA SHEET 2 OF 2

PCN/WCN 30241 A WCD CAEB05 WCD DATE 89033

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 361 | MATRCA | CHK | 1.0 | TRANSIT | | | | | | | | | | | TANK IS WATER. PRESSURE CHECK WITH NITROGEN. NO GC ON TANK. LEAK TEST |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | WG10 | 1 | | .17 | TANK | 1 | | .17 | |
| 9999 | ↓ | OUT DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

LSC-200922C

AUG 15 '89 9:00 FROM AFLC TINKER OK PAGE.009

# OPERATION OFILE

NAME P. HUNT ALC OKC DATE 8-10-89 RCC MATRA SHEET 1 OF 1

PCN/REV 35023A WCD CAEY10 WCD DATE 89175

PIN

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MATRA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 110 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | ALT. NO'S ARE 4907, 5718, 5719, 5721, 5722, 4906 4647, 5802, 5801, 4908 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .50 | OC 0C5770 | 1 | 100 | .50 | |
| 340 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE ALT OC NO'S IN QR #0 |
| | | | | SETUP | | | | | | | | | | | WELD COVERS. |
| | | | | PROCESS | — | — | | 1 | 100 | .50 | 0C5720 | 1 | 100 | .50 | |
| 350 | | CHK | 1.0 | TRANSIT | | | | | | | | | | | PRESSURE CHK IN WATER TANK WITH NO OC NO.; USES LIQUID NITROGEN. TIME INCLUDES REMOVAL. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 100 | .17 | TANK | 1 | 100 | .50 | |
| 999 | | OUT DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

LSC-2000920

AUG 15 '89 9:01 FROM AFLC TINKER OK PAGE.010

# OPERATION PROFILE

NAME P HUNT ALC OKC DATE 8-10-89 NCC MATPCA SHEET 1 OF 1

PCN MCN 38694A WCD CAEM09 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FORMULAS % | MANDATORY FORMULAS MIN. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED MIN. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED MIN. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MSRA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | WG10 | | | | | | | | |
| 115 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | ALT. NO'S. ARE 4907, 5720 5719, 5721 5722 4906 4647 5802 5821 4908 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | | 1 | 100 | .17 | OC5719 | 1 | — | .17 | |
| 999 | | OUT DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

AUG 15 '89 9:02 FROM AFLC TINKER OK PAGE.011

# OPERATION PROFILE

NAME T. HUNT MC OKC DATE 8-10-09 RCC MATPCA SHEET 1 OF 1

NSN 38718A WCD CAEM10 WCD DATE 88239

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MAPCA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 175 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | ALT OC NOS ARE 4987, 5720, 5718, 5719, 5721, 4906, 4687 5802, 5801, 4905 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | W610 | 1 | 100 | .5 | OC5722 | 1 | — | .5 | |
| 255 | | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE ALT OC NOS IN OP 175 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | W610 | 1 | 100 | .67 | 045722 | 1 | | .67 | WELD COVER, [illegible] |
| 256 | | CHK | 1.0 | TRANSIT | | | | | | | | | | | WATER TANK HAS NO OC NO; PRESSURE CHECK USING NITROGEN |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | W610 | 1 | 100 | .17 | TANK | 1 | 100 | .17 | |
| 999 | | OUT DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

LSC-[illegible]

AUG 15 '89 9:03 FROM AFLC TINKER OK

PAGE.012

# OPERATION FILE

NAME P. HUNT ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 1

RCII NSN 49315A WCD CAEY09 WCD DATE 88307

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW TIMES % | MANDATORY FLOW TIMES HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MATPCA | IN DATE | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 105 | MATPCA | WELD. | 1.0 | TRANSIT | | | | | | | | | | | ALT. NO'S ARE 4907, 5720 5718, 5719, 5721, 5722, 4647, 5802, 5801, 4908 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | WU10 | 1 | 100 | 2.0 | DC4906 | 1 | 100 | 2.0 | |
| 999 | MATPCA | OUT DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| | | | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |

AUG 15 '89 9:04 FROM AFLC TINKER OK

# OPERATION PROFILE

NAME P. HUNT ALC OKC DATE 8-10-89 NCC MATPCA SHEET 1 OF 1

ECN NSN 4971IA PRI WCD CAEC07 WCD DATE 89045

| OPERATION NUMBER | NCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW HOURS % | MANDATORY FLOW HOURS HRS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED HRS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED HRS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MATPCA | IN DATE | | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 55 | MATPCA | WELD | 1.0 | TRANSIT | | | | | | | | | | | ALT OC NO'S ARE: 4967, 5720, 5718, 5719, 5724, 5722, 4647, 5802, 5801, 4908 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .67 | OC4906 | 1 | 100 | .67 | WELD EXTENSION STRIPS ONTO UNDERSIDE |
| 70 | MATPCA | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE OP. 55 FOR ALT. OC NO'S |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .25 | OC4906 | 1 | 100 | .25 | WELD FILTER AND CONNECTIONS |
| 270 | MATPCA | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE OP. 55 FOR ALT. OC NO'S. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .50 | OC4906 | 1 | 100 | .25 | WELD LID TO EXCITER |
| 271 | MATPCA | CHK | 1.0 | TRANSIT | | | | | | | | | | | WATER TANK HAS NO OC NO. USE NITROGEN TO PERFORM LEAK TEST. TIME INCLUDES AVG. REWORK. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .17 | TANK | 1 | 100 | .17 | |

AUG 15 '89 9:05 FROM AFLC TINKER OK PAGE.014

# OPERATION PROFILE

NAME P. HUNT ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 1

ECN NSN 98001A P/N WCD CAEC07 WCD DATE 89045

| OPERATION NUMBER | RCC | OPERATION DESCRIPTION | MANDATORY OCCURRENCE FACTOR | OPERATION TYPE | MANDATORY FLOW TIMING % | MANDATORY FLOW TIMING MTS. | MANPOWER SKILL CODE/ LEVEL | MANPOWER QTY. | MANPOWER TIME REQUIRED % | MANPOWER TIME REQUIRED MTS. | EQUIPMENT EQUIPMENT CODE | EQUIPMENT QTY. | EQUIPMENT TIME REQUIRED % | EQUIPMENT TIME REQUIRED MTS. | DATA SOURCE COMMENTS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | MATPCA | IN DATE | 1.0 | TRANSIT | | | | | | | | | | | |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | | | | | | | | | | | |
| 55 | MATPCA | WELD | 1.0 | TRANSIT | | | | | | | | | | | ALT OC NOS ARE: 4907, 5720, 5718, 5719, 5721, 5722, 4906, 5802, 5801, 4908 |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .67 | OC4967 | 1 | 100 | .67 | |
| 70 | MATPCA | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE ALT. NOS IN OP. 55 WELD FILLER AND IT. CONNECTIONS. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .67 | OC4967 | 1 | 100 | .67 | |
| 270 | MATPCA | WELD | 1.0 | TRANSIT | | | | | | | | | | | SEE ALT. NOS IN OP. 55 WELD LID TO EXCITER. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .50 | OC4967 | 1 | 100 | .50 | |
| 271 | MATPCA | CHK | 1.0 | TRANSIT | | | | | | | | | | | WATER TANK HAS NO OC NO.; LEAK CHECK USING NITROGEN. |
| | | | | SETUP | | | | | | | | | | | |
| | | | | PROCESS | — | — | WG10 | 1 | 100 | .17 | TANK | 1 | 100 | .17 | |

AUG 15 '89 9:06 FROM AFLC TINKER OK PAGE.015

**TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM**

CONTROL NO. 89-037F

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

ALC OC DATE 05/13/89
RCC MATPCA ITEM NO. —
NOUN "General Suggestion"

IIO # 3

**TYPE PROPOSAL**

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

**CURRENT METHOD**

Much of the present testing equipment found in the MATPCA work areas are outdated and exhibit long down-times for repair. Both the technicians and the first line supervisory personnel express dissatisfaction with this equipment.

**PROPOSED METHOD**

A detailed study of the testing equipment should be performed in conjunction with an analysis of the forecasted demand of the presently worked items. If economically feasible, the testing equipment should be replaced with newer, more generalized testing equipment.

**BENEFIT OF CHANGE**

The benefits would be threefold:

(A) faster, more accurate testing of the individual items.
(B) Reduced down-time and lower maintenance costs of test equipment.
(C) more effective use of skilled employees time.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 201114

# COST BENEFIT [illegible] CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD HRS / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD HRS / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
|---|---|---|---|---|---|---|
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MATL | O.H. RATE | | | TOTAL COST |
|---|---|---|---|---|---|---|
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| | | | | TOTAL COST | | |

## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

**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** 05/15/89
**RCC** MATPCA **ITEM NO.** –
**NOUN** "General Suggestion"

IEO # 4

**CURRENT METHOD**

Several replacement parts shipped from outside manufacturers have been noted to have high failure rates after installation. Many of these items are electrical parts used in the accessory units worked by the MATPCA area. These electrical parts have a high damage potential from moisture, and several cases of improper packaging at the factory have been blamed for these failures.

**PROPOSED METHOD**

A parts tracking procedure should be designed and implemented that would identify the number and origin of failed parts drawn from new stock. This could easily be done by installing the appropriate data processing system into the existing system, and noting occurences of failures at the existing computer terminals already in place (notably the supervisors offices).

**BENEFIT OF CHANGE**

The benefits of this system, especially if incorporated into a large number of USAF support operations, could prove to be immense. The present system depends solely on the reporting of incidence of abnormal failure rates by the technicians themselves.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

SER[illegible]ES PROGRAM

## COST BENE[illegible]CULATIONS

### OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

### NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

### IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
|---|---|---|---|---|---|---|
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| | | | | | | |
| | | | | TOTAL COST | | |

### SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 8-1-v.54F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

ALC OC DATE 5/8/89
RCC MATPCA ITEM NO. — PHIL PARKER
NOUN General Suggestion

PIO # 5

**CURRENT METHOD**

Long delay times are occurring in backshop (specifically MATPCM and MATPIW) operations on items sent from MATPCA electrical repair unit. Time spent at backshop areas ranges from 24.0 - 72.0 hours. (These delays are seen in other backshop operations involving other RCCs).

**PROPOSED METHOD**

A detailed analysis of delivery schedules, operation times, and idle time after work completed should be performed. This data should be compared to revised and updated demand schedules for each item sent to back shop.

**BENEFIT OF CHANGE**

This analysis is important so that we may effectively streamline all operations for a particular end item, as well as provide a quicker response time for return to inventory (critical in a defense industry) of critical parts. It would allow increased productivity and more effective utilization of existing facilities and staff.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 2011-1A

SER. ES PROGRAM

## COST BENL T LCULATIONS

### OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
|---|---|---|---|---|---|---|
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| NOTES: | | | TOTAL COST | | | |

### NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
|---|---|---|---|---|---|---|
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| NOTES: | | | TOTAL COST | | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

### IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
|---|---|---|---|---|---|---|
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| | | | | TOTAL COST | | |

### SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ _____ | $ _____ |
| IMPLEMENTATION COSTS | - _____ | - _____ |
| NET SAVINGS | $ _____ | $ _____ |

ISC-20131A

TECHN.. GY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 8 - 56F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

ALC 0c DATE 5/16/89
RCC MATRA ITEM NO. —
NOUN General Suggestion

Phil Parker
PIO # 9

**CURRENT METHOD**

Many of the items worked in this RCC have RTV or potting compound used to anchor internal components as well as provide insulation. These materials are tedious to remove, requiring a great deal of skilled technician's time.

**PROPOSED METHOD**

A study should be performed to determine whether formed rubber housings or sheets could be substituted for the presently used RTV or potting compounds. Also, the use of phenolic blocks formed to hold components in place should be analyzed.

**BENEFIT OF CHANGE**

A great deal of time and effort could be reduced on the targeted electrical items if these suggested methods prove feasible. More effective use of resources and skilled technicians would occur.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 20131A

SE. CES PROGRAM

## COST BENL .r .LCULATIONS

### OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

### NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

### IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MATL | O.H. RATE | | | TOTAL COST |
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### SUMMARY

| | ANNUAL | ENTENDED |
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| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 81-057F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

ALC OC DATE 05/13/89
RCC MATPCA ITEM NO. —
NOUN "General Suggestion" - ALC wide

Phil Barker
PIO # 12

TYPE PROPOSAL
- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☒ OTHER Health & Safety

**CURRENT METHOD**

Several different types of hand tools have been observed in use in the Electrical Components Overhaul RCC (MATPCA). Many of these tools do not conform to presently recommended occupational Ergonomic - Human Factors Standards

**PROPOSED METHOD**

The replacement of many of the presently used hand tools, both manual and power, by ergonomically sound designs would increase worker efficiency by decreasing fatigue and wasted effort, as well as reduce the costs of worker compensation claims and lost time due to injury.

**BENEFIT OF CHANGE**

A great deal of information has been collected in recent years pertaining to the effects that incorrectly designed tools have on industrial workers. Decreased productivity as well as debilitating illnesses such as Carpal Tunnel Syndrome and reoccurring Tendonitis have been clearly demonstrated. These problems are easily corrected by selection of the proper tool designs (See attached data).

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 20131A

SER ES PROGRAM

## COST BENEI .. .LCULATIONS

### OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

### NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

### IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MATL | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

### SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 87-058F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

ALC OC DATE 5/6/87
RCC MATRCA ITEM NO. —
NOUN General suggestion

Phil Parker
PID # 15

**CURRENT METHOD**

Presently, an old refrigerator packed with dessicant is being used as a humidity control chamber. Many of the internal components of items worked in this ACC have a high damage potential from moisture exposure.

**PROPOSED METHOD**

The presently used system is very inadequate given the needs of this ACC. A specifically designed humidity control chamber should be purchased for use in this area.

**BENEFIT OF CHANGE**

A much lower rate of moisture damaged components, as reported by the individual technicians, would be seen. This would save restocking costs of damaged components, as well as reduce costs of repeated repairs due to damage

**PRODUCTIVITY IMPROVEMENT SUMMARY**

ISC 2017JA

SERV. ES PROGRAM

## COST BENE.. . .LCULATIONS

### OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

### NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

### IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

### SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC 20131A

TECHN... GY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. D. 59F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

ALC OC DATE 5/15/89
RCC MATPCA ITEM NO. 35113A
NOUN Control Relay Box

PNIL Parker
PIO # 16

**CURRENT METHOD**

The amplifier assy. for this control box is not carded any repairable time, even though existing technicians report that they can usually repair the component.

**PROPOSED METHOD**

This amplifier assy. should be made a repairable item with standard overhaul time assigned to this task.

**BENEFIT OF CHANGE**

Technicians report that the replacement costs for this item is $2700.00, While a detail cost analysis has not yet been authorized, savings of repair vs. replacement of each component should be significant.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 20111

SEI[illegible]ES PROGRAM

## COST BENE[illegible]LCULATIONS

### OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

### NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

### IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

### SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $_____ | $_____ |
| IMPLEMENTATION COSTS | - _____ | - _____ |
| NET SAVINGS | $_____ | $_____ |

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 87-J60F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

ALC OC DATE 5/15/85

RCC MATRCA ITEM NO. —

NOUN General Suggestion

PNIC Parker

PIO # 17

**CURRENT METHOD**

Many internal components for items worked by this Rcc are not assigned repairable time. Many of these components could be repaired by existing skilled technicians.

**PROPOSED METHOD**

A detailed cost analysis should be performed on repair vs. replacement of individual internal components on a variety of items worked by this Rcc.

**BENEFIT OF CHANGE**

The cost savings possible in this analysis may prove very attractive given present economic considerations.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 20171A

VALUE INSERTION ENGINEERING
SERVICES PROGRAM

# COST BENEFIT CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS = (DELTA COST) (12 MO. SCHEDULE) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS = (DELTA COST) (5 YR PROJECTION) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

## SUMMARY

| | ANNUAL | EXTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC 20131A

**TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM**

**CONTROL NO.** 89-061F

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

**TYPE PROPOSAL**

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

**ALC** OC **DATE** 5/15/89
**RCC** MATRA **ITEM NO.** 35111A
**NOUN** Auto. Ignition Actuator

PHIL Parker
PEO # 18

**CURRENT METHOD**

Presently, if the switch assembly in the cover housing is inoperative, the entire housing assembly must be replaced at a cost of $800.00 per assembly. The switch is installed into the housing using a special potting compound, which is unavailable from the vendor.

**PROPOSED METHOD**

Technicians report that if given the potting compound, they can replace the switch at a cost of ~$100.00.

**BENEFIT OF CHANGE**

As stated, if the potting compound can be acquired from Bendix, who also produces the cover housing, the cost benefit would be approximately $700.00 per item worked.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 20137-

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

# COST BENEFIT CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS (DELTA COST) (12 MO. SCHEDULE) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS (DELTA COST) (5 YR PROJECTION) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| TOTAL COST | | | | | | |

## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

**TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM**

**CONTROL NO.** 89-062F

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

**TYPE PROPOSAL**

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

**ALC** OC **DATE** 5/25/89
**RCC** MATPCA **ITEM NO.** 34252A
**NOUN** Flowmeter Pwr. Supply

PHIL Parker
PIO # 19

**CURRENT METHOD**

Presently, the internal circuit boards are not tested any time for repair although technicians are capable of performing these repairs at a relatively low cost in man hours.

**PROPOSED METHOD**

A focus study should be performed using a detailed cost analysis of the cost benefit of repairing the internal circuit boards of this item vs. replacement of the board assembly.

**BENEFIT OF CHANGE**

Possible benefits include lower overhaul costs with subsequent savings being utilized in other critical areas.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

TECH[illegible]GY INSERTION ENGINEERING
SERVI[illegible]ROGRAM

# COST BENEFIT CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD HRS / PART | COST / HR | O.H. / HR | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD HRS / PART | COST / HR | O.H. / HR | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $_____ | $_____ |
| IMPLEMENTATION COSTS | - _____ | - _____ |
| NET SAVINGS | $_____ | $_____ |

LSC-28131A

**TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM**

**CONTROL NO.** RRB-QF7

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

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

BOB BUTTRY

**TYPE PROPOSAL**

- [x] **QUICK FIX**
- [ ] **FOCUS STUDY**
- [ ] **OTHER** _____

**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.

## 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.** RRR-0F4

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

**TYPE PROPOSAL**
- [X] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

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

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

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

BOB BUTTRY

**TYPE PROPOSAL**

- [x] **QUICK FIX**
- [ ] **FOCUS STUDY**
- [ ] **OTHER** _____

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

**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**

BOB BUTTRY

**TYPE PROPOSAL**

- [x] **QUICK FIX**
- [ ] **FOCUS STUDY**
- [ ] **OTHER** _____

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

**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.

OR IN ACCORDANCE WITH THE WARRANTY TERMS.

**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.

## 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] = $_____.

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 81-088

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC OC DATE 05/19/89
RCC MATRA ITEM NO. 97133A
NOUN Electromag 3-Way select valve.

Phil Parker

PIO # 13

**CURRENT METHOD**

Most of these items have one port blocked off. They are used for hot air bleed-off purposes. Orisonally, the third port was used for fuel transfer. When overhauled, the item is required by technical order to be tested on the fuel transfer test stand in building 3108.

**PROPOSED METHOD**

Since the item is no longer used in its orisonally designed manner, and the third port (fuel) is blocked off by the purchasing organization, the required testing procedure should be deleted.

**BENEFIT OF CHANGE**

By deleting the unnecessary test, turnaround on this item would be shortened by one hour for each individual 3-way select valve. This would free skilled technicians for other duties, free testing equipment for other uses, and otherwise reduce operating expenses.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC 7911-1

SERVI[illegible] ROG[illegible]M

# COST BENEFI[illegible] CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS ( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS ( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MATL | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

**TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM**

**TI PROGRAM**
**COST BENEFIT ANALYSIS REPORT**

CONTROL NO. 89-011Q

**TYPE PROPOSAL**
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC OC DATE 05/05/89
RCC MATRA ITEM NO. 38669A
NOUN Ignition Exciter Leak Check. OAM # 123

PIO # 2

**CURRENT METHOD**

The ignition exciter unit is filled with high pressure Nitrogen gas and heated in an oven. After the unit is cooled it is placed in a water bath to check for leakage. The water bath must be at a specific temperature ( ? ) to perform the test. It was noted that shop personnel routinely reduce the bath's temperature to prevent the water level from evaporating.

**PROPOSED METHOD**

It is suggested that the installation of an insulated cover on the existing water bath would maintain required heat while subsequently reducing the evaporation rate of the bath.

**BENEFIT OF CHANGE**

As the above described leak test is a one minute operation, and the heating time required for the water bath is ~15-20 minutes, it would appear that operator productivity would be enhanced significantly by maintaining the water bath's temperature at or near the optimal test range. The proposed change should be relatively inexpensive with no impact on work load occurring.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

LSC-20131A

VALUE INJECTION ENGINEERING
SE[illegible] PRO[illegible]IAM

# COST BENE[illegible]FIT [illegible]LCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

ISC-20131A

TECHNOL... INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 81-...Q

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC OC DATE 5/15/89
RCC MATRA ITEM NO. 97133A
NOUN Electromag 3-way valve

PHIL Parker
PIO # 14

**CURRENT METHOD**

No specific requirement for testing this item with compressed air before it is placed on the fuel transfer station now exists. Operator preference is the determinant as to WHETHER this operation is performed.

**PROPOSED METHOD**

Initial leak testing with compressed air before placement on the fuel transfer station should be made a specified requirement for this valve. (This is dependent on outcome of PIO control number suggestion, which deletes the fuel transfer testing procedure entirely)

**BENEFIT OF CHANGE**

By testing the valve assembly with compressed air, and thereby determining whether leaks actually exists, the possibility of lost time in transportation and set-up on the fuel transfer equipment will be removed.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

SERV[illegible] PROGRAM

# COST BENEFIT CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 89-...10

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC OC DATE 5/10/89
RCC MATPCA ITEM NO. 38645A
NOUN TEMP. AMPLIFIER

Phil Parker

PIO # 7

**CURRENT METHOD**

The A3 module of this item requires approximately 9.0 hours to remove and replace. This is due to it being a "select fit" component. This means that the electrical specifications and tolerances must be determined through testing before installation can occur.

**PROPOSED METHOD**

Technicians report that when the individual specifications for an A3 module are provided by the vendor, they have tested within limits at this installation. It is therefor suggested that all A3 modules have their factory determined specifications sent with them to this RCC.

**BENEFIT OF CHANGE**

Technicians report that by utilizing the factory specifications of the A3 module, and thereby deleting the initial testing procedures, installation time can be reduced from 9.0 hours to 3.0 hours for this component. Turnaround to Air Force inventory is shortened, more effective use of existing resources is accomplished, and more productive use of skilled technicians can occur.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

ESC 20171A

VE/VALUE INSERTION ENGINEERING
SER. PROGRAM

# COST BENEFIT CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## SUMMARY

| | ANNUAL | EXTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. _____

# TI PROGRAM
# COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC OC DATE 5/19/85
RCC MATPCA ITEM NO. 61234A
NOUN Ignition Exciter

Mike Parker
PIO # 8

## CURRENT METHOD

Presently this item is not targeted as a selective overhaul (MATROC) item. Technicians routinely perform a diagnostic test on this exciter, and they report a 50% failure rate. This failure rate includes replacement of the internal transformer unit for pitting due to arcing damage.

## PROPOSED METHOD

By designating this ignition exciter as a MATROC item, and requiring that an initial functional test be performed, it is reasonable to assume that 50% of all items processed would be ready to return to inventory in one to two hours. It is also suggested that a time limit for visual inspection of the internal transformer be set at two to three years intervals (applicable to overhaul facilities.

## BENEFIT OF CHANGE

The benefits of this change would include quicker turnaround time and return to A.F. inventory, better utilization of resources and skilled technicians, and reduced operating costs.

## PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20131A

SER. PRC AM

# COST BENE[illegible]CULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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| | | | | TOTAL COST | | |

## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 87-.02

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC Oc DATE 5/16/89
RCC MATPCA ITEM NO. 50217A
NOUN Ign. Exciter

Phil Parker

PEO # 10

**CURRENT METHOD**

This ignition exciter uses a potting compound to anchor the internal components as well as act as an insulator for them. This compond must be chipped out for overhaul purposes.

**PROPOSED METHOD**

Use of RTV sealant as in the case of other related ignition exciters is suggested.

**BENEFIT OF CHANGE**

The use of the RTV sealant would expidite internal component removal during overhaul, making better use of present resources and and skilled technician's time.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

TECH. .OGY INSERTION ENGINEERING
SERVI 'ROGRAM

# COST BENEFIT CALCULATIONS

## OLD METHOD

| DESCRIPTION | STD HRS / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS (DELTA COST) (12 MO. SCHEDULE) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD HRS / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS (DELTA COST) (5 YR PROJECTION) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MATL | O.H. RATE | | | TOTAL COST |
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## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 89-039R

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER _____

ALC OC DATE 5/19/89
RCC MATPCA ITEM NO. 50217A
NOUN Ignition Exciter

PMC Parker
PEO # 11

**CURRENT METHOD**

Presently this item is not targeted as a selective overhaul (MATROC) item. Technicians routinely perform a diagnostic test on this exciter, and they report a 50% failure rate. This failure rate includes replacement of the internal transformer unit for pitting due to arcing damage.

**PROPOSED METHOD**

By designating this ignition exciter as a MATROC item, and requiring that an initial functional test be performed, it is reasonable to assume that 50% of all items processed would be ready to return to inventory in one to two hours. It is also suggested that a time limit for visual inspection of the internal transformer be set at two to three years intervals (applicable to overhaul facilitie

**BENEFIT OF CHANGE**

The benefits of this change would include quicker turnaround time and return to A.F. inventory, better utilization of resources and skilled technicians, and reduced operating costs.

