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(Wheels)
Data Base Documentation Book for OO-ALC/MANPGP Book 2 of 3

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Technology Insertion (TI)/Industrial Process Improvement (IPI) Data Base Documentation Book Volume for OO-ALC/MANPGP (Wheels) Book 2 of 3. This document contains detailed information about layouts equipment and processes for this RCC (Resource Control Center). *+*14. SUBJECT TERMS MAINTENANCE, DATABASE, EQUIPMENT,
AF, AFLC, TECHNOLOGY INSERTION, MANPGP, WHEELS

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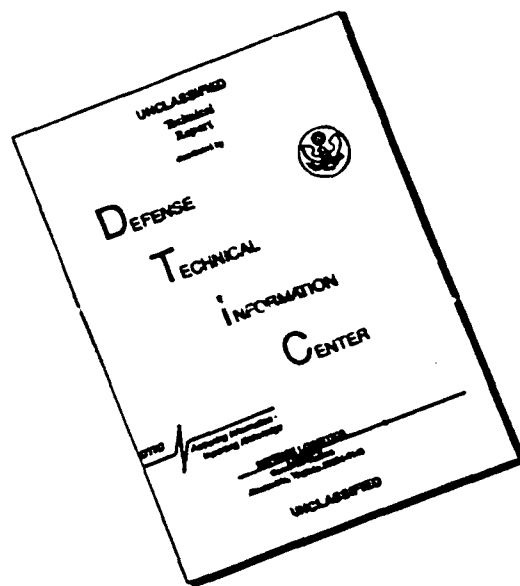
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**TECHNOLOGY INSERTION-ENGINEERING SERVICES
PROCESS CHARACTERIZATION
TASK ORDER NO. 1**

BOOK 2 OF 3

DATABASE DOCUMENTATION BOOK

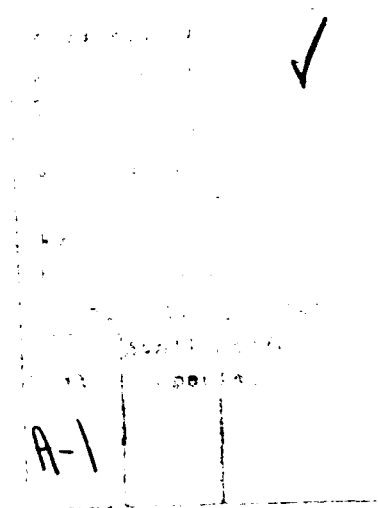
OO-ALC

MANPGP

(WHEELS - WCD'S)

**CONTRACT SUMMARY REPORT
15 DECEMBER 1989**

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



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

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N S N	P C N	O P E R S	O B S E R	P P P		P G W S		P P P		P R A S		P P R B S		P W W S		P W W S		L T O T		C U M			
				P P	P P	P G	P W	P P	P R	P P	P R	P P	P R	P W	P W	P W	P W	L	T	O	T	C	U
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OGDEN 80/20 SORTED BY TOTAL HRS

N S N	P C N	O P E R S	O B S E R	P G P P	P G W S	P G W P	P N A S	P N A P	P R A S	P R A P	P R B P	P R C S	P R C P	P W S	P W W P	L T O T	C U M
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9989P-LGM118A	T5733N	.	.	.	.	.	.	.	.	.	.	.	.	.	.	81	0.871203
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LOG-00008492028	T1384I	.	.	.	.	.	86	0.0025	.	.	.	.	.	.	.	53	0.873821
SYS-00005140002	T2709I	.	.	.	.	.	.	.	.	.	.	.	.	23	0.0011	17	0.873907

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ALC.SASCAN CNTL(OO8020P)

QGDEN 80/20 SORTED BY TOTAL HRS

N S N	P C N	O B S E R	P G S	P G P	P W S	P W P	P A S	P A P	P R S	P R B	P R C	P R S	P R C	P R S	P W S	P W P	P W S	P W P	L T	C U M
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233098516153	M4631D																		659.88	0.0081736
8140011515345	M4823K																		176.07	0.0090423
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8:12 FRIDAY, APRIL 7, 1989

ALC SASCAN CNTL(008020P)

OGDEN 80/20 SORTED BY TOTAL HRS

[illegible]

OGDEN 80/20 SORTED BY TOTAL HRS

[illegible]

WHEEL / BRAKE
A-7

- 1- 13101N ~~DELETED~~
- 2- 13102N ~~DELETED~~
- 3- 13103N ~~DELETED~~
- 4- 13104N ~~DELETED~~
- 5- 13105N ~~DELETED~~
- 6- 13106N ~~DELETED~~
- 7- 13150N NOSE ASSY 2P
- 8- 13151N NOSE OUTBOARD 2P
- 9- 13152N NOSE INBOARD 2P

BRAKE

- 1- 13201N BRAKE ASSY 2RP
- 2- 13202N TORQUE ^{PLATE} ~~FORCE~~ 2RP
- 3- 13203N CARRIER & LINING 2RP
- 4- 13204N PRESSURE PLATE 2RP
- 5- 13205N Brake Assy 2RP
- 6- 13206N Torque Plate Assy 2RP
- 7 13207N Disk and Linings Assy

WHEELS/BRAKES
A-10

- 1-38101N MLC INBOARD ZRP
- 2-38102N MLC ASSY ZRP
- 3-38107N MLC OUTBOARD ZRP
- 4-38150N NLG INBOARD ZRP
- 5-38151N NLG OUTBOARD ZRP
- 6-38152N NLG ASSY ZRP

BRAKES

- 1-38201N BRAKE ZRP
- 2-38202N TORQUE TUBE ZRP
- 3-38203N ROTATING DISK ZRP
- 4-38204N STATIONARY DISK ZRP
- 5-38205N BACKING PLATE ZRP
- 6-38207N PRESSURE PLATE ZRP
- 7-38206N BRAKE ASSY ZRP

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~~BRAKE~~

- 1-12201N BRAKE HOUSING ZRP
- 2-12202N NOT FOUND. DELETED
- 3-12203N TORQUE TUBE ZRP
- 4-12204N BACKING PLATE ZRP
- 5-12205N PRESSURE PLATE ZRP
- 6-12206N STATOR ZRP
- 7 12207N Brake ASSY

B-52 WHEELS

Pull

- 1 16101N MLC INBOARD ZRP
- 2 16102N MLC OUTBOARD ZRP
- 3 16103N WHEEL IS CONDEMNED IN DISASSY ZRP
- 4 16104N MLC OUTBOARD ZRP
- 5 16105N MLC INBOARD ZRP
- 6 16106N MLC WHEEL ASSY ZRP
- 7 16107N W/H IS CONDEMNED IN DISASSY ZRP NO 958
- 8 16108N W/H IS CONDEMNED IN DISASSY ZRP NO 958
- 9 16109N MLC WHEEL ASSY ZRP

BRAKES

Pull

- 1-16201N CARRIER ASSY ZRP 17-16206N ~~Compressor~~
- 2-16202N PRESSURE PLATE ZRP 18-16209N ~~Link Assn~~ ZRP
- 3-16203N STATOR PLATE ZRP
- 4-16205N ROTOR SEGMENT ASSY ZRP
- 5-16206N HYDRAULICS
- 6-16207N
- 7-16208N
- 8-16209N
- 9-16210N
- 10-16211N
- 11-16212N
- 12-16213N
- 13-16214N
- 14-16215N
- 15-16217N
- 16-16204N Backing Plate B-52 ZRP

C-5A & B WHEELS

Pull

- 1- 21101N NLG WHEEL ASSY ZRP
- 2- 21103N NLG INBOARD ZRP
- 3- 21104N NLG OUTBOARD ZRP
- 4- 21150N NLG OUTBOARD ZRP
- 5- 21151N NLG INBOARD ZRP
- 6- 21152N NLG ASSY ZRP
- 7- 21153N NLG INSERT Cap ZRP
- 8- 21154N M Wheel Cup ZRP
- 9- 21155N M Wheel Cup ZRP
- 10- 21156N N Wheel Cup ZRP
- 11- 21157N N Wheel ^{MISC} 5-2 ZRP
- 12- 21158N N Wheel ^{MISC} 5-11 ZRP

C-5A & B BRAKES

- 21201N BECKING PLATE ZRP
- 1- 21202N STATOR/CARRIER CS ZRP
- 2- 21203N ROTOR/CARRIER CS ZRP
- 3- 21204N END PLATE/CARRIER CS ZRP
- 4- 21205N DELETE
- 5- 21206N HOUSING PISTON ASSY ZRP
- 6- 21207N TORQUE TUBE ZRP
- 7- 21208N Brake Assy ~~DELETE~~ ZRP
- 8- 21209N PRESSURE PLATE ASSY ZRP
- 9- 21210N Brake Torque Tube ASSY ZRP
- 10- 21211N Tube Torque ZRP
- 11- 21212N Torque Tube ASSY ZRP
- 12- 21213N Disk Rotor ASSY ZRP
- 13- 21214N Disk - STATOR ZRP
- 14- 21215N SPACER PLATE ZRP
- 15- 21216N BRAKE ASSY ZRP

C-7A WHEELS

- 1- 20102N WHEEL INBOARD ZDP
- 2- 20103N WHEEL OUTBOARD ZDP
- 3- 20104N WHEEL ASSY ZDP

BRAKES

- 1- 20201N DELETED/NO Q/N

C-130 WHEELS

- 1-18104N MLC WHEEL ASSY (DELETED)
- 18106N MLC WHEEL INBOARD ZRP
- 18108N MLC WHEEL ASSY ZRP
- 1-18108N MLC WHEEL OUTBOARD ZRP
- 18111N MLC WHEEL ASSY ZRP
- 18112N MLC WHEEL INBOARD ZRP
- 18113N MLC WHEEL OUTBOARD ZRP
- 3-18150N NLG WHEEL ASSY ZRP
- 1-18151N NLG WHEEL ASSY (NAVY TO. REQUESTED DELETED)
- 1-18152N NLG WHEEL OUTBOARD ZRP
- 2-18153N NLG WHEEL INBOARD ZRP
- 3-18154N NLG WHEEL INBOARD (NAVY) ZRP
- 1-18155N NLG WHEEL OUTBOARD (NAVY) ZRP
- 5-18156N NLG WHEEL ASSY (NAVY) ZRP

VC-130 BRAKES

- 1-18201N TORQUE TUBE ZRP
- 2-18202N PRESSURE PLATE ZRP
- 3-18203N BRAKE 130 ZRP
- 4-18204N BRAKE ASSY ZRP
- 5-18205N
- 6-18206N BRAKE DELETED
- 7-18207N BRAKE ASSY DELETED
- 8-18208N HOUSING DELETED
- 9-18209N ROTATING DISK ZRP
- 10-18210N ROTOR ZRP
- 11-18211N BACKING PLATE ZRP
- 12-18212N STATOR ZRP
- 13-18213N PLATE Subassembly ZRP
- 14-18214N Brake ASSY ZRP
- 15-18215N Brake Assy ZRP
- 16-18216N Housing Assy ZRP

WHEELS/ BRAKES

C-141

- 1-19102N M/W OUTBOARD ZRP
- 2-19103N M/W OUTBOARD ZRP
- 3-19104N M/W INBOARD ZRP
- 4-19105N M/W ASSY
- 5-19106N M/W ZRP
- 6-19107N M/W ASSY ZRP
- 7-19108N M/W OUTBOARD ASSY ZRP

- 1-19201N PLATE BACKING W
- 2-19202N BRAKE ASSY W
- 3-19203N TORQUE TUBE W
- 4-19204N ROTATING DISK W
- 5-19205N PRESSURE PLATE W

WHEELS/BRAKES

E-3A

- 1- 39101N WHEEL ASSY 2PP
- 2- 39102N W/H INBOARD 2PP
- 3- 39103N W/H OUTBOARD 2PP
- 4- 39150N NOSE W/H ASSY 2PP
- 5- 39151N NOSE W/H INBOARD 2PP
- 6- 39152N NOSE W/H OUTBOARD 2PP

BRAKES

- 1- 39201N BRAKE ASSY W
- 2- 39202N ROTATING DISK W
- 3- 39203N PRESSURE PLATE W
- 4- 39204N STATIONARY DISK W
- 5- 39205N BACKING PLATE W
- 6- 39206N Torque Tube
- 7- 39207N Deleted.
- 8- 39208N BRAKE ASSY W

WHEELS/BRAKES

F-4

- 1- 01101N W/H DEMOUNTABLE, M ZRP
- 2- 01102N W/H FLANGE, M ZRP
- 3- 01103N WHEEL, M
- 4- 01104N WHEEL FLANGE, M
- 5- 01105N SLEEVE BUSHING, M ZRP
- 6- 01106N RING EXCITER, M ZRP
- 7- 01107N W/H ASSY, M ZRP
- 8- 01108N NOSE WHEEL, M
- 9- 01150N W/H OUTBOARD, N ZRP
- 10- 01151N W/H OUTBOARD, N ZRP
- 11- 01152N RING, BEARING ADT., M ZRP
- 12- 01153N W/H INBOARD, N ZRP
- 13- 01154N WHEEL ASSY, N ZRP
- 14- 01155N W/H INBOARD, N ZRP
- 15- 01156N WHEEL ASSY, N ZRP

BRAKES

- 1- 01202N BRAKE HOUSING F4C ZRP
- 2- 01207N HOUSING ASSEMBLY ZRP

WHEELS / BRAKES

F-5

Paul
Wheels
only

- 1-34101N FLANGE, M/W ERP
- 2-34102N WHEEL ASSY, M ERP
- 3-34103N WHEEL ASSY, M ERP
- 4-34104N WHEEL DEMOUNTABLE, M ERP
- 5-34105N WHEEL ASSY, M ERP
- 6-34106N WHEEL ~~WHEEL~~ HUB ERP
- 7-34107N FLANGE, M ERP
- 8-34108N WHEEL OUT BOARD ERP
- 9-34109N WHEEL IN BOARD ERP

BRAKES

1-34201N Plate Sub. ASSY PWR ERP	14-34214N - Brake AS ²
2-34202N ROTATING DISK ERP	
3-34203N STATIONARY DISK ERP	
4-34204N ~~BRAKE ASSY~~ HOUSING ASSY ERP	
5-34205N DISK SECONDARY ERP	
6-34206N TORQUE TUBE ERP	
7-34207N TORQUE TUBE ERP	
8-34209N PRESSURE PLATE ERP	
9-34210N BACKING PLATE ERP	
10-34208N ROTATING DISK ERP	
11-34211N STATOR ERP	
12-34212N Brake ASSY ERP	
13-34213N DISK ASSY ERP	

WHEELS/ BRAKES
F-15

- 1-36101N WHEEL INBOARD, M-
- 2-36103N WHEEL INBOARD C/D 2DP
- 3-36104N WHEEL ASSY C/D 2DP
- 4-36105N WHEEL OUTBOARD, M 2DP
- 5-36106N WHEEL FLANGE-
- 6-36107N ROTOR DRIVE KEYS 2DP
- 7-36108N WHEEL ASSY, M-
- 8-36150N WHEEL HALF OUTBOARD 2DP
- 9-36152N WHEEL HALF INBOARD 2DP
- 10-36153N WHEEL ASSY 2DP
- 36154N DRIVE KEY DRIVE-

BRAKES

- 1-36203N BRAKE ASSY AB 2DP
- 2-36204N HOUSING A/B 2DP
- 3-36205N BACKING PLATE
- 4-36206N BRAKE HOUSING C/D
- 5-36207N TUBE, TORQUE C/D
- 6-36208N BOLTS 2DP
- 36209N TORQUE TUBE A/B 1DP
- 8-36210N DELETED
- 9-36212N BOLT

- 36213N ROTATING DISK A/B
- 11- 36214N STATIONARY DISK A/B
- 12- 36215N ROTATING DISK A/B ZRP
- 13- 36216N END PLATE A/B ZRP
- 14- 36217N PRESSURE PLATE A/B ZRP
- 15- 36218N STATIONARY DISK A/B ZRP
- 16- 36219N BACKING PLATE C/D
- 17- 36220N STATIONARY DISK C/D
- 18- 36221N ROTATING DISK C/D
- 19- 36222N PRESSURE PLATE C/D
- 20- 36223N BRAKE HEAT STACK C/D
- 21 36224N HEAT SHIELD, HOUSING ZRP
- 36225N END PLATE
- 23 36226N PRESSURE PLATE
- 24 36227N DISK SUBASSY, STATOR
- 25 36228N HEAT STACK ASSY
- 26 36229N BRAKE ASSY
- 27 36230N END ~~PLATE~~ PLATE
- 28 36231N PRESSURE PLATE ASSY
- 29 36232N DISK SUBASSY, STATOR
- 30 36233N ROTOR SUB ASSY
- ~~31- 36234N~~ ~~HEAT STACK ASSY~~ BRAKE ASSY
- ~~32- 36235N~~ ~~HEAT STACK ASSY~~
- 33 36236N HEAT STACK ASSY ZRP

F15
Brake

WHEELS / BRAKES
F-16

- 1-37101N WHEEL INBOARD, M 1AP
- 2-37102N WHEEL FLANGE, M 1AP
- 3-37103N WHEEL ASSY, M 1AP

✓ F-16 BRAKES

- 1-37201N ~~BRAKE ASSY~~ HOUSING 2AP
- 2-37202N TORQUE TUBE 2AP
- 3-37203N BACKING PLATE 2AP
- 4-37204N ROTATING DISK 2AP
- 5-37205N PRESSURE PLATE 2AP
- 6-37206N STATIONARY DISK 2AP
- 7-37207N END PLATE 2AP
- 8-37208N Heat Stack ASSY 2AP
- 9-37209N Brake ASSY 2AP
- 10-37210N Brake ASSY 2AP
- 11-37211N End Plate 2AP

F-16 Brakes

- 12- 37212N STATIONARY DISK ZRP
- 13- 37213N Pressure PLATE ZRP
- 14- 37214N ROTATING DISK. ZRP
- 15- 37215N Heat Stack ASSY ZRP

WHEELS/BRAKES
F-100

- 1- 02100N INBOARD W/H HALF TRP
- 2- 02101N OUTBOARD W/H HALF TRP
- 3- 02103N INBOARD W/H TRP
- 4- 02104N M/W ASSEMBLY TRP
- 5- 02105N M/W ASSEMBLY TRP
- 6- 02102N M/W OUT BOARD TRP
- 7 04104N M/W F-100/F-106 ASSY TRP
- 8 04103N I.B. F-100/F-106 TRP
- 9 04101N O.B F-100/F-106 TRP

✓ BRAKES

- 1- 02201N Brake Assy
- 2- 02202N Hub Assy
- 3- 02203N Ring
- 4 02204N Rotating Disk

✓F-104

BRAKE

- 1-07201N w Plate STATOR
- 2-07202N w Pressure PLATE
- 1-07203N w Brake ASSY
- 1-07204N w Backing PLATE
- 5-07205N w Brake F106
- 1-07206N w ROTOR
- 1-07207N w BOLT

WHEEL

- 1-04101N M/W ASSY BEB
- 2-04103N M/W I.B. BEB
- 3-04104N M/W O.B. BEB

WHEELS/BRAKES F-111

- 1- 08101N W/H INBOARD(M) ZRP
- 2- 08102N W/H OUTBOARD(M) ZRP
- 3- 08103N DELETED
- 4- 08105N WHEEL ASSY (M) ZRP
- 5- 08106N DELETED
- 6- 08107N DELETED
- 7- 08150N W/H INBOARD (N) ZRP
- 8- 08151N WHEEL ASSY (N) ZRP
- 9- 08152N WHEEL ASSY (N) ZRP
- 10- 08153N W/H OUTBOARD (N) ZRP
- 11- 08154N W/H OUTBOARD (N) ZRP
- 12- 08155N W/H INBOARD (N) ZRP
- 12- 08108N W/H SUB ASSY O/B
- 13- 08109N W/H SUB ASSY I/B
- 14- 08110N WHEEL ASSY ZRP

✓ BRAKES

- 1- 08201N STATOR CARRIER
- 2- 08202N STATOR PLATE
- 3- 08203N Brake F111
- 4- 08204N Pressure PLATE
- 5- 08205N Backing PLATE
- 6- 08206N Pressure PLATE FB111
- 7- 08207N Brake FB111
- 8- 08208N Torque Tube
- 9- 08209N Torque Tube FB111
- 10- 08210N Deleted.
- 11- 08211N Rotating Disk
- 12- 08212N Backing PLATE

WHEELS

FB-111

- 13- 08108N w/H Out Board. BEB
- 14- 08109N w/H IN Board. BEB
- 15 08110N w- ASSY BEB

WHEELS/ BRAKES
KC-135

Pull

- 1-15101N M/W INBOARD/OUTBOARD ASSY
- 2-15102N M/W OUTBOARD ✓
- 3-15103N M/W INBOARD ✓
- 4-15150N M/W INBOARD JRP
- 5-15151N M/W OUTBOARD ✓
- 6-15152N M/W INBOARD ✓
- 7-15153N M/W ASSY ✓
- 8-15154N M/W OUTBOARD JRP
- 9-15155N M/W ASSY JRP

Pull

✓ BRAKES

- 1-15201N Backing Plate
- 2-15202N Brake KC135
- 3-15203N Brake STATOR
- 4-15204N Pressure Plate
- 5-15205N Rotor Segment