**PRODUCTIVITY IMPROVEMENT SUMMARY**

SE[illegible] PRO[illegible]AM

# COST BEN[illegible]LCULATIONS

## OLD METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

ANNUAL SAVINGS

( DELTA COST ) ( 12 MO. SCHEDULE ) = 1st YEAR SAVINGS

## NEW METHOD

| DESCRIPTION | STD. HRS. / PART | COST / HR. | O.H. / HR. | | | TOTAL COST / PART |
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| NOTES: | | | | TOTAL COST | | |

EXTENDED SAVINGS

( DELTA COST ) ( 5 YR PROJECTION ) = TOTAL SAVINGS

## IMPLEMENTATION COSTS

| DESCRIPTION | LABOR COST | MAT'L | O.H. RATE | | | TOTAL COST |
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## SUMMARY

| | ANNUAL | ENTENDED |
|---|---|---|
| GROSS SAVINGS | $ | $ |
| IMPLEMENTATION COSTS | - | - |
| NET SAVINGS | $ | $ |

LSC 20131A

**TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM**

**CONTROL NO.** RRB-FS2

**TYPE PROPOSAL**

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER _____

# TI PROGRAM
# COST BENEFIT ANALYSIS REPORT

BOB BUTTRY

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

**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 REPETATIVE CAUSES FOR SCRAPPING PARTS.

**PRODUCTIVITY IMPROVEMENT SUMMARY:** PRODUCTIVITY IMPROVEMENT IS DIRECTLY RELATED TO REDUCING SCRAP BY CORRECLTY 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 = $ _____

J. CARTER

4-25-89

PIO#1 ON ENTERING AREA (CA) MY FIRST OBSERVATION WAS THE ODOR OF TRI-CHLORETHANE USED AS A DEGREASER. FROM PAST EXPERIANCE, I HAVE FOUND TRI-CHLOR TO BE A DIFICULT CHEMICAL TO WORK WITH. BIO-ACT IS A NATURAL DEGREASER THAT IS BIO-DEGRADEABLE MATERIAL THAT WHEN CONTAMINATED, MAY BE DISPOSED OF BY INCENERATION. TEST EQUIPMENT WAS SOMEWHAT ANTIQUATED, BUT CENTRALLY LOCATED AND EASILY ACCESSABLE BY ALL TECHNICIANS. LIGHTING WIASE ADEQUATE, AREA WAS CLEAN, AND COMPRABLE TO MOST FABRICATION FACILLITIES. THE TECHNICIANS SEEMED WELL TRAINED & QUITE COMPETANT FOR ASSIGNED TASKS

4-26-89

PIO#2 OBSERVED PHYSICAL MEASURING OF CASTINGS & MACHINED PARTS. METHODS USED WERE CONVENTIONAL MICROMETERS & STANDARD INSPECTION INSTRUMENTS. THE USE OF A SMALL "CORDAX" (COORDINANT MEASURING) MACHINE WOULD ENHANCE DIMENSIONAL CREDIBILITY.

4-27

PIO#3 OBSERVED EXCESSIVE, MOISTURE INDUCED, CONTAMINATION OF CASES, RESULTING IN RE-CLEANING OF CASES. A CLEAN ROOM ENVIROMENT WOULD ELUMINATE THIS CONDITION. HUMIDITY & TEMPERATURE CONTROL WOULD ENHANCE LONGIVITY OF THE PRODUCT.

4-28

PIO#4 OBSERVED MULTI-STEP TESTING OF PRODUCT THIS OPERATION COULD BE IMPROVED BY THE USE OF A "FAULT FINDER" A CNC TEST UNIT WITH A PRINT OUT. THIS WOULD ALSO GIVE TRACEABILITY OF ALL REPAIRS WITH A PERMINANT RECORD.

5-4-89 OBSERVED EXCESSIVE TRANSIT TIME PCA TO PCD.

PIO#5 REQUESTS THE TRANSFER OF ONE / ARBOR PRESS TO PCA AREA

5-5-89 ELECTRONIC TEST BENCH # OC 4929 & OC 3609 WENT DOWN AT APPROX 10:00 HRS & WAS OUT OF SERVICE WITH APPROX. FIFTY COMPLETED UNITS

PIO#7 AWAITING TEST. A "QUICK FIX" WOULD BE TO PLACE FIBERGLASS FURNACE FILTERS ON TOP OF LOUVERED CABINATES. REDUCING THE AMOUNT OF CONTAMINATION TO ELECTRONIC COMPONANTS.

PIO#8 TEST STAND # OC 5507 THIS UNIT PURCHASED AT COST APPROX $1.3 MIL. IS MARGINALY FUNCTIONAL (5%) AND IS NOT COST EFFECTIVE (1.0 MAN HRS TO TEST EXCITERS)

(PIO # 8 CONT.)

SIMMONS, THE OEM., HAS A SIMPLE TEST STAND THAT CONDUCTS THE SAME TESTS IN SEVEN MIN. WITH A PRINT OUT FOR Q.A. RECORDS.

PIC #6 WHILE OBSERVING A TEST OPER, I CHECKED THE PREVENTIVE MAINT & CALIBRATION ON THE FOLLOWING TEST ITEMS:

OC 3952 - NITROGEN LEAK TEST 20 SEPT 78

OC 3952 ELECTEST BENCH 4-21-89

OC 3953 " " " 7 APR 86

OC 4929 " " " 4-7-86

OVENS (4 EA) MAINT ONLY AT BREAKDOWN OIL SIGHT GAGE IMPOSSIBLE TO SEE - YEARS OF STAIN BLACKENED THE UNIT. TECHNICIANS HAVE NOT BEEN INSTRUCTED ON DAILY MAINT. REQUIREMENTS. OBSERVED WCD ON 35023A NOT TO ACT METHOD. SUGGEST PLANNERS CONSULT TECHNICIANS TO VERIFY SEQUENCING & METHODS

ENG. NOTES: JACK CARTER

5-2-89

PCN 42590 FLOW CHART

OP 010 & 015 - REC & VERIFY

PIA's OP 020 BREAK SOLDER SEAL ON CASE - OPEN DIG OUT EPOXY-FOAM - NOTE - EVRY EFFORT SHOULD BE MADE TO DELETE THIS OPER. IT IS VERY LABOR INTENSIVE & NOT COST EFFECTIVE.

030 MOVE TO TRICHLOR TANK FOR CLEANING

040 VISUAL INSPECTION AT WORK BENCH

OP 060 THRU 120 - ELECTRICAL TESTING DONE AT TEST STAND - IDENTIFY SUB-STANDARD PARTS

380 REPAIR OR REPLACE PARTS AS REQ'D.

390 RE ASSEMBLE ALL COMPONIAN

PCN 37719A AUTOMATIC PILOT - 48 UNITS PER MO. NOTE: THIS OPER WILL BE PHASED OUT OVER THE NEXT TWO TO THREE YEARS - AREA WAS WELL LIGHTED, OPERATOR COMPETANT & WELL TRAINED EQUIPMENT ADEQUATE TO THE PRODUCT REQUIREMENTS.

Phillip J Farmer

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA (3005.4) | RCC |
|---|---|---|
| 05/04/89 | Interview performed with Wendel Hawkins, described rework of combox assy. While not specifically noted as an operation on the WCD, the requirement to disassemble (and all related operations) is determined by the results of an initial diagnostic test of the combox unit. If the item checks out OK, the switch is replaced and aligned, and the unit is typically cleaned and released for use. Switch replacement, adjustment, and cleaning procedures take ~20 minutes to perform. All work is done at technicians bench, with specialized testing equipment and tools being checked out from a central tool bin located in the unit. If a disassembled part is out of tolerance, it is replaced w/ new parts. Two main testers are used, and both are portable units (only two in unit): (1) Switch adjustment device (SA120) (2) Dial Indicator (DI110) Total time reported: 7.52 hrs/unit Total time allowed: ? Note: Possibility of lower grade "test technician" to perform initial test procedure, route tested items to rework technician or inventory as required. | MAT PCA |
| 05-04-89 PIO #1 | Suggest the creation of a primary "initial tester" of the combox assy unit. This individual could be at a lower grade level, and be responsible for routing the unit to the overhaul technician if required or performing the shorter refitting task if test is OK. Benefits: Quicker turnover and return to inventory, better utilization of skilled overhaul techs. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 05/05/89 | Interview with Larry Ware (WG-10) on Ignition Exciter (38669A) rework. Unit requires several test procedures (see ops. profile). After the initial cleaning, inspection, and testing, the unit is hand-carried to the machine shop (MATPEM) or the mechanic for Lid removal. Note that only one machine is normally designated for this task, and that the unit will normally remain at MATPEM for 24 hrs until it returns to MATPCA. The unit is then disassembled, inspected, and several internal items are tested. Parts are removed and replaced as required. After reassembly and testing, the unit is hand-carried to the welding shop (MATPIW) by the mechanic, and the lid is welded on. Time at MATPIW is ~ 24 hr. | MATPCA |
| | Note: It appears that rebuild kits are normally ordered (by regulation) only when units are received. This can cause up to 2 day delay for kit receival into unit. Technicians are ordering extra kits to avoid this. | |
| | Note: If the filter assy (ops 85) is bad, very long delay ( ) due to backshop ( ) turnaround. | |
| | Note: If items replaced with new replacement items, then no requirement to test unit for specific item function. Technicians note high rate of failure of new items (suggest study of actual reliability of new items?). Technicians are presently performing tests. | |
| | Note: water bath being adjusted down to prevent evaporation. Requires ~15-20 minutes to reach optimal heat. | |
| PIO #2 | Suggest the installation of a lid on water bath to reduce evaporation while maintaining heat at operational level. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/8/69 | Interview with Larry Ware on PCI 49711A. An initial test is performed on this unit. If the test is OK the unit is routed to inventory. If the unit fails it is routed to overhaul. There is a ~50% failure rate. | MATPCA |
| | Note: If the housing must be extended, then the capacitor assy. must be removed to increase frames being produced during the welding opn. It should also be noted that due to the nature of this large capacitor assy., there exists a significant electrical hazard associated with this item. Time must be taken in discharging and disassembling this unit. | |
| | There are several testing procedures involved in the overhaul of this unit. It is also an involved process to disassemble and repair the capacitor assembly. Much of the testing equip. is outdated and prone to long down times, and in some cases modified testing must be performed due to inadequate or missing equipment. | |
| | Note that there are several cases where inspections and/or tests can indicate that further machining or welding must be performed as support work. The possibility therefor exists that significant time may be spent on any one item in backshop operations. | |
| 5/28/69 PIO # 3 | Suggestion that a detailed analysis be performed as to viability of new test equipment (generalized in nature) given decreasing demand of these items. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/8/85 (5/7/85) | (continued) PN 49711A. | MATPCA |
| PIO = 4 | Mr. Ware notes that new parts from the manufacturer are displaying a high failure rate, mainly due to improper packing from the manufacturer | |
| | Note: This item is the same as PCN 98031A, except for the gap tube assy. The new gap tube assy in the 49711A uses Kr 85 as compared to the older 98031A model's $Cs_{137}$. This modification was to reduce radiation exposure to the employee. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 05/08/89 | Interview with Donelda Stroud on PCN 30241A. As with most of the igniter exciters, this item requires an initial functional test. If the item tests OK, it is routed back into inventory. The failure rate of this item is reported as ~ 95%, so most items are overhauled. The exciter must be sent to the machine shop (MATPCM) for lid removal. Note that there is significant delay time (24 HR) before the item is returned to MATPCA. This is due to several factors, especially the fact that normally only one (MATPCM machinist and welder are assigned for this task. Also note that Ms. Stroud reports that 30% of the disassembled units are rejected pending for terminal rework or casing repair. Another 24 hr delay is incurred by this action. The unit is returned to MATPCA for further overhaul, and sent back to welding for lid replacement. It can be seen that there exists the possibility of a 48-72 hr delay above and beyond the specific time required for repair of the item. | MATPCA |
| | Time required for task: | |
| | Time corded task: | |
| | PIO # 5 Suggestion for study of back shop operations for all MATPCA support work. Target MATPCM and MATPIW for long delay times. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 05/09/89 | Interview with Wendel Hawkins on PCN 50078A. This is an ignition exciter which requires an initial function test be performed. It is reported that 90% of the items fail and are overhauled. The other 10% are routed back into the inventory. | MATPCA |
| | This item is presently having an Air Force audit performed which requires computer tracking and extra paperwork. This is indicated in the operation profile sheet. | |
| | The components of this item have a high damage potential when exposed to moisture, which requires that the unit be kept in MATPCA's dehumidifier (which is, in actuality an unpowered refrigerator packed with dessicant), long drying times in both the oven and this dehumidifier are required. The unit must be sealed and pressurized so that moisture does not enter the casing. This in turn required a rather high degree of skilled soldering be performed around the casing and input leads. Care must be taken not to heat the casing overly much during this procedure, as internal components are heat sensitive. | |
| | PIO # 6 Suggest the use of some form of epoxy sealant that would remove the soldering operation. This should save much time and effort by operator. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 05/19/89 | Interview with Mr. Wendel Hawkins, WG-10, on ignition exciter (3551DA). This item has an initial functional test, the results of which determine rather it is overhauled or returned to inventory. It was reported that this item has a 50% failure rate.<br><br>The testing of internal components in this item is a somewhat complex procedure. Several test stands are required, as well as individual handheld equipment such as ohmmeters and voltmeters.<br><br>Note that if the internal connectors need to be reworked the item must be sent to welding (MATPIW). Approximately 15% of all units require this additional operation. All disassembled units will have the lid removed by MATPCM and replaced by MATPIW. Possible back shop time is therefor 48-72 hours. | MATPCA |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/10/89 | Interview with James Dye on PCN 38515A TEMP. AMPLIFIER | MAT PCA |
| | This is a very complex overhaul item. The temp. amplifier is a MATROC item and only 40% fail the initial test and require overhaul. Of these, 95% of the failure involves a module failure. There are five modules, and each will require a different replacement time if it fails. Note especially the A3 module. If the A3 module fails there is an 9.0 hour repair time involved. This is due to the fact that this is a "Select Fit" item which requires individual testing and specifications determination before it can be installed. (See following PIO suggestion). | |
| | There is a great deal of rewiring and rerouting of wire, either a module change. RTV sealant must also be applied over these wires (which is very tedious to remove). | |
| | Functional testing is performed at three temperatures (ambient cold HOT), with most failures occurring at the cold temperatures. A failure at any temperature will stop testing and require troubleshooting be performed. After repair or replacement of parts, testing must repeated. | |
| | PIO # 7 Suggest that manufacturer supply data of related parts for "select fit" items. In the case of A3 module, reduce time from 9.0 hrs to ~3.0 hours for change. (i.e. reduce need for determining existing specifications). | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/10/69 | Interview with Wallace Wylie on PCN 38643A, Temp. Amplifier. | MATRCA |
| | This item is rather complex in both its testing and repair. The amplifier consists of five major internal components, any one of which may cause the item to fail. These internal components are modules numbered 1-5. The individual failure rates are listed on the operation profile sheet for opas. 151-153. | |
| | This item is classified as a MATRCC item, and requires an initial functional test be performed. 80% of all amplifiers of this type tested pass the test. They are then returned to inventory. The other twenty percent require disassembly and replacement of one or more modules. It should be noted that the amplifier interior is sealed with a potting compound which is very difficult to remove. Note that the amplifier fails mostly during the ambient temperature phase of testing. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/16/89 | Interview with Mr. Humphrey on PCN 61234A, ignition exciter. | MATRCA |
| | This item is not designated a MATROC item, but most technicians are performing an initial functional test as part of their troubleshooting procedure. This item is reported as having a 40% loss rate of these initial tests. This would seem to indicate that making this a "selective overhauled" item is a viable option. | |
| | Note that there are several internal components in this exciter which can fail and each of these will take a different repair time. Also note that there is often the possibility of more than one internal component failing at any one time. | |
| | It should be mentioned that this exciter's tube assemblys are installed in a formed rubber casing. This casing is easily removed and prevents arcing while installed. | |
| | PIO # 8 Suggest that this exciter be designated as a MATROC item to take advantage of 40% loss rate. mention transformer inspection. | |
| | PIO # 9 Suggest that focus study be performed on all exciters as well as many other electrical accessory items now using RTV or potting compound. Explore feasibility of using formed rubber housing (prevents arcing, protects from shock, seals, etc.). | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/16/89 | Interview with Mr. Humphrey on PCN 50217A, ignition exciter. | MATRCA |
| | This item is basically identical to the ignition exciter PCN 61234A. Again no initial function test is required, although troubleshooting before overhaul indicates that 40% of all items tested are fully functional. | |
| | The only real differences existing between the two aforementioned PCNs is that the 50217A as two capacitors in the capacitor #1 assy. as opposed to one in the 61234A. It should also be noted that instead of RTV being used as an internal insulator and sealer, a hardening compound is poured into the exciter during closeout. This forms a hard plastic cover which is time-consuming to remove. | |
| | PIO #10 Suggest use of RTV sealer as in case of 61234A. Much easier to remove. | |
| | PIO #11 Same as suggestion #8. | |

# DAILY ACTIVITY LOG

| DATE/RCC | SUBJECT/ACTIVITY | NEXT ACTION/ ASSIGNMENT |
|---|---|---|
| 05/19/89 | Interview on solenoid ASSY (38644A). This item will have the the casing opened and a visual inspection performed. If all internal components are within wear limits, a functional test is performed. 20% of all items are judged fit to be returned to inventory. Turnaround time is two hours in these cases. 80% of these items require overhaul. If the armiture assembly must be removed, the item is sent to welding. Turnaround at MATPLW is estimated by the interviewee as 72.0 hours average. This is due to this item being designated as a low priority item.<br><br>In rebuilding this item, an internal actuation device must be adjusted by placement of shims and washers. As this is an imprecise procedure, the possibility exists for multiple teardowns on each item. This was reported as rare.<br><br>Total time required for rebuild is 3.5 hours.<br><br>PIO # 12 Observation of improperly designed hand tools (power and manual). Suggest use of Ergonomical tool designs. | MATPCA |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 05/19/89 | Interview with Wendel Hawkins on PCN # 97133A, Electromag 3-way select valve. | MAT REA |
| | This item is rebuilt each time it enters the depot, and a rebuild kit is required for each item. | |
| | One port of the valve is closed off by the user organization due to this items modified use as an air bleed-off valve. Technical Specifications still in effect require that the valve be tested on the fuel transfer equipment located in bld. 3108. This test utilizes the third port normally plugged while in use on aircraft engines, and would appear unnecessary. | |
| | It should also be noted that there is no specific requirement to leak test the valve with compressed air before taking the item to the test equipment in 3108. If the item leaks with compressed air being applied, then the test using the fuel transfer station could not be performed. | |
| | PIO # 13 Suggest the test requirement for fuel transfer procedure be deleted from tech. data. | |
| | PIO # 14 Suggest that testing of the value with compressed air before being sent to fuel transfer station in bld. 3108 (if above PIO not acceptable). | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/19/89 | Interview with Wendel Hawkins on PCN # 345STA, Solenoid Valve. | MAT PCA |
| | This item is 100% overhaul. Operations 115 to 170 of the WCD (CAEZ04) are performed in building 3108 by personnel assigned to the fuel testing facility. | |
| | A rebuild kit is required for each solenoid valve that is overhauled. | |
| | Total time for rebuild, including a 12.0 hour mandatory flow time in bld. 3108, 14.6 hours. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/19/69 | Interview with Richard Franklin about Automatic Ignition Actuator, ACN 35111A. | MATPCA |
| | This is a 100% overhaul item. It requires a disassembly and visual inspection as well as electrical testing. | |
| | Note that there is a requirement to electrically test the actuation switch in the cover & switch assembly, under present conditions, if the switch tests bad, the entire cover housing must be replaced. The switch is set into the housing with a special potting compound, which must be purchased from BENDIX Corporation. Bendix also manufacturers the cover housing. Technicians report that they are unable to obtain the potting compound, and must replace the entire housing assembly as a unit. The cost of a new housing assembly is $800.00, which makes the reluctance of Bendix in providing the potting compound as highly suspect. | |
| | PIO # 18 suggest that Bendix be encouraged to sell both the potting compound and small switch assy. to user organization. This cover housing assy. should be a repairable item. | |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/19/89 | Interview with LARRY Ware on ignition exciter PCN 50297A.<br><br>This is a MATROC item which requires an initial functional test. Five percent of all items tested fail and must be overhauled. The rest are returned to inventory.<br><br>Note that there is are 24.0 hour delays at both the Machining (MATPCM) and welding (MATPIW) backshop operations.<br><br>This item must be sandblasted and painted after overhauled. A rebuild kit is required for each overhauled item.<br><br>PIO # 15 Humidity control chamber required in MATPCA area. Presently using an old refrigerator packed with decsicent. | MATPCA |

| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/19/85 | Encountered with Richard Franklin on PCN 35112A, control relay box. | MAT PCA |
| | This item is a MATPOC item, but pass rate is only about 5%. Note that a major internal component is the amplifier assembly. This component is produced in ENGLAND at a purchase price of $2,700.00. The component is often repairable at a cost of $100 or less. No repair time is allowed for these components. | |
| | PIO # 16 The amplifier assy. for the control relay box PCN 35112A should be made a repairable item and have a standard repair time assigned to it. Average savings per component: $2600.00 | |
| | PIO # 17 Focus study should be performed to specifically identify all repairable parts, and a detailed cost analysis made to compare costs of repair vs. replacement of individual components. | |

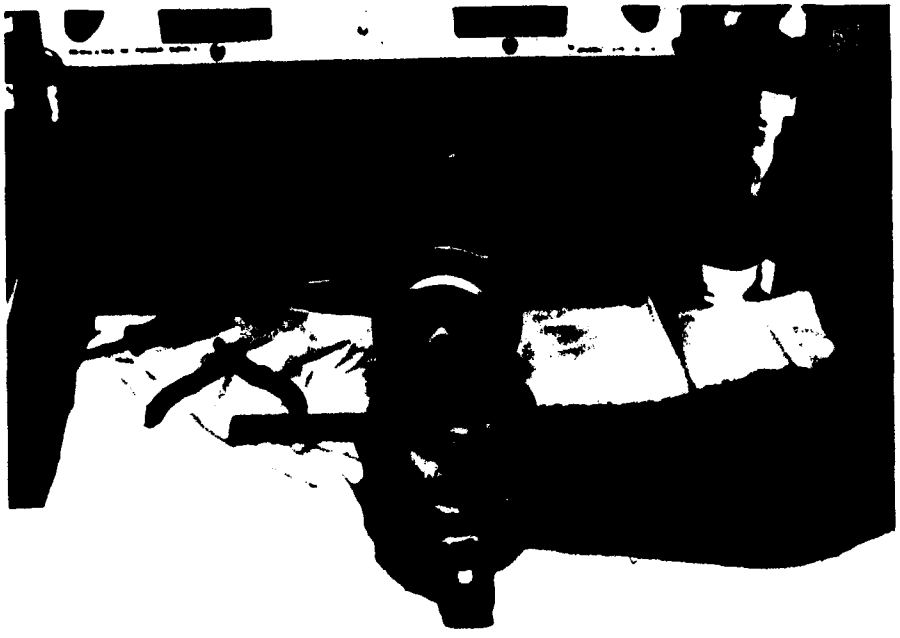
| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/22/85 | Interview with Donelda Stroud on PCN 35033A, Liquid level sensor. | MATPCA |
| | This is an inspectable item which may be returned to inventory if it passes both a visual and electrical inspection. The sensor is partially disassembled and the terminal boards are inspected for cracks etc. If no obvious defect exists, an electrical test is performed using a multimeter. If this test is OK, the item is reassembled and return to inventory. ~20% of all sensors fail either the visual or electrical inspections. Of these, approximately 15% of all those require replacement of the terminal board itself. These are then retested and reassembled if now functional. | |

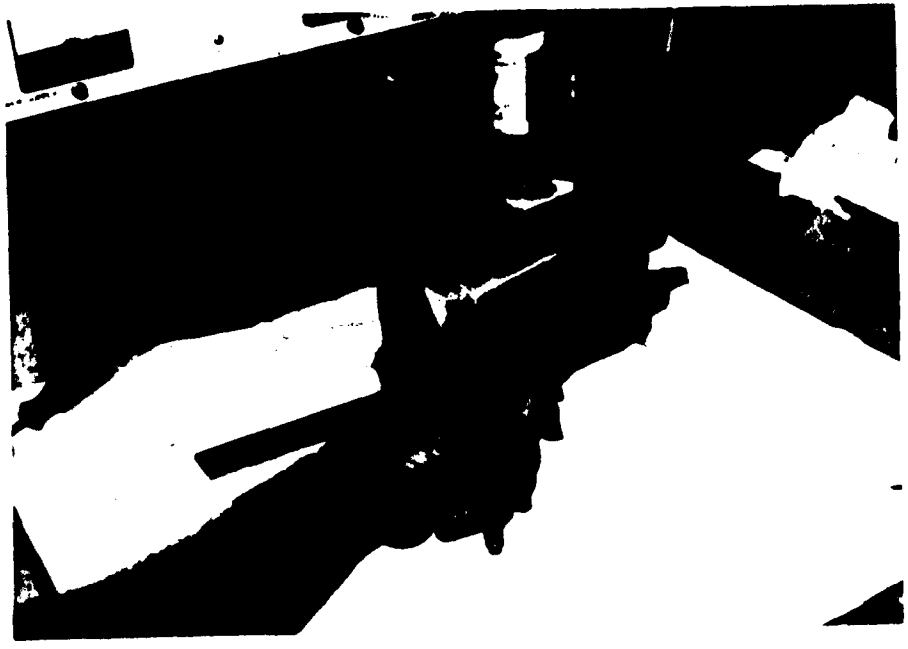
| DATE/PIO # | PIO SUBJECT AND SUPPORTING DATA | RCC |
|---|---|---|
| 5/25/89 | Interview with Franklin Martin on PCN 34252A, Flowmeter PWR. Supply. | MATPCA |
| | This PWR Supply is a MATROC designated item. Technicians report that only 5% of the tested items are functional, the rest requiring overhaul. | |
| | Note that the internal circuit board of this item is repairable. The technicians will do this repair in their spare time, this item is not assigned a primary responsibility in this. Again, they are not given a standard time to work these and any repair is therefore left to the initiative of the employee. Cost of replacement: $n/a Cost of repair: unknown at this time | |
| | Note: This item is the same as PCN 34253A in all respects except the housings. All internal components are interchangeable. | |
| | PIO # 19 Suggest a focus study be performed of cost-benefit of repairing the internal circuit boards mentioned above. Should include cost analysis of repair vs. replace, economic order quantity of parts, etc. | |







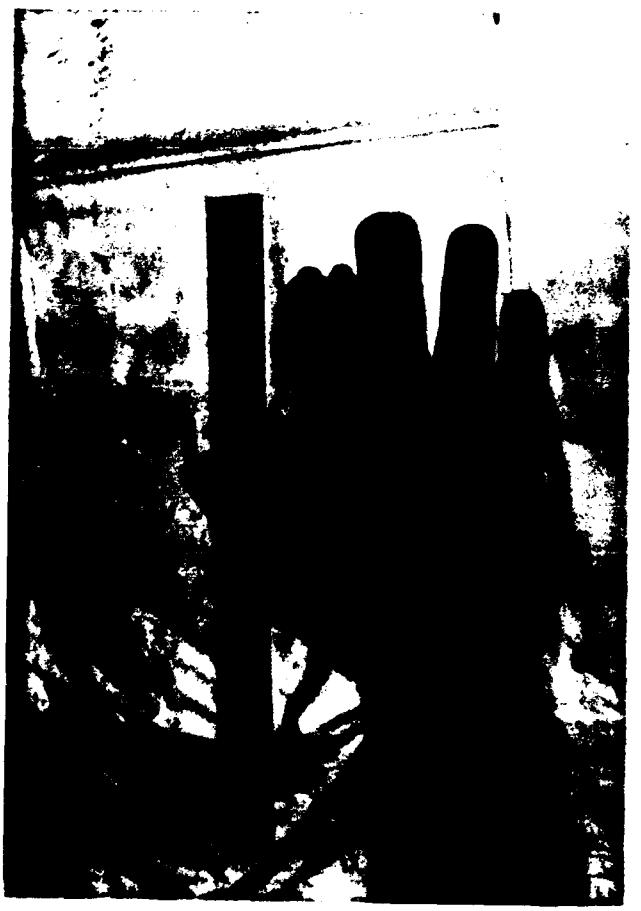


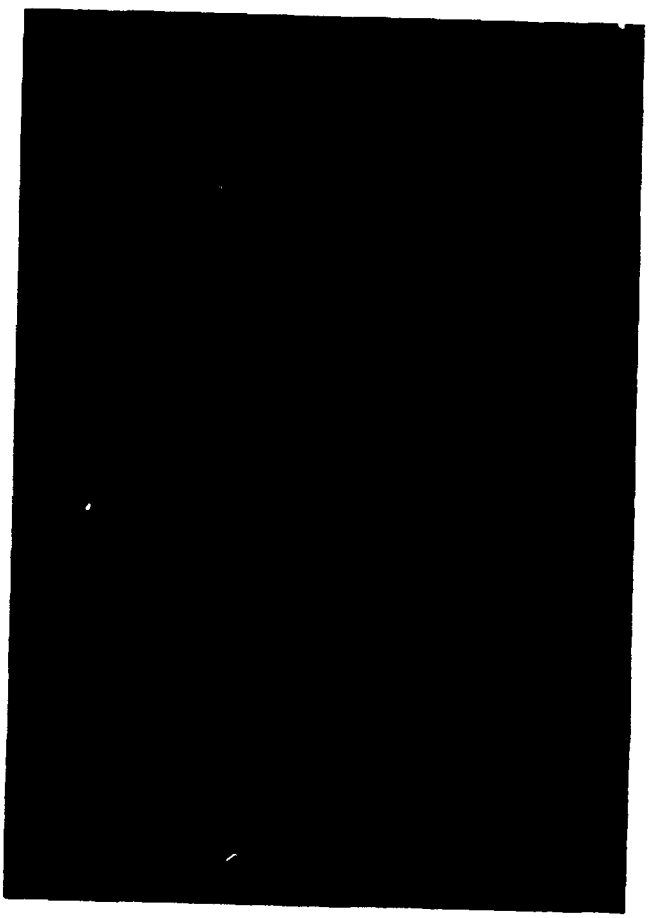












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| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/REC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| | | MTPCAP | 89094 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 6B671/0 | | 2J-1F41-13-/, WP 009 00 8/16/H |
| | | CHG 20 |

| 10.MODEL/DESIGN/SERIES | 11.STOCK NR |
|---|---|
| T-1 A1/402D | |

| 13.MISC | 14.NOUN/END ITEM NOUN |
|---|---|
| | CARBUX ASSEMBLY PACT |
| | WORLDTRON/MATEAC/659Z0 |

15.DISP 16.PDN/

| STATION NO. | 17.WORK TO BE ACCOMPLISHED | 18.REQMTS | 20 |
|---|---|---|---|
| | ▶ 30056A 2040001/292020N TF41-A1 | | |
| | ▶ 6117GA 2040001/292020L TF41 A2 | | |
| | F 2040 00 702 7643DN TF41-A2 | | |
| W 40 | 010 RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | |
| | 020 ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | M | |
| | 030 DISASSEMBLE. | M | |
| | 040 CLEAN AS REQUIRED. | M | |
| | 050 INSPECT. Visual | M | |
| | 060 INSPECT SHUTOFF VALVE DRIVING ARM FOR SPLINE WEAR. ACT_____INCH | M 10 | |
| | 070 INSPECT MANUAL FULL CONTROL DRIVING ARM FOR SPLINE WEAR. ACT_____INCH | M | |
| | 080 INSPECT MAIN FULL CONTROL DRIVING ARM FOR SPLINE WEAR. ACT_____INCH | M | |
| | 090 INSPECT DRIVING SHAFT GEAR FOR ACT_____INCH *SPANNER WRENCH NO 6/90371 | M | |
| | 100 INSPECT SHUTOFF VALVE DRIVING GEAR SHAFT,SPLINE WEAR . ACT_____INCH | M | |

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| 15.DISP | 16.PDN/STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 110 | INSPECT DRIVE SHAFT, SPLINE WEAR<br>.<br>ACT_____INCH | M | | |
| | 120 | LUBRICATE AS REQUIRED. | M | | |
| | 130 | REASSEMBLE. | M | | |
| | 140 | TIGHTEN SPANNER NUT (14)<br>SPANNER WRENCH NO. 6726371<br>ACT_____IN/LBS | M | | |
| | 150 | ADJUST STOP UNTIL GAGE IS IN CONTACT WITH BOTH STOP & CONTROL ARM.<br>ACT_____INCH | M | | |
| | 155 | REMOVE THE INDEXING PIN AND ROTATE CAMBOX LEVER TOWARD INTERMEDIATE. CONTINUE UNTIL SWITCH ACTUATES AND LIGHT COMES ON.<br>ACT_____DEG.<br>GAGE, SETTING CAMBOX LOCKOUT SWITCH | M | | |
| | 158 | HORIZONTALLY ALIGN SWITCH ROLLER TO SURFACE. TIGHTEN THE TWO SWITCH LOCKNUTS & LOCKWIRE TO EACH OTHER.<br>ACT:_____IN/LB<br>TORQUE WRENCH | M | | |
| | 160 | TEST: ROTATE CAMBOX INPUT SHAFT CLOCKWISE UNTIL A 0.1875 TO 0.1880 IN. DIA. RIGGING PIN CAN BE INSERTED THROUGH THE INDEX HOLE MARKED IDLE.<br>MEASURE THE ANGULAR TRAVEL OF CAMBOX<br>ACT_____DEG. | M | | |
| | 170 | ROTATE CAMBOX INPUT SHAFT CLOCKWISE UNTIL 0.1875 TO .1880 RIGGING PIN CAN BE INSERTED IN HOLE MARKED INT. MEASURE TOTAL ANGULAR TRAVEL OF CAMBOX INPUT LEVER.<br>ACT_____DEG. | M | | |
| | 220 | CHECK BACKLASH "B" OF THE CAMBOX TO FUEL SHUTOFF VALVE OUTPUT LEVER AT POINT "C".<br>ACT:_____INCH | M | | |
| | 230 | THE TORQUE REQUIRED TO MOVE THE CAM-BOX INPUT FROM THE OFF TO IDLE RANGE<br>ACT:_____IN/LB | M | | |

(CONTINUED)

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| 15.DISP STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19.INSP | 20.QA |
|---|---|---|---|---|---|
| | | *TORQUE WRENCH | | | |
| | 260 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | | | |
| | 270 | SAFETYWIRE. | | | |
| | [illegible] | OPERATIONS COMPLETED & PAPERWORK PROCESSED. | | | |
| | [illegible]70 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O.'s [illegible] CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS. | | | |
| | [illegible] | COMPLY WITH MACR 66-[illegible] ITEM 53 | | | |

TYPE WORK PERFORMED_____

CAEB05 * WORK CONTROL DOCUMENT * JC 1.DATE 07033 PAGE 1 OF 2 PAGES

| 12.ORIG/PROD NR | 13.QUANTITY | 14.PROD SECTION/RSC | 15.DATE SCHED | 16.DATE COMP |
|---|---|---|---|---|
| | | MIPCAJ | 87094 | |

| 17. SRT NUMBER | 19.ITEM SERIAL NR | 18/12.ITEM DATA/OPTIONAL |
|---|---|---|
| | | 8L1 / 15 14 |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG |
| 30/ 45/67 | | |

DONELDA STROUD
KATY WILCSON

| 1.MISC | 14.NOUN/END ITEM NOUN | |
|---|---|---|
| | IGNITION EXCITER | PACI |
| | 30/45/67/MAILAC/65/20 | |

| ITEM | NSN | C/N |
|---|---|---|
| 10 [illegible] 1 | 2920009048118RU | 30241A |
| 10 [illegible] 2 | 2920011711013RU | [illegible]01A |

| OPERATION NR | 17.WORK TO BE ACCOMPLISHED | 1.G.M.CHK 1/"I" | 2/"C" |
|---|---|---|---|
| 010 | RECEIVE, IDENTIFY AND ATTACH PAPER WORK. | M | |
| [illegible] | ALL REFERENCED ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDER. EACH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | |
| 020 | INSPECT & CLEAN. | M | |
| [illegible] | MOVE TO MACHINE SHOP MATRON FOR REMOVAL OF COVER. | M | |
| 040 | DISASSEMBLE. | M | |
| 050 | MIPIW<br>WELD FILTER AND OUTPUT TERMINALS.<br>REQ._____NOT REQ._____ | M | |
| 310 | REPAIR OR REPLACE AS NECESSARY. | M | |
| 320 | **REASSEMBLE.** | M | |
| [illegible] | MIPIW<br>MOVE TO WELDING SHOP MIPIW [illegible]<br>AND WELD COVER WITH FILLER ROD (X-[illegible]<br>WELD NO. 35 AND ACCOMPLISH LEAK TEST | M | |
| 365 | PAINT<br>REQ_____ NOT REQ_____ | M | |
| 370 | ~~BAKE FOR TWO HOURS AT 190 DEG F TO~~<br>225 DEG F. | M | |

CAE005 * WORK CONTROL DOCUMENT * 30 1.DATE 07033 PAGE 2 OF 2 PAGES

| 15.DISP | 16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19 | 20.QA |
|---|---|---|---|---|---|---|
| | | 380 | TEST: HERMETIC SEALING AND LEAKAGE. | M | | |
| | | 440 | PRESSURIZE EXCITER TO 15 PSIG WITH DRYAIR HAVING A DEW POINT OF 65 DEG F. | M | | |
| | | 460 | LEAKAGE TEST: IMMERSE EXCITER IN WATER 100 TO 200 DEG F FOR ONE MINUTE. NO LEAKAGE ALLOWED. | M | | |
| | | 480 | ELECTRICAL TEST: | M | | |
| | | 490 | APPLY FOUR DAB COATINGS AND FOR WARMED TO FORM VULCANIZATION. | M | | |
| | | 500 | SAFETYWIRE | M | | |
| | | 510 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., WITH CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE ENGINEERING ORDERS. | M | | |
| | | 520 | OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M | | |
| | | 530 | COMPLY WITH MASI 66 367, PARA 3.3. | M | | |
| | | | TYPE WORK PERFORMED_____ | | | |

CAL004 * WORK CONTROL DOCUMENT * 72-10 1.DATE 89043 PAGE 1 OF 3 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 34044A | | MTPCAF | 89074 | |

| 7.ART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 41469/42590 (M) | | TO MAT87-16 |
| | | PB MAT87-3 |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | 8E1 8 8-3 8/87AR |
| TF35 P7 | 2925009862055RV1 | CHG 21 |
| | | 8E1 8 8-3-1 8006 R |
| 13.MISC | 14.NOUN/END ITEM NOUN | CHG 3 |
| | IGNITION EXCITER PACI | JOHN GEISSLER |
| | JENNINGS/MATLAC/65920 | |

| STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.A | 19.T | 20.M |
|---|---|---|---|---|
| | 20% TOTAL TEARDOWN | | | |
| W-43 | 010 RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 015 ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 DISASSEMBLE. | M | 120 | |
| | 030 CLEAN AS REQUIRED. | M | 6 | |
| | 040 INSPECT. (VISUAL) | M | 6 | |
| | 060 TEST CAPACITORS IAW T.O. FLASH 20' METER 40' (REPLACE EPOXY) 2 CAP | OC 4929 M | .12 | OC 4929 35% R |
| | 070 TEST FILTER IAW T.O. TEST STAND 1 FILTER | M | 6 | 15% R |
| | TEST INDUCTORS(2) 3 MIN 10% REPL | | | |
| | 080 TEST RESISTORS IAW T.O. (4) EA | M | 6 | 5% R |
| | 090 TEST DISCHARGER TUBE #24498 AND 24222 IAW T.O. (3) EA (TEST ST 20') | M | 12 | 60% R |
| | 100 TEST FEED-THROUGH TERMINAL IAW T.O. (1) EA TEST STAND | M | 6 | 5% R |
| | 110 TEST PWR TRANSF. IAW T.O. | M | 6 | 5% R |
| | 120 TEST VIBRATOR IAW T.O. | M | 6 | JP DAT 109% FIOD |
| | 380 REPAIR OR REPLACE AS NECESSARY. | M | 12 .42 | DEC HR |

CALCO4 * WORK CONTROL DOCUMENT * 72-10 1.DATE 87045 PAGE 2 OF 3 PAGES

| 15.DISP 16.PDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"T" | 20"U" |
|---|---|---|---|---|---|
| | 390 | REASSEMBLE. & TORQUE As Req'D | M | 180 3.0 | |
| DELETE | ~~440~~ | ~~TORQUE ALL INSIDE SCREWS & NUTS AND CAP (13) IAW T.O.~~ | ~~M~~ | | |
| | 460 | INTERMEDIATE TEST: APPLY 14 V FOR 10 SECONDS MAX. OBTAIN 3100 3400V. ACT:_____V<br>INPUT VOLTAGE 14 24 29<br>SPARKS OVER 10 SEC 5.0 5.0 5.0<br>PERIOD (MINIMUM)<br>ACTUAL ____ ____ ____<br>AMPS (MAXIMUM) 5.0 5.0 5.0<br>ACTUAL ____ ____ ____<br>CONTINUOUS DUTY CIRCUIT TEST: STOR-AGE CAPACITOR VOLTAGE<br>ACTUAL_____VOLTS<br>INPUT CURRENT<br>ACTUAL_____AMP<br>SPARK RATE, LEFT HAND OUTPUT, 10-20 SPARKS IN 10 SECONDS.<br>TRIGGERING CIRCUITS TEST: APPLY 24 VDC FOR 10 SECONDS. CONSISTENT SPARKING MUST BE OBSERVED IN WINDOWS OF BOTH TESTER.<br>INSERT SHORTING CAP TO ONE TESTER AT A TIME. MUST WORK CORRECTLY.<br>TESTER #1: GAP 0.200, 20 PSIG.<br>TESTER #2: GAP 0.100, 5 PSIG.<br>OBTAIN GAP 0.200 INCH, 20 PSIG. "C" PIN 115 V 400 CYCLE. CONSISTENT SPARKING. | M | X 9 | TEST STAN OC 4929 |
| | 520 | FILL WITH POTTING COMPOUND AND BAKE IAW T.O. FLOW 180 MIN | 6 M | | |
| | 525 | TORQUE ALL SCREWS OR NUTS OUTSIDE OF CASE. IAW T.O. (SOLDER SEAL CASE) | M 18 | | |
| | 530 | TEST FOR LEAKS: APPLY 15 PSIG. LEAK-AGE 1 X 10 -6 CUBIC CENTIMETERS PER SECOND MAXIMUM. (ALT LEAK CHECK IN WATER)<br>ACTUAL_____ | M 6 | | OC 3952 |
| | 540 | PRESSURE GAS CHARGE EXCITER. 30 FLOW OVEN | M 6 | | 24 OC |
| | 560 | PAINT 240 FLON | SNAG M 18 | | ? |
| | 570 | FINAL TESTING<br>OUTPUT ENERGY LEVEL AND SPARK | M 9 | OC 4929 (SEE 460) | |

(CONTINUED)

| STATION | OP NO. | 17. WORK TO BE ACCOMPLISHED | 18. MEAN | 19. | 20. |
|---|---|---|---|---|---|
| | | RATE OF INTERMITTENT DUTY CIRCUIT. APPLY 24 V INPUT CURRENT 5.0 AMPS MAXIMUM. STORED ENERGY ACTUAL_____METER READING SPARK RATE ACTUAL_____ OUTPUT ENERGY LEVEL OF CONTINUOUS DUTY CIRCUIT. APPLY 115 V 400 CYCLE INPUT CURRENT 2.5 AMPS RMS. STORED ENERGY ACTUAL_____METER READING SPARK RATE ACTUAL_____ TESTING CIRCUITS IN INTERMITTENT DUTY CIRCUIT GAP 0.100 IN @ 5 PSIG. APPLY 24 VDC FOR 10 SEC MINIMUM. CONSISTENT SPARKING. INSERT SHORTING CAP TO EACH OUTPUT TERMINAL IN TURN. MUST FIRE CONSISTENTLY. TESTER #1: GAP 0.200, 25 PSIG TESTER #2: GAP 0.100, 5 PSIG. MUST FIRE CONSISTENTLY. REVERSE AND TEST. OBTAIN GAP 0.200 INCH, 20 PSIG. APPLY PIN "D" 115 V 400 CYCLE. OBSERVE CONSISTENT SPARKING. | | | |
| | 650 | SAFETY WIRE | M 3 | | |
| | 660 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M 3 | | |
| | 670 | OPERATIONS COMPLETED & PAPERWORK PROCESSED. AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M 6 | | |
| | 680 | COMPLY WITH MAUI 66-36 PARA 13<br>TYPE WORK PERFORMED _____ | M 3 | | |

12 HRS

LEAK TEST BENCH / ENDERSON

WORK CONTROL DOCUMENT | DATE 88307 PAGE [illegible] OF 9 PAGES

| 12. ORIG/PROD NR | 13. QUANTITY | 14. PROD SECTION/RCC | 15. DATE ORDERED | 16. DATE COMP |
|---|---|---|---|---|
| [illegible]120A | | ATPCA | 88092 | |

PART NUMBER | 19. ITEM SERIAL NR | 18/12. TECH DATA/OPTIONS
[illegible] | | TO [illegible]
| | REV. 4-80 [illegible]
MODEL/DESIGN/SER | STOCK NR | CHG 21
[illegible] | [illegible]840040AR2260P[illegible]

MISCELLANEOUS NOUN/END ITEM NOUN
[illegible] ASSY [illegible]
[illegible]/MATEAC[illegible]5970

| OPERATION NO | 17. WORK TO BE ACCOMPLISHED | | | | |
|---|---|---|---|---|---|
| 010 | REC IN, IDENTIFY & ATTACH PAPERWORK. | M | | | |
| 015 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE | M | | | |
| 020 | DISASSEMBLE AS REQUIRED. | M | | | |
| 030 | CLEAN AS REQUIRED. | M | | | |
| 040 | [illegible], STRAIGHTEN IF NECESSARY | M | | | |
| 045 | FLUORESCENT PENETRANT INSPECTION PARA 3-47 | [illegible] | | | |
| | ROUTE TO [illegible], [illegible] | | | | |
| 050 | WORK COMPLETED, ROUTE TO ATPCA | M | | | |
| 060 ATPCA | REPAIR & REPLACE AS NECESSARY | M | | | |
| 070 | REASSEMBLE IAW T.O. NOTE: BAKE PROBES PRIOR TO RESISTANCE CHECK IAW NOTE PARA. 4-5A. | M | | | |
| 080 | CHECK RESISTANCE (WHEATSTONE BRIDGE) ACT QHAS | M | | | |
| 090 | CHECK INSULATION RESISTANCE (MEGGER) ACT QHAS | M | | | |
| 100 | HEATER PROBE TEST [illegible] (JETCAL ANALYZER) ACT SPREAD. ENTER ACTUAL TEMPERATURE VALUE FROM | M | | | |

(CONTINUED)

| CAGE/DODAAC = WORK CONTROL DOCUMENT = JC | 5.DATE 03JUL7 | PAGE 2 OF 2 PAGES |
|---|---|---|
| 11A.DISP 14.PDN/ | | |

| STATION OP NO. | 12.WORK TO BE ACCOMPLISHED | 13.M,C,H,I,V,P,T | 14.PMA |
|---|---|---|---|
| | STEP 100 ABOVE ON PURPOSE OF SERVICEABLE TAG, DD 1574. | | |
| 110 | SAFETY WIRE. | M | |
| 120 | COMPLETE & FORWARD [illegible] TO DATA PROCESSING | M | |
| 130 | I CERTIFY THAT THIS END ITEM HAS BEEN INCORPORATED FOR I.R. / TCTO: CURRENT REVISIONS, SUPPLEMENTS AND APPROVED DEVIATIONS. | M | |
| 140 | OPERATIONS CONDUCTED IN ACCORDANCE WITH | M | |
| 150 | COMPLY WITH PARA 6A 3A, PARA 14 | M | |
| | TYPE MARK PERFORMED | | |

CAAC02 * WORK CONTROL DOCUMENT * JC 1.DATE 89010 PAGE 1 OF 1 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/REC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 34252A | | MTRCA | 89139 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL |
|---|---|---|
| 8TJ51GAA4 | | SL14-2-/-13 342/4H |
| | | CHG 13 May 22, 1989 |

| 10.MODEL/DESIGN/SERIES | 11.STOCK NR |
|---|---|
| B52 | 6130007726566NT |

Mr. Martin Chuckle, + this is the same equipment Incurs as JCN # 34253A.

| 13.MISC | 14.NOUN/END ITEM NOUN |
|---|---|
| | FLOWMETER PWR SUPPLY PAC |
| | YEART/MATEAA/65920 |

| 15.DISP-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"F" | 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. | | | |
| W-41 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 050 | DISASSEMBLE | M | | |
| | 060 | CLEAN | M | | |
| | 070 | INSPECT | M | | |
| | 100 | LUBRICATE AS REQUIRED | M | | |
| | 110 | REASSEMBLE | M | | |
| | 115 | TEST. | M | | |
| | 120 | COMPLY WITH MAUI 66-36, PARA 13<br>TYPE WORK PERFORMED Overhauled | M | | |
| | 170 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., WITH CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | This mechanic M stamp WCD-Sheet. Item 4.027 | | |
| | 180 | OPERATIONS COMPLETE AND PAPERWORK PROCESSED. | M | | |

[illegible] * WORK CONTROL DOCUMENT * JC    1.DATE [illegible]   PAGE 1 OF 1 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| [illegible] | | MITCA | [illegible] | |

| 7.PART NUMBER | 8.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| [illegible] | | SL14 2 / 13 [illegible] CHG 13 |

| 9.MODEL/DESIGN/SERIES | 11.STOCK NR |
|---|---|
| B52 | [illegible]/NT |

13.[illegible] 14.NOUN/END ITEM NOUN
FUEL FLOWMETER PWR SUPPLY PAC
YEARY/MATLAA/65920

| 15.DISP STATION | 16.PDN/ OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19.[illegible] | 20.[illegible] |
|---|---|---|---|---|---|
| | | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | | | |
| W 41 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 020 | DISASSEMBLE. | M | | |
| | 030 | CLEAN. | M | | |
| | 040 | INSPECT. | M | | |
| | 050 | LUBRICATE AS REQUIRED. | M | | |

| | | | |
|---|---|---|---|
| | 060 | REASSEMBLE. | M |
| | 080 | COMPLY WITH MAOI 66 33, PARA 13. | |
| | | TYPE WORK PERFORMED_____ | M |
| | 090 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M |
| | 100 | OPERATIONS COMPLETE AND FACILITY PROCESSED. | M |