WHEELS/BRAKES
T-33

- 1- 32102N WHEEL ASSY JAP
- 2 32101N Flange Demountable JAP
- 3 32103N Wheel Sub Assembly JAP
- 4 11101N W/H OUTBOARD MLC JAP
- 5 11103N W/H ASSY MLC JAP
- 6 11104N W/H INBOARD MLC JAP

✓ BRAKES

- 1- 32201N Brake T-33
- 32202N ROTOR

T-38

✓BRAKES

- 1-33201N Brake ASSY T-38
- 2-33203N Torque Plate
- 3-33204N Carrier & Lining
- 4-33205N Disk Plate
- 5-33202N Wear Plate

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C/N 15468A-15542A

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C/N 90101A

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C/N 17576A-17575A

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C/N 16837A -16836A
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C/N 17565A

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C/N 17143A -17142A
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C/N 15592A - 15468A

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15101 N on 1st

15102 N page

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19058 - 19508 N -

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17565A pg 3

19059 - 19510 N

19060 - 19511 N

19061 - 19512 N

19062 - 19513 N

19063 - 19514 N

19064 - 19515 N

19065 - 19516 N

19066 - 19517 N

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C/N 69354A - 1857A

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C/N 69354A ~~contd~~

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C/N 19588A - 26183A X
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C/N 15162A - 15054A
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C/N 69595A - 15139A
(9)

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C/N 74521A - 
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C/N 15068A

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C/N 25874A - 26413A

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37202 N

37203 N

37204 N

37205 N

37206 N

37207 N

37208 N

37209 N

37210 N

37211 N

C/N 68521A - 62905A

(12) 15757

~~Deleted 18104 N~~

18106 N

18107 N

18108 N

18111 N

18112 N

18113 N

18150 N

~~Deleted 18151 N~~

18152 N

18153 N

18154 N

repeated
number
15757A
pg 10

(7)

C/N 68521 A cmtel

18155 N
18156 N

C/N 25737A
(367)

37001 N
37002 N
37003 N
37004 N
37005 N
37006 N
37007 N
37008 N
37009 N
37010 N
37011 N x
37012 N
37013 N
37014 N
37015 N
37016 N
37017 N
37018 N
37019 N
37020 N
37021 N
37022 N
37023 N
37025 N
37026 N
37027 N
37028 N
37029 N
37030 N
37031 N

C/N 19844A
(21)

18002 N
18003 N
18004 N
18005 N
18007 N
18008 N
18009 N
18010 N
18011 N
18012 N
18013 N
18014 N
18015 N
18016 N
18017 N
18018 N
18019 N
18020 N
18021 N
18022 N
18023x

C/N 15295A - 15583A
(11) -15519

08201 N
08202 N
08203 N
08204 N
08205 N
08206 N
08207 N
08208 N ✓
08209 N
~~08210 N~~
08211 N
08212 N

C/N 16915A - 17234A
(82) -17327A

15001 N -17451A
15002 N -17347A
15003 N -17348A
15004 N -17349A
15005 N ✓ -17407x
15006 N -69554A
15007 N
15010 N
1502 N
15013 N
15014 N
15015 N
15016 N
15017 N
15018 N
15019 N
15020 N
15022 N
15023 N
15024 N
15025 N ✓
15026 N
15027 N
15028 N
15030 N
15031 N
15032 N
15034 N
15035 N
15037 N
15038 N
15039 N
15040 N
15041 N
15042 N
15043 N ✓

17327A
C/N 16915A - 17234A

15044 N	15082 N
15045 N	15083 N
15046 N	15084 N
15047 N	15096 N *
15048 N	15097 N
15049 N	15098 N
15050 N ✓	15101 N
15051 N	15102 N
15052 N	15103 N
15053 N	15104 N
15054 N	
15055 N	
15056 N	
15057 N	
15060 N ✓	
15061 N	
15062 N	
15063 N	
15064 N	
15065 N	
15066 N	
15067 N X	
15068 N	
15069 N	
15070 N	
15071 N	
15072 N	
15073 N	
15074 N	
15075 N	
15076 N	
15077 N	
15078 N	
15079 N	
15080 N	
15081 N	

19937A - 19938A
C/N (21)

38500 N
38501 N
38502 N
38503 N
38504 N
38505 N
38506 N
38507 N
38508 N
38509 N
~~38510 N~~
~~38511 N~~
38512 N
38513 N
38517 N
38531 N
~~38532 N~~
38533 N
38534 N
38535 N
38536 N
38537 N
38538 N
38539 N

15523A
C/N (12)

08101 N	08153 N
08102 N	08154 N
~~08103 N~~	08155 N
08105 N	08108 N
~~08106 N~~	08109 N
~~08107 N~~	08110 N ✓
08150 N	
08151 N	
08152 N	

7
C/N 15161A
(5)

19201 N
19202 N
19203 N
19204 N
19205 N

C/N 15752A
(7)

38201 N
38202 N
38203 N
38204 N
38205 N
38207 N
38206 N

C/N 17354A
(26)

08500 N
08501 N
08502 N
08503 N
08504 N ✓
08505 N
08506 N
08509 N
08510 N
08511 N
08512 N
08513 N
08514 N
08515 N
08516 N
08517 N
08518 N

C/N 17354A

08519 N
08520 N
08521 N
08522 N
08523 N
08524 N
08525 N
08526 N
08527 N

C/N 15485A - 16266A
(15) - 16267A

01101 N
01102 N
01103 N
01104 N
01105 N
01106 N
01107 N
01108 N
01150 N
01151 N
01152 N
01153 N
01154 N
01155 N
01156 N

C/N 26338A - 26337A
(31)

36000 N
36001 N
36002 N
36003 N
36004 N
36006 N

(9)
C/N 26338A - 26337A

36007 N
36008 N
36009 N
36010 N
36011 N
36012 N
36013 N
36014 N
36015 ~~deleted~~
36016 N
36017 N
36018 N
36019 N
36020 N
36021 N
36022 N
36023 N
36024 N ✓
36025 N
36026 N
36029 N
36030 N
36031 N
36032 N
36033 N
36034 N

C/N 25425 - 15686A
(6)

38101 N
38102 N
38107 N
38150 N
38151 N
38152 N

C/N 72898 A
(16)

21101 N
21103 N
21104 N
21150 N
21151 N
21152 N
21153 N
21154 N ✓
21155 N
21156 N
21157 N
21158 N
21159 N
21160 N
21161 N
21162 N

C/N 15327A - 15728A
(12)

18201 N
18202 N
18203 N ✓
18204 N
~~18206 N deleted~~
~~18207 N deleted~~
~~18208 N deleted~~
18209 N
18210 N
18211 N
18212 N
18213 N
18214 N
18215 N
18216 N

C/N 15757A - 62905A
- 68521A

(12)
~~18104 N deleted~~
18106 N
18107 N
18108 N
18111 N
18112 N
18113 N
18150 N
~~18151 N deleted~~
18152 N
18153 N
18154 N
18155 N
18156 N

repeated under
68521 A
on pg 6

C/N 15603A - 15654A - 16264A
(5)

15201 N
15202 N
15203 N
15204 N
15205 N

C/N 17313A - 17339A - 69657A - 17348A
17451A - 17327A - 17245A

(82)

15001 N
15002 N ✓
15003 N
15004 N
15005 N
15006 N
15007 N
15010 N

cntd
C/N 17313A-17239A-69657A
174514-17327A-17245A
-17348A

- 15012 N ✓
- 15013 N
- 15014 N
- 15015 N
- 15016 N
- 15017 N
- 15018 N
- 15019 N
- 15020 N
- 15022 N
- 15023 N
- 15024 N
- 15025 N
- 15026 N
- 15027 N
- 15028 N
- 15030 N
- 15031 N
- 15032 N
- 15034 N
- 15035 N
- 15037 N
- 15038 N
- 15039 N
- 15040 N
- 15041 N
- 15042 N
- 15043 N
- 15044 N
- 15045 N
- 15046 N
- 15047 N
- 15048 N
- 15049 N ✓
- 15050 N
- 15051 N

- 15052 N
- 15053 N
- 15054 N
- 15055 N
- 15056 N
- 15057 N
- 15060 N
- 15061 N
- 15062 N
- 15063 N
- 15064 N
- 15065 N
- 15066 N
- 15067 N
- 15068 N
- 15069 N
- 15070 N
- 15071 N
- 15072 N
- 15073 N
- 15074 N
- 15075 N
- 15076 N
- 15077 N
- 15078 N
- 15079 N
- 15080 N
- 15081 N
- 15082 N
- 15083 N
- 15084 N
- 15086 N
- 15097 N ✓
- 15098 N
- 15101 N
- 15102 N
- 15103 N
- 15104 N

C/N 17142A-17143A
69855A

- 16001 N
- 16002 N
- 16003 N
- 16004 N
- 16005 N
- 16006 N
- 16007 N
- 16008 N
- 16009 N
- 16010 N
- 16011 N
- 16012 N
- 16013 N
- 16014 N
- 16015 N
- 16016 N
- 16017 N
- 16018 N
- 16019 N
- 16021 N
- 16022 N
- 16023 N
- 16024 N
- 16025 N
- 16026 N
- 16027 N

C/N 16123A
(28)

- 18400 N ✓
- 18401 N
- 18402 N
- 18403 N
- 18404 N
- 18405 N

~~Unit~~
C/N 16123A

- 18406 N
- *18407 N
- 18408 N
- 18409 N
- 18410 N
- 18411 N
- ~~18412 N deleted~~
- 18413 N
- 18414 N
- ~~18415 N deleted~~
- 18416 N
- 18417 N
- 18418 N
- 18419 N
- *18420 N
- 18421 N
- 18422 N
- 18423 N
- 18424 N
- 18425 N
- 18426 N
- 18427 N
- 18428 N
- 18429 N

C/N 74568A
~~(6)~~ (6)

- 13201 N
- 13202 N
- 13203 N
- 13204 N
- 13205 N
- 13206 N
- 13207 N deleted

C/N 15226A-15139A -64595A
~~(7)~~ (7)

- 16101 N
- 16102 N
- 16103 N
- 16104 N
- 16105 N
- 16106 N
- ~~16107 N deleted~~
- ~~16108 N deleted~~
- 16109 N

C/N 17474A-~~17475A~~
-17476A
(23)

- 33000 N
- 33001 N
- 33002 N
- 33003 N
- 33004 N
- 33005 N
- 33006 N
- 33007 N
- 33008 N
- 33009 N
- 33010 N
- 33011 N
- 33012 N
- 33013 N
- 33014 N
- 33015 N
- 33016 N
- 33017 N
- 33018 N
- 33019 N
- 33020 N
- 33021 N
- 33022 N ✓

(13)

C/N 15387

(5)

33201 N

33203 N

33204 N ✓

33205 N

33202 N

C/N 72877A

(41)

21501 N

21502 N

21503 N

21504 N

21505 N

21507 N

21508 N

21509 N

21510 N

21511 N

21512 N

21513 N

21514 N

21516 N

21517 N

21518 N

21519 N

21520 N

21521 N

21522 N

21523 N

21525 N

21526 N

21527 N

21528 N

21529 N

21530 N

21531 N

21532 N

21533 N

21534 N

21535 N

21537 N

21538 N

21541 N

21542 N

21543 N

21544 N

21545 N

21547 N

21550 N

21551 N

C/N 26642A-25737A

(26) (27) -26111A

37500 N

37501 N

37502 N

37503 N

37504 N

37505 N

37506 N

37507 N

37508 N

37509 N

37510 N

37511 N

37512 N

37513 N

37514 N

37515 N

37516 N

37517 N

37518 N

37519 N

37520 N

37521 N

37522 N

37523 N

37524 N / 37524

37525 N

37526 N

C/N 42626A

(24)

16501 N

16502 N

16503 N

16504 N

16505 N

16507 N

16508 N

16509 N

16510 N

16522 N

16523 N

16524 N

16525 N

16526 N

16527 N

16528 N

16529 N

16530 N

16531 N

16532 N

16533 N

16534 N

16535 N

16536 N ✓

C/N 72896 A - 15698 A

(15)

21201 N
21202 N
21203 N
21204 N
~~21205 N Deleted~~
21206 N
21207 N
21208 N
21209 N
21210 N
21211 N
21212 N
21213 N
21214 N
21215 N
21216 N

17527 A chud

13017 N (F)

13018 N

13019 N

13020 N

÷

C/N 83317 A

(7)

37701 N

37702 N

37703 N ✓

37704 N

37705 N

37706 N

37707 N

C/N 17527 A - 17595 A

(18)

13000 N

13001 N

13002 N

13003 N

13005 N

13007 N

13009 N

13010 N

13011 N

13012 N

13013 N

13014 N

13015 N ✓

13016 N

~~C/N 26559 A - 26560 A~~
C/N 26559 A - 26560 A
(31) (31)

36203 N

36204 N

36205 N ✓

36206 N

36207 N

36208 N

36209 N

~~deleted~~ 36210 N

36212 N

36213 N

36214 N

36215 N ✓

36216 N

36217 N

36218 N

36219 N

36220 N

36221 N

36222 N

36223 N

36224 N ✓

36225 N

36226 N

36227 N

36228 N

36229 N

36230 N

36231 N ✓

36232 N

36233 N

36234 N

36236 N ✓

WHEEL GROUPINGS TO BE PROCESS CHARACTERIZED

<u>FAMILY NO.</u>	<u>FAMILY CHARACTERISTICS</u>	<u>AIRCRAFT</u>	<u>PEN</u>	<u>STD. HRS.</u> <u>(MANPGP)</u>	<u>WED</u>
<i>THEMAN</i> <i>AL</i>	1 6 0 MAGNESIUM	<i>TC</i> KC-135N	15592A	2.67	151531
<i>KYLE</i>	2 6 0 ALUMINUM - LARGE	<i>TC</i> B-52M	69595A	2.47	16136A1
<i>AL</i>	3 2 0 ALUMINUM - MEDIUM (MAIN WHEELS)	"KC-135M" A-10M, C-5M C-130M, C-141M E-34M, F-4M F-5M, F-15M F-16M, F-100M F-106M, F-111M FB-111M	90101A	2.75	21101N
<i>MEL</i>	4 2 0 ALUMINUM - SMALL	~~E-3BNE~~ A-10N, C-5N A-7N, C-130N E-3AN, F-4N	16267A	2.09	01156N

1 0 0

File: 1001 WHEELWLD, W/K/

NAME:

ALU: UU

RLU: WHEELS

ITEM CODE	AIRCRAFT MODEL	WCU #	WL TYPE	PLANT STOCK	1st	2nd	3rd	4th	WIR #	MAX WIP	SID HRS
155Y2A	KU-135N	15152N	4	U	14	82	140	95		13/8	10.13
155Y2A	KU-135N	15152N	4	U							
155Y2A	KU-135N	15152N	4	U							
6Y5Y5A	B-52M	16106N	4	U	350	338	181	14		13/8	14.05
6Y5Y5A	B-52M	16105N	4	U							
6Y5Y5A	B-52M	16102N	4	U							
YU101A	U-5M	21101N	4	U	2298	2033	1850	1521		13/8	13.38
YU101A	U-5M	21103N	4	U							
YU101A	U-5M	22104N	4	U							
1626/A	F-4N	U1156N	4	U	260	223	330	184		13/8	7.14
1626/A	F-4N	U1155N	4	U							
1626/A	F-4N	U1150N	4	U							

NAME:
PCN: 15592A

ALL: UU

RCC:MANPGW

WCD: 15153N

MODDATE:88713

UP #	RCC	UP	DESC	UP	UCCU	UP	MAND	FLW	SKIL	TIME	REV	EQUIP	TIME	REV
					FAC	TYPE	%	HRS	CODE	%	HRS	CODE	%	HRS
IN	MANPGW		IND		1.00	P			HBUS	1	0.10	FL0001	1	0.10
005	MANPGW		SPL1		1.00	P			HBUS	2	0.40	PM0Y21		0.40
010	MANPGP		MICH		1.00	P			UVHD	1	0.02	PM0Y40	1	0.02
020	MANPGP		ASSY		1.00	P				45	0.20			0.20
023	MANPGP		ASSY		1.00	P				15	0.30			0.30
020	MANPGP		ASSY		1.00	P			YH0Y	1	2.00	WA0002	1	2.00
030	MANPGP		PNI		1.00	P			3S0Y	1	0.30	WA0003	1	0.30
030	MANPGP		PNI		1.00	P				40	0.10			0.10
998	MANPGP		CHK		1.00	P			3S0Y	1	0.10	WA0003	1	0.10
999	MANPGP		INSP		1.00	P			3S0Y	1	0.10	WA0003	1	0.10
9999	MANPGP		SELL		1.00	P			UVHD	1	0.02			0.10

311501

NAME: PLN: 1626/A

ALL: UU

KU: WHEELS

MLD: 0115001 WLDHTE: 88275

UP #	RUC	UP DESG	UUU FAC	UP TYPE	UP MANU %	FLW MRS	SKIL CODE	TIME %	REV MRS	EQUIP CODE	QTY	LINE REV
UU5	MANPUS	UIS	1.00	P			HBUS	1 100	0.08	PM0421	1 100	0.08
UU5A	MANPUS	TRANS	1.00	I						PM0421	1 100	0.08
UU5B	MANPUS	LUAD	1.00	P			HBUS	1 100	0.04	PM0425	1 100	0.04
UU5C	MANPUS	PRUC	1.00	P	100	0.05				PM0425	1 100	0.04
UU5D	MANPUS	LUAD	1.00	I						PM0421	1 100	0.08
UU5E	MANPUS	LUAD	1.00	P			HBUS	1 100	0.08	PM0425	1 100	0.08
UU6	MANPUS	REM	1.00	S			HBUS	1 100	0.04			
UU6A	MANPUS	REM	1.00	P			HBUS	1 100	0.04	HB0001	1 100	0.04
UU6B	MANPUS	LUAD	1.00	I						PM0421	1 100	0.08
UU6C	MANPUS	LUAD	1.00	P			KIUS	1 100	0.08	PM0401	1 100	0.08
UU7	MANPUS	PRUC	1.00	I						PM0401	1 100	3.47
UU7A	MANPUS	PRUC	1.00	S			KIUS	1 100	0.08			
UU7B	MANPUS	PRUC	1.00	P	100	2.87				PM0416	1 100	3.47
UU7C	MANPUS	UNLD	1.00	I						PM0401	1 100	0.08
UU7D	MANPUS	UNLD	1.00	P			KIUS	1 100	0.08	PM0002	1 100	0.08
UU7E	MANPUS	LUAD	1.00	I			KIUS	1 100	0.03	PM0416	1 100	0.03
UU7F	MANPUS	CLN	1.00	S			KIUS	1 100	0.05			
UU7G	MANPUS	CLN	1.00	P			KIUS	1 60	0.25	PM0416	1 60	0.25
UU7H	MANPUS	CLN	1.00	P			KIUS	1 40	0.15	PM0416	1 40	0.15
UU7I	MANPUS	UNLD	1.00	I						PM0002	1 100	0.08
UU7J	MANPUS	UNLD	1.00	P			KIUS	1 100	0.08	PM0416	1 100	0.08
UU7K	MANPUS	LUAD	1.00	I						PM0002	1 100	0.08
UU7L	MANPUS	LUAD	1.00	P			KIUS	1 100	0.08	PM0401	1 100	0.08
UU7M	MANPUS	REM	0.10	I			JAU7	1	0.06	PM0177	1	0.80
UU7N	MANPUS	REM	0.10	S			JAU7	1	0.80	PM0177	1	0.77
UU7O	MANPUS	REM	0.10	P			JAU7	1	0.77	PM0002	1 100	0.08
UU7P	MANPUS	UNLD	1.00	I						PM0401	1 100	0.08
UU7Q	MANPUS	UNLD	1.00	P			KIUS	1 100	0.08	PM0416	1 100	0.08
UU7R	MANPUS	LUAD	1.00	I			KIUS	1 100	0.03	PM0416	1 100	0.15
UU7S	MANPUS	LUAD	1.00	P			KIUS	1 100	0.04	PM0416	1 100	0.08
UU7T	MANPUS	BLSI	1.00	S			KIUS	1 100	0.15	PM0401	1 100	0.08
UU7U	MANPUS	BLSI	1.00	P			KIUS	1 100	0.08	PM0002	1 100	0.08
UU7V	MANPUS	UNLD	1.00	I			KIUS	1 100	0.08	PM0401	1 100	0.08
UU7W	MANPUS	UNLD	1.00	P			KIUS	1 100	0.08	PM0416	1 100	0.03
UU7X	MANPUS	LUAD	1.00	I						PM0416	1 100	0.15
UU7Y	MANPUS	LUAD	1.00	P			KIUS	1 100	0.08	PM0401	1 100	0.08
UU7Z	MANPUS	PRUC	1.00	I			KIUS	1 100	0.08	PM0401	1 100	1.03
UU7AA	MANPUS	PRUC	1.00	S			KIUS	1 100	0.08	PM0401	1 100	1.03
UU7AB	MANPUS	PRUC	1.00	P	100	0.86				PM0401	1 100	0.02
UU7AC	MANPUS	PP1	0.75	I						PM0401	1	1.03
UU7AD	MANPUS	PP1	0.75	P						PM0401	1	1.03
UU7AE	MANPUS	PP1	0.75	P						PM0401	1	1.03
UU7AF	MANPUS	PP1	0.25	I						PM0401	1	0.02
UU7AG	MANPUS	PP1	0.25	P						PM0401	1	1.10
UU7AH	MANPUS	PP1	0.25	P						PM0401	1	1.10
UU7AI	MANPUS	UNLD	1.00	I			KIUS	1 100	0.03	PM0401	1 100	0.08
UU7AJ	MANPUS	UNLD	1.00	P			KIUS	1 100	0.03	PM0416	1 100	0.03