DAAG24 * WORK CONTROL DOCUMENT * JC 1.DATE 07010 PAGE 1 OF 1 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/REC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 34253A | | MTPCA | 07134 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 6TJ510AA5 | | 5L14 2 7 13 042/4H |
| | | CHG 13 |

10.MODEL/DESIGN/SERIES 11.STOCK NR
852 6130007720567/NTF

13.MISC 14.NOUN/END ITEM NOUN
FULL FLOWMETER PWR SUPPLY PACI
-7L4A7/MATEAA/65920

15.DISP 16.FDN/
STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.RECHI 19/

| | | | |
|---|---|---|---|
| | | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIRECTIONS AND TOLERANCES REQUIRING COMPLIANCE. | |
| W-41 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M |
| | 020 | DISASSEMBLE. | M |
| | 030 | CLEAN. | M |
| | 040 | INSPECT. | M |
| | 050 | LUBRICATE AS REQUIRED. | M |
| | 060 | REASSEMBLE. | M |

CAEZ04 * WORK CONTROL DOCUMENT * JC 1.DATE 89161 PAGE 1 OF 2 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 34551A | | MTFCAF MATRA | 89055 | |

| 7. ART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| | | PO MAT3/-3 |
| | | 6J15-2 155-3 862441 |
| | | CHG 3 |

| 8.MODEL/DESIGN/SERIES | 11.STOCK NR |
|---|---|
| M 41 A1/A2 | |

13.MISC 14.NOUN/END ITEM NOUN
SOLENOID VALVE PAGE
MULTINUM/MATLAB/35920

| C/N | NSN | C/N |
|---|---|---|
| 6867277 | 2915001769790R | 34397A |
| 6867277 | 2915001769790E | 6117/A |
| 6867235 | 4810001114113CN | 34551A |

| 15.DISP STATION | 16.PDR/SP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"S" |
|---|---|---|---|---|---|
| M-41 | 010 | RECEIVE, IDENTIFY AND ATTACH PAPERWORK. | M | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 | DISASSEMBLE. | M | | |
| | 030 | CLEAN. | M | | |
| | 040 | INSPECT. | M | | |
| | 050 | APPLY 90 VDC FOR 5 SECONDS BETWEEN EACH PIN AND BODY. . ACT: MEGOHMS. | M | | |
| | 060 | CHECK CONTINUITY PINS (1-2) AND (3-4). PINS (1-2) ACT: OHMS PINS (3-4) ACT: OHMS . | M | | |
| | 080 | CHECK AIR GAP IAW T.O. . ACT: INCH . . | M | S | |

| 15.DISP STATION | 16.FUN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 090 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 100 | REASSEMBLE. | M | | |
| | 110 | TORQUE SCREWS (12).<br>ACT: LB IN<br>*TORQUE WRENCH | M | | |
| 3100 | 115 | PERFORM LOW PRESSURE FLOW LEAKAGE TEST AT 330 PSIG. NO LEAKAGE ALLOWED OVER A PERIOD OF 2 MINUTES. *TEST SET. | M | | |
| Routing Symbol | 130 | PERFORM VALVE LEAKAGE TEST AT 1900 PSIG FOR 2 MINUTES. NO LEAKAGE ALLOWED. **TEST STAND** | M | | |
| | 140 | CALIBRATION: CHECK FLOW THROUGH VALVE.<br>ACT: LB/HR | M | | |
| | 150 | CHECK LEAKAGE FROM OUTLET CONNECTION.<br>ACT: CC/MIN | M | | |
| | 160 | APPLY 1930 PSIG INLET PRESSURE. NO LEAKAGE EXCEPT FROM OUTLET CONNECTION. | M | | |
| | 170 | APPLY 130 PSIG. NO LEAKAGE ALLOWED OVER 2 MINUTE PERIOD. | M | | |
| W-43 | 175 | ~~PAINT~~<br>REQ NOT REQ | M | | |
| | 178 | [redacted] ELECTRICAL CHECK APPLY 500 VDC [redacted] SECONDS BETWEEN EACH PIN AND [redacted]Y. ACT: MEGOHMS. | M | | |
| | 180 | AFTO FORM 349 COMPLETED AND FORWARDED TO DATA AUTOMATION. | M | | |
| | 235 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M | | |
| | 240 | OPERATIONS COMPLETE AND PAPER-WORK PROCESSED. | M | | |
| | 255 | COMPLY WITH MAUI 66-36, PARA 13 TYPE WORK PERFORMED | M | | |

Routing Symbol

Del

Leave in 3100

CACY10 * WORK CONTROL DOCUMENT * 00 1.DATE 88307 PAGE 1 OF 5 PAGES

| 12.ORIG/PROD NR | 13.QUANTITY | 14.PROD SECTION/REC | 15.DATE SCHED | 16.DATE COMP |
|---|---|---|---|---|
| 35023A | | MTPCA | 89094 | |

| 7.PART NUMBER | 19.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 42127 (M) | | PO MAT88-3 |
| | | 8E1-8-12-3 8/2008 |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 8 |
| TF30 P103,107,1 -09 | 2925009413/08PG1 | |

13.MISC 14.NOUN/END ITEM NOUN
IGNITION EXCITER PAGE
COMPKINS/MATEAC/65920

JOHN

| STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.M OR | 19."I" | 20."S" |
|---|---|---|---|---|
| W 41 | 010 RECEIVE, IDENTIFY & ATCH PAPERWORK. | M | | |
| | 015 ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 PRELIMINARY CHECK: MEASURE RESISTANCE BETWEEN OUTPUT TERMINAL AND GROUND<br>*VIVM* ACT:_____OHMS. | M | | |
| | 030 TEST: OUTPUT ENERGY LEVEL & SPARK RATE:<br>.<br>ACT:_____JOULES<br>OBTAIN STORED ENERGY<br>.<br>*EXCITER TESTER*<br>ACT:_____METER READING | M | | |
| | 040 APPLY 21.0 VOLTS/RMS. OBTAIN 1.0 SPARKS PER SECOND MINIMUM. | M | | |
| | 050 TEST TRIGGERING CIRCUIT: ADJUST FOR CAP & INTERNAL PRESSURE.<br>.<br>ACT_____INCH ACT_____PSIG<br>APPLY 21.0 VOLTS/RMS 400 CYCLE.<br>OBTAIN CONSISTANT SPARKING. | M | | |
| | 060 PRESSURE TEST: SUBMERGE IN WATER 180 DEG F MIN FOR 1 MINUTE. NO LEAKS<br>.<br>. | M | | |
| | 070 DISASSEMBLE. | M | | |

COMPOUND

SIX MIN OPTS

| 15.DISP 16.FDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 080 | REMOVE COVERS. | M | | |
| | 090 | CLEAN AS REQUIRED. | M | | |
| | 100 | INSPECT. | M | | |
| 0 30 | 110 MTPIW | WELD INPUT & OUTPUT TERMINALS<br>REQ:_____NOT REQ:_____ | M | | |
| | 130 | FLASH TEST CAPACITOR: IAW T.O.<br>.<br>. | M | | |
| | | "C" "D" & CASE ACT:_____SEC | | | |
| | | ACT:_____MA. | | | |
| | | "A" & "B" ACT:_____SEC | | | |
| | | ACT:_____MA. | | | |
| | | "A" "B" & CASE ACT:_____SEC | | | |
| | | ACT:_____MA. | | | |
| | 140 | CHECK CAPACITANCE:<br>"A" TO "B" | M | | |
| | | ACT:_____UF | | | |
| | | "B" TO "C" | | | |
| | | ACT:_____UF | | | |
| | | "C" TO CASE - | | | |
| | | ACT:_____UF | | | |
| | | "D" TO CASE - | | | |
| | | ACT:_____UF | | | |
| | | "B" TO CASE -<br>ACT:_____UF<br>*CAPACITOR BRIDGE TESTER* | | | |
| | 150 | FILTER TEST: IAW T.O. | M | | |
| | | ACT:_____OHM | | | |
| | 160 | APPLY 500 VOLTS DC BETWEEN PINS OF INPUT RECEPTACLE FOR ONE MINUTE MIN | M | | |

(CONTINUED)

| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | IMUM. NO BREAKDOWN ALLOWED. | | | |
| | 170 | CHECK LEAKAGE BETWEEN "B" & GROUND FOR ONE MINUTE.<br>.<br>*VTVM* ACT:_____MEGOHM. | M | | |
| | 180 | MEASURE RESISTOR'S (7)<br>.<br>NO. 1 ACT:_____OHMS<br><br>NO. 2. ACT:_____OHMS<br><br>*VTVM* | M | | |
| | 190 | RECTIFIER TUBE TEST: APPLY 3000 VOLT INVERSE CURRENT AFTER APPROX 30 SEC. OBTAIN.<br><br>#1 ACT:_____SEC<br>ACT:_____MA<br>#2 ACT:_____SEC<br>ACT:_____MA<br>#3 ACT:_____SEC<br>ACT:_____MA<br>#4 ACT:_____SEC<br>ACT:_____MA<br><br>*TEST CONSOLE* | M | | |
| | 200 | OBTAIN 10 MILLIAMPERES FLOW. VOLTAGE DROP.<br><br>#1 ACT:_____VOLTS<br>#2 ACT:_____VOLTS<br>#3 ACT:_____VOLTS<br>#4 ACT:_____VOLTS | M | | |
| | 210 | ESS POSITION - OBTAIN BREAKDOWN. STABILIZED STRIKING VOLTAGE<br>.<br><br>#1 ACT:_____VOLTS | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"I" | 20"Q" |
|---|---|---|---|---|---|
| | | #2 ACT:_____VOLTS | | | |
| | | #3 ACT:_____VOLTS | | | |
| | | #4 ACT:_____VOLTS | | | |
| | 220 | DISCHARGER TUBE TEST: IAW T.O. ACT:_____ *TEST CONSOLE, VOLTASCOPE, DISCHARGER TUBE TESTER* | M | | |
| | 230 | HIGH TENSION CIRCULATOR TEST:IAW T.O. | M | | |
| | 240 | POWER TRANSFORMER TEST: IAW T.O. | M | | |
| | 250 | MEASURE RESISTANCE BETWEEN TWO SECONDARY LEADS. ACT_____OHMS ACT_____OHMS | M | | |
| | 260 | APPLY 1.5 VOLTS BETWEEN PRIMARY INPUT LEAD & GROUND. EXCITER CURRENT . ACT:_____AMP | M | | |
| | 270 | CHECK VOLTASCOPE WAVEFORM FOR "FLASH" AT 2500 VOLTS PEAK ON SECONDARY. | M | | |
| | 280 | HIGH TENSION TRANSFORMER TEST: CHECK CONTINUITY. | M | | |
| | 290 | ADJUST GAP & AN INTERNAL PRESS. ACT:_____INCH ACT:_____PSIG ACT:_____VOLTS | M | | |
| | 300 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 310 | REASSEMBLE. | M | | |
| | 320 | INTERMEDIATE TEST ON OPEN EXCITER: APPLY INPUT VOLTAGE OF 21.0 VOLTS (RMS). OBTAIN 1.0 SPARKS PER SECOND MINIMUM ACT:_____ | M | | |

(CONTINUED)

| CAEY10 * WORK CONTROL DOCUMENT * JC | 1.DATE 88307 | PAGE 5 OF 5 PAGES |
|---|---|---|

| 15.DISP STATION | 16.FDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"I" | 20"Q" |
|---|---|---|---|---|---|
| | | OBTAIN INPUT CURRENT<br>.<br>ACT:_____AMPS<br>OBTAIN STORAGE CAPACITOR VOLTAGE<br>.<br>ACT:_____VOLTS<br><br>*OUTPUT TESTER EXCITER TESTER VOLTASCOPE* | | | |
| | 330 | TEST TRIGGERING CIRCUIT: IAW T.O.<br>. | M | | |
| 0-35 | 340 MTPIW | WELD COILS IAW T.O.<br>. | M | | |
| 0-35 | 350 MTPIW | PRESSURE TEST: IAW T.O. | M | | |
| | 360 | GAS CHARGING: BAKE EXCITER 30 MINUTES. FILL DRY NITROGEN 10 POUND GAUGE. SOLDER TUBE. | M | | |
| | 380 | BAKE 400 DEG. F. FOR 25 MINUTES. | M | | |
| | 390 | TEST EXCITER: IAW T.O.<br>.<br>ACT:_____AMP<br>.<br>OBTAIN STORED ENERGY<br>.<br>ACT:_____METER READING | M | | |
| | 400 | APPLY 21.0 VOLTS (RMS). OBTAIN 1.0 SPARKS PER SECOND MINIMUM.<br><br>ACT:_____ | M | | |
| | 410 | TRIGGERING CIRCUIT TEST: IAW T.O. | M | | |
| | 420 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M | | |
| | 460 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS. | M | | |
| | 470 | OPERATIONS COMPLETED & PAPERWORK PROCESSED. | M | | |
| | 475 | COMPLY WITH MAUI 66-36, PARA 13<br><br>TYPE WORK PERFORMED_____ | M | | |

CACYLL * WORK CONTROL DOCUMENT * JC 1.DATE 88307 PAGE 1 OF 2 PAGES

| 2.ORDR/PROD NR | 3.QUANTITY | 4.PROD SECTION/REC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 35033A | | MTFCA | 89093 | |

| 7.LOT NUMBER | 9.TLM.SERIAL NR | 10/12.TLUH DATA/OPTIONAL |
|---|---|---|
| C1251154 (M) | | PO MA7334-3 |
| | | 7J14-3-3 8518SH |
| 11).MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 5 |
| H 40 103 107 10 | 6660001102680MW | |

| | 14.MAIN/END ITEM NOUN |
|---|---|
| | LIQUID LEVEL SENSOR PAC |
| | CONFIGS/MATLAB/65970 |

| 15.OPER 16.PDN/ STATION NO. | 17.WORK TO BE ACCOMPLISHED | 18.REQUIRED "19" "20"G" |
|---|---|---|
| | F 6330-00-945-4772FB<br>MET72A<br>3503A3<br>3503A3C | |
| M 005 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M |
| 015 | ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. FOR DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M |
| 020 | DISASSEMBLE AS REQUIRED. | A |
| 030 | CLEAN AS REQUIRED. | M |
| 040 | INSPECT. | M |
| 050 | MEASURE INSULATION RESISTANCE BE-TWEEN ALL FEED THRU LEADS AND CASE GROUND<br>#1 ACT: MEGOHMS<br>#2 ACT: MEGOHMS<br>#3 ACT: MEGOHMS<br>#4 ACT: MEGOHMS<br>#5 ACT: MEGOHMS<br>#6 ACT: MEGOHMS<br>*MULTIMETER | M |
| 070 | REPAIR OR REPLACE AS NECESSARY. (REPAIR IS LIMITED TO FOUR ITEMS AS PER T.O.) | M |
| 080 | DISASSEMBLE. | M |
| 090 | SAFETY WIRE OR SEALING COMPOUND THAT CONFORMS TO MIL-S-22473D WILL BE USED TO SECURE TERMINAL BLOCK SCREWS (5). | M |

| CAEY11 * WORK CONTROL DOCUMENT * JC | 1.DATE 8UJ0/ | PAGE 2 OF 2 PAGES |
|---|---|---|
| 15.DISP 16.TDN/ | | |

| STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.ACCH | 19"P" | 20"S" |
|---|---|---|---|---|
| 110 | CONTINUITY AND RESISTANCE CHECK: | | | |
| | | M | | |
| | 4 TO 2 ACT: | | | |
| | | | | |
| | 6 TO 2 ACT: | | | |
| | | | | |
| | DIFFERENCE ACT: | | | |
| | | | | |
| | 4 TO 5 ACT: | | | |
| | | | | |
| | 6 TO 5 ACT: | | | |
| | | | | |
| | DIFFERENCE ACT: | | | |
| | | | | |
| | 4 TO 1 ACT: | | | |
| | | | | |
| | 6 TO 1 ACT: | | | |
| | | | | |
| | DIFFERENCE ACT: | | | |
| | | | | |
| | 4 TO 3 ACT: | | | |
| | 6 TO 3 ACT: | | | |
| | | | | |
| | DIFFERENCE ACT: | | | |
| 120 | AFTER ITEM 34, COMPLETED & FORWARDED TO DATA AUTOMATION. | M | | |
| 130 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TUTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE FIRELESS ORDERS. | M | | |
| 140 | OPERATIONS COMPLETED & PAPERWORK PROCESSED | M | | |
| 155 | COMPLY WITH NAVE 66-56, PARA 13 | | | |
| | | M | | |
| | TYPE WORK PERFORMED | | | |

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|---|---|---|

| 2.ORIG/REQD NR | 3.QUANTITY | 4.PROD SECTION/REC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| | | MTPCAP | 89081 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| | | OFL-2-32-3 041958 |
| | | CHG 5 |

8.MODEL/DESIGN/SERIES 11.STOCK NR
1141 A1/A2/402D

13.MISC 14.NOUN/END ITEM NOUN
AUTOMATIC IGNITION ACTUATOR ASY
WALTERON/MATEAC/45926

| P/N | NSN | C/N |
|---|---|---|
| 45927-39 | 2925000085485RC | 41296 |
| (10-33470-3) | | |
| 45927-40 | 2925000085485QN | 35111A |
| (10-33470-4) | | |

| 15.DISP | 16.PGM/STATION/OP NO. | 17. WORK TO BE ACCOMPLISHED | 18.MECH | 19.T* | 20.M* |
|---|---|---|---|---|---|
| M-43 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | .10 MIN | | |
| | | | M | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | M .15 MIN | | |
| | 020 | DISASSEMBLE. | .60 MIN | | |
| | | | M | | |
| | 030 | CLEAN AS REQUIRED. | .20 MIN | | |
| | | | M | | |
| | 040 | INSPECT AS REQUIRED. | .15 MIN | | |
| | | | M | | |
| | 050 | CHECK THE ELECTRICAL OPERATION OF SWITCH CONTAINED IN COVER & SWITCH ASSY. *OHMMETER → Hand-Tools | .5 MIN | | |
| | | | M | | |
| | 060 | CHECK LEAKAGE RESISTANCE OF EACH CONTACT PIN & THE SWITCH HOUSING. MINIMUM ALLOWABLE RESISTANCE SHALL BE WITHIN SPECIFIED MEGOHMS. | M .5 MIN | | |
| | | ACT: ACT: *500 VOLT MEGGER | | | |
| | 070 | REPAIR AS NECESSARY. | .15 MIN | | |
| | | | M | | |
| | 080 | PLACE COVER & SWITCH ASSY IN OVEN & HEAT 1 HR. AT 350 DEG. F. TO LOOSEN | M | | |

(CONTINUED)

Oshkosh

LVG-10 → LAVIC 5-19-89
Ma Richard Franklin

| CAEZOS * WORK CONTROL DOCUMENT * JC | 1.DATE 08222 | PAGE 2 OF 4 PAGES |
|---|---|---|

| 15.DISP 16.PDN/ STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH 19"P" 20"Q" |
|---|---|---|
| | POTTING COMPOUND. → | |
| 090 | WIPE SWITCH WITH A CLEAN CLOTH MOISTENED WITH METHYLETHYLKETONE OR EQUIVALENT. ALLOW TO AIR DRY . WITHIN PRESCRIBED LIMITS. | M |
| | ACT IND | |
| 100 | POSITION ITEMS PREVIOUSLY REMOVED INSIDE THE COVER WITH HOLES LINED UP & INSTALL BRACKET & SWITCH ASSY USING 2 LARGE ALLEN HEAD SCREWS & LOCKWASHERS PREVIOUSLY REMOVED. TORQUE SCREWS WITHIN LIMITS. | M |
| | ACT IN/LBS | |
| | *TORQUE WRENCH | |
| 110 | AT THE MOMENT SWITCH PLUNGER TRIPS SWITCH TO ON, DISTANCE FROM PLUNGER ACTUATING LEVER TRIP TO COVER MATING SURFACE SHALL BE WITHIN PRESCRIBED LIMITS. | M |
| | ACT: IN/LB | |
| | *DEPTH MICROMETER | |
| 120 | REPLACE AS NECESSARY. → Delete | M |
| 130 | LUBRICATE AS REQUIRED. | .5min M |
| 140 | REASSEMBLE | .30min M |
| 150 | TORQUE ADAPTER REQUIRED | M |
| | *TORQUE WRENCH | |
| 160 | INSTALL SCREWS THEN SUCCESSIVELY & GRADUALLY TIGHTEN DIAGONALLY OPPO SITE SCREWS UNTIL DIAPHRAGM IS DRAWN DOWN EVENLY. TORQUE SCREWS WITHIN IN/LBS LIMITS. | M |
| | ACT: | |
| 170 | INSTALL SCREWS, SUCCESSIVELY & GRADUALLY TIGHTEN SCREWS UNTIL COVER IS DRAWN DOWN EVENLY. TORQUE SCREWS TO REQUIRED IN/LBS. | M |
| | ACT: | |
| 180 | POSITION SCREW IN CENTER HOLE OF SWITCH HOUSING. THREAD SCREW INTO | .5min M |

(CONTINUED)

| CAEZ00 * WORK CONTROL DOCUMENT * JC | 1.DATE 88222 | PAGE 3 OF 4 PAGES |
|---|---|---|

| 15.DISP | 16.PDN/STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19.QA | 20.QC |
|---|---|---|---|---|---|
| | | HOUSING UNTIL MAX DEPTH IS REACHED<br>ACT: INCH | | | |
| | 190 | SPRING ADJUSTMENT DURING ASSEMBLY. OBTAIN ACT PRESS GAGE OF 4.4 PSI. | M | | |
| | 200 | INSTALL THE ADAPTER IN BOLT OF COVER & SWITCH ASSY. TORQUE ADAPTER TO PRESCRIBED LIMITS.<br>ACT: IN/LBS | M | | |
| | 210 | CHECK & ENSURE WASHER IS STILL ALIGNED. INSTALL SPRING & PLUG IN HOUSING. TORQUE PLUG WITHIN LIMITS<br>ACT: IN/LBS | M | | |
| | 220 | INSTALL VALVE ASSY IN SWITCH HOUSING TORQUE VALVE BODY TO PRESCRIBED LIMITS.<br>ACT: IN/LBS | M | | |
| | 230 | TEST SWITCH ASSY FOR LEAKAGE.<br>ACT:<br>LEAK DETECTOR TESTER | M | | |
| | 240 | TESTING. | M | | |
| | | Cover Hill: | | | |
| | 250 | CONNECT AIR HOSE ASSEMBLY | M | | |
| | 260 | ADJUST THE ACTUATOR PRESS REGULATOR UNTIL ACTUATOR PRESSURE GAUGE INDICATES 7 PSI<br>REQ NOT REQ | M | | |
| | 270 | DEPRESS AND HOLD TEST BUTTON ON TEST SET TO DECREASE AIR PRESSURE ON SWITCH ASSEMBLY. THE ACTUATOR SWITCH SHALL NOT COME ON. | M | | |
| | 280 | COMPLETE IAW T.O. 6E1-2-32-3 PARA 7-3. SUB PARA 6 | M | | |
| | 290 | AFTER 13 PSI CHECK IS SATISFACTORILY COMPLETED, REPEAT AT 35 PSI | M | | |
| | 300 | OBSERVE HOW LONG ACTUATOR SWITCH INDICATOR OF TEST REMAINS LIT. THIS IS THE "ON" TIME OF SWITCH ASSY. "ON" TIME SHALL BE WITHIN LIMITS.<br>ACT: SEC. | M | | |
| | 310 | ADJUST THE ACTUATOR PRESS REGULATOR UNTIL ACTUATOR PRESSURE GAUGE IN- | M | | |

(CONTINUED)

| CAEZQG | WORK CONTROL DOCUMENT * JC | 1.DATE 05229 | PAGE 4 OF 4 PAGES |
|---|---|---|---|
| 15.DISP 16.PDN/ | | | |
| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MOCH 19"P" 20"Q" |
| | | DICATES 7 PSI.<br>SECOND TO INLET ADAPTER OF SWITCH<br>ASSEMBLY.<br>REQ: NOT REQ:<br>*LEAK DETECTOR TESTER* | .2min |
| | 320 | IF READJUSTMENT OF SCREW (20) WAS<br>REQUIRED, REPEAT THE 13 PSI CHECK.<br>ACT: | M .1min |
| | 330 | USING A SUITABLE SOURCE, GRADUALLY<br>APPLY 480 - 500 PSI OF CLEAN DRY AIR<br>AT A RATE NOT EXCEEDING 50 PSI PER<br>SECOND TO INLET ADAPTER OF SWITCH<br>ASSEMBLY<br>ACT ACT<br>*LEAK DETECTOR TESTER* | M .5min |
| | 340 | IMMERSE ACTUATOR ASSY IN A TANK OF<br>CLEAN WATER AT ROOM TEMPERATURE &<br>OBSERVE FOR LEAKAGE FOR 5 MINUTES.<br>LEAKAGE SHALL NOT EXCEED ONE BUBBLE<br>PER MINUTE.<br>ACT | M .6min |
| | 350 | AFTER FORM 349 COMPLETED & FORWARDED<br>TO DATA AUTOMATION. | M .10min |
| | 360 | SAFETY WIRE | .15min<br>M |
| | 370 | I CERTIFY THAT THIS END ITEM HAS<br>BEEN OVERHAULED (AM T.O., TCTO,<br>CURRENT REVISIONS, SUPPLEMENTS AND<br>APPLICABLE PROCESS ORDERS. | M .1min |
| | 380 | OPERATIONS COMPLETED & PAPERWORK<br>PROCESSED. | M .5min |
| | 390 | COMPLY WITH MAOI 66-36, PARA 13 | M .1 min |
| | | TYPE WORK PERFORMED OVERHAUL | |

CAEZ02 * WORK CONTROL DOCUMENT * JC 1.DATE 88202 PAGE 1 OF 2 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| | 01 | MTPCAI | 89135 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL |
|---|---|---|
| 6869188 | 6447 | 8D3-19-12-3 8/289H<br>CHG 4 |

| 10.MODEL/DESIGN/SERIES | 11.STOCK NR |
|---|---|
| TF41-A1 ENGINE | RINCON# R-719 |

| 13.MISC | 14.NOUN/END ITEM NOUN | |
|---|---|---|
| | CONTROL RELAY BOX | PAC |
| | WOLFFRUM/MATEAC/65920 | |

| P/N | NSN | C/N |
|---|---|---|
| 6869188 (M) | 2925001565633CN | 35113A<br>61230A |

MECHANIC: MR Franklin Machinist SKILL-CODE: A/10 WG-10

* Hand tools only.

| 15.DISP STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| W 43 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M .15min | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M .30min | | |
| | 020 | DISASSEMBLE. | M .30min | | |
| | 030 | CLEAN AS REQUIRED. | M .5min | | |
| | 040 | INSPECT AS REQUIRED. | M .10min | | |
| * | 050 | REPAIR OR REPLACE AS NECESSARY. | * M Repair - Consult engineering time. Replace Allow 1/2 hr. | | |
| | 060 | REASSEMBLE. | M .10min | | |
| | 070 | CONNECTING. | M .1min | | |
| | 080 | CONNECT THE LONG LINK HARNESS (6 FT LONG) TO THE SMALL RECEPTACLE ON THE REAR OF THE TEST BOX. Delete | M | | |
| | 090 | CONNECT THE SHORT LINK HARNESS (2 FT LONG) TO THE LARGE RECEPTABLE ON THE REAR OF THE TEST BOX. Delete | M | | |
| | ✓100 | CONNECT THE FREE END OF THE SHORT LINK HARNESS TO THE RECEPTACLE ON THE RELAY BOX. | M .1min | | |
| | ✓110 | CONNECT THE FREE END OF THE LONG LINK HARNESS TO A 400 CPS FULL WAVE RECTIFIED ELECTRICAL SUPPLY VARIABLE | M .1min | | |

(CONTINUED)

| CAEZ02 * WORK CONTROL DOCUMENT * JC | 1.DATE 88202 | PAGE 2 OF 2 PAGES |
|---|---|---|

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | BETWEEN 16V & 30V WITH A ZENER DIODE TO LIMIT ANY PEAKS OR SPIKES TO 33V. *TEST FIXTURE | | | |
| | 120 | TEST | .2 hrs M | | |
| | 130 | SET THE ELECTRICAL SUPPLY TO GIVE AN OUTPUT OF 16V. | M .2 hrs | | |
| | 140 | SET THE ELECTRICAL SUPPLY TO GIVE AN OUTPUT OF 30V. | M .2 hrs | | |
| | 150 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M .5 hrs | | |
| | 160 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M .1 hrs | | |
| | 170 | OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M .5 hrs | | |
| | 175 | COMPLY WITH MAOI 66-36, PARA 13<br>TYPE WORK PERFORMED → BIENNIAL | M 3½ hrs. | | |

CACY12 * WORK CONTROL DOCUMENT * JC 1.DATE 08307 PAGE 1 OF 4 PAGES

| | | | |
|---|---|---|---|
| 2.PROD NR 3Q610A | 3.QUANTITY | 4.PROD SECTION/ROC MTPCA | 5.DATE 08307 |

6.PART NUMBER 3Q610 1 (M)

19.ITEM SERIAL NR

10/12.TECH DATA/OPTIONAL
PO RATED 3
GL1 0 25 3
CHG 11

7.MODEL/DESIGN/SERIES 8111

11.STOCK NR 2926094G01/2701

12.ASSY/END ITEM NOUN
EDITOR EXCITER PAGI

WENDIE HAWKINS

| SEQUENCE NO. | 13.WORK TO BE ACCOMPLISHED | |
|---|---|---|
| 4 | RECEIVE, IDENTIFY & ATTACH TRAVELER | |
| 010 | ALL REFERENCES ARE TO THE BASIC E... AND APPLICABLE PROCESS ORDERS. ... DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | |
| 020 | MOVE TO MACHINE SHOP FOR REMOVAL OF ... | |
| 030 | DISASSEMBLE. | |
| 040 | ... AND SOLDER TERMINALS. | |
| 050 | REM_____ OUT R__R_____ | |
| 060 | CLEAN AS REQUIRED. | |
| 070 | INSPECT. | |
| 080 | CHECK RESISTORS: FROM NO. 5 WHITE WIRE TO NO. 6 WHITE WIRE<br>ACT_____MEG ACT_____MEG<br>OHMMETER<br>WHITE WIRE ON SPARK GAP TO WHITE WIRE ON V2. RESISTANCE<br>ACT:_____OHMS ACT:_____OHMS<br>OHMMETER<br>WHITE WIRE ON V4 TO NO.2 WHITE WIRE. RESISTANCE<br>ACT:_____OHMS ACT:_____OHMS<br>NO.4 BROWN WIRE TO NO.3 WHITE WIRE. CAPACITANCE, INITIAL, AFTER 3000 VDC FOR 15 SECONDS MIN.<br>ACTUAL_____UF ACTUAL_____UF<br>CAPACITOR ANALYZER<br>NO.4 BROWN WIRE TO WHITE WIRE ON | |

(CONTINUED)

CAEY12 * WORK CONTROL DOCUMENT * JC 1.DATE 08307 PAGE 2 OF 4 PAGES

| 15.DIS | 16.PDN/ STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.REMARKS | 19.QTY |
|---|---|---|---|---|
| | | SPARK GAP. CAPACITANCE READY WITH 3500 VDC FOR 15 SECONDS MINIMUM MINIMUM.<br><br>ACTUAL_____UF ACTUAL_____UF<br>WHITE WIRE ON SPARK GAP TO TERMINAL ON EXHAUST TIP END OF SPARK GAP.<br>BREAKDOWN VOLTAGE<br><br>ACT:_____VDC ACT:_____VDC<br>*TESTER JET IGNITION SYSTEM<br>NO.1 RED WIRE(CATHODE) TO NO.2 WHITE WIRE (ANODE) PLATE TO CATHODE PLATE<br>.<br>ACT:_____MILA ACT:_____MILA<br>WHITE WIRE ON SPARK GAP(CATHODE) TO NO.1 RED WIRE(ANODE) PLATE TO CATHODE PLATE<br>ACT:_____MILA ACT:_____MILA | | |
| | 080 | ADJUST VOLTAGE UNTIL SPARK GAP IS FIRED PULSE GENERATOR FIRES AT A RATE OF ONE PULSE EVERY 2 TO 3 SEC.<br>ADJ IGNITION CONTROL TEST SET | M | |
| | 090 | CHECK THAT SPARK GAP IS FIRED SPARK GAP HEAD CAN BE ADJUSTED FOR 1" SPARKS.<br>*VARIABLE SPARK GAP ASSEMBLY<br>PROCEDURE | M | |
| | 100 | CAPACITOR ASSEMBLIES CHECK CAPACITANCE FROM LEAD TO LEAD<br><br>ACT:_____UF ACT:_____UF<br>*CAPACITOR ANALYZER | M | |
| | 110 | ADJUST POTENTIAL TO 4500 V DC BE FUSED LEADS FOR A PERIOD OF NOT LESS THAN 10 SEC OR NOT MORE THAN 20 SEC.<br>*TESTER JET IGNITION SYSTEM | M | |
| | 120 | RESISTANCE OF PRIMARY WINDING<br>.<br>ACTUAL_____OHM<br>*OHMMETER | M | |
| | 130 | RESISTANCE OF SECONDARY WINDING<br>.<br>ACTUAL_____OHM | M | |
| | 140 | T2 RESISTANCE OF PRIMARY WINDING<br>.<br>ACTUAL_____OHM | M | |
| | 150 | RESISTANCE OF SECONDARY WINDING<br>.<br>ACTUAL_____OHM | M | |

| CACY12 * WORK CONTROL DOCUMENT * JC | 1.DATE 08307 | PAGE 4 OF | PROJECT |
|---|---|---|---|
| OPERATION NO. | 17.WORK TO BE ACCOMPLISHED | 18. | 19. |
| 160 | RESISTOR ASSY. TEST CONNECT METER LEADS FROM BLUE LEAD TO COMMON. OBSERVE METER.<br><br>ACTUAL_____OHMS<br>*OHMMETER | M | |
| [illegible] | CONNECT METER LEADS FROM YELLOW TO COMMON. OBSERVE METER.<br>.<br>ACTUAL_____OHMS | M | |
| [illegible] | CONNECT METER LEADS FROM BLACK TO COMMON. OBSERVE METER.<br>.<br>ACTUAL_____OHMS<br>*OHMMETER | M | |
| 170 | CHECK VALUE OF CAPACITANCE.<br>.<br>ACTUAL_____UF | M | |
| 180 | CHECK FOR CONTINUITY BETWEEN CASE PINS B & C AND THEIR RESPECTIVE PINS FOR TERMINALS. RESISTANCE SHOULD BE LESS THAN ONE OHM.<br>*OHMMETER | M | |
| [illegible] | CONTINUITY BETWEEN PIN B & CASE SHOULD BE LESS THAN ONE OHM.<br>ACTUAL_____OHM | M | |
| [illegible] | CHECK CAPACITANCE BETWEEN INPUT PIN B & HOUSING AND PIN C & HOUSING.<br><br>ACTUAL_____UF ACTUAL_____UF<br>*CAPACITOR ANALYZER | M | |
| 230 | CHECK INSULATION RESISTANCE BETWEEN INPUT PINS B & C.<br>.<br>ACTUAL_____MEGOHMS<br>*MEGGER -- 500 VDC | M | |
| 240 | APPLY BREAKDOWN VOLTAGE OF 200 VDC AT FULL CHARGE FOR 10 SECONDS FROM EACH INPUT PIN B & C TO HOUSING.<br>*JET IGNITION COMPONENTS TEST SET | M | |
| 245 | SOLDER RESISTORS TOGETHER IN SERIES CIRCUIT, INSTALL TUBING & HEAT SHRINK BY EXPOSING TO 347 DEG. F. FOR ONE MINUTE MINIMUM. | M | |
| 250 | REASSEMBLE. | | |

| CAEY12 * WORK CONTROL DOCUMENT * JC | 1.DATE 08307 | PAGE 4 OF 4 PAGES |
|---|---|---|
| 1...WUC 1c.FDN/ | | |
| STATION/UP NO. | 17.WORK TO BE ACCOMPLISHED | 18.AUTH/ |
| | 255 TEST OC | |
| 0-05 | 260 MIPIW MOVE TO WELDING SHOP TO WELD I.D. TEST AS REQUIRED. | M |
| | 280 TEST: EVACUATE EXCITER TO ONE LIGHT OF MERCURY & PRESSURIZE WITH 50 PSIG OF HELIUM. *~~MASS SPECTROMETER~~ LEAK DETECTOR | M |
| | 290 CLOSE VACUUM LINE & PRESSURIZE EXCITER TO 200 PSI W/ 2% OR MORE BOTTLE DRY GASEOUS NITROGEN A DEW POINT OF -60 DEG C (-76 DEG F) MAX & PURGE OF 72 HRS MINIMUM DURATION. | M |
| | 300 CHECK EXCITER FOR WATER, MAINTAIN AT 200 PSIG MINIMUM FOR ONE HOUR. LEAKAGE TEST TO EVACUATION TOOL | M |
| | 310 TEST: TESTING FOR MAIN BURNER. MFG ROTOR SPEED (RPM) 1,000 MAINBURNER ACTUAL_____ ACTUAL_____ NONE REQ | M |
| | ~~OVERSPEED TEST~~ OMIT MFG ROTOR SPEED (RPM) 1,000 MAINBURNER AUXILIARY ACTUAL_____ ACTUAL_____ | |
| | MFG ROTOR SPEED (RPM) 30,000 MAINBURNER AUXILIARY ACTUAL_____ ACTUAL_____ | |
| | SET RPM'S AT 1,000 & CHECK CAP. CAP TIMES CONSISTENTLY AT 21 SEC MINIMUM FOR 10 SECONDS. | M |
| | 320 AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M |
| | 330 I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O.'S TO-'S CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PRODUCT CHANGES. | M |
| | 340 OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M |
| | 350 COMPLY WITH MAOI 00-350 PARA 1. TYPE WORK PERFORMED_____ | M |

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| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/ROC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 38643A | | MTPCAF | 80094 | |

7. ART NUMBER: 311D19163

9.ITEM SERIAL NR:

10/12.TECH DATA/OPTIONAL: TO MAT03-13 631 2 21 3 CHG 11 8/19/11

10.MODEL/DESIGN/SERIES: J77 15

11.STOCK NR: 2915000033452

13.MISC: TEMP AMPLIFIER AMPLIFIER PAL - PERRY/MATEAC/669220

14.NOUN/END ITEM NOUN:

15.DISP 16.PLN/

| 17.SEQUENCE NO. | 17/.WORK TO BE ACCOMPLISHED | 18.RECEIVED | 19.W | 20.W |
|---|---|---|---|---|
| 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| 020 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| 030 | INSPECTION (VISUAL) | M | | |
| 040 | FULL COOLING TUBE TEST: NO LEAKAGE ALLOWED. | M | | |
| 045 | (PRE-TEST) RESISTANCE CHECK | M | | |

20 min warmup
4 min set up

| CONNECTOR | PINS | OHMS (ACT) |
|---|---|---|
| J1 | "A" AND "B" | |
| J2 | "A" AND "C" | |
| J3 | "B" AND "C" | |

| 050 | POWER APPLICATION TEST (PRE TEST) | M | | |
|---|---|---|---|---|

DIFFERENTIAL CURRENT - ACT _____ MA.

R100 COUNTER-CLOCKWISE RESULTANT-ACT _____ MV.

R100 CLOCKWISE-RESULTANT-ACT _____ MV.

| 060 | NULL VOLTAGE COMPENSATION (PRE-TEST) | M | | |
|---|---|---|---|---|

| 070 | STATIC GAIN TEST (PRE-TEST) | M | | |
|---|---|---|---|---|

| MILLIVOLTS FROM NULL | DIFFERENTIAL OUTPUT ACT (MA.) |
|---|---|
| +1 | |
| +5 | |
| +10 | |
| +5 | |
| 0 | |

(CONTINUED)

CAEM04 * WORK CONTROL DOCUMENT * JC 1.DATE 83239 PAGE 2 OF 5 PAGES

| 15.DIST-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | -1 _____<br>-5 _____<br>-10 _____<br>-3 _____<br>0 _____ | | | |
| | 080 | TEMPERATURE VS. ENGINE SPEED TEST (PRE TEST)<br>ALTERNATOR FREQUENCY CPS — MILLIVOLT VALUE ACT<br>840 _____<br>820 _____<br>810 _____<br>798 _____<br>800 _____<br>800 _____<br>820 _____ | M | | |
| | 090 | FREQUENCY RESPONSE TEST (PRE-TEST)<br>27 LINES, FREQUENCY .30 TO .350CPS<br>ACT:_____<br>36 LINES, FREQUENCY .45 TO .54 CPS<br>ACT:_____ | M | | |
| | 100 | SPEED DERIVATIVE TEST (PRE-TEST)<br>.1 CPS (23-27MV)_____ACT<br>.2 CPS (45-57MV)_____ACT<br>.3 CPS (68-86MV)_____ACT<br>.5 CPS (116-157MV)_____ACT | M | | |
| | 120 INFO | IF ALL TEST PASSED, MOVE TO STEP 340 | M | | |
| | 130 | DISASSEMBLY AS REQ. 45 min | M | | |
| | 140 | CLEAN AS REQ. 20 min | M | | |
| | 150 | INSPECT PARTS: | M | | |
| | 160 | INSPECT POTENTIOMETER: 5 min | M | | |
| | 170 | REPAIR OR REPLACE AS REQ. take 2hr Grom. 1/2 hr Connectors 1/2 hr | M | | |
| | 180 | REASSEMBLY OF SUBASSEMBLIES potting 10 min 5 over Lap, Safety 20 min | M | | |
| | 190 | REASSEMBLY OF COMPONENTS see notes | M | | |

Find in test

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15.DISP-16.PDN/---

| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19 | 20 Q |
|---|---|---|---|---|---|
| | 200 | SATRUABLE-REACTOR CURRENT TEST<br>RESISTANCE OF R101 DECADE BOX<br>ACT_____ | M | | |
| | 210 | TOP SPEED BREAK TEST<br>RESISTANCE OF R104 DECADE BOX<br>ACT:_____ | M | | |
| | 220 | THERMOCOUPLE AMPLIFIER TEST<br>R104 ACT_____<br>R106 ACT_____ | M | | |
| | 230 | SLOPE TEST<br>R102 ACT:_____ | M | | |
| | 240 | FREQUENCY RESPONSE TEST<br>27 LINES, FREQUENCY .50 TO .35 CPS<br>ACT_____<br>35 LINES, FREQUENCY .45 TO .34 CPS<br>ACT_____ | M | | |
| | 250 | SPEED DERIVATIVE TEST<br>.1 CPS (23-29MV)_____ACT<br>.2 CPS (45-57MV)_____ACT<br>.3 CPS (68-86MV)_____ACT<br>.5 CPS (114-143MV)_____ACT | M | | |
| | 260 | INSTALL RESISTOR | M | | |
| | 270 | RESISTANCE CHECK<br>CONNECTOR PINS OHMS (ACT)<br>J1 "A" AND "B" _____<br>J2 "A" AND "B" _____<br>J3 "A" AND "B" _____ | M | | |
| | 280 | POWER APPLICATION TEST<br>DIFFERENTIAL CURRENT-<br>ACT_____MA.<br>R100 COUNTER-CLOCKWISE<br>RESULTANT-ACT:_____MV.<br>R100 CLOCKWISE-<br>RESULTANT-ACT:_____MV. | M | | |
| | 290 | NULL VOLTAGE COMPENSATION | M | | |
| | 300 | STATIC GAIN TEST<br>MILLIVOLTS FROM NULL / DIFFERENTIAL OUTPUT ACT (MA.)<br>+1 _____<br>+5 _____<br>+10 _____<br>+3 _____ | M | | |

(CONTINUED)

N/A

Normally this is the hot test

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|---|---|---|

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"I" | 20"Q" |
|---|---|---|---|---|---|
| | | 0 _____<br>-1 _____<br>-5 _____<br>-10 _____<br>-3 _____<br>0 _____ | | | |
| | 310 | TEMPERATURE VS ENGINE SPEED TEST<br>ALTERNATOR FREQUENCY CPS — MILLIVOLT VALVE ACT.<br>_____<br>_____<br>_____<br>_____<br>_____<br>_____<br>_____<br>_____ | M | | |
| | 320 | FREQUENCY RESPONSE TEST<br>27 LINES, FREQUENCY .30 TO .35 CPS<br>ACT:_____<br>35 LINES, FREQUENCY .40 TO .54 CPS<br>ACT:_____ | M | | |
| | 330 | SPEED DERIVATIVE TEST<br>.1 CPS (23-29MV)_____ACT<br>.2 CPS (45-57MV)_____ACT<br>.3 CPS (68-86MV)_____ACT<br>.5 CPS (116-157MV)_____ACT | M | | |
| | 340 | SHOCK TEST 10 min<br>OUTPUT DIFFERENTIAL CURRENT.<br>ACT:_____ | M | | |
| | 350 | MECHANICAL PRESSURE TEST 10 min<br>OUTPUT DIFFERENTIAL CURRENT.<br>ACT:_____ | M | | |
| | 360 | VIBRATION TEST 30 min | M | | |
| | | HIGH TEMPERATURE TEST | M | | |
| | 380 | COMPLETE & FORWARD AFTO 349 TO DATA PROCESSING. | M | | |
| | 390 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS. | M | | |
| | 400 | OPERATIONS COMPLETE, PAPERWORK PROCESSED. | M | | |

| CAEM04 * WORK CONTROL DOCUMENT * JC | 1.DATE 88JAN | PAGE 5 OF 5 PAGES |
|---|---|---|

| 15.DISP-16.PDN/STATION | OF NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 410 | COMPLY WITH MAUI 66-36, PARA 13<br>TYPE WORK PERFORMED | M | | |

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|---|---|---|

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 50217A | | MTPCAP | 86198 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL | |
|---|---|---|---|
| 44387 | | PO-MAT86-3 | |
| | | 8E1-8-9-3 | 84153H |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 9 | |
| TF33-PW102 | 2925011615596RV | | |

| 13.MISC | 14.NOUN/END ITEM NOUN |
|---|---|
| | IGNITION EXCITER |

| 15.DISP-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| W-43 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 | DISASSEMBLE. | M | | |
| | 030 | CLEAN AS REQUIRED. | M | | |
| | 040 | INSPECT AS REQUIRED. | M | | |
| | 050 | CAPACITOR TEST: TRIGGER CAPACITOR, APPLY 5000VDC BETWEEN CAPACITOR TERMINAL & GROUND FOR NOT MORE THAN 30 SECONDS. LEAKAGE.<br>.<br>ACTUAL_____MICROAMP.<br>*CAPACITOR BRIDGE TESTER | M | | |
| | 060 | CHECK CAPACITANCE.<br>.<br>ACTUAL_____UF | M | | |
| | 080 | CHECK CAPACITANCE.<br>.<br>ACTUAL_____UF | M | | |
| | 090 | TEST 3 STORAGE CAPACITORS AS A CONNECTED GROUP. APPLY 4000VDC BETWN FREE END ON INTER-CONNECT LEAD & GROUND ON CASE. LEAKAGE<br>.<br>ACTUAL_____MICROAMP | M | | |
| | 100 | CHECK CAPACITANCE AT SAME TERMINAL<br>.<br>.<br>ACTUAL_____UF | M | | |

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 110 | FILTER TEST: APPLY 300 VDC BETWN "B" PIN & GROUND FOR NO MORE THAN 30 SEC THERE MUST BE NO SIGN OF BREAKDOWN. | M | | |
| | 120 | CHECK LEAKAGE BETWEEN EITHER TERMINAL AND CASE:<br>.<br>ACTUAL_____MEGOHMS<br>*VACUUMTUBE VOLTMETER | M | | |
| | 130 | CAPACITANCE.<br>.<br>ACTUAL_____UF<br>*CAPACITOR BRIDGE TESTER | M | | |
| | 140 | RESISTOR TEST (29): MEASURE RESISTANCE BETWN UPPER TERMINAL OF RESISTOR LEAD & CASE.<br>.<br>ACTUAL_____OHMS<br>*VACUUMTUBE VOLTMETER | M | | |
| | 160 | TEST RESISTOR ASSY (45) MEASURE RESISTANCE BETWEEN RESISTOR LEADS.<br>.<br>.<br>ACTUAL_____MEGOHMS | M | | |
| | 170 | TEST EACH RESISTOR INDIVIDUALLY: MEASURE RESISTANCE BETWN RESISTOR TERMINALS.<br>.<br>ACTUAL_____MEGOHMS | M | | |
| | 180 | RECTIFIER TEST: USE HIGH VOLTAGE REGULATOR TO ADJUST VOLTAGE TO 5000V READ INVERSE VOLTAGE CURRENT.<br>.<br>ACTUAL_____MEGOHMS<br>*TEST FIXTURE | M | | |
| | 190 | RAISE VOLTAGE UNTIL MILLIAMMETER SHOWS READING OF 100MA. FORWARD VOLTAGE DROP ACROSS RECTIFIER.<br>.<br>ACTUAL_____VOLTS<br>*DC VOLTAGE REGULATOR | M | | |
| | 240 | READ VOLTAGE OVER A PERIOD OF 30 SECONDS.<br>ACTUAL_____VOLTS | M | | |

| 15.DISP STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 250 | HIGH TENSION TRANSFORMER TEST: CHECK RESISTANCE BETWN THE 2 TERMINALS TO WHICH PRIMARY LEADS ARE ATTACHED.<br><br>ACTUAL_____OHM<br>*OHMMETER | M | | |
| | 260 | ADJUST FOR GAP & INTERNAL PRESSURE.<br><br>ACTUAL_____INCH ACTUAL_____PSIG<br><br>*IGNITION OUTPUT TESTER | M | | |
| | 270 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 280 | TO CLINCH KNURLED FLANGE TO CASE, TORQUE A NUT AGAINST OUTER WALL OF CASE.<br>ACTUAL_____IN/LB<br><br>*TORQUE WRENCH. | M | | |
| | 300 | ALL SCREWS & LOCKNUTS SHOULD BE TORQUED.<br>ACTUAL_____IN/LB<br>*TORQUE WRENCH | M | | |
| | 310 | TEST IAW T.O. 8E1-8-9-3, PARA 2-36 SUB PARA "A"<br><br>*TEST FIXTURE | M | | |
| | 340 | RAISE TRANSIFIER VOLTAGE REGULATOR UNTIL WAVE FORM DISPLAYED ON VOLTA-SCOPE SHOWS FIRST PEAK.<br><br>ACTUAL_____VOLTS | M | | |
| | 350 | THE FIRST HALF CYCLE SHOULD BE NEGATIVE & MUST SHOW AT LEAST 2 POSITIVE PEAKS & 2 NEGATIVE PEAKS WITHIN THE PERIOD OF 1 MILLISECOND.<br><br>*TEST FIXTURE | M | | |
| | 360 | REASSEMBLE. | M | | |
| | 370 | TEST STORAGE CAPACITOR: RAISE INPUT VOLTAGE TO 14V FOR NO MORE THAN 10 SECONDS. VALUE<br><br>ACTUAL_____VOLT<br>*VOLTASCOPE | M | | |
| | 380 | TEST:<br>INPUT VOLTAGE 14 | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL_____AMP ACTUAL_____SR<br><br>INPUT VOLTAGE 24<br>INPUT CURRENT<br>SPARK RATE<br><br><br>ACTUAL_____AMP ACTUAL_____SR<br><br><br>INPUT VOLTAGE 29<br>INPUT CURRENT<br>SPARK RATE<br><br><br>ACTUAL_____AMP ACTUAL_____SR | | | |
| | 390 | TIGHTEN HEX NUTS AT INPUT END, LARGE NUT SHOULD BE TORQUED & THE 2 SMALLER NUTS.<br><br>ACTUAL_____FT/LBS ACTUAL_____IN/LB<br>*TORQUE WRENCH | M | | |
| | 400 | SOLDER UNIT. | M | | |
| | 410 | TEST EXCITER FOR LEAKS USING A PROBE WITH 14 PSIG. LEAKAGE.<br><br>ACTUAL_____CC<br>*VEECO LEAK DETECTOR | M | | |
| | 420 | SUBMERGE EXCITER IN WATER HEATED TO MINIMUM OF 49 DEG C (120 DEG F) FOR 1 MINUTE. | M | | |
| | 430 | GAS CHARGING: BAKE EXCITER 15 MIN. AT 275 DEG F. THEN TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO BAKE FOR ADDITIONAL 15 MINUTES. | M | | |
| M-41 | 440 | PAINT. | M | | |
| | 450 | BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F. OR AIR DRY. | M | | |
| | 460 | TEST: SET MICROMETER UNTIL SCALE READING INDICATES SPARK GAP OF 0.100 INCH. ADJUST NITROGEN INLET UNTIL GAGE HOLDS STEADY. | M | | |