U30A	MANPKU	LUHD	1.00	P	U107	1	100	0.08	PM0501	1	100	0.08
U45	KA	KEPK	0.25	I	JA10	1		0.02				0.17
U45	KA	KEPK	0.25	S	JA10	1		0.17	PM1211	1		0.51
U45	MANPKA	KEPK	0.25	P	JA10	1		0.51	PM1211	1		0.51
U50	MANPKA	KEPK	0.05	I	JA10	1		0.02				0.56
U50	MANPKA	KEPK	0.05	S	JA10	1		0.56	PM2577	1		0.62
U50	MANPKA	KEPK	0.05	P	JA10	1		0.62	PM2577	1		0.62
U60	MANPKA	KEPK	0.80	I	JA10	1		0.02				0.56
U60	MANPKA	KEPK	0.80	S	JA07	1		0.56	PM2576	1		0.46
U60	MANPKA	KEPK	0.80	P	JA07	1		0.46	PM2576	1		0.60
U65	MANPKU	MUVE	1.00	I	UVH0	1		0.60	FL0002	1		0.05
U70	MANPKU	ULN	1.00	I	UP05	1		0.05	PM4118	1		0.01
U70	MANPKU	ULN	1.00	S	UP07	1		0.01	CE20	1		0.01
U70	MANPKU	ULN	1.00	P	UP07	1		0.05	CE20	1		0.08
U70	MANPKU	ULN	1.00	P	UP07	1		0.05	PM5681	1		0.08
U70	MANPKU	ULN	1.00	P	UP07	1		0.01	CE20	1		0.01
U70A	MANPKU	KINS	1.00	S	UP07	1		0.01	CE20	1		0.01
U70A	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70A	MANPKU	KINS	1.00	P	UP07	1		0.01	PM5670	1		0.01
U70B	MANPKU	ULN	1.00	S	UP07	1		0.01	CE20	1		0.01
U70B	MANPKU	ULN	1.00	P	UP07	1		0.01	CE20	1		0.01
U70B	MANPKU	ULN	1.00	P	UP07	1		0.01	CE20	1		0.01
U70C	MANPKU	KINS	1.00	S	UP07	1		0.01	CE20	1		0.01
U70C	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70C	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70D	MANPKU	DEUX	1.00	S	UP07	1		0.01	CE20	1		0.01
U70D	MANPKU	DEUX	1.00	P	UP07	1		0.01	CE20	1		0.17
U70D	MANPKU	DEUX	1.00	P	UP07	1		0.05	PM5705	1		0.17
U70D	MANPKU	DEUX	1.00	P	UP07	1		0.01	CE20	1		0.01
U70D	MANPKU	DEUX	1.00	P	UP07	1		0.01	PM5705	1		0.01
U70E	MANPKU	KINS	1.00	S	UP07	1		0.01	CE20	1		0.01
U70E	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70E	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70E	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70F	MANPKU	ANZ2	1.00	P	UP07	1		0.05	CE20	1		0.58
U70F	MANPKU	ANZ2	1.00	P	UP07	1		0.05	CE20	1		0.58
U70F	MANPKU	ANZ2	1.00	P	UP07	1		0.01	CE20	1		0.01
U70G	MANPKU	KINS	1.00	S	UP07	1		0.01	CE20	1		0.01
U70G	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70G	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70H	MANPKU	SEAL	1.00	S	UP07	1		0.01	CE20	1		0.01
U70H	MANPKU	SEAL	1.00	P	UP07	1		0.01	CE20	1		0.01
U70H	MANPKU	SEAL	1.00	P	UP07	1		0.05	CE20	1		0.08
U70H	MANPKU	SEAL	1.00	P	UP07	1		0.01	CE20	1		0.01
U70I	MANPKU	KINS	1.00	S	UP07	1		0.01	CE20	1		0.01
U70I	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70I	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70J	MANPKU	KINS	1.00	S	UP07	1		0.01	CE20	1		0.01
U70J	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70J	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70J	MANPKU	KINS	1.00	P	UP07	1		0.01	CE20	1		0.01
U70K	MANPKU	DRY	1.00	I	UP07	1		0.01	CE20	1		0.01
U70K	MANPKU	DRY	1.00	P	UP07	1		0.01	CE20	1		0.01
U70K	MANPKU	DRY	1.00	P	UP07	1		0.01	CE20	1		0.01
U70K	MANPKU	DRY	1.00	P	UP07	1		0.01	CE20	1		0.01
U70L	MANPKA	MUVE	1.00	I	UVH0	1		0.60	PM4118	1		0.60
U70L	MANPKA	INSI	1.00	I	JA02	1		0.02				
U70L	MANPKA	INSI	1.00	S	JA08	1		0.08				
U70L	MANPKA	INSI	1.00	P	JA08	1		0.17				
U70L	MANPKA	INSI	1.00	P	JA08	1		0.02				
U70L	MANPKA	INSI	1.00	P	JA08	1		0.50	PM5201	1		0.50
U70L	MANPKA	INSI	1.00	P	JA08	1		0.23	PM5201	1		0.23
U70L	MANPKA	INSI	1.00	P	JA08	1		0.02				

100	MANPGR	LUMD	1.00	P	350Y	1	0.04	F10Y22	1	0.04
100A	MANPGR	WASH	1.00	P	350Y	1	0.01	F10Y22	1	0.01
100B	MANPGR	PRIM	1.00	P	350Y	1	0.02	F10Y22	1	0.02
100B	MANPGR	PRIM	1.00	P				F10438	1	0.02
100C	MANPGR	DRY	1.00	P	1			F10Y22	1	1.00
100E	MANPGR	PN11	1.00	P	350Y	1	0.02	F10Y22	1	0.02
100E	MANPGR	PN11	1.00	P				F10438	1	0.02
100F	MANPGR	PN12	1.00	P	350Y	1	0.02	F10Y22	1	0.02
100F	MANPGR	PN12	1.00	P				F10437	1	0.02
100G	MANPGR	DRY	1.00	P	U.S			F10Y22	1	0.50
100H	MANPGR	SRP	1.00	P	YHUY	1	0.03	F10Y22	1	0.03
100I	MANPGR	UNLD	1.00	P				F10Y59	1	0.10
120	MANPGR	INSI	1.00	P	YHUY	1		F10Y40	1	0.10
120	MANPGR	INSI	1.00	P			0.10	6400004	1	0.10

SECRET

REF ID: A68097

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1004	MANIPGP	1.00	P	3SU7	1	U.01	PMU722	1	U.01
1004	MANIPGP	1.00	P	3SU7		U.02	PMU722	1	U.02
1008	MANIPGP	1.00	P				PMU438	1	U.02
1008	MANIPGP	1.00	P				PMU722	1	1.00
100C	MANIPGP	1.00	P				PMU722	1	U.02
100D	MANIPGP	1.00	P	3SU7	1	U.02	PMU436	1	U.02
100E	MANIPGP	1.00	P				PMU722	1	U.02
100F	MANIPGP	1.00	P				PMU722	1	U.02
100F	MANIPGP	1.00	P	3SU7	1	U.02	PMU722	1	U.02
100F	MANIPGP	1.00	P	3SU7	1	U.02	PMU437	1	U.02
100G	MANIPGP	1.00	P	U.S			PMU722	1	U.00
100H	MANIPGP	1.00	P	YHUY	1	U.03	PMU722	1	U.03
100I	MANIPGP	1.00	P				PMU757	1	U.10
120	MANIPGP	1.00	P	YHUY	1	U.10	PMU740	1	U.10
120	MANIPGP	1.00	P				WAAUUU4	1	U.10

File: 10-11-11

File name: 1610214, Wk

ALL: UN

5:17:44M: 2.7M

187.88:31400.71 NJ71:91:0700

187.88: 71407.717

NAME:
PUN:

PLN: 64543N

UP	KCU	UP	DESC	UCLD	UP	MANID	FLOW	SKIL	UTIL	TIME	EQUIP	QTY	%	TIME	REQ
#				PAC	TYPE	%	HRS	CODE		%	CODE			HRS	HRS
UU05	MANP'GW	UTS	1.00	P				HBUS	1	100	PMU9Z1	1	100	0.08	0.08
UU05A	MANP'GW	TRANS	1.00	I							PMU9Z1	1	100	0.08	0.08
UU05B	MANP'GW	LUAD	1.00	P				HBUS	1	100	PMU4Z6	1	100	0.04	0.04
UU05C	MANP'GW	PRUC	1.00	P	100	0.5					PMU4Z6	1	100	0.50	0.50
UU05D	MANP'GW	UNLD	1.00	I							PMU9Z1	1	100	0.08	0.08
UU05E	MANP'GW	UNLD	1.00	P				HBUS	1	100	PMU4Z6	1	100	0.08	0.08
UU06	MANP'GW	REM	1.00	S				HBUS	1	100	HB00U1	1	100	0.04	0.04
UU06	MANP'GW	REM	1.00	P				HBUS	1	100	HB00U1	1	100	0.04	0.04
UU06A	MANP'GW	LUAD	1.00	I							PMU9Z1	1	100	0.08	0.08
UU06A	MANP'GW	LUAD	1.00	P				KIUS	1	100	PMU9U1	1	100	0.08	0.08
UU07	MANP'GW	PRUC	1.00	I							PMU9U1	1	100	3.43	3.43
UU07	MANP'GW	PRUC	1.00	S				KIUS	1	100					
UU07	MANP'GW	PRUC	1.00	P	100	2.87					PMUe16	1	100	3.47	3.47
UU07A	MANP'GW	UNLD	1.00	I							PMU9U1	1	100	0.08	0.08
UU07A	MANP'GW	UNLD	1.00	P				KIUS	1	100	C000U2	1	100	0.08	0.08
UU07B	MANP'GW	LUAD	1.00	I							C000U2	1	100	0.02	0.02
UU07B	MANP'GW	LUAD	1.00	P				KIUS	1	100	PMU416	1	100	0.08	0.08
UU07	MANP'GW	CLN	1.00	S				KIUS	1	100					
UU07	MANP'GW	CLN	1.00	P				KIUS	1	20	PMU416	1	20	0.15	0.15
UU07	MANP'GW	CLN	1.00	P				KIUS	1	80	PMU416	1	80	0.25	0.25
UU07	MANP'GW	UNLD	1.00	I							C000U2				
UU07A	MANP'GW	UNLD	1.00	P				KIUS	1	100	PMU416	1	100	0.04	0.04
UU07A	MANP'GW	LUAD	1.00	I							C000U2				
UU07B	MANP'GW	LUAD	1.00	P				KIUS	1	100	PMU9U1	1	100	0.08	0.08
UU07B	MANP'GW	REMV	0.07	I				JAU7	1	0.06					
UU07B	MANP'GW	REMV	0.07	S				JAU0	1	1.04	PMU177	1		1.04	1.04
UU07B	MANP'GW	REMV	0.07	P				JAU0	1	0.85	PMU177	1		0.85	0.85
UU11	MANP'GW	CLN	0.10	I							C000U2	1	100	0.05	0.05
UU11	MANP'GW	CLN	0.10	I							PMU9U1	1	100	0.08	0.08
UU11	MANP'GW	CLN	0.10	S				KIUS	1	100					
UU11	MANP'GW	CLN	0.10	P				KIUS	1	80	PMU416	1	80	0.05	0.05
UU11	MANP'GW	CLN	0.10	P				KIUS	1	20	PMU416	1	20	0.10	0.10
UU12	MANP'GW	PRUC	1.00	I							PMU9U1	1	100	1.03	1.03
UU12	MANP'GW	PRUC	1.00	S				KIUS	1	100					
UU12	MANP'GW	PRUC	1.00	P	100	0.86					PMU9U0	1	100	1.03	1.03
UU15	MANP'WA	FP1	0.75	I							PMU9U1	1		0.02	0.02
UU15	MANP'WA	FP1	0.75	P				DBUY	2	0.05	PMU9U1	1		1.05	1.05
UU15	MANP'WA	FP1	0.75	P							PMU679E	1		1.05	1.05
UU15A	MANP'WA	FP1	0.25	I							PMU9U1	1		0.02	0.02
UU15A	MANP'WA	FP1	0.25	P				DBUY	1	0.10	PMU9U1	1		1.10	1.10
UU15A	MANP'WA	FP1	0.25	P							PMU679E	1		1.10	1.10
UU16	MANP'GW	UNLD	1.00	P				KIUS	1	100	PMU9U1	1	100	0.08	0.08
UU16A	MANP'GW	LUAD	1.00	P				KIUS	1	100	C000U2	1	100	0.05	0.05
UU17	MANP'GW	CLN	1.00	I							C000U2	1	100	0.08	0.08
UU17	MANP'GW	CLN	1.00	P				KIUS	1	80	PMU410	1	80	0.50	0.50
UU17	MANP'GW	CLN	1.00	P				KIUS	1	20	PMU410	1	20	0.75	0.75
UU17A	MANP'GW	TRANS	1.00	I							C000U2	1	100	0.08	0.08

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File name: 16106 N.

File name: 16106 N.

NAME:		ALU: UU		KCU: WHEELS		WCU: 16106N		WCU DATE: 88245	
PLN: 67575A		UP		UP		UP		UP	
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#		FAC		TYPE		FLW		SKIL	
		HRS		%		HRS		CODE	
		TIME		%		TIME		HRS	
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NAME: YUIUIA
FUN: YUIUIA

ALL: UN

KLUL:WHELS

WCD: 21101N WCDDATE: 88354

February 21/10/1911, 11:45

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REF: YULVIA

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WLD: 21103N WLDUAE: 222237

UP	#	KCC	UP	DESC	UCCU	UP	MAND	FLOW	SKIL	TIME	REK	EQUIP	TIME	REK
					FAC	TYPE	%	HRS	CODE	%	HRS	CODE	%	HRS
U05	MANP3W		U15	1.00	P				HB05	1 100	0.08	M100Y21	1 100	0.08
U05A	MANP3W		IRANS	1.00	I							M100Y21	1 100	0.08
U05B	MANP3W		LUAD	1.00	P				HB05	1 100	0.04	M100426	1 100	0.04
U05C	MANP3W		PRUC	1.00	P		100	0.5				M100426	1 100	0.50
U05D	MANP3W		UNLD	1.00	I							M100Y21	1 100	0.08
U05E	MANP3W		UNLD	1.00	P				HB05	1 100	0.08	M100426	1 100	0.08
U06	MANP3W		REM	1.00	S				HB05	1 100	0.04			
U06A	MANP3W		REM	1.00	P				HB05	1 100	0.04	M100001	1 100	0.04
U06B	MANP3W		LUAD	1.00	I							M100Y21	1 100	0.08
U06C	MANP3W		LUAD	1.00	P				K105	1 100	0.08	M100Y01	1 100	0.08
U06D	MANP3W		PRUC	1.00	I							M100Y01	1 100	2.89
U06E	MANP3W		PRUC	1.00	S			2.89	K105	1 100	0.08			
U06F	MANP3W		PRUC	1.00	P		100					M100616	1 100	2.89
U06G	MANP3W		UNLD	1.00	I							M100Y01	1 100	0.08
U06H	MANP3W		UNLD	1.00	P				K105	1 100	0.08	C000002	1 100	0.08
U06I	MANP3W		LUAD	1.00	I				K105	1 100	0.03	C000002	1 100	0.03
U06J	MANP3W		LUAD	1.00	P							M100416	1 100	0.03
U06K	MANP3W		CLN	1.00	S				K105	1 100	0.04			
U06L	MANP3W		CLN	1.00	P				K105	1 50	0.16	M100416	1 50	0.16
U06M	MANP3W		CLN	1.00	P				K105	1 50	0.08	M100416	1 50	0.08
U06N	MANP3W		LUAD	1.00	P				K105	1 100	0.08	M100Y01	1 100	0.08
U06O	MANP3A		REMU	0.50	I				JAU5	1	0.02		1	0.02
U06P	MANP3A		REMU	0.50	S				JAU5	1	0.28	M101788	1	0.28
U06Q	MANP3A		REMU	0.50	P			0.05	JAU5	1	0.24	M101788	1	0.24
U06R	MAN		ELM	0.50	P									
U06S	MANP3W		PRUC	1.00	I							M100Y01	1 100	1.03
U06T	MANP3W		PRUC	1.00	S				K105	1 100	0.08			
U06U	MANP3W		PRUC	1.00	P		100	0.86				M100Y01	1 100	1.03
U06V	MANP3A		FP1	0.75	I							M100Y01	1	0.02
U06W	MANP3A		FP1	0.75	P							M100679E	1	1.05
U06X	MANP3A		FP1	0.75	P				DB0Y	1	0.10	M100Y01	1	1.05
U06Y	MANP3A		FP1	0.25	I							M100Y01	1	0.02
U06Z	MANP3A		FP1	0.25	P				DB0Y	1	0.10	M100Y01	1	1.10
U06A	MANP3W		UNLD	1.00	I							M100679E	1	1.10
U06B	MANP3W		UNLD	1.00	P							C000002	1 100	0.04
U06C	MANP3W		LUAD	1.00	P				K105	1 100	0.04	M100Y01	1 100	0.04
U06D	MANP3W		LUAD	1.00	S				K105	1 100	0.04	M100410	1 100	0.04
U06E	MANP3W		CLN	1.00	P				K105	1 50	0.25	M100410	1 50	0.25
U06F	MANP3W		CLN	1.00	P				K105	1 50	0.15	M100410	1 50	0.15
U06G	MANP3W		UNLD	1.00	I							C000002	1 100	0.08
U06H	MANP3W		UNLD	1.00	P				K105	1 100	0.05	M100410	1 100	0.05
U06I	MANP3W		IRANS	1.00	I							C000002	1 100	0.08
U06J	MANP3W		INSP	1.00	P				U107	1 60	0.35			
U06K	MANP3W		INSP	1.00	P				U107	1 40	0.15			
U06L	MANP3W		LUAD	1.00	P				U107	1 100	0.08	M100Y01	1 100	0.08
U06M	MANP3A		PUL1	1.00	I			0.02	JAU5	1	0.02			
U06N	MANP3A		PUL1	1.00	S			0.28	JAU5	1	0.28			
U06O	MANP3A		PUL1	1.00	P			0.3	JAU5	1	0.30			

[illegible]