(CONTINUED)

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15.DISP-16.PDN/

| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACTUAL_____PSIG<br>*IGNITION OUTPUT TESTER | | | |
| | 470 | TEST:<br>INPUT VOLTAGE 14<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL_____AMP<br>ACTUAL_____PER 10 SEC<br>INPUT VOLTAGE 24<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL_____AMP<br>ACTUAL_____PER 10 SEC<br><br>INPUT VOLTAGE 29<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL_____AMP<br>ACTUAL_____PER 10 SEC | M | | B |
| | 490 | APPLY 24V INPUT CURRENT. OBTAIN ONE (1) OF THE FOLLOWING:<br>METER READING<br><br>72.5<br>78.0<br>83.0<br>87.5<br>91.5<br><br>ACTUAL_____ | M | | |
| | 500 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M | | |
| | 545 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M | | |
| | 546 | COMPLY WITH MAOI 66-36, PARA 13<br><br>TYPE WORK PERFORMED_____ | M | | |
| | 550 | OPERATIONS COMPLETED & PAPERWORK PROCESSED. | M | | |

2.4 /

CAEMOQ * WORK CONTROL DOCUMENT * JC 1.DATE 88239 PAGE 1 OF 4 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 30645A | | MTPCAP | 87094 | |

| 7. ART NUMBER | 9.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL | |
|---|---|---|---|
| 633E490001 | | PO MAT08-13 | |
| | | TOPS 101 | 83014H |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | 6J1 2-25-3 | 88061H |
| J79-17 | 2915001X3800?PL1 | CHG 10 | |

13.MISC 14.NOUN/END ITEM NOUN
AMPLIFIER, TEMP PAC
PERRY/MATLAC/65920

James Dyo

| 16.DISP 16.PDN/ OPERATION NO. | 17.WORK TO BE ACCOMPLISHED | 18.MEQ | 19"T" | 20"G" |
|---|---|---|---|---|
| | /2 19 ITEM 2771/A | | | |
| 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | T M | | |
| 020 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| 030 | INSPECTION (VISUAL) | M | | |
| 040 | PERFORM FULL COOLING TUBE TEST (PRE-TEST) (PARA 11-5.) FULL TEMP: ACT_____DEG. | M | | |
| 050 | PERFORM INSULATION RESISTANCE TEST (PRE-TEST) ACT_____MEGOHMS OVEN ACT_____MEGOHMS | M | | |
| 060 | SET UP AMPLIFIER FOR PRE TEST (PARA 11-7) | M | | |
| 070 | PERFORM OPEN THERMOCOUPLE PRE-TEST. | M | | |
| 080 | NULL VOLTAGE COMPENSATION (PRE-TEST) | M | | |
| 090 | PERFORM POTENTIOMETER RANGE TEST (PRE-TEST) | M | | |
| 100 | STATIC GAIN TEST (PRE-TEST) MILLIVOLTS FROM NULL DIFFERENTIAL OUTPUT ACT (MA) +1 | M | | |

(CONTINUED)

| 15.DISP-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"I" | 20"Q" |
|---|---|---|---|---|---|
| | | +5 _____<br>+10 _____<br>-1 _____<br>-5 _____<br>-10 _____ | | | |
| | 110 | TEMPERATURE VS. ENGINE SPEED TEST (PRE-TEST) NORMAL SCHEDULE<br>ALTERNATOR FREQUENCY HZ — T S LIMITS ACT<br>600 _____<br>700 _____<br>740 _____<br>765 _____<br>770 _____<br>792 _____<br>804 _____<br>816 _____<br>825 _____<br>840 _____ | M | | |
| | 120 | TEMPERATURE VS ENGINE SPEED RESET TEST (PRE-TEST)<br>ALTERNATOR FREQUENCY HZ — T S LIMITS ACT<br>792 _____<br>840 _____ | M | | |
| | 130 | ACCELERATION (STALL) RESET (PRE-TEST)<br>ALTERNATOR FREQUENCY HZ — MILLIVOLT VALVE ACT<br>770 _____<br>804 _____ | M | | |
| | 140 | COMBAT RATING RESET<br>ALTERNATOR FREQUENCY HZ — T S VALUES ACT | M | | |

(CONTINUED)

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| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"T" | 20"Q" |
|---|---|---|---|---|---|
| | | 770 _____ | | | |
| | | 804 _____ | | | |
| | 150 | CHECK RELATIONSHIP OF 5 PLATES. | M | | |
| | 160 | ACCELERATION RESET RESPONSE TEST (PRE TEST)<br>PLN DISPLACEMENT ACT_____% | M | | |
| | 170 | FREQUENCY RESPONSE TEST (PRE-TEST) | M | | |
| | 180 | SPEED DERIVATIVE TEST (PRE-TEST) | M | | |
| | 190 | OBTAIN THE POSITIVE & NEGATIVE OUTPUT MILLIAMPERE SWEEPS AT ALL THREE "LIFT" SETTINGS.<br>.1 CPS SWEEP ACT_____MA<br>.3 CPS SWEEP ACT_____MA<br>.5 CPS SETTING ACT_____MA | M | | |
| | 200 | SPEED DERIVATIVE RESPONSE TEST (PRE TEST) | M | | |
| | 210 | HIGH TEMPERATURE TEST. | M | | |
| | 220 | COLD TEMPERATURE TEST. | M | | |
| | 230 | TROUBLESHOOT. | M | | |
| | 240 | IF ALL TESTS PASS MOVE TO STEP 03 | M | | |
| | 250 | DISASSEMBLE AS REQUIRED. | M | | |
| | 260 | CLEAN AS REQUIRED. | M | | |
| | ~~270~~ | INSPECT AS DIRECTED.<br>RESISTANCE ACT_____OHMS<br>TORQUE CHECK ACT_____OZ/IN | M | | |
| | ~~280~~ | REPAIR OR REPLACE AS REQUIRED. | M | | |
| | ~~290~~ | REASSEMBLE SUB-ASSY'S AS DIRECTED. | M | | |
| | ~~300~~ | REASSEMBLE COMPONENTS AS DIRECTED. | M | | |

CAEM08 * WORK CONTROL DOCUMENT * JC 1.DATE 80237 PAGE 4 OF 4 PAGES

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"T" | 20"Q" |
|---|---|---|---|---|---|
| | 310 | PERFORM FINAL ASSEMBLY AS DIRECTED. | M | | |
| | 320 | FINAL INSPECTION & PERFORMANCE TESTS | M | | |
| | 330 | COMPLETE & FORWARD AFTO 349 TO DATA PROCESSING. | M | | |
| | 340 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS. OPERATIONS COMPLETE & PAPERWORK PROCESSED. | M | | |
| | 350 | COMPLY WITH MAOI 36-36, PARA 13 TYPE WORK PERFORMED_____ | M | | |

CAEM03 * WORK CONTROL DOCUMENT * JC 1.DATE 88237 PAGE 1 OF 3 PAGES

| 2.~~ORIG/PROD~~ NR | 3.QUANTITY | 4.PROD SECTION/REC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 38669A | | MTPCA | 87094 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 10-35397/8-2 | | PO MAT00 16 |
| | | BE1 2 36 13 8C0920 |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 0 |
| J/9 15/17 | 2925009921235PL | LARRY WARE |

| 13.MISC | 14.NOUN/END ITEM NOUN |
|---|---|
| | IGNITION EXCITER PAC |
| | PERRY/MATEAC/60920 |

15.DISP 16.PSN/

| STATION NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"T" | 20"Q" |
|---|---|---|---|---|
| 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| 020 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS, TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| 025 | ITEMS CONTAIN PRECIOUS METALS, SEE MMOI 65 4 FOR PROCESSING & CONTROL. | M | | |
| 030 | clean → cleaning<br>INSPECTION (VISUALLY) | M | | |
| 035 | FUNCTIONAL TEST | M | | |

| APPLIED VOLTAGE | ACTUAL INPUT CURRENT | ACTUAL SPARK RATE | ACTUAL OUTPUT VOLTAGE |
|---|---|---|---|
| 14 | _____ | _____ | N/A |
| 24 | _____ | _____ | _____ |
| 30 | _____ | _____ | N/A |

| | | | | |
|---|---|---|---|---|
| 040 MTPEM | MOVE TO MACHINE SHOP TO REMOVE LID. | M | | |
| 045 | DISASSEMBLE | M | | |
| 050 | CLEAN AS REQUIRED. | M | | |
| 055 | INSPECT AS REQUIRED. | M | | |
| 060 | TEST TUBE ASSEMBLY. .2 | M | | |

CAEM63 * WORK CONTROL DOCUMENT * 30 1.DATE 80239 PAGE 2 OF 3 PAGES

| 15.DISP STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 065 | TEST SPARK GAP.<br>ACT _____VDC .3 | M | | |
| | 070 | TEST RESISTOR ASSEMBLY<br>RESISTANCE ACT_____OHMS .2 | M | | |
| | 075 | TEST TRANSFORMER VIBRATOR ASSEMBLY<br>RESISTANCE ACT_____OHMS | M | | |
| | 080 ✓ | CAPCIATOR ASSEMBLY<br>GREEN LEAD - WHITE A LEAD<br>ACT _____MICROFARAD .4<br>YELLOW LEAD - WHITE B LEAD<br>ACT _____MICROFARAD | M | | |
| | 085 | TEST FILTER ASSEMBLY<br>CONNECTOR INPUT PIN - HOUSING<br>ACT _____MICROFARAD<br>*INSULATION RESISTANCE<br>CONNECTOR INPUT PIN - HOUSING<br>ACT _____MEG .05<br>*500 VOLT MEGGAR | M | | |
| | 090 | REPAIR OR REPLACE AS REQUIRED. | M | | |
| | 095 | REASSEMBLY | M | | |
| | 100 | TORQUE:<br>NUT (37) ACT_____LB IN.<br>NUT (14) ACT_____LB IN.<br>NUT (27) ACT_____LB IN.<br>SCREW (19) ACT_____LB IN.<br>PLUG (3) ACT_____LB IN. | M | | |
| | 105 | TEST EXCITER ELECTRICALLY | M | | |

| APPLIED VOLTAGE | ACTUAL INPUT CURRENT | ACTUAL SPARK RATE | ACTUAL OUTPUT VOLTAGE |
|---|---|---|---|
| 14 | _____ | _____ | N/A |
| 24 | _____ | _____ | _____ |
| 30 | _____ | _____ | N/A |

| | | | |
|---|---|---|---|
| 0-35 | 110 MTPIW | MOVE TO MTPIW (WELDING SHOP) TO HAVE LID WELDED. | M |
| | 115 | LEAK CHECK EXCITER. | M |
| | 120 | EVACUATE AND PURGE EXCITER. oven time = cool time = 45. | M |

CAEM03 * WORK CONTROL DOCUMENT * JC 1.DATE 86239 PAGE 3 OF 3 PAGES

| 15.DISP STATION | 16.FDN/ OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"T" | 20"Q" |
|---|---|---|---|---|---|
| | 123 | LEAK CHECK EXCITER (AROUND PLUG) (USING THE WATER METHOD) | M | | |
| | 125 | PAINT | M | | |
| | 130 | TEST EXCITER | M | | |

| APPLIED VOLTAGE | ACTUAL INPUT CURRENT | ACTUAL SPARK RATE | ACTUAL OUTPUT VOLTAGE |
|---|---|---|---|
| 14 | _____ | _____ | N/A |
| 24 | _____ | _____ | _____ |
| 30 | _____ | _____ | N/A |

| | | | | |
|---|---|---|---|---|
| | 140 | EXCITER 10-353975 2 (RADIOACTIVE) MAY BE REWORKED TO 10-353975 3 (NONRADIOACTIVE). IF DONE, REIDENTIFY TO 10 353975 3 OR (10CC5339P3). RADIOACTIVE STICKER WILL NOT BE USED IF REIDENTIFIED. | M | | |
| | 150 | COMPLETE & FORWARD AFTO 349 TO DATA PROCESSING. | M | | |
| | 155 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS. | M | | |
| | 160 | OPERATIONS COMPLETE, PAPERWORK PROCESSED. | M | | |
| | 165 | COMPLY WITH MAUI 86-36, PARA 13 TYPE WORK PERFORMED_____ | M | | |

CAEM09 * WORK CONTROL DOCUMENT * A1 1.DATE 082... PAGE 1 OF 2 PAGES

3.7.4

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHLD | 6.DATE COMP |
|---|---|---|---|---|
| 38694A | | MTPCAP | 89094 | |

| 7..ART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 31/193-7 | | PO MAT00 13 |
| | | 11L2 2 4/ 13 0324HR |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 17 |
| 3/7 10/17 | 2925009637064 | |

12.MISC 14.NOUN/LNG ITEM NOUN
SOLENOID ASSY PAGE
PERRY/MATLAC/65920

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | I/P | I/V |
|---|---|---|---|---|---|
| | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 020 | ALL REFERENCES ARE TO BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 030 | DISASSEMBLE SOLENOID ASSY. | M | | |
| | 040 | REPLACE VALVE ASSY (22) | M | | |
| | 050 | RECORD QUANTITY & THICKNESS OF WASHERS (16) FOR REASSEMBLY PURPOSES | M | | |
| | 060 | RECORD QUANTITY & THICKNESS OF SHIMS (25) AND WASHERS (26) FOR REASSEMBLY PURPOSES. | M | | |
| | ~~070~~ | ~~CLEAN PARTS AS REQUIRED.~~ | M | | |
| | ~~080~~ | ~~INSPECT PARTS.~~ | M | | |
| | 090 | CHECK RESISTANCE OF COIL ASSEMBLY ACT_____OHMS AND_____OHMS | M | | |
| | 100 | PERFORM DIELECTRIC TEST. | M | | |
| | 110 | REASSEMBLE SOLENOID ASSEMBLY | M | | |
| | ~~115~~ | IF NEW PIN IS REQ. SEND ASSEMBLY TO MTPIW FOR WELDING. REQ._____NOT REQ._____ | M | | |
| | 120 | TEST AS REQUIRED. | M | | |

| CAEMO? * WORK CONTROL DOCUMENT * JC | 1.DATE 80287 | PAGE 2 OF 2 PAGE(S) |
|---|---|---|
| 15.DISP 16.PDN/ | | |

| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.RECEIVED | 19.QUANTITY | 20.QUANTITY |
|---|---|---|---|---|---|
| | 130 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M | | |
| | 140 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O. 1CTO'S, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS. | M | | |
| | 150 | COMPLY WITH MASO [illegible]-36, PARA 13 TYPE WORK PERFORMED_____ | M | | |

CALM02 * WORK CONTROL DOCUMENT * JC 1.DATE 83237 PAGE 1 OF 3 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 30710A | | MTPCAP | 87094 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 10/12.TECH DATA/OPTIONAL |
|---|---|---|
| 10-377625-1 | | 8E1 2-36 23 8796.2H |
| | | CHG 1 |
| 8.MODEL/DESIGN/SERIES | 11.STOCK NR | 8E1 2-36 3 8712H |
| 377 | 2925011625027PL1 | CHG 12 |
| | | 8E1 2-36 306 8301H |
| 13.RISC | 14.NOUN/END ITEM NOUN | 8E1-2 36-306L 8334H |
| | IGNITION EXCITER (LOW SMOKE/FAST | 8E1 2-36 306L 8430H |
| | PERRY/BATAVIA/60720 | 8E1-2 36 306H 8006H |
| | | 8E1 2-36 306H 8430H |

DONELDA STROUD

| 15.DISP STATION/OP NO. | 16.PDM/ | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"I" | 20"C" |
|---|---|---|---|---|---|
| | | P 1X6CC/81P3 2925007927904PL 30.70A | | | |
| | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 020 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. EACH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| 022 | INS CLEAN | | | | |
| | 025 | ITEMS CONTAIN PRECIOUS METALS, SEE MAOI 65-4 FOR PROCESSING & CONTROL. | M | | |
| | 030 MTPCM | RECEIVE EXCITER: REMOVE LID AND WELDS: RETURN TO MATPCA. | M | | |
| | 040 | DISASSEMBLE | M | | |
| | 050 | HOUSING ASSEMBLY, CHECK FLANGES MINIMUM HEIGHT ACT:_____INCH REWORK IAW 8E1 2-36 23 PARA 5-4.H. (6). REWORK: REQ_____ NOT REQ_____ | M | | |
| | 060 MTPCM | MILL HOUSING EDGE FOR HOUSING EXTENSION: ACT:_____INCH | M | | |
| | 070 MTPIW | WELD EXTENSION ON THE HOUSING | M | | |
| | 080 MTPIW | WELD BRACKETS AND STUDS TO MODIFIED HOUSING. WHEN FINISHED MTPIW WILL RETURN BOX TO MTPCA. | M | | |
| | 090 MTPCA | MTPCA WILL MODIFY EXCITER AS REQ. BY TCTO. | M | | |

CAEM02 * WORK CONTROL DOCUMENT * JC 1.DATE 80237 PAGE 2 OF 3 PAGES

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 100 | *TEST HOUSING AND TRANSFORMER ASSY. (60); MEASURE PRIMARY AND SECONDARY RESISTANCE.<br>GREENWIRE WHITEWIRE_____ACT OHMS<br>BROWNWIRE-RED WIRE_____ACT OHMS<br>* OHMETER | M | | |
| | 110 | *TEST ELECTRON TUBE ASSY. (25) (26)<br>INVERSE CURRENT FLOW_____ACT MA<br>OPERATING CURRENT_____ACT MA<br>* 11-6002 ELECTRON TUBE TEST SET | M | | |
| | 120 | *TEST RESISTOR ASSY. (44)<br>RESISTANCE_____ACT OHMS<br>* OHMETER | M | | |
| | 130 | TORQUE VALUES:<br>SCREWS (58) 2_____ACT LB/INS<br>SCREW (56) 1_____ACT LB/INS<br>NUTS (57) 4_____ACT LB/INS<br>NUT (15) 1_____ACT LB/INS<br>SCREW (31) 2_____ACT LB/INS<br>SCREW (10) 2_____ACT LB/INS<br>NUT THRLAD (13)1_____ACT LB/INS | M | | |
| | 140 | WHEN COMPRESSING CAPACITOR ASSEMBLY THROUGH FORCE GUAGE_____ ACT LBS OF FORCE WERE APPLIED. | M | | |
| | 145 MTPCM | CUP GOES TO MACH. SHOP TO BE CUT OFF AT SCRIBED LINE. | M | | |
| | 150 MTPIW | THE BOX MAY HAVE TO GO TO MTPIW AFTER ANY ONE PROCEDURE TO HAVE THE PLATE ON THE VIBRATOR ASSY. (51) 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 | | |
| | 160 MTPCA | EXCITER WILL BE TESTED IAW 8E1-2-36-3 EXCEPT FOR DIFFERENCES NOTED IN TCTO. | M | | |
| | 170 | "BEFORE" COVER TEST:<br>A/B<br>70 VAC_____ACT SPARK RATE (S/R)<br>115 VAC_____ACT S/R____ACT OUTPUT<br>120 VAC_____ACT S/R<br><br>MAIN<br>14 VDC_____ACT S/R<br>24 VDC_____ACT S/R_____ACT OUTPUT<br>30 VDC_____ACT S/R | M | | |
| | 180 MTPIW | FINISH PACKING EXCITER THEN SEND WITH COVER TO MTPIW FOR | M | | |

(CONTINUED)

DELETE & CONSUME WHERE USED

155 ASSY

COMBINE

ASS 175

U-41

CALMO2 * WORK CONTROL DOCUMENT * JC    1.DATE 08237  PAGE 3 OF 3 PAGES
1..DISP 16.PDN/—

| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19 | 20 |
|---|---|---|---|---|---|
| | | WELDING OF COVER TO HOUSING. MTPIW<br>WILL SEND BACK TO MTPCA | | | |
| | 190<br>MTPCA | TEST FOR LEAKAGE, EVACUATE, AND<br>PURGE IAW 8E1 2-36-3. | M | | |
| | 195 | TORQUE PLUG (13):<br>ACT:______________IN/LB | M | | |
| | 200 | TEST EXCITER "AFTER" TEST<br>A/B<br>90 VAC_____________ACT S/R<br>115 VAC_____ACT S/R_______ACT OUTPUT<br>120 VAC_____________ACT S/R<br><br>MAIN<br>14 VDC_________ACT S/R<br>24 VDC______ACT S/R_____ACT OUTPUT<br>30 VDC______ACT S/R | M | | |
| | 210 | TEST USING 11-4700-1 TESTER AND<br>11-9600 SPARK GAP ASSY. TESTER.<br>24 VOLTS DC INPUT<br>ACT: SEC FIRED______________________<br>FIRING STOPS<br>ACT: KR___________________________ | M | | |
| | 220 | CLEAN AS REQUIRED | M | | |
| | 230 | PAINT AS REQUIRED | M | | |
| | 240 | MARK NEW PART NUMBER 10 397625 1<br>(GE 106C5281P5), A LETTER R IN REV<br>BLOCK, AND ORIGINAL SERIAL NUMBER,<br>CURRENT, VOLTAGE, AND TYPE LETTERS<br>ON NEW IDENT. PLATE. DO NOT APPLY<br>RADIOACTIVE WARNING PLATE AS WARNING<br>NO LONGER APPLIES. (AS PER TCTO)<br>INSTALL IDENT. PLATES. | M | | |
| | 250 | I CERTIFY THAT THIS END ITEM HAS<br>BEEN OVERHAULED IAW T.O., TCTO,<br>CURRENT REVISIONS, SUPPLEMENTS, AND<br>APPLICABLE PROCESS ORDERS. | M | | |
| | 260 | OPERATIONS COMPLETED & PAPERWORK<br>FORWARDED. | M | | |
| | 270 | COMPLY WITH MAOI 66-36, PARA 13<br>TYPE WORK PERFORMED_______________ | M | | |

CAEC07 * WORK CONTROL DOCUMENT * /2-10 1.DATE 87045 PAGE 1 OF 3 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/ROU | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| | | MTPCAP | 87094 | |

7. PART NUMBER 9.ITEM SERIAL NR 10/12.TECH DATA/OPTIONAL
PO MAT3/ 16
PO MAT3/ 1
PO MAT3/ 3

10.MODEL/DESIGN/SERIES 11.STOCK NR
TF33 3/11A 292500/3/217RV1

CLI 2 22-103 6630UH
CHG 20
CLI 2 22-103 1 7721UH

13.MISC 14.NOUN/END ITEM NOUN
IGNITION EXCITER PART
JENNINGS/MATEAC/65720

LARRY WARE

| 15.DISP STATION/OP NO. | 16.PDR/ | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"T" | 20"Q" |
|---|---|---|---|---|---|
| | | P/N 3/8200<br>P/N 10-10/860-1<br>MATTA 96001(A) (1)<br>C/N 47/11A<br>P/N 10 617060 1<br>(SUPERCEDES 10-10/860-1)<br>S/N 292501138761RV | | | |
| W 43 | 010 | RECEIVE, IDENTIFY & ATCH PAPERWORK. | M | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| V-41 | 020 | MOVE TO MACHINE SHOP & REMOVE LID. | M | | |
| | 030 | DISASSEMBLE. | M | | |
| | 040 | CLEAN AS REQUIRED. | M | | |
| | 050 | INSPECT. | M | | |
| | 051 | INSPECT HOUSING ASSEMBLY HEIGHT<br>ACT_____INCH.<br>REPLACED NEW YES___ NO____<br>REPAIR REQ_____NOT REQ_____ | M | | |
| W 41 | 055<br>MTPCA | MOVE UNDERSIZE HOUSINGS TO WELDING FOR EXTENSION STRIPS | M | | |
| | 060 | MEASURE RESISTANCE OF FILTER, BETWEEN INPUT PIN & OUTPUT LEAD.<br>.<br>ACTUAL_____OHM<br>*OHMMETER | M | | |
| 0-33 | 070<br>MTPIW | WELD FILTER AND CONNECTORS. | M | | |