20

NAME: YULIA
PUNK: YULIA

ALL: UN

STATHM: 77M

WLD: 117: 00M
N41117: 00M
/E788: 10007M

UP #	KCU	UP	DESC	UCCU	UP TYPE	UP MAND	FLOW	SKIL	TIME	REU	EQUIP	TIME	REU
				PAC	%	HRS	HRS	CODE	WTY	%	WTY	%	HRS
U05	MANPFW	U15		1.00	P			HBUS	1	100	PMU921	1	100
U05A	MANPFW	IMANS		1.00	I						PMU921	1	100
U05B	MANPFW	LUAD		1.00	P			HBUS	1	100	PMU426	1	100
U05C	MANPFW	PKUC		1.00	P	100	0.5				PMU426	1	100
U05D	MANPFW	UNLD		1.00	I						PMU921	1	100
U05E	MANPFW	UNLD		1.00	P			HBUS	1	100	PMU426	1	100
U06	MANPFW	REM		1.00	S			HBUS	1	100			
U06A	MANPFW	REM		1.00	P			HBUS	1	100	PMU001	1	100
U06B	MANPFW	LUAD		1.00	I			HBUS	1	100	PMU921	1	100
U06C	MANPFW	LUAD		1.00	P			KIUS	1	100	PMU901	1	100
U06D	MANPFW	PKUC		1.00	I						PMU901	1	2.89
U06E	MANPFW	PKUC		1.00	S		2.89	KIUS	1	100			
U06F	MANPFW	PKUC		1.00	P	100					PMU616	1	2.89
U06G	MANPFW	UNLD		1.00	I						PMU901	1	100
U06H	MANPFW	UNLD		1.00	P			KIUS	1	100	CUUU02	1	100
U06I	MANPFW	LUAD		1.00	I			KIUS	1	100	CUUU02	1	100
U06J	MANPFW	CLN		1.00	S			KIUS	1	100	PMU416	1	100
U06K	MANPFW	CLN		1.00	P			KIUS	1	50	PMU416	1	50
U06L	MANPFW	CLN		1.00	P			KIUS	1	50	PMU416	1	50
U06M	MANPFW	LUAD		1.00	P			KIUS	1	100	PMU901	1	100
U06N	MANPFW	PKUC		1.00	I						PMU901	1	100
U06O	MANPFW	PKUC		1.00	S		0.86	KIUS	1	100			
U06P	MANPFW	PKUC		1.00	P	100					PMU690	1	100
U06Q	MANPFW	PMI		0.75	I						PMU901	1	0.02
U06R	MANPFW	PMI		0.75	P			DBUY	2	0.05	PMU901	1	1.05
U06S	MANPFW	PMI		0.75	P						PMU69/E	1	1.05
U06T	MANPFW	PMI		0.25	I						PMU901	1	0.02
U06U	MANPFW	PMI		0.25	P						PMU69/E	1	1.10
U06V	MANPFW	PMI		0.25	P			DBUY	1	0.10	PMU901	1	1.10
U06W	MANPFW	UNLD		1.00	I						CUUU02	1	100
U06X	MANPFW	UNLD		1.00	P			KIUS	1	100	PMU901	1	100
U06Y	MANPFW	LUAD		1.00	S			KIUS	1	100	PMU410	1	100
U06Z	MANPFW	CLN		1.00	P			KIUS	1	50	PMU410	1	50
U07	MANPFW	CLN		1.00	P			KIUS	1	50	PMU410	1	50
U07A	MANPFW	UNLD		1.00	I						CUUU02	1	100
U07B	MANPFW	UNLD		1.00	P			KIUS	1	100	PMU410	1	100
U07C	MANPFW	IMANS		1.00	I						CUUU02	1	100
U07D	MANPFW	INSP		1.00	P			D107	1	40			
U07E	MANPFW	INSP		1.00	P			D107	1	60			
U07F	MANPFW	LUAD		1.00	P			D107	1	100	PMU901	1	100
U07G	MANPFW	IMRD		0.05	I		0.06	JAU7	1	0.06			
U07H	MANPFW	IMRD		0.05	S		0.28	JAU7	1	0.28	PM25/6	1	0.28
U07I	MANPFW	IMRD		0.05	P		0.84	JAU7	1	0.84	PM25/6	1	0.84
U07J	MANPFW	REMU		0.05	I		0.02	JAU8	1	0.02			
U07K	MANPFW	REMU		0.05	S		0.28	JAU8	1	0.28			
U07L	MANPFW	REMU		0.05	S		0.34	JAU8	1	0.34			
U07M	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07N	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07O	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07P	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07Q	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07R	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07S	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07T	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07U	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07V	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07W	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07X	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07Y	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U07Z	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08A	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08B	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08C	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08D	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08E	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08F	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08G	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08H	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08I	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08J	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08K	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08L	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08M	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08N	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08O	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08P	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08Q	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08R	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08S	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08T	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08U	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08V	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08W	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08X	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08Y	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U08Z	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09A	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09B	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09C	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09D	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09E	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09F	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09G	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09H	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09I	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09J	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09K	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09L	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09M	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09N	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09O	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09P	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09Q	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09R	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09S	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09T	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09U	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09V	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09W	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09X	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09Y	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U09Z	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10A	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10B	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10C	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10D	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10E	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10F	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10G	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10H	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10I	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10J	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10K	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10L	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10M	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10N	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10O	MANPFW	REMU		0.05	P		0.02	JAU8	1	0.02			
U10P	MANPFW	REMU											

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100	MANPGR	INSI	1.00	P	0.00	YHUY	1	1.00	PM1500	1	0.00
101	MANPGR	MAUH	0.05	P	0.02	JH10	1	0.02		1	0.00
102	MANPGR	MAUH	0.05	S	0.24	JH10	1	0.24	PM1500	1	0.24
103	MANPGR	MAUH	0.05	S	0.00	JH10	1	0.00	PM1500	1	0.00
104	MANPGR	INSI	0.05	P	0.02	JHUY	1	0.02		1	0.02
105	MANPGR	INSI	0.05	S	0.10	JHUY	1	0.10	PM1500	1	0.10
106	MANPGR	INSI	0.05	P	0.08	JHUY	1	0.08	PM1500	1	0.08
107	MANPGR	INSI	1.00	P	0.02	JHUY	1	0.02		1	0.02
108	MANPGR	INSI	1.00	S	0.31	JHUY	1	0.31	PM1500	1	0.31
109	MANPGR	INSI	1.00	P	0.43	JHUY	1	0.43	PM1500	1	0.43
110	MANPGR	MUVE	1.00	P	0.10	UVDH	1	0.10	FL0001	1	0.10
111	MANPGR	LUAD	1.00	P	0.10	YHUY	1	0.10	PM0431	1	0.10
112	MANPGR	HEAT	1.00	P							
113	MANPGR	HEAT	1.00	P							
114	MANPGR	INSI	1.00	P	0.01	YHUY	1	0.01	PM0430	1	0.01
115	MANPGR	UNLD	1.00	P							
116	MANPGR	LUAD	1.00	P	0.01	SSUY	1	0.01	PM0430	1	0.01
117	MANPGR	WASH	1.00	P							
118	MANPGR	WASH	1.00	P	0.01	SSUY	1	0.01	PM0430	1	0.01
119	MANPGR	WASH	1.00	P	0.01	SSUY	1	0.01	PM0430	1	0.01
120	MANPGR	WASH	1.00	P	0.01	SSUY	1	0.01	PM0430	1	0.01
121	MANPGR	PRIM	1.00	P	0.02	SSUY	1	0.02	PM0430	1	0.02
122	MANPGR	PRIM	1.00	P							
123	MANPGR	DRY	1.00	P	1						
124	MANPGR	PAIN	1.00	P							
125	MANPGR	PAIN	1.00	P	0.02	SSUY	1	0.02	PM0430	1	0.02
126	MANPGR	PAIN	1.00	P							
127	MANPGR	PAIN	1.00	P	0.02	SSUY	1	0.02	PM0430	1	0.02
128	MANPGR	DRY	1.00	P	0.02	SSUY	1	0.02	PM0430	1	0.02
129	MANPGR	STRIP	1.00	P							
130	MANPGR	UNW	1.00	P	0.02	YHUY	1	0.02	PM0430	1	0.02
131	MANPGR	INSI	1.00	P							
132	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
133	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
134	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
135	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
136	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
137	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
138	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
139	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
140	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
141	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
142	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
143	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
144	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
145	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
146	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
147	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
148	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
149	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10
150	MANPGR	INSI	1.00	P	0.10	YHUY	1	0.10	PM0430	1	0.10

[illegible]

[illegible]

File: 151011.WK1
 10/10/10 10:10:10

NAME: 155Y2A WLD: 15152N WCDUHE:88201
 ALL: UU RCU:WHEELS

UP	W	RCU	DESC	UP	UCCU	PAC	TYPE	UP	MANU	FLOW	SKIL	CODE	TIME	REV	TIME	REV
UU5	MANPFW		UTS	1.00	P						HBUS		1 100	0.08	PMU921	1 100 0.08
UU5A	MANPFW		IRAN	1.00	I										PMU921	1 100 0.08
UU5B	MANPFW		LUAD	1.00	P						HEUS		1 100	0.04	PMU425	1 100 0.04
UU5C	MANPFW		PRUC	1.00	P		100	0.5							PMU425	1 100 0.50
UU5D	MANPFW		UNLD	1.00	I						HBUS		1 100	0.08	PMU921	1 100 0.08
UU5E	MANPFW		UNLD	1.00	P						HBUS		1 100	0.08	PMU425	1 100 0.08
UU6	MANPFW		REM	1.00	S						HBUS		1 100	0.04	PMU001	1 100 0.04
UU6A	MANPFW		REM	1.00	P						HBUS		1 100	0.04	PMU921	1 100 0.08
UU6B	MANPFW		LUAD	1.00	I										PMU901	1 100 0.08
UU6A	MANPFW		LUAD	1.00	P						KIUS		1 100	0.08	PMU901	1 100 3.47
UU7	MANPFW		PRUC	1.00	I						KIUS		1 100	0.08		
UU7	MANPFW		PRUC	1.00	S										PMU616	1 100 3.47
UU7	MANPFW		PRUC	1.00	P		100	2.89							PMU901	1 100 0.08
UU7B	MANPFW		UNLD	1.00	I						KIUS		1 100	0.08	CUUUU2	1 100 0.08
UU7B	MANPFW		UNLD	1.00	P										CUUUU2	1 100 0.02
UU7C	MANPFW		LUAD	1.00	I						KIUS		1 100	0.02	PMU416	1 100 0.02
UU7C	MANPFW		LUAD	1.00	P						KIUS		1 100	0.05		
UU7	MANPFW		CLN	1.00	S						KIUS		1 50	0.08	PMU416	1 50 0.08
UU7	MANPFW		CLN	1.00	P						KIUS		1 50	0.16	CUUUU2	1 100 0.04
UU7	MANPFW		CLN	1.00	P						KIUS		1 100	0.04	PMU416	1 100 0.04
UU7A	MANPFW		UNLD	1.00	I						KIUS		1 100	0.08	CUUUU2	1 100 0.08
UU7A	MANPFW		UNLD	1.00	P						KIUS		1 100	0.08	PMU901	1 100 0.08
UU7B	MANPFW		LUAD	1.00	I						KIUS		1 100	0.08	PMU901	1 100 0.72
UU7B	MANPFW		LUAD	1.00	P						KIUS		1 100	0.08		
UU7C	MANPFW		PRUC	1.00	I						KIUS		1 100	0.08	HUUUU1	1 100 0.72
UU7C	MANPFW		PRUC	1.00	S										PMU901	1 100 0.02
UU7B	MANPFW		PRUC	1.00	P		100	0.6							PMU901	1 100 0.02
UU7	MANPFW		FPI	0.75	I						UBUY		2	0.05	PMU901	1 1.05
UU7	MANPFW		FPI	0.75	P										PMU679E	1 1.05
UU7	MANPFW		FPI	0.75	P										PMU901	1 0.02
UU7A	MANPFW		FPI	0.25	I						UBUY		1	0.10	PMU901	1 1.10
UU7A	MANPFW		FPI	0.25	P										PMU679E	1 1.10
UU7A	MANPFW		FPI	0.25	P										PMU901	1 0.03
UU7B	MANPFW		UNLD	1.00	I										PMU901	1 0.04
UU7B	MANPFW		UNLD	1.00	P										PMU901	1 0.20
UU7B	MANPFW		EDDY	1.00	I						DN10		1	0.10	PMU921	1 0.10
UU7B	MANPFW		EDDY	1.00	P										PMU901	1 100 0.08
UU7B	MANPFW		UNLD	1.00	I						KIUS		1 100	0.08	CUUUU2	1 100 0.02
UU7B	MANPFW		UNLD	1.00	P										CUUUU2	1 100 0.02
UU7B	MANPFW		LUAD	1.00	I						KIUS		1 100	0.02	PMU416	1 100 0.02
UU7B	MANPFW		LUAD	1.00	P						KIUS		1 100	0.08	PMU416	1 100 0.08
UU7B	MANPFW		CLN	1.00	P						KIUS		1 100	0.08	PMU416	1 100 0.02
UU7B	MANPFW		UNLD	1.00	I						KIUS		1 100	0.02	CUUUU2	1 100 0.02
UU7B	MANPFW		UNLD	1.00	P						KIUS		1 100	0.02	CUUUU2	1 100 0.02
UU7B	MANPFW		IRAN	1.00	I						KIUS		1	0.05	PMU901	1 0.05
UU7B	MANPFW		IRAN	1.00	P										PMU901	1 0.20
UU7B	MANPFW		MAGN	1.00	I										PMU901	1 0.05
UU7B	MANPFW		MAGN	1.00	P										PMU901	1 0.05

U4UA	MANPFW	LUAD	1.00	1	U1U	0.08	0.00002	1	100	0.003
U4UA	MANPFW	LUAD	1.00	F	U4UY	PMU7U1	1	100	0.003	
U47	KA	META	0.03	1		0.06				
U47	MANPKA	META	0.03	S	U4UY	0.28	PM5197	1	0.28	
U47	MANPKA	META	0.03	F	U4UY	0.30	PM5197	1	0.30	
U6U	MANPKA	REAM	0.46	1	J41U	0.02				
U6U	MANPKA	REAM	0.46	S	J41U	0.36	PM5197	1	0.36	
U6U	MANPKA	REAM	0.46	F	J41U	2.12	PM5197	1	2.12	
U7U	MANPKA	MACH	0.03	1	J41U	0.02				
U7U	MANPKA	MACH	0.03	S	J41U	0.30	PM4136	1	0.30	
U7U	MANPKA	MACH	0.03	F	J41U	0.61	PM4136	1	0.61	
U7UA	MANPFW	LN	0.46	1	HBUD	0.02	PMU7U1	1	0.03	
U7UA	MANPFW	LN	0.46	F		0.25	PMU7U1	1	0.33	
U8U	MANPKA	FP1	0.46	1			PMU7U1	1	0.02	
U8U	MANPKA	FP1	0.46	F			PMU6.9E	1	1.03	
U8U	MANPKA	FP1	0.46	F	UBUY	0.10	PMU7U1	1	1.07	
UYU	MANPKA	BEAK	1.00	1	J41U	0.02				
UYU	MANPKA	BEAK	1.00	S	J41U	1.04	PM5197	1	1.04	
UYU	MANPKA	BEAK	1.00	F	J41U	0.89	PM5197	1	0.89	
11U	MANPKA	BEAK	1.00	1	J41U	0.02				
11U	MANPKA	BEAK	1.00	S	J41U	1.04	PM5197	1	1.04	
11U	MANPKA	BEAK	1.00	F	J41U	0.83	PM5197	1	0.83	
13U	MANPKA	KEPA	0.46	1	J41U	0.02				
13U	MANPKA	KEPA	0.46	S	J41U	0.36	PM5197	1	0.36	
13U	MANPKA	KEPA	0.46	F	J41U	5.31	PM5197	1	2.31	
14U	MANPKA	BEAK	0.46	1	J41U	0.02				
14U	MANPKA	BEAK	0.46	S	J41U	0.80	PM2576	1	0.80	
14U	MANPKA	BEAK	0.46	F	J41U	0.79	PM2576	1	0.79	
17U	MANPFW	UUMN	1.00	1	HBUD	0.30				
17U	MANPFW	PRUC	1.00	1			PMU7U1	1	100	
17U	MANPFW	PRUC	1.00	S		0.08			1.26	
17U	MANPFW	PRUC	1.00	F	K1UD	100	0.08	1	100	
17U	MANPFW	UUMN	1.00	F			HU00U1	1	100	
18U	MANPFW	LUAD	1.00	F	HBUD	0.30	PMU7U1	1	0.30	
18U	MANPFW	LUAD	1.00	F	Y6UY	0.10	PMU732	1	0.10	
18UA	MANPFW	LN	1.00	F	Y6UY	0.30	PMU313	1	0.30	
18UB	MANPFW	PRUC	1.00	S	Y6UY	0.70	PM1342	1	0.70	
18UB	MANPFW	PRUC	1.00	F	Y6UY	0.10	PM1342	1	1.30	
18UC	MANPFW	LN	1.00	F	Y6UY	0.10	PM6613	1	0.10	
18UD	MANPFW	LUKE	1.00	F			PM6614	1	0.10	
18UE	MANPFW	LN	1.00	F	Y6UY	0.10	U1U0U1	1	1.30	
18UE	MANPFW	LN	1.00	F		0.3	PMU3U3	1	0.20	
18UE	MANPFW	LN	1.00	F	Y6UY	0.10	PM6612	1	0.10	
19U	MANPKA	INSI	1.00	1	JAUB	0.02				
19U	MANPKA	INSI	1.00	S	JAUB	0.19	PM5685		0.19	
19U	MANPKA	INSI	1.00	F	JAUB	0.08	PM5685		0.08	
19S	MANPKA	MACH	1.00	1	J41U	0.02				
19S	MANPKA	MACH	1.00	S	J41U	0.30	PM7276	1	0.30	
19S	MANPKA	MACH	1.00	F	J41U	0.24	PM7276	1	0.24	
20U	MANPKA	INSI	1.00	1	U4UY	0.02				
20U	MANPKA	INSI	1.00	S	U4UY	0.19	PM5685	1	0.19	
20U	MANPKA	INSI	1.00	F	U4UY	0.08	PM5685	1	0.08	
20S	MANPKA	INSI	1.00	1	U4UY	0.02				
20S	MANPKA	INSI	1.00	S	U4UY	0.19	PM5685	1	0.19	
20S	MANPKA	INSI	1.00	F	U4UY	0.08	PM5685	1	0.08	
21U	MANPKA	MACH	1.00	1	J41U	0.02				
21U	MANPKA	MACH	1.00	S	J41U	0.30	PM7276	1	0.30	
21U	MANPKA	MACH	1.00	F	J41U	0.24	PM7276	1	0.24	
21S	MANPKA	INSI	1.00	1	U4UY	0.02				
21S	MANPKA	INSI	1.00	F	U4UY	0.19	PM5685	1	0.19	

KC-135 NLG NOSE WHEEL

BILL OF MATERIALS

15592A

* = MHI

ROUTED	ITEM	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	PER OF	YIELD	SCRAP	PART	IMIC	REV	EFFECTIVITY	TECH	OKO	PENDING	PENDING	PENDING	AFTO	22
	10	1211A2303		1630004210319	173808	WHEEL ASSY	11	1EA													
	1.1	IN.P.L.		IN.S.L.		WHEEL HALF ASSY. (I.B.)	11	1EA													
	1.2	42620		13110001437585	160038	CLIP, WHEEL BEARING	11	1EA													
	1.2	1211A252		15365006558114	173808	RING, RETAINING	11	1EA													
	1.2	1211A250		15310006533209	173808	PLATE, RETAINING	12	1EA													
	1.2	1211A251		15330006180671	173808	FELT, MECHANICAL	11	1EA													
	1.2	1212A831-1		IN.S.L.		WEIGHT, BALANCE	12	ARI													
	1.2	1212A831-2		IN.S.L.		WEIGHT, BALANCE	11	ARI													
	1.2	1212A831-3		IN.S.L.		WEIGHT, BALANCE	11	ARI													
	1.2	IN.P.L.		IN.S.L.		WHEEL HALF SUBASSY (I.B.)	11	1EA													
	1.3	16829496-01		13120001321919	198747	BUSHING, TIEBOLT	112	AR1EA													
	1.3	IN.P.L.		IN.S.L.		BUSHING & CLIP ASSY (PSEUDO)	11	ARI													
	1.4	163831152-79		IN.S.L.	198747	BUSHING, BEARING CLIP	11	1EA													
	1.4	42620		13110001437585	160038	CLIP, BEARING	11	ARI													
	1.3	IN.P.L.		IN.S.L.		BUSHING & CLIP ASSY (PSEUDO)	11	ARI													
	1.4	1779019-01		IN.S.L.		BUSHING, CLIP & LOCKRING	11	1EA													
	1.4	42620		13110001437585	160038	CLIP, BEARING	11	1EA													
	1.3	1211A245-1		11630012427804	173808	WHEEL HALF (I.B.)	11	1EA													
	1.1	IN.P.L.		IN.S.L.		WHEEL HALF ASSY (O.B.)	11	1EA													
	1.2	129520		13110001000569	160038	CLIP, WHEEL BEARING	11	1EA													
	1.2	12044878		15365005150151	173808	RING, RETAINING	11	1EA													
	1.2	12044875		11630006965810	173808	CAP, HUB	11	1EA													
	1.2	1212A831-1		IN.S.L.		WEIGHT, BALANCE	12	1EA													
	1.2	1212A831-2		IN.S.L.		WEIGHT, BALANCE	11	1EA													
	1.2	1212A831-3		IN.S.L.		WEIGHT, BALANCE	11	1EA													
	1.2	IN.P.L.		IN.S.L.		WHEEL HALF SUBASSY (O.B.)	11	1EA													
	1.3	16829496-01		13120001321919	198747	BUSHING, TIEBOLT	112	AR1EA													
	1.3	IN.P.L.		IN.S.L.		BUSHING & CLIP ASSY (PSEUDO)	11	ARI													
	1.4	163831152-75		IN.S.L.	198747	BUSHING, BEARING CLIP	11	1EA													
	1.4	129520		13110001000569	160038	CLIP, BEARING	11	1EA													
	1.3	1211A244-3		11630012427813	173808	WHEEL HALF (O.B.)	11	1EA													
	1.1	17753-03		12640000218295	179934	VALVE ASSY, PNEUMATIC	11	1EA													
	1.2	165		11650002224525	179934	CAP, VALVE	11	1EA													
	1.2	164		12640008105861	179934	INSIDE, VALVE	11	1EA													
	1.2	1753		IN.S.L.	179934	STEER, VALVE	11	1EA													
	1.2	186-30		12640000218295	179934	PACKING, PREFORMED	11	1EA													
	1.1	18627436-4		12640001219430	196906	VALVE, PNEUMATIC (O.S.)	11	AR1EA													
	1.1	1801-070		15310005966861	172962	NUT, SELF-LOCKING	112	1EA													
	1.1	180960-716		15310001670822	188044	WASHER, FLAT	124	1EA													
	1.1	180101424		15306002064904	188044	BOLT, MACHINE	112	1EA													
	1.1	12126767		15330005840459	173808	PACKING, PREFORMED	11	1EA													