- (CONTINUED)

| CAEC07 * WORK CONTROL DOCUMENT * 72-10 1.DATE 87045 PAGE 2 OF 3 PAGES | | | | | |
|---|---|---|---|---|---|
| 15.DISP-16.PDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MEAS | 19."T" | 20."U" |
| | | REQ:_____NOT REQ:_____ | | | |
| | 080 | MEASURE CAPACITANCE BETWEEN INPUT PIN & HSG.<br>.<br>ACT_____UF<br>*CAPACITOR ANALYZER* | M | | |
| | 090 | CHECK INSULATION RESISTANCE BETWEEN INPUT PIN & FILTER HOUSING BY APPLYING 400 VDC. INSULATION RESISTANCE<br>.<br>ACT_____MEGOHMS<br>*400 VOLT MEGGER* | M | | 5550 |
| | 100 | (TRANSFORMER) MEASURE PRIMARY RESISTANCE BETWEEN BLACK LEAD & GREEN LEAD.<br>ACT_____OHM<br>*OHMMETER* | M | | |
| | 110 | MEASURE SECONDARY RESISTANCE BETWEEN WHITE & RED LEAD OF TRANSFORMER.<br>.<br>ACT_____OHM | M | | |
| | 120 | CHECK CAPACITANCE OF CAPACITOR, P/N 10-107202<br>*CAPACITOR ANALYZER* ACT:_____UF | M | | |
| | 130 | CAPACITANCE BETWEEN NO 1 LEAD AND GROUND<br>ACT_____UF | M | | |
| | 140 | CAPACITANCE BETWEEN NO 2 LEAD AND GROUND<br>ACT_____UF | M | | |
| | 150 | CAPACITANCE BETWEEN NO 3 & 5 LEAD<br>.<br>ACT_____UF | M | | |
| | 160 | CAPACITANCE BETWEEN NO 4 & 5 LEAD<br>.<br>ACT_____UF | M | | |
| | 170 | APPLIED VOLTAGE BETWEEN NO 1 LEAD & GROUND<br>ACT_____VDC<br>APPLIED VOLTAGE BETWEEN NO 2 LEAD & GROUND<br>ACT_____VDC<br>APPLIED VOLTAGE BETWEEN NO 3 & 5 LEAD<br>ACT_____VDC<br>APPLIED VOLTAGE BETWEEN NO 4 & 5 LEAD<br>ACT_____VDC | M | | 600 |

(CONTINUED)

| CALCO7 * WORK CONTROL DOCUMENT * /2-10 1.DATE 0/04 | | | |
|---|---|---|---|
| 15.DISP 16.PDN/ | | | |
| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH |
| | | THERE SHALL BE NO VOLTAGE BRK DN OR FLASHOVER OF ANY SECTION DURING A 15 SECOND PERIOD OF APPLIED VOLTAGE. *JET IGNITION COMPONENT SET* | |
| | 180 | MEASURE RESISTANCE OF RESISTOR (6) & RESISTORS (7) WHICH TOGETHER MAKE UP RESISTOR ASSY. RESISTANCE READING FOR RESISTOR (6) ACTUAL_____MEGOHMS RESISTANCE READING FOR RESISTORS (7) . ACT_____ TO _____OHM *OHMMETER* | M |
| | 190 | VOLTAGE BREAKDOWN FOR SPARK GAP TEST . ACT_____VDC _____VDC *JET IGNITION COMPONENT TEST SET* | M |
| | 200 | CHECK RECTIFIER ASSEMBLY FOR CONTINUITY OF RECTIFIERS. ACT_____MA *ELECTRON TUBE TEST SET* | |
| | 205 | CHECK COIL FOR CONTINUITY BETWEEN CA TERMINAL & THE CONTACT PIN IN THE OUTLET. *OHMMETER* | M |
| | 210 | REPAIR OR REPLACE AS NECESSARY VIBRATOR SHALL BE REPLACED AT EACH IGNITION EXCITER OVERHAUL. | M |
| | 230 | REASSEMBLE . | M |
| | 240 | VACUUM DRY IGN EXCITER FOR PERIOD OF 4 HRS AT 120 DEG F MIN ONE INCH MER CURY ABSOLUTE PRESS MAX. | M |
| | 250 | FILL CAPACITOR ASSEMBLY COMPARTMENT WITH RESIN. | M |
| | 260 | BAKE IGNITION EXCITER AS FOLLOWS: 200 DEG F/1 HR. 240 DEG F/1 HR. 300 DEG F/2 HRS. | M |
| | 270 MTPIW | MOVE TO WELDING SHOP & WELD LID TO EXCITER & PERFORM LEAK TEST. | M |
| | 300 | CLOSE VACUUM LINE & PRESSURIZE IGN ITION EXCITER TO 15 PSI GAGE WITH DRY AIR OR NITROGEN HAVING A DEW | M |

(CONTINUED)

| CAEC07 * WORK CONTROL DOCUMENT * 72-10 1.DATE 87045 | PAGE 4 OF 5 PAGES |
|---|---|

| 15.DISP-16.PDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | POINT OF 65 DEG F. OR BELOW | | | |
| W-41 | 310 MIPIA | PAINT<br>REQ_____ NOT REQ_____ | M | | |
| WW-41 | 320 MIPIA | PAINT IGNITION EXCITER. APPLY LACQUER, FED SPEC TT-L 32, TO A FILM THICKNESS OF<br>ACT_____INCH | M | | |
| | 330 MIPIA | ALLOW TO DRY FOR 40 MINUTES IN DUST-FREE ATMOSPHERE. IF PAINT BLISTERS, STRIP POROUS AREA. CLEAN & REPAINT. | M | | |
| | 340 | TEST: CHECK CONTINUITY BETWEEN TWO OUTPUT TERMINALS OF IGN. EXCITER.<br>*OHMMETER* | M | | |
| | 350 | TEST: APPLIED VOLTAGE (VDC) 14.0<br>INPUT CURRENT<br>SPARK RATE (PER SECOND)<br>OUTPUT VOLTAGE (VOLTS)<br>ACT_____VOLTS<br>ACT_____AMPS<br>ACT_____S/R<br>APPLIED VOLTAGE 24<br>IN/OUT CURRENT<br>SPARK RATE<br>OUTPUT VOLTAGE<br>ACT:_____AMPS MAX<br>ACT:_____S/R<br>ACT:_____VOLTS<br>APPLIED VOLTAGE 30<br>INPUT CURRENT<br>SPARK RATE<br>OUTPUT VOLTAGE<br>ACT_____VDC<br>ACT:_____VOLTS<br>ACT:_____AMPS MAX.<br>ACT:_____S/R | M | | 3996<br>or 4289 |
| | 360 | AFTO 349 COMPLETE & FORWARDED TO DATA AUTOMATION. | M | | |
| | 370 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS. | M | | |
| | 380 | OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M | | |

CAEC07 * WORK CONTROL DOCUMENT * /2-10 1.DATE 89045 PAGE 3 OF 3 PAGES

| 15.DISP-16.PDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 385 | COMPLY WITH MAOI 66-36, PARA 13<br><br>TYPE WORK PERFORMED_____ | M | | |

CAEZ05 * WORK CONTROL DOCUMENT * JC 1.DATE 80204 PAGE 1 OF 3 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| | | MIPCAP | 80094 | |

7.. ART NUMBER 9.ITEM SERIAL NR 10/12.TECH DATA/OPTIONAL
BE1 8-22-3 8/2078
CHG 16

10.MODEL/DESIGN/SERIES 11.STOCK NR
11-41 A1/402D

13.[illegible] 14.NOUN/END ITEM NOUN
IGNITION EXCITER PACI
WOLFRUM/MATEAD/80220

| P/N | NSN | C/N |
|---|---|---|
| 10-80/990-3 | 2920010776866WL | 6120-1A |
| 10-80/990-5 | 2920010776866WN | 4[illegible] |
| 6076127 | 2920010776866CM | 6076A |

WRENDEL HAWKINS

15.Date 16.Init

| STATION NO. | 17.WORK TO BE ACCOMPLISHED | | 18.REMARKS |
|---|---|---|---|
| | NOTE: EXCITERS 6072033, 6076173, 6076129, ARE WORKED THE SAME EXCEPT AS NOTED IN DIFFERENCE DATA SHEETS LOCATED IN T.O. | | |
| 005 | COMPLETE AF FORM 1594 IAW AFM 400 1, VOL II/00-ALC/AFB OK 1 | M | |
| 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | |
| 015 | ALL REFERENCES ARE TO THE BASIC T.O. [illegible] PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | |
| 020 | TEST EXCITER: APPLIED VOLTAGE (VAC) 1%, INPUT FREQUENCY (HERTZ)-400, INPUT CURRENT (AMPS MAX) -3, SPARK RATE (SPARK PER MIN) OUTPUT VOLTAGE (VOLTS) | M | |
| | SIDE #1 | | |
| | AMPS_____ | | test eq'p ? |
| | SPARK RATE_____ | | oc 3906 |
| | OUTPUT VOLTAGE_____ | | |
| | | | oc ← volt-current meas. |
| | SIDE #2 | | |
| | AMPS_____ | | |
| | SPARK RATE_____ | | |
| | OUTPUT VOLTAGE_____ | | |
| 030 | AN EXCITER FAILING ANY TEST SHOULD BE DISASSEMBLED ONLY TO THE EXTENT REQUIRED TO LOCATE AND CORRECT CAUSES OF MALFUNCTION AND LIMITED AS REQUIRED TO ACCOMPLISH MECHANICAL | M | |

(CONTINUED)

CAEZOS * WORK CONTROL DOCUMENT * 30 1.DATE 80204 PAGE 2 OF 3 PAGES

| 15.DISP STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19."I" | 20."Q" |
|---|---|---|---|---|---|
| | | AND/OR ELECTRICAL REPAIR. | | | |
| | 040 | DISASSEMBLE. | M | | |
| | 050 | CLEAN AS REQUIRED. | M | | |
| | 060 | INSPECT. | M | | |
| | 070 | CHECK COMPONENTS PARTS AS NECESSARY. | M | | |
| | 080 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 086 | IF REQUIRED: ROUTE HOUSING P/N 10-303761 & COVER P/N 10-301361 FOR PLATING. REQ_____ NOT REQ_____ | M | | |
| | 091 | ENSURE DEPTH OF CONTACT HEAD IN INSULATOR SHELL (167) IS 0.375. ACTUAL_____INCH | M | | |
| | 092 | APPLY AN EVEN COATING OF RTV 3111 CURE RUBBER ADHESIVE. ALLOW ASSEMBLY TO CURE FOR 24 HRS MIN AT ROOM TEMP. | M | | |
| | 270 | REASSEMBLE. | M | | |
| | 275 | SOLDER EXCITER. | M | | |
| | 310 | PRESSURIZE EXCITER WITH 15 PSI NITROGEN. SUBMERGE EXCITER IN WATER HEATED TO A MINIMUM OF 120 DEG F WITH SUFFICIENT AMOUNT OF WETTING AGENT. FOR MINIMUM OF 1 MINUTE. | M | | |
| | 370 | CLOSE OVEN AND HEAT IGNITION EXCITER TO 210 DEGF TO 230 DEG F FOR 1/2 HR. | M | | |
| | 380 | EVACUATE IGNITON EXCITER TO 1 INCH MERCURY & CONTINUE BAKING FOR 4 TO 12 HRS MINIMUM. | M | | |
| | 390 | CLOSE VACUUM LINE & PRESSURIZE IGNITION EXCITER TO 15 PSIG WITH DRY AIR OR NITROGEN HAVING A DEW POINT OF -65 DEG F. | M | | |
| | 400 | REMOVE IGNITION EXCITER WITH STOP-COCK FROM OVEN & ALLOW TO COOL TO | M | | |

(CONTINUED)

CAE205 * WORK CONTROL DOCUMENT * 30 1.DATE 88204 PAGE 5 OF 7 PAGES

| 16.DISP-16.FDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19 "P" | 20 "U" |
|---|---|---|---|---|---|
| | | ROOM TEMP | | | |
| | 410 | SEAL PLUG & IMMERSE EXCITER IN WATER MAINTAINED AT A TEMPERATURE OF 190 TO 200 DEG. F. FOR 1 MINUTE. | M | | |
| | 420 | TEST EXCITER: APPLIED VOLTAGE (VAC) -19, INPUT FREQUENCY (HERTZ) - 400, INPUT CURRENT (AMPS MAX) - 3, SPARK RATE (SPARK PER MIN) OUTPUT VOLTAGE (VOLTS) SIDE #1 AMPS_____ SPARK RATE_____ OUTPUT VOLTAGE_____ SIDE #2 AMPS_____ SPARK RATE_____ OUTPUT VOLTAGE_____ | M | | |
| R 30 | 430 RATING | PAINT | M | | |
| | 440 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION | M | | |
| | 450 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M | | |
| | 460 | OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M | | |
| | 465 | NAVY FORM DNAV 4790/115 OR AF FORM AFTO 95 FILLED OUT COMPLETELY AND STAPLED TO SERVICEABLE TAG. | M | | |
| | 485 | COMPLY WITH MAO1 66-36, PARA 13 TYPE WORK PERFORMED_____ | M | | |
| | 490 | COMPLETE AF FORM 1574 AND AFTO FORM 205 ( IF APPLICABLE) AND ANNOTATE TCO/TCN ON THE AF FORM 1574 SERVICEABLE TAG IAW AFM 400 1 VOL II/DO-ALC TAB SUP 1. | M | | |

IUN/SERIES

040 VE TO MACHINE

045 DISASSEMBLE

INSPECT AS REQUIRED

ACT

1

1

2

5

45

24

dry N2

OVEN



CAEC05 * WORK CONTROL DOCUMENT * JC 1.DATE 89045 PAGE 1 OF 7 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| [redacted] 61234 | | MTPCAP | 89121 | |

| 7.PART NUMBER | 9.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL | |
|---|---|---|---|
| 41540 (M) | | PO MAT87-3 | |
| | | PO MAT87-16 | |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | 8E1-8-9-3 | 86135H |
| TF33-5/9 | 2925004637319RV | CHG 10 | |
| | | 8E1-8-9-3-1 | 78152H |
| 13.MISC | 14.NOUN/END ITEM NOUN | CHG 3 | |
| | IGNITION EXCITER PAC | | |
| | JENNINGS/MATEAC/65920 | | |

| 15.DISP-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | 61234A 2925-01-011-2325RV 42721 (TF33 P5/7) | | | |
| | | NOTE<br>MODIFY ABOVE P/N EXCITEK ASSEMBLILS IAW T.O. 8E1-8-9-3-1 (OVERHAUL CONFIGURATION CHANGE DATA) | | | |
| W-43 | 010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 | DISASSEMBLE. Transformer change 4-5 hrs | M | | |
| | 030 | ~~CLEAN AS REQUIRED~~ | M | | |
| | 040 | INSPECT AS REQUIRED. | M | | |
| | ~~045~~ | ~~ROUTE COVER/CASE TO PLATING AS REQ~~ | M | | |
| | 050 | CAPACITOR TEST: TRIGGER CAPACITOR, APPLY 5000VDC BETWEEN CAPACITOR TER-MINAL & GROUND FOR NOT MORE THAN 30 SECONDS. LEAKAGE.<br>.<br>ACTUAL MICROAMP.<br>*CAPACITOR BRIDGE TESTER | M | | |
| | 060 | CHECK CAPACITANCE.<br>.<br>ACTUAL UF | M | | |
| | 070 | TEST BREAKER CAPACITOR BY APPLYING 600VDC BETWN TERMINAL & GROUND FOR NOT MORE THAN 30 SECONDS.<br>. | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACTUAL MICROAMP | | | |
| | 080 | CHECK CAPACITANCE.<br>.<br>ACTUAL UF | M | | |
| | 090 | TEST 3 STORAGE CAPACITORS AS A CONNECTED GROUP. APPLY 4000VDC BETWN FREE END ON INTER-CONNECT LEAD & GROUND ON CASE. LEAKAGE<br>.<br>ACTUAL MICROAMP | M | | |
| | 100 | CHECK CAPACITANCE AT SAME TERMINAL<br>.<br>.<br>ACTUAL UF | M | | |
| | 110 | FILTER TEST: APPLY 300 VDC BETWN "B" PIN & GROUND FOR NO MORE THAN 30 SEC THERE MUST BE NO SIGN OF BREAKDOWN. | M | | |
| | 120 | CHECK LEAKAGE BETWEEN EITHER TERMINAL AND CASE:<br>.<br>ACTUAL MEGOHMS<br>*VACUUMTUBE VOLTMETER | M | | |
| | 130 | CAPACITANCE.<br>.<br>ACTUAL UF<br>*CAPACITOR BRIDGE TESTER | M | | |
| | 140 | RESISTOR TEST (29): MEASURE RESISTANCE BETWN UPPER TERMINAL OF RESISTOR LEAD & CASE.<br>.<br>ACTUAL OHMS<br>*VACUUMTUBE VOLTMETER | M | | |
| | 150 | TEST EACH RESISTOR INDIVIDUALLY.<br>.<br>ACTUAL OHMS<br>.<br>ACTUAL OHMS | M | | |
| | 160 | TEST RESISTOR ASSY (45) MEASURE RESISTANCE BETWEEN RESISTOR LEADS.<br>.<br>.<br>ACTUAL MEGOHMS | M | | |
| | 170 | TEST EACH RESISTOR INDIVIDUALLY; MEASURE RESISTANCE BETWN RESISTOR TERMINALS. | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACTUAL MEGOHMS | | | |
| | 180 | RECTIFIER TEST: USE HIGH VOLTAGE REGULATOR TO ADJUST VOLTAGE TO 5000V READ INVERSE VOLTAGE CURRENT. | M | | |
| | | ACTUAL MEGOHMS | | | |
| | | *TEST FIXTURE | | | |
| | 190 | RAISE VOLTAGE UNTIL MILLIAMMETER SHOWS READING OF 100MA. FORWARD VOLTAGE DROP ACROSS RECTIFIER. | M | | |
| | | ACTUAL VOLTS | | | |
| | | *DC VOLTAGE REGULATOR | | | |
| | 195 | VIBRATOR OVERHAUL: COIL TEST: MEASURE RESISTANCE BETWEEN SECONDARY OUTPUT TERMINAL & GROUND. ACT: OHMS | M | | |
| | | *VACUUMTUBE VOLTMETER | | | |
| | 200 | VIBRATOR TEST: | M | | |
| | | INTERMEDIATE VOLTAGE 2400 SPARK RATE. | | | |
| | | ACTUAL SPM | | | |
| | | INTERMEDIATE VOLTAGE 2500 SPARK RATE | | | |
| | | ACTUAL SPM | | | |
| | | INTERMEDIATE VOLTAGE 2600 SPARK RATE | | | |
| | | ACTUAL SPM | | | |
| | | INTERMEDIATE VOLTAGE 2700 SPARK RATE | | | |
| | | ACTUAL SPM | | | |
| | | *VOLTASCOPE | | | |
| | 210 | PRIMARY WAVE FORM FOR AN INPUT RANGE MUST NOT EXCEED AMP & VARIATIONS BETWN PEAKS. | M | | |
| | | ACT VOLTS | | | |
| | | ACTUAL AMP ACTUAL AMP | | | |
| | | *VOLTAGE REGULATOR | | | |
| | 220 | PRIMARY WAVE FORM FOR AN INPUT RANGE MUST NOT EXCEED AMP & VARIATIONS BETWN PEAKS. | M | | |

(CONTINUED)

| 15.DISP-16.PDN/STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACT VOLTS<br>ACTUAL AMP ACTUAL AMP | | | |
| | 230 | DISCHARGER TUBE TEST: RAISE VOLTAGE SOURCE SLOWLY TO MAX OF 5000V. IF TUBE BREAKS DOWN AT LEVEL BELOW 4100 VOLTS, REPLACE. IF IT BREAKS DOWN BETWN 4100 & 5000V, OR IF IT DOES NOT BREAK DOWN AT ALL, IT IS A GOOD TUBE.<br>REPLACED<br>NOT REPLACED<br>*TEST FIXTURE | M | | |
| | 240 | READ VOLTAGE OVER A PERIOD OF 30 SECONDS.<br>ACTUAL VOLTS | M | | |
| | 250 | HIGH TENSION TRANSFORMER TEST: CHECK RESISTANCE BETWN THE 2 TERMINALS TO WHICH PRIMARY LEADS ARE ATTACHED.<br>ACTUAL OHM<br>*OHMMETER | M | | |
| | 260 | ADJUST FOR GAP & INTERNAL PRESSURE.<br>ACTUAL INCH ACTUAL PSIG<br>*IGNITION OUTPUT TESTER | M | | |
| | 270 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 280 | TO CLINCH KNURLED FLANGE TO CASE, TORQUE A NUT AGAINST OUTER WALL OF CASE.<br>ACTUAL IN/LB<br>*TORQUE WRENCH. | M | | |
| | 300 | ALL SCREWS & LOCKNUTS SHOULD BE TORQUED.<br>ACTUAL IN/LB<br>*TORQUE WRENCH | M | | |
| | 310 | TEST IAW T.O. 8E1-8-2-3, PARA 2-36 SUB PARA "A"<br>*TEST FIXTURE | M | | |
| | 340 | RAISE TRANSFORMER VOLTAGE REGULATOR UNTIL WAVE FORM DISPLAYED ON VOLTA-SCOPE SHOWS FIRST PEAK.<br>ACTUAL VOLTS | M | | |

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 350 | THE FIRST HALF CYCLE SHOULD BE NEGATIVE & MUST SHOW AT LEAST 2 POSITIVE PEAKS & 2 NEGATIVE PEAKS WITHIN THE PERIOD OF 1 MILLISECOND.<br><br>*TEST FIXTURE | M | | |
| | 360 | REASSEMBLE. | M | | |
| | 370 | TEST STORAGE CAPACITOR; RAISE INPUT VOLTAGE TO 14V FOR NO MORE THAN 10 SECONDS. VALUE<br><br>ACTUAL VOLT<br>*VOLTASCOPE | M | | |
| | 380 | TEST:<br>INPUT VOLTAGE 14<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL AMP ACTUAL SR<br><br>INPUT VOLTAGE 24<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL AMP ACTUAL SR<br><br>INPUT VOLTAGE 29<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL AMP ACTUAL SR | M | | |
| | 390 | TIGHTEN HEX NUTS AT INPUT END, LARGE NUT SHOULD BE TORQUED & THE 2 SMALLER NUTS.<br><br>ACTUAL AMP ACTUAL IN/LB<br>*TORQUE WRENCH | M | | |
| | 400 | SOLDER UNIT. | M | | |
| | 410 | TEST EXCITER FOR LEAKS USING A PROBE WITH 14 PSIG. LEAKAGE.<br><br>ACTUAL CC<br>*VEECO LEAK DETECTOR | M | | |
| | 420 | SUBMERGE EXCITER IN WATER HEATED TO MINIMUM OF 49 DEG C (120 DEG F) FOR | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | 1 MINUTE. | | | |
| | 430 | GAS CHARGING: BAKE EXCITER 15 MIN. AT 275 DEG F. THEN TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO BAKE FOR ADDITIONAL 15 MINUTES. | M | 1 hr | |
| W-41 | 440 | PAINT. | M | | |
| | 450 | BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F. OR AIR DRY. . | M | | |
| | 460 | TEST: SET MICROMETER UNTIL SCALE READING INDICATES SPARK GAP OF 0.100 INCH. ADJUST NITROGEN INLET UNTIL GAGE HOLDS STEADY.<br><br>ACTUAL PSIG<br>*IGNITION OUTPUT TESTER | M | | |
| | 470 | TEST:<br>INPUT VOLTAGE 14<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL AMP<br>ACTUAL PER 10 SEC<br>INPUT VOLTAGE 24<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL AMP<br>ACTUAL PER 10 SEC<br><br>INPUT VOLTAGE 29<br>INPUT CURRENT<br>SPARK RATE<br><br>ACTUAL AMP<br>ACTUAL PER 10 SEC | M | | |
| | 490 | APPLY 24V INPUT CURRENT. OBTAIN ONE (1) OF THE FOLLOWING:<br>METER READING<br><br>72.5<br>78.0<br>83.0<br>87.5<br>91.5<br><br>ACTUAL | M | | |

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| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 500 | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M | | |
| | 545 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M | | |
| | 546 | COMPLY WITH MAOI 66-36, PARA 13<br><br>TYPE WORK PERFORMED | M | | |
| | 550 | OPERATIONS COMPLETED & PAPERWORK PROCESSED. | M | | |

CAEB09 * WORK CONTROL DOCUMENT * JC  1.DATE 89033  PAGE 1 OF 4 PAGES

| 12.ORIG/PROD NR | 13.QUANTITY | 14.PROD SECTION/RCC | 15.DATE SCHED | 16.DATE COMP |
|---|---|---|---|---|
| 971338 | | MTPCAJ | 89131 | |

| 9.PART NUMBER | 19.ITEM SERIAL NR | 18/12.TECH DATA/OPTIONAL |
|---|---|---|
| AV11A1134 | | PO MA18/-3 |
| | | 6J15-9-19-3 84245H |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 1 |
| J-57 | 4810002041575RV | |