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

CONTROL NUMBER LIST

ABC	IN	CONTROL JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G019
		NUMBER	DESC					FLOW DAYS
ENS	RIGB	15585A	-J	F-106 MLG	BRAKE ASSY	1630-00-165-1029	151806-2	481-4-223 24
ENS	RIGB	15587A	-G-J	F-111 MLG	BRAKE PRESSURE PLATE	1630-00-264-0752	329-16-1	481-2-483 19
ENS	PRIC	15592A	-G-J	KC-135 MLG	WHEEL	1630-00-421-0319	211A243M3	4M3-7-113 30
ENS	RIGB	15601A	-G-J	T-39 MLG	BRAKE ASSY	1630-00-553-4734	9550338-1	481-2-1073 28
ENS	RIGB	15603A	-G-J	KC-135 MLG	BRAKE BACKING PLATE	1630-00-591-8349	2601844	481-4-263 16
ENS	RIGB	15616A	-J	C-141 MLG	BRAKE BACKING PLATE	1630-00-567-8162	9533668	481-2-373 19
ENS	RIGB	15621A	-J	F-106 MLG	BRAKE PRESSURE PLATE	1630-00-671-2838	151804	481-4-223 16
ENS	RIGB	15639A	-G-J	C-130 MLG	BRAKE PRESSURE PLATE	1630-01-005-4188	5002564	481-2-1003 16
ENS	RIGB	15641A	-J	F-4 MLG	BRAKE HOUSING SUB ASSY	1630-00-276-9849	5001896	481-2-1093 23
ENS	RIGB	15642A	-G-J	C-130 MLG	BRAKE BACKING PLATE	1630-01-005-4189	5000263	481-2-1003 19
ELE		15643A	-G-J	F-15 MLG	WHEEL	1630-00-123-8803	17 OCT 88	4M1-8-73 22
ENS	RIGB	15644A	-J	F-15 MG A/B	BRAKE HOUSING	1630-00-123-8806	5002269	481-2-1123 16
DOP	PRIC	15651A	-J	F-15 MLG	WHEEL	1630-00-558-2584	5000960-2	4M3-8-23 20
ENS	PRIC	15652A	-G-J	F-15 MLG	WHEEL	1630-01-005-4262	5000864	4M1-8-73 20
ENS	COOP	15677A		A-7 MLG	STRUT ASSY	1620-01-174-1655	8121017-30	4S1-90-3 30
ENS	COOP	15678A		A-7 MLG	STRUT ASSY	1620-01-174-3170	8121017-10	4S1-90-3 0
ENS	PRIC	15686A	-G-J	A-10 MLG	WHEEL	1630-00-596-9637	3-1358	4M3-4-433 16
ENS	RIGB	15698A	-G-J	C-5A MLG	BRAKE ASSY	1630-01-041-4570	2-1179-4	481-2-1063 26
ENS	RIGB	15728A	-J	C-130 MLG	BRAKE HOUSING	1630-00-937-6604	9543433	481-2-1003 16
ENS	RIGB	15744A	-J	F-15 MG A/B	BRAKE ASSY	1630-01-050-5274	5000913-12	481-2-1123 13
ENS	RIGB	15746A	-J	C-141 MLG	WHEEL	1630-01-081-6687	3-1095	4M3-7-1043 20
ENS	RIGB	15747A	-J	F-15 MLG	BRAKE BACKING PLATE	1630-00-132-2821	5002483	481-2-1123 16
ENS	RIGB	15749A	-J	F-5 MLG	BRAKE ASSY	1630-00-227-2000	AA319196	481-2-453 20
ENS	RIGB	15752A	-G-J	A-10 MLG	BRAKE ASSY	1630-01-062-7046	5002372-5	481-2-1143 27
ENS	PRIC	15753A	-J	E-3A MLG	WHEEL	1620-01-009-8474	95605718	4M1-7-1353 20
ENS	PRIC	15757A	-G-J	C-130 MLG	WHEEL	1630-00-914-1329	219A967	4M3-4-363 23
ART	SHEL	15803A	-G	A-7	HOUSING TRANSFER UNIT	1005-00-239-2929	175F631	11W1-7-1-103 20
ART	SHEL	15819A			BREECH MAU-12	1095-00-911-8407	64H13212-3	11B29-3-25-2 12
ENS	PRIC	15822A	-J	F-5 MLG	WHEEL	1630-01-055-5056	250-A-160-C	4M1-1-63 20
ENS	PRIC	15828A	-J	F-16 MLG	WHEEL	1630-01-038-9239	5003062	4M1-7-1363 20
ENS	COOP	15834A		F-16 MLG	PIN ASSY	1620-01-071-0536	2006004-103	4S1-109-3 0
ART	SHEL	15849A		MULTIPLE	AIR FOIL MXU02A/B	1325-00-162-0244	689898-2	11K1-9-3 20
DOP	COOP	15862A		F-16 MLG	PISTON ASSY	1620-01-071-0538	2006002-103	4S2-00-3 35
DOP	POLL	15865A		C-141 MLG	FORWARD LINK	1620-00-927-2601	3610013-111	4S1-73-3 21
DOP	COOP	15866A		C-111 MLG	STRUT ASSY H/W	1620-01-103-7747	7729965-10	4S1-07-3 32
ELE		15874A	-G-J	A-37 MLG	BRAKE HOUSING	1630-01-124-2873	10 OCT 88	481-2-1023 20
DOP	COOP	15984A		F-111 MLG	PIN SHOCK STRUT	1620-00-400-1007	12L9519-5	4A4-15-3 30
ENS	POLL	15998A		C-130 MLG	STRUT ASSY	1620-01-146-5708	7926623-10	4S2-23-3 65
DNR	ANDE	16019A	-J	F-4 MLG	STRUT ASSY	1620-01-024-8844	53-45400-301	4S2-57-3 69
ART	SHEL	16039A		F-16	ECM ADAPTER	1560-01-142-6594MF	16S601-819	16W6-35-3-2 15
ART	SHEL	16099A		MULTIPLE	LAU-100 LANCHR R/H AIM 9	1440-01-104-0368AB	7839472-60	11L1-3-11 7
ARK	ANDE	16101A		LGM-30	T.E. ACTUATOR	1450-00-089-0946AH	67029921-10	35D3-11-25-13 28
ENS	POLL	16123A	-G-J	C-130	BALLSCREW	1620-00-677-6681	16S0E412	16S3-2-48-23 20
ENS	RIGB	16136A		E-3A MLG	BRAKE TORQUE TUBE	1630-01-034-5387	9542482	481-2-1153 13
ART	SHEL	16148A		F-4	CENTERLINE ADAPTER ASSY	1095-00-192-5341BF	53-73023-321	1F4C-3-1-4 16
ART	SHEL	16228A		MULTIPLE	AIRFOIL MXU 602	1325-00-491-0006	689898-1	11K1-9-3 10
ART	SHEL	16229A		MULTIPLE	AIRFOIL MXU 600	1325-00-491-0007	700924-1	11F1-9-3 10
		16264A		KC-135 MLG	BRAKE COLLAR	1620-00-670-6602	69-1172-1	4A4-12-23 45
		16266A	-G-J	F-4 MLG	WHEEL	1630-00-730-0126	3-1185	4M3-7-1103 19
ENS	PRIC	16267A	-G-J	F-4 MLG	WHEEL	1630-00-852-1432	220A123	4M3-7-1143 19

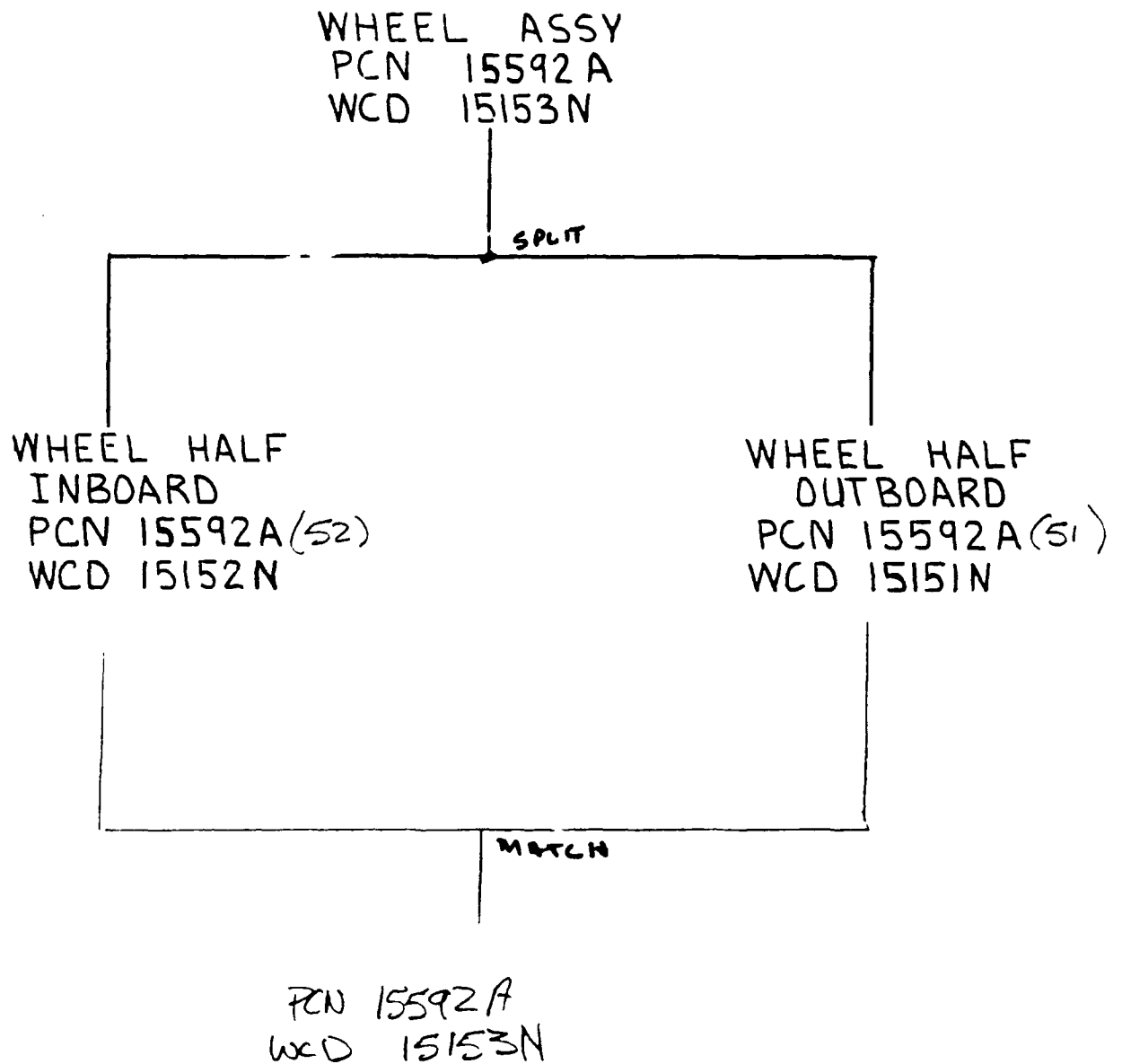
(34024-TIP001)

LATEST DTD REVIEW 10 APR 89

4:37 PM

						FACTORED		
PROD NR	REL	OPER NR	TYP STD	SK	FAC	STAND HOURS	CCC FAC	STAND HOURS
15592A	MNPRK	XNPRK	X	4N	5	.51	1.00	51
								51
								51
	MNPRK	00010	E	YH	5	.05	1.00	5
		PM153	E	YH	5	.13	1.00	13
		OP151	E	3S	5	.33	1.00	33
		PS152	E	3S	5	.33	1.00	33
		PS153	N	3S	5	.42	1.00	42
		PS151	E	YH	5	.69	1.00	69
		PS152	E	YH	5	.69	1.00	69
								2.67
	MNPRK	WC001	E	KI	5	1.76	1.00	1.76
		WA001	E	KI	5	.70	1.00	70
		WA151	N	DI	5	.51	1.00	51
		WA152	N	DI	5	.51	1.00	51
		WA151	N	KI	5	.19	1.00	19
		WA152	N	KI	5	.19	1.00	19
								3.56
	MNPRK	NA151	E	DS	2	.21	.20	16
		NA152	E	DS	5	.31	.20	16
		NA153	E	DS	5	.31	.20	16
		XNPRK	X	DS	2	.40	1.00	40
								85
	MNPRK	KA151	E	JA	1	5.23	.20	1.05
		KA152	E	JA	1	5.11	.20	1.16
								2.21
								10.13

KC-135 NOSE WHEEL



KC-135
PCN 15592A
WCD 15153N

IN INDUCT

S SPLIT WHEEL

WCD 15152N

WCD 15151N

5A DISASSEMBLE CHILLS,
WEIGHTS, KEYS, ETC.

5A DISASSEMBLE CHILLS,
WEIGHTS, KEYS, ET

6 HEAT TO 150°F -
REMOVE BEARING CUP
& STAMP WCD

6 HEAT TO 150°F -
REMOVE BEARING CUP
& STAMP WCD

7 CHEMICAL CLEAN

7 CHEMICAL CLEAN

7A REMOVE FROM
CONVEYER

7A REMOVE FROM
CONVEYER

9 BLAST CLEAN

9 BLAST CLEAN

9A LOAD ON
CONVEYER

9A LOAD ON
CONVEYER

13 MAGNESIUM CLEAN

13 MAGNESIUM CLEAN



↓

15 & PENT INSPECT
15A

15B UNLOAD FROM
CONVEYER

16 EDDY CURRENT
INSPECTION

18 BEAD BLAST

19 LOAD ON
CONVEYER

19A MAGNESIUM CLEAN

30 REMOVE FROM CONVEYER

30A NICK & BURR

40 INSPECT

40A ROUTE FOR REPAIR

47 METAL SET

60 REAM HOLES

70 MACHINE MATING
SURFACE

70A CHEM CLEAN

80 PENT INSPECT

90 BEAR BORE MACHINE

110 SEAT REPAIR
↓

↓

15 & PENT INSPECT
15A

15B UNLOAD FROM
CONVEYER

16 EDDY CURRENT
INSPECTION

18 BEAD BLAST

19 NICK & BURR

40 INSPECT

40A ROUTE FOR REPAIR

47 METAL SET

60 REAM HOLES

70 MACHINE SURFACE

70A CHEM CLEAN

80 PENT INSPECT

100 BEAR BORE MACHINE

120 SEAT REPAIR

130 BOLT HOLE REPAIR

150 VALVE STEM REPAIR

170 DOW 7

180 LOAD
↓

↓

130 BOLT HOLE REPAIR

140 GROOVE REPAIR

170 DOW 7

180 LOAD

180A CLEAN

180B PROCESS
(IMPREGNATE)

180C CLEAN

180D CURE

180E CLEAN

190 INSTALL CUP

195 MACHINE CUP

200 INSTALL BUSHING

205 INSTALL CUP

210 MACHINE BUSHING

215 INSTALL BUSHING

220 INSTALL BUSHING

260 INSPECT

265 HEAT WHEEL

265A INSTALL RACE

↓

↓

180A CLEAN

180B PROCESS
(IMPREGNATE)

180C CLEAN

180D CURE

180E CLEAN

185 INSTALL CUP

190 MACHINE CUP

195 INSTALL BUSHING

220 INSTALL BUSHING

260 INSPECT

265 HEAT WHEEL

265A INSTALL RACE

265B UNLOAD FROM LINE

270 LOAD ON
PAINT LINE

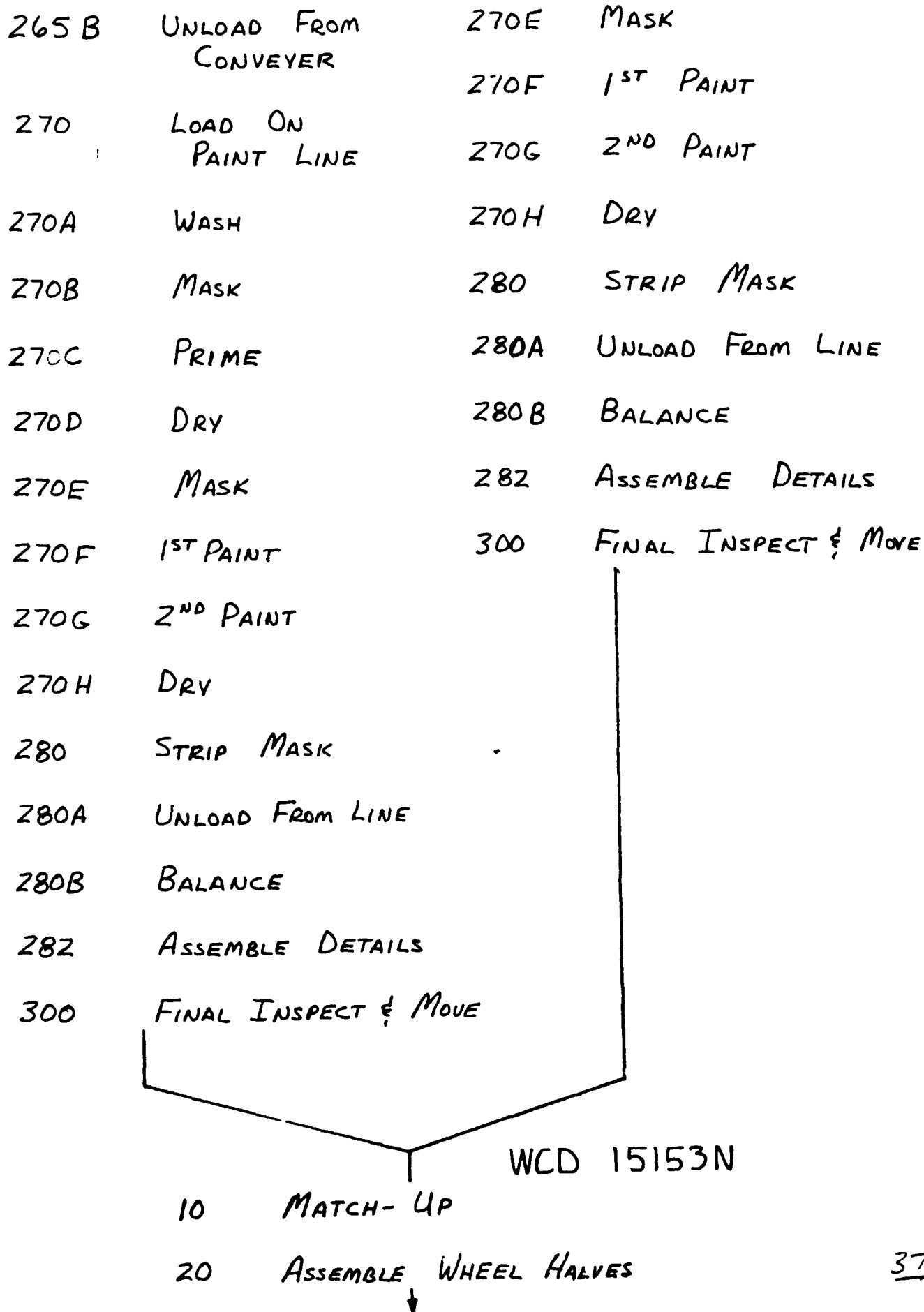
270A WASH

270B MASK

270C PRIME

270D DRY

↓



↓
30 TOUCH UP PAINT

98 VERIFY WCD COMPLETENESS

99 FINAL VISUAL INSPECT

9999 SELL

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

7 PART NUMBER	8 TECH DATA 4W-1-61 4W3-7-113	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL 15143 A 15592 A
13 SERIAL NUMBER	14 NOUN WHEEL ASSY	

15. DISPATCH STATION	16. PERF RCC OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 211A243M2 211A243M3		NSN C/N 1630006896014 15143A 1630004210319 15592A			
		***** UNIT COST: \$242.10 ***** GOVERNING DIRECTIVES: AFLOR 66-51 - MANDI 66-3			
		FPI IAW MIL-STD-6866 DDW IAW MIL-M-3171A *****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)			

21. FINAL DESTINATION DISPATCH FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A C	23. DOCUMENT/SN 15153N

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL ASSY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	211A243M 211A243M2 211A243M3							
13A	010	*MATCH-UP* *****ROUTED ITEMS***** *REQD* NEW REWORED NO SERVICEABLE 958 REWORK					001 MNP GP 002 07 003 MU02		
		W/H OUTBOARD / / 15151N W/H INBOARD / / 15152N							
		C/P MOVE							
13	020	ASSEMBLE *REQD*					001 MNP GP 002 07 003 WA03		
13	030	FINAL PAINT & TOUCH-UP *C/P MOVE *REQD*					001 MNP GP 002 09 003 TU04		
13	098	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*					001 MNP GP 002 09 003 TU04		
13	099	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNP GP 002 09 003 TU04		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15153N			
		B		D					

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN WHEEL ASSY		12 OPTIONAL			
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15153N			
		B		D					

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

7 PART NUMBER	8 TECH DATA 4W-1-61 4W3-7-113	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL 15143 A 15592 A
13 SERIAL NUMBER	14 NOUN WHEEL HALF OUTBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
211A244-2		N.S.L. 15143A			
211A244-3		1630012427813 15592A			
		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 DOW IAW MIL-M-3171A			
		*****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15151N
		B	D	

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED	
7 PART NUMBER		8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF OUTBOARD					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED			18 MECHANIC	19 "P"	20 "Q"
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
	001	211A244 211A244-1 211A244-2 211A244-3					
		DISASSEMBLE *C/P MOVE				001 MNPBW	
	REQD					002 02	
						003 WDO3	
		REMOVE CUP FROM WHEEL HALF *C/P MOVE				001 MNPBW	
	REQD					002 02	
						003 WDO3	
		CHEM CLEAN *C/P MOVE				001 MNPBW	
	REQD					002 03	
						003 AD02	
		BLAST CLEAN *C/P MOVE				001 MNPBW	
	REQD					002 03	
						003 BL01	
		MAGNESIUM CLEAN				001 MNPBW	
	REQD					002 03	
						003 MC04	
						001 MNPNA	
	REQD				M	002 05	
						003 ZY05	
		BEAD, SEAT AND HUB AREAS IAM T.O. PAGE 1 *C/P MOVE			M	001 MNPNA	
	REQD					002 05	
						003 EC04	
		GLASS BEAD BLAST ENTIRE WHEEL *C/P MOVE				001 MNPBW	
	REQD					002 03	
						003 BL07	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE			23 DOCUMENT/BN		
DISPATCH	FUNCTIONAL CODE	A			15151N		
		B					
		C					
		D					

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN

WHEEL HALF OUTBOARD

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

NICK & BURR
REMOVE TORQUE VALVE EXCEPT DRY
TORQUE 500 INCH POUNDS
EMBOSSED ON WHEEL HALVES

001 MNPBW
002 04
003 NB04

*** NOTE ***
RE-IDENTIFY REMORKED WHEEL HALVES
IAW T.O. 4W3-7-113
*C/P MOVE

E & I AND ROUTE
TIE BOLT HOLE I.D. 0.453 MAX
REQD TIE BOLT WALL THICKNESS 0.605 MIN
(SEE IDENT. NOTE)

001 MNPBW
002 04
003 E102

OVERSIZE BRG BORE I.D. 4.361 MIN
4.362 MAX
*C/P MOVE

69 047 METAL SET IAW T.O.

.05 *C/P MOVE

001 MNPRA
002 01
003 BE01

69 060 REAM TIE BOLT HOLES TO REMOVE
CORROSION .447 MIN .453 MAX ID IAW
PAGE 6
*C/P MOVE

001 MNPRA
002 01
003 DR02

69 070 MACHINE MATING SURFACE & O RING
SEALING SURFACE IAW PAGE 9
*C/P MOVE

001 MNPRA
002 01
003 LE05

05 (TYPE 1 METHOD C) TIE BOLT HOLES
AFTER MACHINING FOR DRAGS IAW PAGE
7 PARA (3)
*C/P MOVE

001 MNPRA
002 05
003 ZY05

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

69 100 BEARING BORE REPAIR (OUTBOARD)
PAGE 8 & AF DWG 33B31152
*C/P MOVE

001 MNPRA
002 01
003 MV04

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
✓ 69	120 .05	BEARING BORE SEAT REPAIR (OUTBOARD) IAW 63B31152 *C/P MOVE					001 MNPRA 002 01 003 MVD4		
✓ 69	130 .59	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE					001 MNPRA 002 01 003 DR02		
✓ 69	150 .05 <i>Added</i>	VALVE STEM HOLE REPAIR P/N 211A243M2 & P/N 211A243M3 ONLY IAW PAGE 9 FIG 6 *C/P MOVE					001 MNPRA 002 01 003 DR02		
✓ 69	160 .03 <i>Added</i>	VALVE STEM HOLE REPAIR P/N 211A243M ONLY IAW FIG 2 & 4 PAGE 9 PARA 5 * * * N O T E * * *					001 MNPRA 002 01 003 DR02		
		RE-IDENTIFY REWORKED WHEEL HALVES IAW T.O. 4WS-7-133 *C/P MOVE							
		TREAT (DOW 7) *C/P MOVE *REQD*					001 MNPBW 002 03 003 MCD4		
✓ 13	180 *REQD*	IMPREGNATE *C/P MOVE *REQD*					001 MNPBP 002 07 003 MIO4		
✓ 69	185 .63	INSTALL CUP INTO BEARING BORE BUSHING P/N 29520 P/N 63B31152-75					001 MNPRA 002 01 003 BE01		
✓ 69	190 .61	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L. *C/P MOVE					001 MNPRA 002 01 003 LE09		
✓ 69	195 .80	INSTALL BUSHING AND CUP ASSEMBLY BEARING BORE P/N N.P.L. *C/P MOVE					001 MNPRA 002 01 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		15151N			
		B		D					

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

10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF OUTBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
✓ 69	220 ~~220~~ 73	INSTALL TIE BOLT HOLE BUSHING IAW PAGE 7 *C/P MOVE		001 MNPRA 002 01 003 BE01	
✓ 13	260 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE		001 MNP GP 002 07 003 PF05	
✓ 13	265 71	RACE INSTALLATION *C/P MOVE P/N29520		001 MNP GP 002 07 003 RI06	
✓ 13	270 *REQD*	PAINT *C/P MOVE		001 MNP GP 002 09 003 BS02	
✓ 13	280 *REQD*	BALANCE *C/P MOVE		001 MNP GP 002 07 003 WB01	
✓ 13	282 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE		001 MNP GP 002 07 003 WA03	
✓ 13	300 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 07 003 WA03	
✓ 13	310 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 07 003 WA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15151N
		B	D	

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC MNPDM		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA 4W-1-61 4W3-2-113			9 ITEM SERIAL NO.			
10 MODEL-DESIGN-SERIES KC-135 NOSE			11 STOCK NUMBER			12 OPTIONAL 15143A 15592A			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC/O' NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
P/N		NSN C/N							
211A245		N.S.L. 15143A							
211A245-1		1630012427804 15592A							
GOVERNING DIRECTIVES: AFLOR 66-51 LANDI 66-3 FPI IAW MIL-STD-4846 DDW IAW MIL-M-3171A									
*****MAGNESIUM*****									
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(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
						15152N			
		B				D			

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2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	211A245 211A245-1							
		DISASSEMBLE *C/P MOVE					001 MNP GW		
	REQD						002 02		
							003 WD03		
		REMOVE CUP FROM WHEEL HALF *C/P MOVE					001 MNP GW		
	REQD						002 02		
							003 WD03		
		CHEN CLEAN *C/P MOVE					001 MNP GW		
	REQD						002 03		
							003 AC02		
		BLAST CLEAN *C/P MOVE					001 MNP GW		
	REQD						002 03		
							003 BL01		
		MAGNESIUM CLEAN					001 MNP GW		
	REQD						002 03		
							003 MC04		
		*C/P MOVE				M	001 MNP NA		
	REQD						002 05		
							003 ZY05		
		BEAD, SEAT AND HUB AREAS IAW T.O. PAGE 1 *C/P MOVE				M	001 MNP NA		
	REQD						002 05		
							003 EC04		
		GLASS BEAD BLAST ENTIRE WHL *C/P MOVE					001 MNP GW		
	REQD						002 03		
							003 BL07		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED					
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.					
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL							
13. SERIAL NUMBER			14. NOUN WHEEL HALF INBOARD										
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"		20. "Q"		
				SECOND MAG CLEAN FOR NICK & BURR *C/P MOVE*					001 MNP GW 002 04 003 NB04				
				NICK & BURR REMOVE TORQUE VALUE EXCEPT DRY TORQUE 500 INCH POUNDS EMBROSSED WHEEL HALVES *C/P MOVE*									
				E & I TIE BOLT HOLE I.D. 0.453 MAX TIE BOLT WALL THICKNESS 0.605 MIN (SEE IDENT NOTE)					001 MNP GW 002 04 003 EI02				
				1ST OVERSIZE BEARING BORE I.D. 5.116 MIN TO 5.117 MAX 2ND OVERSIZE BEARING BORE I.D. 5.237 MIN 5.242 MAX. *C/P MOVE									
169		047		METAL SET IAW I.D. *C/P MOVE					001 MNPRA 002 01 003 BE01				
169		060		REAM TIE BOLT HOLES TO REMOVE CORROSION .447 MIN .453 MAX ID IAW PAGE 6 *C/P MOVE					001 MNPRA 002 01 003 BR02				
169		070		MACHINE MATING SURFACE & O RING SEALING SURFACE IAW PAGE 7 *C/P MOVE					001 MNPRA 002 01 003 LE05				
		.03		(TYPE 1 METHOD C) TIE BOLT HOLES AFTER MACHINING FOR CRACKS IAW PAGE 7 PARA (3) *C/P MOVE			M		001 MNPNA 002 05 003 ZY05				
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. (CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN									
DISPATCH		FUNCTIONAL CODE		A		C						15152N	
				B		D							

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

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

69	090 .31	BEARING BORE REPAIR (INBOARD) IAW PAGE 8 & AF DWG 63B31152 *C/P MOVE		001 MNPRA 002 01 003 MVD4	
69	110 .03	BEARING BORE SEAT REPAIR (INBOARD) IAW 63B31152 *C/P MOVE		001 MNPRA 002 01 003 MVD4	
69	130 .66	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE		001 MNPRA 002 01 003 DRD2	
69	140 SA dropped	BEARING BORE & LOCK RING GROOVE REPAIR (INBOARD) IAW FIG 5B & PAGE 10B PARA X-1 *C/P MOVE		001 MNPRA 002 01 003 LV02	
		TREAT (DOW 7) *C/P MOVE *REQD*		001 MNPBW 002 03 003 MCD4	
13	180 *REQD*	IMPREGNATE *C/P MOVE		001 MNPBP 002 07 003 MID4	
69	190	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVE P/N42620 P/N63B31152-79		001 MNPRA 002 01 003 BED1	
69	195 AS	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L. *C/P MOVE		001 MNPRA 002 01 003 LED9	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15152N
		B	D	

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
69	200 A2	INSTALL BUSHING AND CUP ASSY INTO BEARING BORE *C/P MOVE P/N N.S.L.		001 MNPRA 002 01 003 BE01	
69	205 66 604	INSTALL CUP INTO BEARING BORE AND LOCK RING BUSHING *C/P MOVE P/N 42620 P/N7729019-01		001 MNPRA 002 01 003 BE01	
69	210 59 60P	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY *C/P MOVE P/N N.P.L.		001 MNPRA 002 01 003 LEO9	
69	215 59 60P	INSTALL BUSHING AND CUP ASSY INTO BEARING BORE *C/P MOVE P/N N.S.L.		001 MNPRA 002 01 003 BE01	
69	220 83	INSTALL TIE BOLT HOLE BUSHING IAW PAGE 7 *C/P MOVE		001 MNPRA 002 01 003 BE01	
13	260 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE		001 MNPGP 002 07 003 PF05	
13	265 83	RACE INSTALLATION *C/P MOVE P/N 42620		001 MNPGP 002 07 003 RI06	
13	270 *REQD*	PAINT *C/P MOVE		001 MNPGP 002 09 003 BS02	
13	280 *REQD*	BALANCE *C/P MOVE		001 MNPGP 002 07 003 WB01	
13	282 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE		001 MNPGP 002 07 003 WA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15152N
		B	D	

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15153N WORK CONTROL DOCUMENT (MEDS)

DATE 88145

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 5592A	3 QUANTITY 1ea	4 PRODUCTION SEC RCC MNFGW	5 DATE SCHED	6 DATE COMPLETED 6 JUL 88

7 PART NUMBER	8 TECH DATA 4b-1-61 4W3-7-113	9 ITEM SERIAL NO 3505/3004

10 MODEL DESIGN SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL ASSY	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 O
P/N		NSN C/N			
211A243M		1630005166758 37989A			
211A243M2		1630006896014 15143A			
211A243M3		1630004210319 15592A			
		***** UNIT COST: \$242.10 *****			
		GOVERNING DIRECTIVES: AFLCR 66-51			
		MANOI 66-3			
		FPI IAW MIL-STD-6866			
		DOW IAW MIL-M-3171A			
		*****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	15153N
		B	D	

15153N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88145

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCT: ON SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN WHEEL ASSY							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
13	020 *REQD*	ASSEMBLE *C/P MOVE FEB 22 1989							
13	030 *REQD*	FINAL PAINT & TOUCH-UP *C/P MOVE				23 FEB 1989			
13	098 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 9580				23 FEB 1989			
13	099 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE				23 FEB 1989			
		COORDINATION PLANNING: LARRY PRICE WK MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C		15153N			
		B		D					

15151N

WORK CONTROL DOCUMENT (MEDS) / WIP

BB210

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 15592A/84A	3 QUANTITY 1 EA	4 PRODUCTION SEC RCC MNPGW	5 DATE SCHED 20 OCT 1988	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA 4W-1-61 4W3-7-113	9 ITEM SERIAL NO 3505		

10 MODEL DESIGN SERIES KC-135 NOSE	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER E17022	14 NOUN WHEEL HALF OUTBOARD	

15 DISPATCH STATION	16 PER. REC'D NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
P7N		NSN C7N			
211A244		N.S.L. 37989A			
211A244		N.S.L. 37989A			
211A244		N.S.L. 15143A			
211A244-3		1630012427813 15592A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 DOW IAW MIL-M-3171A			
		*****MAGNESIUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. (CONTINUED)			

21 FINAL DESTINATION DISPATCH	22 COORDINATION/INITIATING RCC SIGNATURE/DATE A. Tom Wilson 16 Sep 88 MANSN 16 SEP 1988 B. [Signature] 17 Sep 88	23 DOCUMENT/SN 15151N

15151N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 88210

2

PAGE OF PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 M	20 O	
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	211A244 211A244-1 211A244-2 211A244-3							
34D	005	DISASSEMBLE *C/P MOVE							
	REQD	03 OCT 1988							
34D	006	REMOVE CUP FROM WHEEL HALF *C/P MOVE							
	REQD	03 OCT 1988							
34C	007	CHEM CLEAN *C/P MOVE							
	REQD	03 OCT 1988							
34B	009	BLAST CLEAN *C/P MOVE							
	REQD	03 OCT 1988							
34C	012	MAGNESIUM CLEAN							
	REQD								
34C	015	FPI *C/P MOVE							
	REQD								
34	017	EDDY - CURRENT BEAD, SEAT AND HUB AREAS IAW T.O. PAGE 1 *C/P MOVE							
	REQD								
34B	019	GLASS BEAD BLAST ENTIRE WHEEL *C/P MOVE							
	REQD	OCT 07 1988							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						15151N			

15151N

WORK CONTROL DOCUMENT (MEDS)

DATE 88210

3
PAGE OF PAGES

1 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED		
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL				
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD							
15 DISPATCH		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED			18 JAN 1988		19 JAN 1988	
21				NICK AND BURR REMOVE TORQUE VALVE EXCEPT DRY TORQUE 500 INCH POUNDS EMBOSSED ON WHEEL HALVES ***NOTE*** RE-IDENTIFY REWORKED WHEEL HALVES IAW T.O. 4W3-7-113 *C/P MOVE			2 - JAN 1988		mc	
34E		040		E & I ANL ROUTE TIE BOLT HOLE I.D 0.453 MAX *REQD* TIE BOLT WALL THICKNESS 0.605 MIN (SEE IDENT. NOTE)			2 - JAN 1988		M	
				OVERSIZE BRG BORE I.D. 4.361 MIN 4.362 MAX *C/P MOVE						
69		047		METAL SET IAW T.O. *C/P MOVE						
69		060		REAM TIE BOLT HOLES TO REMOVE CORROSION .447 MIN .453 MAX ID IAW PAGE 6 *C/P MOVE						
69		070		MACHINE MATING SURFACE & O RING SEALING SURFACE IAW PAGE 9 *C/P MOVE					M	
34Z		080		FPI (TYPE 1 METHOD C) TIE BOLT HOLES AFTER MACHINING FOR CRACKS IAW PAGE 7 PARA (3) *C/P MOVE			M		K	
				*****NOTE***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT.* *****						
69		100		BEARING BORE REPAIR (OUTBOARD) IAW PAGE 8 & AF DWG 63B31152 *C/P MOVE						
21		FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN			
DISPATCH		FUNCTIONAL CODE		A			C			
				B			D			
							15151N			

2 JOB ORDER NO		3 QUANT		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF OUTBOARD							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	120	BEARING BORE SEAT REPAIR (OUTBOARD) IAW 63B31152 *C/P MOVE							
69	130	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE							
69	150	VALVE STEM HOLE REPAIR P/N 211A243M2 & P/N 211A243M3 ONLY IAW PAGE 9 FIG 6 *C/P MOVE					M		
69	160	VALVE STEM HOLE REPAIR P/N 211A243M ONLY IAW FIG 2 & 4 PAGE 9 PARA 5 * * * N O T E * * *					M		
		RE-IDENTIFY REWORKED WHEEL HALVES IAW T.O. 4W3-7-133 *C/P MOVE							
34C	L/D *REQD*	TREAT (DOW 7) *C/P MOVE				13 JAN 1980	71179		
13	180 *REQD*	IMPREGNATE *C/P MOVE				71104	71164		
	185	INSTALL CUP INTO BEARING BORE BUSHING P/N 29520 P/N 63B31152-75				14 FEB 1980			
69	190	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY P/N N.P.L. *C/P MOVE							
69	195	INSTALL BUSHING AND CUP ASSY INTO BEARING BORE P/N N.P.L. *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15151N			
		B		D					

15151N

WORK CONTROL DOCUMENT (MEDS)

DATE 88210

5 5
PAGE OF PAGES

1 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOON WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
69	220	INSTALL TIE BOLT HOLE BUSHING IAW PAGE 7 *C/P MOVE							
13	260	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE *REQD* 14 FEB 1989							
13	265	RACE INSTALLATION P/N29520 *C/P MOVE 14 FEB 1989							
13	270	PAINT *REQD* *C/P MOVE 14 FEB 1989							
13	280	BALANCE *REQD* *C/P MOVE FEB 15 1989							
13	282	INSTALL SEALS & RETAINERS *C/P MOVE *REQD* FEB 15 1989							
13	300	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETION & AGENCY *REQD* OF ALL PRECEDING OPERATIONS TO 958 FEB 22 1989							
13	310	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD* FEB 22 1989							
COORDINATED BY: PLANNING/WK MEASURE: TOM WIXOM SCHEDULING: JIM COLBIN PRODUCTION: ROGER MURRAY QUALITY: ED OVERDIER									
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						15151N			

15152N WORK CONTROL DOCUMENT (MEDS)

DATE 88221

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 5592A/84A		3 QUANTITY 1 EA		4 PRODUCTION SEC/RCC MANPCW		5 DATE SCHED 02 OCT 1988		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA 4W-1-61 4W3-7-113			9 ITEM SERIAL NO 3004			
10 MODEL DESIGN SERIES KC-135 NCSE			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER E395			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION P/N		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED			18 MECHANIC		19 P
211A245				NSN C/N N.S.L. 37989A					
211A245-1				1630012427824 15143A					
211A245-1				1630012427804 15592A					
				GOVERNING DIRECTIVES: AFM 66-51 MANOI 66-3					
				FPI IAW MIL-STD-6866					
				DOW IAW MIL-M-3171A					
				*****MAGNESIUM*****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.C.) AND T.C. SUPPLEMENTS REFERENCED. THE APPLICABLE T.C.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				WARNING					
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				REQC (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
21. FINAL DESTINATION DISPATCH			22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN			
FUNCTIONAL CODE			A Frank H. Bigby MANPCW/21 July 88 21 July 88 Lt. Mark A. Smith Ray Talbot 22 July 88			15152N			

15152N WORK CONTROL DOCUMENT (MEDS)

DATE 88221

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INECARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
	001	211A245 211A245-1							
34D	005	DISASSEMBLE *C/P MOVE 03 OCT 1988				71204	71204		
34C	007	CHEM CLEAN *C/P MOVE 03 OCT 1988				70025	70025		
34E	009	BLAST CLEAN *C/P MOVE 03 OCT 1988				70025	70025		
34C	012	MAGNESIUM CLEAN *C/P MOVE 06 OCT 1988				70025	70025		
34Z	015	FPI *C/P MOVE 06 OCT 1988				70025	70025		
34	017	ELLY - CURRENT HEAD, SEAT AND RUE AREAS *REQD* IAW T.O. PAGE 1 *C/P MOVE 06 OCT 1988				70025	70025		
34B	019	GLASS HEAD BLAST ENTIRE WEL *REQD* OCT 07 1988				70025	70025		
34E	021	NICK AND FURR REMOVE TORQUE VALUE EXCEPT DRY TORQUE 500 INCH POUNDS EMBOSSED WHEEL HALVES 11 OCT 1988				71737	71737		
34	040	TIE BOLT HOLE I.D. 0.453 MAX *REQD* TIE BOLT WALL THICKNESS 0.605 MIN (CONTINUED)				71737	71737		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
		B		D					

15152N WORK CONTROL DOCUMENT (MEDS)