13.MISC | 14.NOUN/END ITEM NOUN
ELECTROMAG 3 WAY SELECT VLVPACK
JENNINGS/MATL AC/65920

| 17.DISP-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"I" | 20"Q" |
|---|---|---|---|---|---|
| W 43 | 010 | RECEIVE, IDENTIFY AND ATTACH PAPERWORK. | A | | |
| | 015 | ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 | DISASSEMBLE. | M | | |
| | 030 | CLEAN AS REQUIRED. | M | | |
| | 040 | INSPECT. | M | | |
| | 045 | INSPECT SPRINGS FOR CRACKS USING FED SPEC MIL-I-6868A. | M | | |
| | 050 | INSPECT SPRING (12)<br>O.D.<br>ACT: INCH<br>HEIGHT<br>ACT: INCH<br>LOAD<br>ACT: LBS<br>COMPRESSED.<br>HEIGHT<br>ACT: INCH<br>LOAD<br>ACT: LBS | M | | |
| | 060 | INSPECT SPRING (5).<br>O.D.<br>ACT: INCH<br>WORKING<br>HEIGHT<br>ACT: INCH<br>LOAD<br>ACT: LBS<br>COMPRESSED.<br>HEIGHT<br>ACT: INCH | M | | |

(CONTINUED)

CAEBOB * WORK CONTROL DOCUMENT * JC 1.DATE 07033 PAGE 2 OF 4 PAGES

| 15.DISP STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | LOAD<br>ACT: LBS | | | |
| | 070 | TEST ELECTROMAGNET COIL:<br>APPLY 1000 VOLTS RMS, FOR ONE MINUTE.<br>LEAKAGE<br>ACT MA<br>NO BREAKDOWN OF DIELECTRIC STRENGTH | M | | |
| | 080 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 090 | ROUTE BODY P/N 1043256 TO MIPEM BLDG 3001, POST P-39 FOR MACHINING. MATPCM | M | | |
| | 100 | REASSEMBLE. | M | | |
| | 110 | MEASURE DISTANCE FROM UPPER SURFACE OF ARMATURE TO BODY UPPER LAND SURFACE<br>.<br>P/N ACT IN | M | | |
| | 120 | REQUIRED SPRING (5) WEIGHT<br>.<br>ACT: LBS | M | | |
| | 130 | DISTANCE BETWEEN ARMATURE TOP SURFACE AND BODY UPPER LAND SURFACE<br>ACT: INCH | M | | |
| | 140 | TORQUE SCREW (1)<br>.<br>ACT: IN/LBS | M | | |
| | 150 | MEASURE DISTANCE FROM LOWER END OF BODY SHOULDER TO BOTTOM OF SPRING RECESS IN LOWER NEEDLE WITH PIN INSTALLED.<br>ACT: INCH | M | | |
| | 160 | MEASURE DISTANCE FROM KNIFE EDGE OF CAP TO TOP OF CAP THREAD SHOULDER<br>.<br>ACT: INCH | M | | |
| | 170 | MEASURE DISTANCE FROM TOP OF CAP THREAD SHOULDER TO BOTTOM OF SPRING RECESS IN INSIDE OF CAP.<br>ACT: INCH | M | | |
| | 180 | COMPRESSED LENGTH OF LOWER SPRING. | M | | |

(CONTINUED)

| 15.DISP-STATION | 16.PDN/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACT: | | | |
| | 190 | ASSEMBLE LOWER SPRING (12), CHECK WEIGHT<br>ACT: LBS | M | | |
| | 200 | TORQUE CAP (10)<br>ACT: FT/LBS | M | | |
| | 210 | TEST: FLOW REQUIREMENTS - APPLY 200 PSIG MAXIMUM PRESSURE DROP + /5 DEG F.<br>. | M | | |
| | 220 | SOLENOID DE-ENERGIZED, APPLY FLUID PORT (3). FLOW PORT (2)<br>.<br>ACT: GPM | M | | |
| | 230 | SOLENOID ENERGIZED WITH 18 +/- 1 VOLT DC. APPLY FLUID PORT (1). FLOW PORT (2)<br>ACT: VDC<br>ACT: GPM | M | | |
| | 240 | LEAKAGE TEST: APPLY 50 PSIG TO PRESSURE PORT. LEAKAGE AT WEEP PORT<br>.<br>ACT: | M | | |
| | 250 | APPLY 18 PSIG TO WEEP PORT. LEAKAGE AT TANK PORT<br>.<br>ACT: | M | | |
| | 260 | APPLY 18 +/- 1 VOLT DC TO SOLENOID. APPLY 50 PSIG TO WEEP PORT. LEAKAGE AT TANK PORT<br>.<br>ACT: | M | | |
| | 270 | APPLY 50 PSIG TO WEEP AND TANK PORTS. NO EXTERNAL LEAKAGE ALLOWED. | M | | |
| | 280 | OPERATION TEST: APPLY 50 PSIG TO PRESSURE PORT. APPLY 18 +/- 1 VOLT DC TO SOLENOID. VALVE SHALL FLOW THE APPLIED TEST FLUID.<br>ACT: | M | | |

(CONTINUED)

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| 15.DISP STATION | 16.FDN/ OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACT: | | | |
| | 290 | AFTO FORM 349 COMPLETED AND FORWARDED TO DATA AUTOMATION. | M | | |
| | 300 | SAFETY WIRE | M | | |
| | 310 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS. | M | | |
| | 320 | OPERATIONS COMPLETE AND PAPERWORK PROCESSED | M | | |
| | 325 | COMPLY WITH MAOI 66-36, PARA 13<br>TYPE WORK PERFORMED | M | | |

NUMBER

this is the same as 49711A

replace the gap tube which contain CESium 137 with krypton (Kr) 85. reduces Radioactive ~~Level~~ exposure to employee.

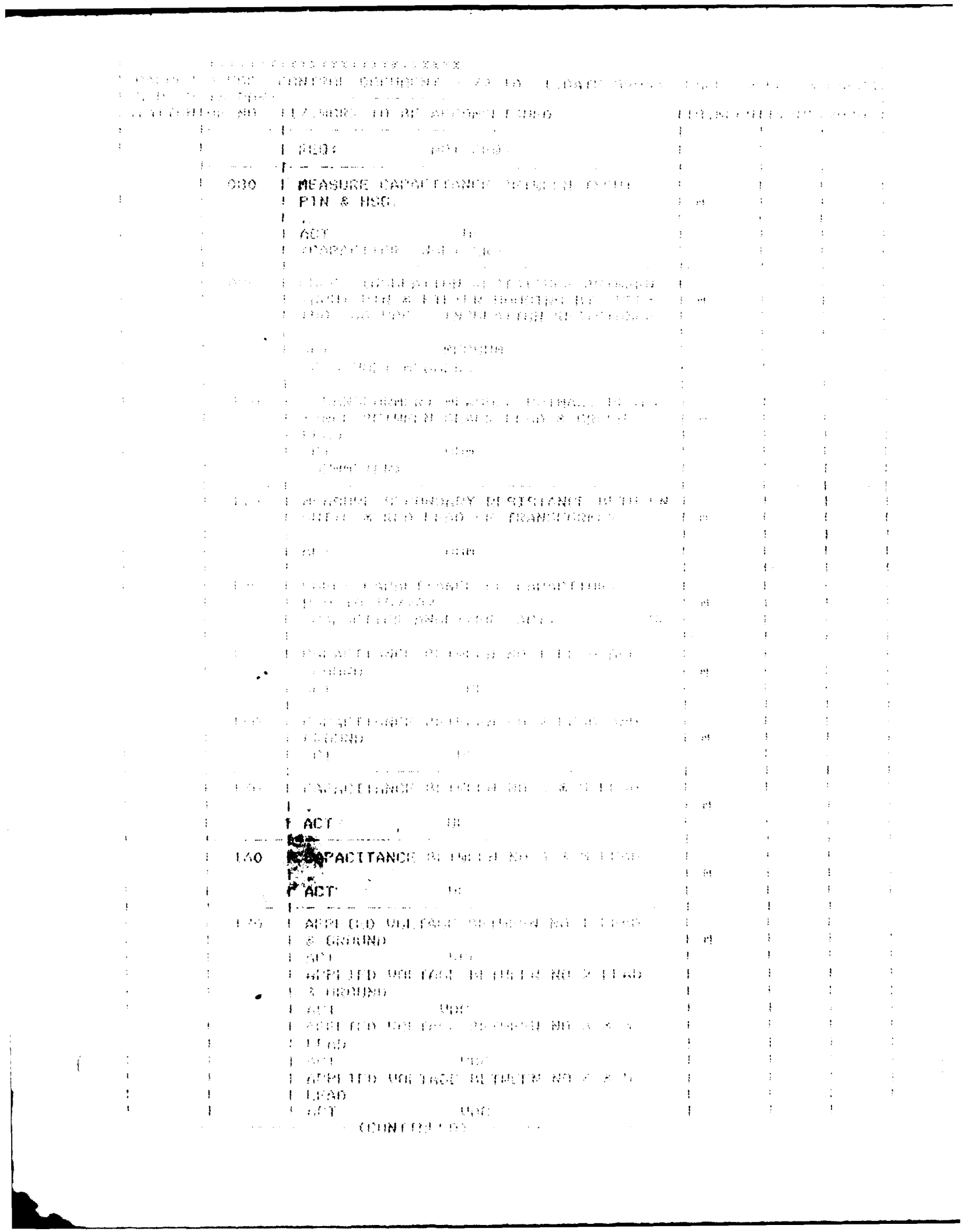
INSPECT

INSPECT

REPLACED NEW

REPAIR

(CONTINUED)



WORK CONTROL DOCUMENT [illegible]

OPERATION NO. | WORK TO BE ACCOMPLISHED

THERE SHALL BE NO [illegible]
FLASHOVER OF ANY SECTION DURING [illegible]
SECOND PERIOD [illegible]
*JET IGNITION [illegible]

150 | MEASURE RESISTANCE OF [illegible]
RESISTORS [illegible]
RESISTOR [illegible]
[illegible]

200 | [illegible]

220 | [illegible]
OPERATION SHALL BE [illegible]

240 | VACUUM DRY [illegible] EXCITER [illegible]
[illegible] AT 190 [illegible]
[illegible] ABSOLUTE [illegible]

250 | [illegible]ILL CAPACI[illegible]
[illegible]ITH RESIN.

260 | [illegible]AKE IGNITION EXCITER AS FOLLOWS:

200 DEG F/1 HR

240 DEG F/1 HR

300 DEG F/2 HRS

[illegible] | [illegible] EXCITER & PERFORM LEAK [illegible]

[illegible] | CLOSE VACUUM [illegible] & PRESSURIZE [illegible]
[illegible] EXCITER [illegible] PSI [illegible] WITH
DRY AIR OR NITROGEN HAVING A DEW

(CONTINUED)

| WORK CONTROL DOCUMENT [illegible] |
|---|

| [illegible] | OPER NO | WORK TO BE ACCOMPLISHED | [illegible] | | | |
|---|---|---|---|---|---|---|
| | | POINT OF [illegible] OPERATION | | | | |
| [illegible] | 310 MIPIA | PAINT | | | | |
| | | RED [illegible] | | | | |
| | 320 MIPIA | PAINT CONTROL [illegible] OVER- FED SET [illegible] [illegible] ACT [illegible] | | | | |
| | [illegible] | [illegible] | | | | |
| | [illegible] | [illegible] | | | | |
| | | [illegible] | | | | |
| | | [illegible] | | | | |
| | | [illegible] SPARK RATE [illegible] ACT [illegible] | | | | |
| | | ACT: [illegible] | | | | |
| | | ACT: [illegible] | | | | |
| | | ACT: [illegible] | | | | |
| | 360 | AFTO 349 COMPLETED & FORWARDED TO DATA [illegible] | M | | | |
| | [illegible] | I CERTIFY THAT THIS [illegible] HAS BEEN OVERHAULED [illegible] CURRENT REVISIONS, [illegible] AND APPLICABLE PROCESS [illegible] | M | | | |
| | 380 | OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M | | | |

CALCO7 & WORK CONTROL DOCUMENT

PIPE 16 EDNZ

OPERATION NO. 112, WORK TO BE ACCOMPLISHED

| | | | | | | |
|---|---|---|---|---|---|---|
| | 303 | COMPLY WITH MANUF... | | | | |
| | | | 4 | | | |
| | | TYPE WORK ... | | | | |

CAEC11 * WORK CONTROL DOCUMENT * 72-10 1.DATE 89045 PAGE 1 OF 6 PAGES

| 2.ORIG/PROD NR | 3.QUANTITY | 4.PROD SECTION/RCC | 5.DATE SCHED | 6.DATE COMP |
|---|---|---|---|---|
| 98093A | | MTPCAP | 89094 | |

| 7 PART NUMBER | 19.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL | |
|---|---|---|---|
| 45317 (M) | | PO MAT87-3 | |
| | | SE1-8-8-3 ENG INST | 87074H |
| 10.MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 21 | |
| TF33-7 | 2925004567627RV1 | SE1-8-8-8-1 | 80007H |
| | | CHG 3 | |
| 13.MISC 14.NOUN/END ITEM NOUN | | | |
| IGNITION EXCITER | PAC | TO | |
| 520 SHIMS/MATEAC/65920 | | | |

| 15.DISP STATION | 16.OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| W-3 | 520 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | M | | |
| | 015 525 | ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE. | M | | |
| | 020 | DISASSEMBLE. ~~CAUTION~~ | M | | |
| DELETE | 525 025 | REPAIR CASE ASSY.<br>REQ. _____ NOT REQ. _____ | M | | |
| | 030 530 | CLEAN AS REQUIRED.<br>(DO NOT WIPE OR BRUSH AWAY THE EXCESS SOLDER & DO NOT DAMAGE SOLDER COATING) | M | | |
| | 040 | INSPECT AS REQUIRED. | M | | |
| | 060 540 | CAPACITOR TEST: TEST SMALLER MULTIPLE CAPACITOR. GROUND "B" TERMINAL TO CASE. APPLY 5000VDC BETWEEN TERMINALS C, D & E AND CASE FOR NOT MORE THAN 30 SECONDS.<br>ACTUAL C. _____<br>*TEST CONSOLE D. _____<br>E. _____ | M | | |
| | 560 | APPLY 5000VDC BETWEEN TERMINALS "A" & "B" FOR NOT MORE THAN 30 SECONDS.<br>ACT: _____ | | | |
| | 560 | REMOVE GROUND FROM "B" TERMINAL. SHRT "B" TERMINAL TO "A" TERMINAL & APPLY 5000VDC BETWEEN TERMINALS "A" & "B" & THE CASE FOR NOT MORE THAN 30 SECONDS.<br>ACT: _____ | | | |
| | 570 | CHECK CAPACITANCE BETWEEN TERMINALS:<br>A TO B _____ ACT: _____<br>B TO C _____ ACT: _____<br>C TO CASE _____ ACT: _____<br>D TO CASE _____ ACT: _____ | | | |

(CONTINUED)

| STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | E TO CASE_____ACT:_____<br>*CAPACITOR BRIDGE TESTER | | | |
| | ~~100~~ 060 | TEST LARGER MULTIPLE CAPACITOR BY APPLYING 5000VDC BETWEEN TERMINALS "A" & "C" FOR NOT MORE THAN 30 SEC.<br><br>ACTUAL_____<br>*TEST CONSOLE<br>WHILE SHORTING TERMINALS "A" & "C" TOGETHER, APPLY 5000VDC BETWEEN TERMINALS "B" & "C" FOR NOT MORE THAN 30 SECONDS.<br>ACT:_____<br>SHORT TERMINALS "A", "B" & "C" TOGETHER & APPLY 5000VDC BETWEEN TERMINALS & CASE.<br>ACT:_____<br>CHECK CAPACITANCE FROM TERMINAL "A" TO "C" & FROM TERMINALS "C" TO "B"<br>ACT:_____A TO C<br>ACT:_____C TO B<br>*CAPACITOR BRIDGE TESTER | M | | |
| | 160 070 | FILTER TEST: APPLY 400VDC BETWEEN LONGER OUTPUT TERMINAL & GROUND, WHILE "C" PIN IS GROUNDED. THERE MUST BE NO SIGN OF BREAKDOWN.<br><br>*TEST CONSOLE<br>APPLY 600VDC BETWEEN SHORTER OUTPUT TERMINAL & GROUND, WHILE "B" PIN IS GROUNDED. THERE MUST BE NO SIGN OF BREAKDOWN.<br>CHECK LEAKAGE BETWEEN SHORTER OUTPUT TERMINAL & GROUND, WHILE "B" PIN IS GROUNDED: THEN CHECK LEAKAGE BETWEEN LONGER OUTPUT TERMINAL & GROUND WHILE "C" PIN IS GROUNDED.<br><br>ACT:_____ACT:_____<br>*VACUUMTUBE VOLTMETER<br>MEASURE CAPACITANCE BETWEEN SHORTER OUTPUT TERMINAL & GROUND<br>ACT:_____<br>*CAPACITOR BRIDGE TESTER<br>BETWEEN LONGER FILTER OUTPUT TERMINAL & GROUND<br>ACT:_____ | M | | |
| | 210 080 | RESISTOR TEST: RESISTORS (6)<br>.<br>(6) ACTUAL_____<br>*VACUUM TUBE VOLTMETER 325 | M | | |
| | 220 | RESISTOR (5)<br>ACTUAL_____ | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | RESISTOR (10)<br>ACTUAL_____ | | | |
| | 270 | AC RECT. TEST:<br>ADJUST VOLTAGE TO 4000V & READ INVERSE VOLTAGE CURRENT ON SAME METER BY PUSHING BUTTON MARKED "500UA".<br>.<br>3952<br>ACTUAL_____<br>*VOLTAGE REGULATOR<br>RAISE VOLTAGE UNTIL MILLIAMETER SHOWS A READING OF 100MA. READ VOLTAGE DROP ACROSS RECTIFIER<br>ACT_____ | 6 M | | |
| | ~~290~~ 090 | TUBE P/N 85944<br>DISCHARGER TUBE TEST: ALLOW DISCHARGER TUBE TO FIRE FOR 4 MINUTES, THEN DURING SUCCEEDING 1 MINUTE PERIOD OBSERVE BREAKDOWN VOLTAGE.<br>.<br>.<br>ACTUAL_____<br>*TEST CONSOLE | M | | |
| | ~~300~~ 090 | TUBE P/N 24222:<br>ADJUST HIGH VOLTAGE REGULATOR UNTIL TUBE IS FIRING AT A RATE OF 1 SPARK PER SECOND; THEN DURING THE SUCCEEDING 30 SECOND PERIOD OBSERVE THE BREAKDOWN VOLTAGE.<br>.<br>ACTUAL_____ | M | | |
| | ~~310~~ 090 | TUBE P/N 24498:<br>VALUE OF BREAKDOWN VOLTAGE OF TUBE UNDER TEST OVER A PERIOD OF 1 MINUTE<br>.<br>ACTUAL_____<br>ACTUAL_____ | M | | |
| | ~~320~~ 100 | FEED-THRU TERMINAL TEST: APPLY 5000V DC BETWEEN TERMINAL & CASE, LEAKAGE<br>.<br>ACTUAL_____ | M | | |
| | 330 | HIGH TENSION TRANSFORMER TEST: SET UP IGNITION OUTPUT TESTER & ADJUST FOR GAP OF 0.200 IN & INTERNAL PRESSURE OF 20 PSIG.<br>.<br>OC 3953 | M | | |

| 15.DISP-16.PDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | 350 | SMALL TRANSF TEST: CHECK CONTINUITY BETWEEN "C" & "A" LEADS AND BETWEEN "C" & "B" LEADS. | M | 6 MIN | |
| | ~~360~~ 110 | POWER TRANSF TEST: APPLY 80V, 400 CYCLE AC, BETWEEN PRIMARY TERMINAL & GROUND. READ EXCITING CURRENT<br>ACTUAL_____<br>SHORT SECONDARY TERMINALS TOGETHER & APPLY 2000 VDC BETWEEN PRIMARY & SECONDARY TERMINALS FOR 30 SECONDS. THERE MUST BE NO EVIDENCE OF ELECTRICAL BREAKDOWN. | M | | |
| | ~~380~~ 120 | IAW CHOPPER TEST (PER T.O. PG 4-17) | M | | |
| | ~~400~~ 380 | REPAIR OR REPLACE AS NECESSARY. | M | | |
| | 415 | HIGH TENSION TRANSF RAISE PRESSURE TO 25PSIG & SUBMERGE UNIT IN WATER. LEAK CHECK FOR BUBBLES. SOLDER BENCH | M 12 M | | |
| | 450 | REMOVE ADAPTER & BAKE ASSY IN OVEN 2 HRS AT A TEMP OF 250 DEG F TO REMOVE ALL TRACES OF MOISTURE. | M 6M | 2 HR FLOW | |
| | ~~480~~ 390 | REASSEMBLE. | M | | |
| | ~~490~~ 390 | LAY A NEW GROUNDING BRAID (14) IN GROOVE IN CAP (13), MAKING CERTAIN IT LIES DEEP IN GROOVE TO PREVENT FRAYING OR PINCHING WHEN CAP IS SCREWED ON. TORQUE CAP<br>ACTUAL_____<br>*TORQUE WRENCH | M | | |
| | ~~500~~ 460 | INTERMEDIATE TEST: STORAGE CAPACITOR: TEST HIGH VOLTAGE LEAD ON "A" TERMINAL OF LARGER MULTIPLE CAPACITOR, RAISE INPUT VOLTAGE TO 14V FOR NOT MORE THAN 10 SECONDS.<br>ACTUAL_____<br>*TEST CONSOLE<br>APPLY INPUT VOLTAGE SUCCESSIVELY AT 14,24, & 29 V. AT A RATE OF NOT LESS THAN 5.0 SPARKS OVER A 10-SEC PERIOD & READ INPUT CURRENT ON TEST CONSOLE<br>(14) ACT_____S/R ACT_____AMPS<br>(24) ACT_____S/R ACT_____AMPS<br>(29) ACT_____S/R ACT_____AMPS<br>READ STORAGE CAPACITOR VOLTAGE ON | M | | |

(CONTINUED)

| 15.DISP-16.PDN/ STATION | OF NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | VOLTASCOPE<br>ACT:_____ VOLTS<br>READ INPUT CURRENT & SPARY RATE IN WINDOW OF OUTPUT TESTER CONNECTED TO LEFT OUTPUT.<br><br>ACT:_____ AMPS ACT:_____ S/R | | | |
| | ~~510~~ 520 | PREPARE UNIT FOR FILLING WITH POTTING COMPOUND BY PRE-BAKING FOR AT LEAST 1 HR AT 300 DEG F. | M | | |
| | ~~450~~ 520 | BAKE EXCITER IN CIRCULATING AIR OVEN AT LEAST 2 HRS AT TEMP OF 225 DEG F. RAISE TEMP TO 300 DEG F CURE 4 HRS. | M | | |
| | ~~520~~ 525 | SOLDER & TORQUE FILTER ATTACHING JAM NUT<br>ACTUAL_____ IN/LBS<br>*TORQUE WRENCH | M | | |
| | ~~565~~ 525 | WHILE APPLYING HEAT TO FLOW SOLDER, TORQUE SLOWLY. FILL SLOTS IN SCREW HEADS WITH SOLDER<br><br>6-32 ACT_____ 8-32 ACT_____<br>*TORQUE WRENCH | M | | |
| | ~~570~~ 530 | PRESSURE TEST: TEST FOR LEAKS USING PROBE WITH 15 PSIG IN EXCITER WITH HELIUM. (ALT LEAK CHECK IN WATER)<br><br>ACTUAL_____<br>*VEECO LEAK DETECTOR | M | | |
| | ~~580~~ 540 ~~560~~ | GAS CHARGING: SET THERMOSTAT AT 290 DEG F; BAKE EXCITER 15 MIN AT THIS TEMP. TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO BAKE FOR AN ADDITIONAL 15 MINUTE.<br><br>*GAS CHARGING FIXTURE | M | | |
| W-41 | ~~590~~ MTPCA | MOVE EXCITER TO PAINT SHOP. | M | | |
| | ~~595~~ 560 | PAINT<br>BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F. | M | | |
| | ~~610~~ 570 | FINAL TEST<br>RAISE INPUT VOLTAGE TO 24V.<br>RAD INPUT CURRENT & METER READING ON TESTER | M | | |

(CONTINUED)

| 15.DISP-16.FDN/ STATION | OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19"P" | 20"Q" |
|---|---|---|---|---|---|
| | | ACT:_____ACT_____<br>*TEST CONSOLE<br>PUSH "COUNTER RESET" BUTTON & READ RATE ON COUNTER.<br>ACT:_____S/R<br>RAISE INPUT VOLTAGE TO 115V AT 400 CYCLES. READ INPUT CURRENT & METER READING ON TESTER<br>ACT:_____ACT:_____<br>RAISE VOLTAGE 115V AT 400 CYCLES & PUSH "COUNTER RESET" BUTTON TO READ | | | |
| | 670 SAME | AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION. | M | | |
| | 680 650 | SAFETY WIRE | M | | |
| | ~~690~~ 660 | I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS AND SUPPLEMENTS | M | | |
| | 700 + | OPERATIONS COMPLETED AND PAPERWORK PROCESSED | M | | |
| | ~~710~~ 680 | COMPLY WITH MAOI 66-36, PARA 13<br>TYPE WORK PERFORMED_____ | M | | |