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PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCT: ON SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL/DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN WHEEL HALF INBOARD							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		(SEE IDENT NOTE) 1ST OVERSIZE BEARING FOR I.D. 5.116 MIN TO 5.117 MAX 2ND OVERSIZE BEARING FOR I.D. 5.237 MIN 5.242 MAX. *C/P MOVE							
59	247 6226	METAL SET IAW T.C. *C/P MOVE				70699		NOV 1988	
69	262	BEAM TIE BOLT HOLES TO REMOVE CORROSION .447 MIN .453 MAX ID IAW PAGE 6 *C/P MOVE							
69	270	MACHINE MATING SURFACE & C RING SEALING SURFACE IAW PAGE 9 *C/P MOVE					M		
342	280	FPI (TYPE 1 METHOD C) TIE BOLT HOLES AFTER MACHINING FOR CRACKS IAW PAGE 7 PARA 13 *C/P MOVE					K		
		***** N C T E ***** IF LAST ADI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****							
69	290	BEARING FOR REPAIR (INBOARD) IAW PAGE 8 & AF DWG 63B31152 *C/P MOVE				70699		NOV 1988	
69	110	BEARING FOR SEAT REPAIR (INBOARD) IAW 63B31152 *C/P MOVE							
69	132	TIE BOLT HOLE REPAIR IAW PAGE 7 AND FIG 5 *C/P MOVE				70699		NOV 1988	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
		B		D					

15152N WORK CONTROL DOCUMENT (MEDS)

DATE 88221

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INFOARD						
15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	140	BEARING CORE & LOCK RING GROOVE REPAIR (INFOARD) IAW FIG 5B & PAGE 10E PARA X-1 *C/P MOVE					M		
34C	170	TREAT (DOW 7) *C/P MOVE *REQD*							
13	180	IMPREGNATE *C/P MOVE *REQD*							
69	195	MACHINE BEARING CORE FUSING P/N63E31152-79							
69	200	INSTALL BEARING CORE FUSING & CUP (INFOARD) *C/P MOVE P/N63E31152-79 P/N42620							
69	225	MACHINE BEARING CORE & LOCK RING FUSING IAW PAGES 10 & 10E AND DWG 7729219							
69	210	MFG & INSTALL BEARING CORE & LOCK RING FUSING AND CUP (INFOARD) IAW PAGES 10 & 10E AND AF DWG 7729219 *C/P MOVE P/N7729219-01 P/N42620					M		
69	222	INSTALL TIE BOLT HOLE FUSING IAW PAGE 7 *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE							
DISPATCH	FUNCTIONAL CODE	A	C					15152N	
		B	D						

15152N WORK CONTROL DOCUMENT (MEDS)

1 DATE PE201

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL FALL INFOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
13	260 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVE 14 FEB 1989						71057	
13	265	RACE INSTALLATION *C/P MOVE							
13	270 *REQD*	PAINT *C/P MOVE 14 FEB 1989				71010			
13	280 *REQD*	BALANCE *C/P MOVE FEB 15 1989				71019	71019		
13	282 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE FEB 15 1989				71019	71019		
13	300 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETION OF ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 FEB 22 1989						71018	
13	310 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE FEB 22 1989						71018	
		COORDINATION PLANNING: FRANK RIGBY WK MEASURE: FRANK RIGBY SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		15152N			
		B		D					

OPER TECH S S W F P P H A K REV

T K W R A FA SUPPORT

CCC <

DESCRIPTION

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

WD001	S	E	HB	EA	5	J	58335	1.00	PERCENT ENGR 99.9	DISSY WHL KC135N	.69		.69		
0001			HB	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A243M			1630005166758					
0020							211A243M2			1630006896014					
0030							211A243M3			1630004210319					
0005			HB	01	25			1.00		DISASSEMBLE WHEEL MED/NOBRK	.167	.042	.209		30
0010	E					RWB-DW-05		1.00	DIS MED WHL (TIE BOLT NO B/K		.15704		.156		
0120	E					RJP-PW-R1		1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012		
0006			HB	01	25			1.00		REMOVE BEARING CUPS	.389	.097	.487	.3	70
0010	E					RWB-BC-01		2.00	REMOVE BEARING CUPS		.16346		.408		
0020	E					RWB-MH-02		.50	LOAD HOOK W/WHEELS F/CLENING		.10532		.065		
0030	E					RJP-PW-R1		1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012		
9000			HB	01	25			.01		LABOR STD HISTORY	.000	.000	.000		0
0010										03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0020										06JUN85 CHANGED SKL CODE,NO TM CHNG					
0030										10JUL85 DN GRD TO N ST/ADD N&B TM (TM WAS .67)					
0900										D.PARKER TECHN MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

-----X-->

7390123456 ELSE PUT IN END

15592A

KC135 N WHL 211A243M3

RCC MNPBW

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

T K NR A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

FFD
TIME

STD
HOURS

A
DLY PCT C

WE151	E	N	DI	EA	5	J	88335	1.00	PERCENT ENGR 12.3	E&I WHL HLF O.B. KC135N	.51		.51	
0001			DI	01	15			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									211A244	N.S.L.				
0020									211A244-1	N.S.L.				
0030									211A244-2	N.S.L.				
0040									211A244-3	1630012427813				
0019			DI	01	27			1.00		NICK & BURR WHEEL MED/HALF	.250	.068	.318	62
0010	E							1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
0020	N							1.00	NICK & BURR WHEEL MED/HALF		.21687		.275	
0030	E							1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0040			DI	01	15			1.00		E & I AND ROUTE WHEEL	.167	.025	.193	38
0010	N							1.00		E&I AND ROUTE WHEEL HALF	.14919		.171	
0020	E							1.00	RENV WHL HLF F/PAINT CONVOYOR		.00633		.009	
0030	E							1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			DI	01	15			.01		LABOR STD HISTORY-MORE	.000	.000	.000	0
0010										TIME NEEDED TO INSP & N & B				
0020										3 JUNE 1983 OLD TIME WAS .50				
0030										REQ D. BALLINGHAM				
0040										03DEC84 2 YEAR REVIEW/NO TIME CHANGE				
0900										N MONROE/MANEAA				

TERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

12/13/88

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15592A KC135 N WHL 211A243M3

RCC MMNPGH

4W3-7-113

81050

OPER TECH S S W F RF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C

WE152	E	N	DI	EA 5	J 88335	1.00	PERCENT ENGR 12.3	E&I WHL HLF I.B. KC135N	.51		.51	
0001		DI	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
					211A245		NSL					
					211A245-1		1630012427804					
0019		DI	01	27		1.00	NICK & BURR WHEEL MED/HALF		.250	.068	.318	62
	0010	E			RLG-RS-NC	1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
	0020	N				1.00	NICK & BURR WHEEL MED/HALF		.21687		.275	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPRMK SIGN OFF DOC		.01001		.012	
0040		DI	01	15		1.00	E & I AND ROUTE WHEEL		.167	.025	.193	38
						1.00	E&I AND ROUTE WHEEL HALF		.14919		.171	
	0020	E			RWB-OH-W2	1.00	RENV WHL HLF F/PAINT CONVDOR		.00633		.009	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPRMK SIGN OFF DOC		.01001		.011	
9000		DI	01	15		.01	LABOR STD HISTORY-MORE		.000	.000	.000	0
	0010						TIME NEEDED TO INSP & N & B					
	0020						3 JUNE 1983 OLD TIME WAS .50					
	0030						REG D. BALLINGHAM					
	0040						03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
	0900						N MCNRGE/MAHEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

PRD NRCP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

14. 06/58

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RCC HNP/5W

4W3-7-113

81050

OPER TECH S S W F F F A/R REV

STEP	T K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
DL		K	C	DC	ELEMENT	FACT	STORED	HOURS	TIME	HOURS	PLY PCT C
							SUPPLEMENTAL				

WM151	S N KI EA S J 88335	1.00 PERCENT ENGR 27.9	DOW 7 WHL HLF O/B KC13SN	.18		.18	
0001	KI 01 15	.00	PART NUMBER/NSN	.000	.000	.000	0
0010		211A244	N.S.L.				
0020		211A244-1	N.S.L.				
0030		211A244-2	N.S.L.				
0040		211A244-3	1630012427813				
0170	KI 01 27	1.00	DOW MAG. WHEEL MED	.147	.040	.187	.7 100
0010 E	RWB-CT-03	1.00 CHEM TREAT A MED MAG PART		.03116		.039	
0020 N	ZLG-CL-M1	.50 LOAD & UNLOAD CARRIER CLEAN		.21200		.134	
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000	KI 01 27	.01	LABOR STD HISTORY	.000	.000	.000	0
0010		03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0020		18JUL85 MOVED N&B TO HB SKL (TM WAS 1.47					
0900		D.PARKER TECHN MANEAA					

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RCC PRD NRCP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPBW

12/13/88
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81050

15592A KC135 N WHL 211A24CM3

OPER TECH S S W F RF A/R REV

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

PFD
TIME

STD
HOURS

A
DLY PCT C

WM152	S	N	KI	EA	5	J	88335	1.00	PERCENT ENGR 27.9	DOW 7 WHL HLF I/B KC135N	.18		.18		
0001			KI	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A245		NSL						
0020							211A245-1		1630012427804						
0170			KI	01	27			1.00		DOW MAG. WHEEL MED	.147	.040	.187	.7	100
0010	E						RWB-CT-03	1.00	CHEM TREAT A MED MAG PART		.03116		.039		
0020	N						ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN		.21200		.134		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DGC		.01001		.012		
9000			KI	01	27			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0020									18JUL85 MOVED N&B TO HB SKL (TM WAS 1.47						
0900									D.PARKER TECHN MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

12/06/88

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KC135 N WHL 211A243M3

RCC MNPNA

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OPER TECH S S W F F F A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C

NA151	S	E	DB	EA 2	J 88335	.20 PERCENT ENGR 99.9	NDI WHL HLF O.B. KC135N	.81	.16	
0001			DB	01	15	.00	PART NUMBER/NSN	.000	.000	.000
0010						211A244	N.S.L.			
0020						211A244-1	N.S.L.			
0030						211A244-2	N.S.L.			
0040						211A244-3	1630012427813			
0080			DB	01	11	.46	ZYGLO WHEEL MED	1.591	.081	.812 .7 100
0010 E						ZLG-ND-Z2 12.00	ZYGLO INSP MED PART BLD 507	.13177		1.755
0020 E						RJP-PW-R1 1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011
9000			DB	01	13	.01	LABOR STANDARD HISTORY	.000	.000	.000
0010						7NOV85 ADDED STEP 0040 DEGREASE <OLD STD .65>				
0900						KERRY COOP MANEAA TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

12/06/88

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15592A

KC135 N WHL 211A243M3

RCC MMNPNA

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OPER TECH S S W F PF A/R REV

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DESCRIPTION

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STEP D L

K C DC ELEMENT

FACT

STORED

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HOURS

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HOURS

DLY PCT C

NA152	S	E	DB	EA	5	J	88335	.20	PERCENT ENGR 99.9	NDI WHL HLF I.B. KC135N	.81		.16		
0001			DB	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
									211A245	NSL					
									211A245-1	1630012427804					
0080			DB	01	11			.46		ZYGLO WHEEL MED	1.591	.081	.812	.7	100
									ZLG-ND-Z2	12.00 ZYGLO INSP MED PART BLD 507	.13177		1.755		
									RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
9000			DB	01	13			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
									7NOV85 ADDED STEP 0040 DECREASE (OLD STD .65)						
									KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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RCC MNPNA

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PER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC

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DESCRIPTION

BASE

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STD

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STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

ILY PCT C

0015	S	X	DB	EA	2	J 88335	1.00	PERCENT ENGR 99.9	NDI WHL KC135N	.39		.39		
0015			DB	01	11		.13		NDI TIE BOLTS 1ST TIME	1.005	.014	.145	36	
0010	E					ZLG-ND-M6	11.00	MAGNAGLO INSP SMALL OBJECT		.09138		1.115		
0020			DB	01	11		.13		NDI DRIVE KEYS 1ST TIME	.822	.012	.119	30	
0010	E					ZLG-ND-M6	9.00	MAGNAGLO INSP SMALL OBJECT		.09138		.912		
2000			DB	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0	
0010								WCD ROUTED PARTS REQUIRING FPI						
0020								211A244	MSL					
0030								211A244-1	MSL					
0040								211A244-2	MSL					
0050								211A244-3	1630012427813					
0060								211A245	MSL					
0070								211245-1	1630012427804					
2001			DB	01	11		1.00		FPI 1ST TIME	.263	.029	.293	.8	73
0030	E					ZLG-ND-Z2	2.00	ZYGLO INSP MED PART BLD 507		.13177		.292		
2003			DB	01	11		1.00		EDDY CURRENT WHEEL	.083	.009	.093	23	
0010	E					ZLG-ND-E3	1.00	SET UP MACHINE -EDDY CURRENT		.03866		.042		
0020	E					ZLG-ND-E1	3.00	EDDY CURRENT - SURFACE SCAN		.00078		.002		
0030	E					ZLG-ND-E0	1.00	PROCESS TIME - PROBE TRAVEL		.00033		.000		
0040	E					ZLG-ND-E4	1.00	S.U. PROBE HOLDER RAD. SCAN		.00392		.009		
0050	E					ZLG-ND-E5	1.00	MATERIAL HANDLING TEST AREA		.00371		.004		
0060	E					ZPL-PW-L1	1.00	ENTER INFO IN LOG BOOK		.01951		.021		
0070	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
			DB	01	13		.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010								7NOV85 ADDED STEP 0040 DEGREASE (OLD STD .65)						
0900								KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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0200	JA 01	15	1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0205	JA 01	15	1.00	INST CUP INTO B B & L R BUSH	.077	.012	.089	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0210	JA 01	15	1.00	MACH BEARING BORE BUSHING	.236	.036	.272	5
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KML-TA-JC	1.00 DIA 5.00-6.00 REM .033-.250		.09193		.105	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0215	JA 01	15	1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0220	JA 01	15	.74	INST TIE BLT BUSH OTED	.314	.035	.268	5
0010 E		RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669		.214	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RBW-BU-A3	11.00 INST ADNL STRAIGHT BUSHING ELEVEN BUSHING		.00886		.112	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				29AUG84 ADD SUB OP 0080 & 0090 <OLD STD> 1.19				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRGP NR

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15592A KC135 N WHL 211A243M3

RCC MNPRA

4W3-7-113

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

DCC <

DESCRIPTION

BASE

PFD

STD

A

STEP D L K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA151	S	E	JA	EA	1	J 68327	.20	PERCENT ENGR 99.9	MACH OUTBD WHL HALF KC-135N	5.27		1.05	
0001			JA	01	15		.00		PART NUMBER/NSN	.000	.000	.000	0
0010						211A244			N.S.L.				
0020						211A244-1			N.S.L.				
0030						211A244-2			N.S.L.				
0040						211A244-3			1630012427813				
0047			JA	01	15		.05		METAL SET REPAIR	.303	.002	.017	0
0010	E					REW-SU-S1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E					GTE-EP-PC	1.00	SEAL SMALL PART WITH EPOXY		.01864		.021	
0030	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15		.46		REP TIE BOLT HOLE,RAD DRILL	2.121	.146	1.122	21
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E					RDR-BO-A2	11.00	O/S ADNL BOSS STP RMR RAD DR	11 ADNL TIE BOLT HOLES	.14687		1.857	
0040	E					REW-DB-A1	12.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBUR 12 TIE BOLT HOLES	.00423		.058	
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15		.05		MACHINE MATING SURFACE	.605	.005	.035	1
0010	E					RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030	E					KML-FF-NB	1.00	FACE FINISH 9 TO 10 ADD 1/8		.00506		.005	
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100			JA	01	15		1.00		BEARING BORE REP - JIG BORE	.886	.133	1.020	19
0010	E					RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 4 PARTS	1.03687		.298	
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					KRM-BA-KC	1.00	BORE HOLE 5.5 X 1.5 GROUP 1		.25649		.294	
0060	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0120			JA	01	15		1.00		BEARING BORE SEAT REP,LARGE	.829	.124	.954	18
0010	E					RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 4 PARTS	1.03687		.298	
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	JIG BORE	.15776		.181	
0030	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					KRM-BA-KA	1.00	BORE HOLE 5.5 X 1/2 GROUP 1		.19948		.229	
0060	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0130			JA	01	15		.46		REP TIE BOLT HOLE,RAD DRILL	2.311	.160	1.223	23
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E					RDR-BO-A2	11.00	O/S ADNL BOSS STP RMR RAD DR	11 ADNL TIE BOLT HOLES	.14687		1.857	
0040	E					KAL-SM-31	12.00	SPOT-FACE OR COUNTERBORE	12 TIE BOLT HOLES	.02004		.276	
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0150			JA	01	15		.25		VALVE STEM HOLE REP RAD DR	.459	.017	.132	3
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E					REW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0160			JA	01	15		.10		VALVE STEM HOLE REP RAD DR	.469	.007	.054	1
0010	E					RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E					RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E					STL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.016	
0040	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0185			JA	01	15		1.00		INST CLIP INTO BUSHING	.077	.012	.089	2
0010	E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	

0020 E	REW-BU-A4	1.00	INST ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0190 JA 01 15		1.00	MACH BEARING BORE BUSHING	.236 .036	.272	5
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0195 JA 01 15		1.00	INST BEARING BORE BUSH & CUP	.077 .012	.089	2
0010 E	REW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0220 JA 01 15		.74	INST TIE BLT BUSH CTBD	.314 .035	.268	5
0010 E	REW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0020 E	REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	REW-BU-A3	11.00	INST ADML STRAIGHT BUSHING ELEVEN BUSHING	.00886	.112	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
9000 JA 01 15		.01	LABOR STANDARD HISTORY	.000 .000	.000	0
0010			29AUS84 ADD SUB QP 0080 & 0090 <OLD STD> 1.19			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

<--->X--->X--->

1234567890123456 ELSE PUT IN END

2MNFSP15592A00010

LABOR STANDARD OPERATIONAL RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNFSP

12/03/88
4WS-7-113

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81050

15592A KC135 N WHL 211A243M3

OPER TECH S S W F FF A/R REV

T K #R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

PFD
TIME

STD
HOURS

A
DLY PCT C

00010	S	E	YH	EA	5	J	88335	1.00	PERCENT ENGR 99.9	ASSY WHL KC135N	.08		.08	
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									211A243M	1630005166758				
0020									211A243M2	1630006896014				
0030									211A243M3	1630004210319				
0020			YH	01	21			1.00		FINAL WHL ASSEMBLY MED/NOERK	.069	.014	.084	100
0010	E							4.00	INSTL UNOBSTRUCTED TIE BOLT		.00975		.047	
0020	E							3.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.036	
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									06JUN84 ADD SUB OP 0001 UNLOAD LINE<OLD STD> 1.68					
0020									06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76					
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0031									3MAR86 CHANGED SKILL CODE FROM YG TO YH					
0032									NO TIME CHANGE					
0900									KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRQF NR

<--X--X--X-->

1234567890123456 ELSE PUT IN END

15592A KC135 N WHL 211A243M3

RCC MNPGB

443-7-113

81050

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

CCC <

DESCRIPTION

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

PP153	E	N	3S	EA	5	J	88335	1.00	PERCENT ENGR	37.9	TOUCH UP PAINT WHL KC135N	.41		.41		
0001			3S	01		00		.00			PART NUMBER/NSN	.000	.000	.000		0
0010							211A243M				1630005166758					
0020							211A243M2				1630006896014					
0030							211A243M3				1630004210319					
0030			3S	01		25		1.00			PAINT TOUCH UP SM & MED	.063	.016	.080		19
0010	E						RWB-FT-02	1.00	FINAL & TUCH UP MED/SM WHL			.05395		.067		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.012		
0098			3S	01		25		1.00			FINAL ACCEPTANCE OF W.C.D.	.132	.033	.166		40
0010	N							1.00			FINAL	.08000		.100		
0020	E						GJP-FP-B5	1.00	FILL OUT FORM 424 & ATTACH			.05255		.065		
0099			3S	01		25		1.00			FINAL VISUAL INSPECTION	.137	.034	.171		41
0010	N							1.00			FINAL VISUAL INSPECTION	.12700		.158		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.012		
9000			3S	01		25		.01			LABOR STANDARD HISTORY	.000	.000	.000		0
0010											06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD>	.57				
0020											06SEP84 ADD STEPS 0005 & 0025 <OLD STD>	.55				
0030											03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0900											N MONROE/MAHEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

ALL PRD NROP NR

<---X---X---X--->

1234567890123456 ELSE PUT IN END

PM153

LABOR STANDARD OPERA IN RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPGP

12/03/88
4WS-7-113

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81050

15592A		K0135 N WHL		211A243M3		RCC MNPGP		4W3-7-113		81050				
OPER	TECH	S	S	W F PF A/R REV										
~B	T	K	NR	A	FA	SUPPORT	DCC	DESCRIPTION		BASE	PFD	STD	A	
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C	
PM153	S	E	YH	EA	5	J	98335	1.00	PERCENT ENGR 84.5	MATCH UP WHL K0135N	.13		.13	
0001		YH	01	00				.00		PART NUMBER/NSN	.000	.000	.000	0
0010							211A243M		1630005166758					
0020							211A243M2		1630006896014					
0030							211A243M3		1630004210319					
0010		YH	01	21				1.00	WHEEL MATCH UP		.110	.023	.134	100
0010	E				MGT-EE-24			1.00	GET EASY AND PLACE EXACT		.00097		.001	
0020	E				RWB-UP-P7			1.00	UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
0030	N							1.00	MATCH WHEEL HALFS 2 HALFS		.01700		.020	
0040	E				RJP-PW-R1			1.00	REM RPL PAPWRK SIGN OFF DCC		.01001		.012	
9000		YH	01	21				.01	LABOR STANDARD HISTORY		.000	.000	.000	0
0010							06JUN84		ADD SUB OP 0001 & UNLOAD LINE<OLD STD> 1.68					
0020							06SEP84		ADD STEPS 0012 & 0013 <OLD STD> 1.76					
0030							03DEC84		2 YEAR REVIEW/NO TIME CHANGE					
0031							3MAR86		CHANGED SKILL CODE FROM Y6 TO YH					
0032									NO TIME CHANGE					
0900									KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

X—X—>

4567890123456 ELSE PUT IN END

2MNP6P15592APP151

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

1. 2/88

A-E046B-MM1-DY-M45 PAGE 0001

RCC MNP6P

4W3-7-113

81050

15592A KC135 N WHL 211A243M3

OPER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

EASE

PFD

STD

A

HOURS

TIME

HOURS

DLY PCT C

PP151	S	E	3S	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PAINT WHL HLF O/B KC135N	.33		.33		
0001			3S	01	15			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010									211A244	N.S.L.					
0020									211A244-1	N.S.L.					
0030									211A244-2	N.S.L.					
0040									211A244-3	1630012427813					
0270			3S	01	25			1.00		PAINT WHEEL	.267	.067	.334	4.0 100	
0010 E									GPL-PA-01	4.00 INST NONTHEADED PLSTC PLUG	.00093		.004		
0020 E									GIG-SF-M1	1.00 MASK & UNMASK MEDIUM PART	.01242		.015		
0030 E									RWB-QH-W1	1.00 HANG WHL HLF ON PAINT CONVYR	.02336		.029		
0040 E									RWB-SC-02	1.00 PNT WHL HALF-ZINC CHROMATE	.11574		.144		
0050 E									RWB-SC-P3	1.00 PNT WHL HALF (2ND COAT) POLY 2 COATS	.10214		.127		
0060 E									RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
9000			3S	01	25			.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010										06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57					
0020										06SEP84 ADD STEPS 0005 & 0025 <OLD STD> .55					
0030										03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0900										N MONROE/MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

: PRD NROP NR

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1234567890123456 ELSE PUT IN END

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15592A KC135 N WHL 211A243M3

RCC MNPSP

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT STORED DESCRIPTION SUPPLEMENTAL BASE HOURS PFD TIME STD HOURS A DLY PCT C

PP152	S	E	3S	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PAINT WHL HLF I/B KC135N	.33		.33		
0001			3S	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A245		NSL						
0020							211A245-1		1630012427804						
0270			3S	01	25			1.00	PAINT WHEEL		.267	.067	.334	4.0	100
0010	E						GFL-PA-01	4.00	INST NONTHREADED PLSTC PLLG		.00093		.004		
0020	E						GIG-SP-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
0030	E						RWB-GH-W1	1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.029		
0040	E						RWB-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE		.11574		.144		
0050	E						RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT) POLY 2 COATS		.10214		.127		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012		
9000			3S	01	25			.01	LABOR STANDARD HISTORY		.000	.000	.000		0
0010									06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57						
0020									06SEP84 ADD STEPS 0005 & 0025 <OLD STD> .55						
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0900									N MONROE/MANEA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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15592A

KC135 N WHL 211A243M3

RCC MMNFGP

4W3-7-113

81050

OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT STORED DESCRIPTION SUPPLEMENTAL BASE HOURS PFD TIME STD HOURS DLY PCT C

PS151	S	E	YH	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PREINSP&ASSY WHL HLF O/B KC1	.69		.69		
0001			YH	01	15			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									211A244	N.S.L.					
0020									211A244-1	N.S.L.					
0030									211A244-2	N.S.L.					
0040									211A244-3	1630012427913					
0180			YH	01	21			1.00		IMPRESNATE WHEEL HALF	.225	.047	.273	.7	39
0010	E								RWB-EC-03	1.00 IMPREGNATE MED SIZED WHEEL	.21563		.260		
0020	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0260			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019		3
0010	E								RWB-JP-W2	1.00 PREP TO ASSY OR DISSY WHEEL	.00442		.005		
0020	E								KAL-GC-46	1.00 INSPECT VISUAL	.00115		.001		
0030	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0265			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.216		31
0010	E								RWB-BC-03	1.00 INSTALL BEARING CUPS	.16838		.203		
0020	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0280			YH	01	21			1.00		BALANCE WHEEL HALF	.111	.023	.134		19
0010	E								GPL-PD-01	4.00 REM NONTHREADED PLASTIC PLUG	.00339		.016		
0020	E								GMC-MT-D1	1.00 REMOVE MASKING TAPE	.00191		.002		
0030	E								RWB-DH-W2	1.00 REMV WHL HLF F/PAINT CONVMOR	.00833		.010		
0040	E								RWB-BB-01	1.00 BALANCE WHEEL HALF	.07734		.093		
0050	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
0282			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050		7
0010	E								RWB-AW-B1	1.00 INSTL BEARING/SNAP RING SECURD	.02459		.029		
0020	E								RWB-AW-C1	1.00 INSTL TIRE CHANGE DATA PLATE	.00692		.008		
0030	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012		
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010										06JUN84 ADD SUB CP 0001 & UNLOAD LINE<OLD STD> 1.68					
0020										06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76					
0030										03DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0031										3MAR86 CHANGED SKILL CODE FROM Y6 TO YH *					
0032										NO TIME CHANGE					
0900										KERRY COOP MANEAA TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

OPER TECH S S W F PF A/R REV

STEP D L K C DC ELEMENT FACT DESCRIPTION BASE PFD STD A
HOURS TIME HOURS DLY PCT C

PS152	S	E	YH	EA	5	J	88335	1.00	PERCENT ENGR 99.9	PRE INSP&ASSY WHL HLF I/B KC	.69		.69		
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							211A245		NSL						
0020							211A245-1		1630012427804						
0180			YH	01	21			1.00	IMPREGNATE WHEEL HALF		.225	.047	.273	.7	39
0010	E						RWB-EC-03	1.00	IMPREGNATE MED SIZED WHEEL		.21563		.260		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0260			YH	01	21			1.00	PREINSPECTION WHEEL HALF		.015	.003	.019		3
0010	E						RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005		
0020	E						KAL-6C-46	1.00	INSPECT VISUAL		.00115		.001		
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0265			YH	01	21			1.00	RACE INSTALLATION WHL/HALF		.178	.037	.216		31
0010	E						RWB-BC-03	1.00	INSTALL BEARING CUPS		.16838		.203		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0280			YH	01	21			1.00	BALANCE WHEEL HALF		.111	.023	.134		19
0010	E						GPL-PD-01	4.00	REM NONTHEADED PLASTIC PLUG		.00339		.016		
0020	E						GMC-MT-D1	1.00	REMOVE MASKING TAPE		.00191		.002		
0030	E						RWB-QH-W2	1.00	REMOV WHL HLF F/PAINT CONVDOR		.00833		.010		
0040	E						RWB-BB-01	1.00	BALANCE WHEEL HALF		.07734		.093		
0050	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0282			YH	01	21			1.00	INSTALL SEALS & RETAINERS		.041	.009	.050		7
0010	E						RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURD		.02459		.029		
0020	E						RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00692		.008		
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0000			YH	01	21			.01	LABOR STANDARD HISTORY		.000	.000	.000		0
0010									06JUN84 ADD SUB GP 0001 & UNLOAD LINE<OLD STD> 1.68						
0020									06SEP84 ADD STEPS 0012 & 0013 <OLD STD> 1.76						
0030									03DEC84 2 YEAR REVIEW/NO TIME CHANGE						
0031									3MAR86 CHANGED SKILL CODE FROM Y6 TO YH						
0032									NO TIME CHANGE						
0900									KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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1234567890123456 ELSE PUT IN END

TECH S S		W F FF A/R REV		JOB T K		NR A FA SUPPORT		OCC		DESCRIPTION		BASE		PFD		STD		A	
STEP D L		K C DC ELEMENT		FACT		STORED		SUPPLEMENTAL		HOURS		TIME		HOURS		DLY PCT C			
40001	S	E	KI	EA	5	J	88335	1.00	PERCENT ENGR 92.3	CLEAN WHL I/B KC135N	1.75			1.75					
0001		KI	01	00				.00	PART NUMBER/NSN		.000	.000	.000						
0010							211A243M		1630005166758										
0020							211A243M2		1630006896014										
0030							211A243M3		1630004210319										
0007		KI	01	27				1.00	CHEM CLEAN WHEEL (MAG)		.424	.114	.538					31	
0010	E				ZLG-CL-M1			2.00	LOAD & UNLOAD CARRIER CLEAN 2EA HALVES		.21200		.538						
0009		KI	01	27				1.00	BLAST CLEAN WHEEL MED		.217	.059	.277					16	
0010	E				RPL-SB-M2			1.00	SANDBLAST MED PART WALK-IN B		.10100		.129						
0020	N				ZLG-CL-M1			.50	LOAD & UNLOAD CARRIER CLEAN		.21200		.134						
0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012						
0013		KI	01	27				1.00	CHEM CLEAN WHEEL (MAG)		.424	.114	.538					31	
0010	E				ZLG-CL-M1			2.00	LOAD & UNLOAD CARRIER CLEAN 2EA HALVES		.21200		.538						
0017		KI	01	27				1.00	BLAST CLEAN WHEEL		.316	.086	.403					23	
0010	E				RPL-SB-L2			1.00	SANDBLAST LARGE PART - HOISTGLASS BEAD		.31693		.402						
9000		KI	01	27				.01	LABOR STD HISTORY		.000	.000	.000					0	
0010									03DEC84 2 YEAR REVIEW/NO TIME CHANGE										
0020									10JUL85 MOVED N&B TO HB SKL (TM WAS 1.47										
0900									D.PARKER TECHN MANEAA										

INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRJP NR

<---X---X--->

1234567890123456 ELSE PUT IN END

EX-06 5(15/5X)7

852 MLG WHEEL ASSEMBLY

BILL OF MATERIALS

69595A

$\# = \text{MMT}$
 $\# = \text{SHOP}$

[illegible]

BLDG 505/507

652 MLG WHEEL ASSEMBLY

$$\begin{aligned} \bullet &= \text{HMI} \\ \bullet\bullet &= \text{SHS} \end{aligned}$$

86

BLDG 505/507

1852 MILG WHEEL ASSEMBLY
BILL OF MATERIALS
69595A

$$\begin{aligned} I_{\text{MMA}} &= 4 \\ dOHS &= 4.4 \end{aligned}$$
[illegible]

PROD		OPER		TYP		STAND		OCC		FACTORED
NR	ACC	NR	STD	SK	FAC	HOURS	FAC	STAND	HOURS	
69595A	MNPRW	XNPRW	X	4N	5	.51	1.00		51	

										51
	MNPRW	DD10	E	YH	5	.54	1.00		54	
		PM10	E	YH	5	.13	1.00		13	
		PP102	E	SS	5	.33	1.00		33	
		PP105	E	SS	5	.33	1.00		33	
		PS102	E	YH	5	.42	1.00		42	
		PS105	E	YH	5	.42	1.00		42	

										2.47
	MNPRW	WD001	N	KI	5	.93	1.00		93	
		WD001	E	H3	5	1.52	1.00		1.52	
		WE102	N	DI	5	.62	1.00		62	
		WE105	N	DI	5	.62	1.00		62	

										3.69
	MNPRW	XNPRW	X	JB	1	.20	1.00		20	

										20
	MNPRW	NA102	E	DB	2	.02	1.00		2	
		NA105	E	DB	2	.02	1.00		2	
		XNPRW	X	DB	2	.39	1.00		39	

										43
	MNPRW	RA102	E	JA	1	1.34	1.00		1.34	
		RA105	E	JA	1	2.20	.65		1.43	

										2.77
	MNPRC	RC102	E	UP	3	1.99	1.00		1.99	
		RC105	E	UP	3	1.99	1.00		1.99	

										3.98

										14.05

CONTROL NUMBER LIST

ITEM	CONTROL NO	ASSEMBLY	DESCRIPTION	STOCK NUMBER	PORT NUMBER	TECHORDER	DATE
DELE	69568A	C-130 MLG	PISTON	1620-00-954-8000	25 NOV 86	452-23-3	
BENT POLL	69569A	C-130 MLG	TORQUE STRUT ASSY	1620-00-605-0005	3880431	451-09-15	35
DELE	69572A	C-130 MLG	CYLINDER	1620-00-623-8912	25 NOV 86	451-37-3	
COOP POLL	69573A	C-130 MLG	TORQUE STRUT	1620-00-623-8913	388045-7	451-69-13	
BENT POLL	69577A	C-130 MLG	BRACE ASSY	1620-00-976-3391	371689-12	45A6-7-3	35
BENT POLL	69578A	C-130 MLG	STRUT ASSY	1620-01-143-1185	7926487-30	452-23-3	65
JENS PRIC	69589A	F-100 MLG	WHEEL	1630-00-667-4924	3-1080	443-7-1023	30
JENS PRIC	69591A	F-100 MLG	WHEEL	1630-00-696-3570	218A381	443-7-1293	30
RIGB PRIC	69595A	B-52	MAIN WHEEL	1630-00-212-8942	3-1192-1	481-4-133	30
DELE	69602A	F-106	GONE SWITCH	1440-00-942-1047AA	11 JULY 86	11L1-3-14-3	47
COVI SHEL	69603A	F-111	INERTIA REEL	1377-01-141-8911	0105157-77	11P9-11-3	07
MART SHEL	69621A	A-37	CONTROL BOX ASSY	1005-00-051-8786	DCX-144A320-9	11W1-15-12-2	04
BENT POLL	69626A	C-130 MLG	STRUT ASSY	1620-00-505-1104	3305591-3	452-23-3	65
BENT POLL	69651A	C-130 MLG	STRUT ASSY	1620-00-623-8911	370438-1	451-37-3	50
BENT POLL	69652A	C-130 MLG	STRUT ASSY	1620-00-111-1418	695001-9A	451-37-3	50
BENT POLL	69653A	C-130 MLG	COLLAR	1620-00-697-0191	352604	452-23-3	07
JENS RIGB	69654A	G-J F-16	BRAKE ASSY	1630-01-110-3642	5003063-6	481-2-1163	30
JENS POLL	69655A	G-J C-130	BALLSCREW	1620-01-065-4867	843012	1663-2-07-3	20
BENT COOP	69657A	KC-135 MLG	STRUT ASSY L/H	1620-01-030-9102	7531273-90	451-56-33	55
BENT COOP	69658A	KC-135 MLG	STRUT ASSY R/H	1620-01-030-9101	7531273-100	451-56-3	55
DELE	69697J	C-141 MLG	ORIFICE TUBE	1620-00-202-5315	2 JAN 85	451-73-3	
COOP	69707A	F-15 MLG	LOMER BRACE	1620-00-305-2009	680450771-1001	452-73-4	30
OLL	69775A	G C-141 MLG	ROOT PIN L	5315-00-500-6001LE	2430234-01	451-23-3	25
COOP TOLM	69777A	B-52 MLG	LOMER LINK	1620-00-217-4961	1-00604	451-20-4	25
JENS PRIC	69794A	J F-15 MLG	WHEEL	1630-01-141-4695	5000864-9	441-0-73	20
MONR TOLM	69803A	CH-3 MLG	STRUT ASSY	1620-01-000-0338	8341139-10	452-50-3	42
JENS RIGB	69807A	J F-15 MLG	A/B BRAKE ASSY	1630-01-010-2118	5000913-10	481-2-1123	23
MONR ANDE	69825A	C-5A MLG	UPPER BEARING	3120-00-251-7338LE	70869	452-67-3	31
DELE	69826A	F-16 MLG	DRAG STRUT	1620-01-101-1700	16 APR 86	45A6-32-3	
COOP TOLM	69833A	F-111 MLG	STRUT ASSY-SHOCK HM	1620-01-103-1950	1130100-503	451-07-3	50
DELE	69834A	F-16 MLG	DRAG STRUT	1620-01-070-9360	26 MAR 86	45A6-32-3	30
DELE	69853A	B-52	BOX END CROSSOVER	1005-00-890-9671	28 OCT 86	11F8-3-7-3	
COOP TOLM	69855A	G B-52 MLG	STEERING PLATE	1620-00-605-2760	5-60457-5	451-57-3	30
MART SHEL	69857A	A-10	EQUALIZER GAU-8	1005-01-003-0383	205F000	11W1-7-14-3	06
DELE	69865A	A-10	DRUM ASSY GAU-8	1005-01-003-1436	05-20-07	11W1-7-14-3	
DELE	69873A	J C-47 MLG	BRAKE	1630-00-959-2052	25 NOV 86	481-5-23	
DELE	69875A	E-101 MLG	UPPER TRUNNION ASSY	1620-01-005-3412	10 OCT 80	444-15-3-2	50
COOP TOLM	69887A	B-52 TIP	OUTER CYLINDER	1620-00-705-7201	5-96053-501	456-2-3-1	42
MONR ANDE	69898A	C-5A MLG	FORWARD DRAG LINK	1620-00-115-7433	4651437-107A	452-67-3	30
MONR ANDE	69899A	C-5A MLG	LOWER BEARING	3120-00-150-1799LE	4694453-101B	452-67-3	30
DELE	69915A	B-52	AMMO CAN	1005-00-21-3225	28 OCT 86	11W1-34-3-1	
DELE	69920A	E-16 MLG	STRUT ASSY	1620-01-070-2749	20 FEB 87	452-00-3-3	
CALD TOLM	71069A	F-111 MLG	LINK ASSY	1620-00-415-0200	12L9540-13	444-15-3	5
DELE	72827A	C-5A MLG	COMP. LINK	1620-00-007-0005	12 DECEMBER 86	451-04-31-3	
DELE	72836A	C-5A MLG	LOWER SIDE BRACE ARM	1620-00-115-7307	5-OCT-87	451-93-3	
DELE	72846A	G C-5A MLG	FLUID TRANS HOUSING	1620-00-110-7019	12 DECEMBER 86	451-93-3-1-103	12
MONR ANDE	72840A	C-0A MLG	UPPER TORQUE ARM F&C	1620-00-235-7031	0030432-101A	452-67-3-72	20
DE	72852A	C-5A MLG	TRUNNION PIN	1620-00-116-2099	4612400-101A	451-93-3	
DE	72877A	G C-5A MLG	STRUT ASSY	1620-00-432-5651	4651403-1036	452-67-3	40
MONR ANDE	72879A	C-5A MLG	OUTER CYLINDER	1620-00-446-3776	4611415-107A	451-93-3	

B-52 MAIN WHEEL

WHEEL ASSY
PCN 69595A
WCD 16106N

WHEEL HALF
INBOARD
PCN 69595A
WCD 16105N

WHEEL HALF
OUTBOARD
PCN 69595A
WCD 16102N

WCD 16106N
PCN 69595A
88245

IN
Induct into
System

1A
LOAD onto
conveyor/workbench

1B
Disassemble
wheel halves

WCD 16102N
88281

WCD 16105N
88281

6
Remove bearing race
from wheel half

6
Remove bearing race
from wheel half

7
Load onto chem
clean line

7
Load onto chem
clean line

7A
Cleaning Process

7A
Cleaning Process

7B
Unload from
cleaning line

9
Blast wheel
half

10
Remove Bearings
Bore bushing
(If Required)

11
Blast bearing
Bore bushing area
(If removed)

12
LOAD onto
Anodize strip
line

12A
Anodize strip

15/15A
Flourescent Particle
Inspect

7B
unload from
Cleaning line

9
Blast wheel
half

10
Remove Drive
Key bushings
(If Required)

11
Remove bearing
bore bushing
(If Req)

12
Blast bearing bore
bushing area
(If Removed)

13
LOAD onto Anodize
Strip line

13A
Anodize strip

15B
Unload from
FPI line

19
Nick and Burr

40
E and I
Inspection

60
machine wheel
half mating
surface

70
Repair Valve
stem hole
(if Required)

90
Tie bolt hole
repair (if Req.)

95
Pre Inspect Clean

15/15A
FPI Inspect

15B
Unload from
FPI line

19
Nick and Burr

40
E and I Inspection

50
Fusc Plug hole
repair

60
machine wheel
half mating
surface

70
Repair tie bolt
hole Boss face

80
Repair Tie bolt hole

95A
FPI. Inspection

85
Pre Inspection
Clean

150
Bearing Bore Seat
Repair (If Req)

85A
FPI Inspect

160
Bearing bore
Repair (If Req)

87
Bearing bore
Seat Repair

180
Bearing bore lock
Ring Girder Repair
(If Req)

90
Bearing bore
Repair

190
Cracked wheel
weight hole
Repair (If Req)

100
Machine Key
bolt holes

210
Cracked time counter
hole repair (If Req)

110
machine drive
Key index holes

220
Pre Inspect Clean

120
Machine wheel ID
Keyseat Area

220A
FPI Inspection

225
Clean wheel
half

230
Shot Peen

240
A, B, C, D, E, F
G, H, I, J, K
Anodize process

250
Install tie bolt
bushing

260
Install cup
into bearing bore
bushing

265
machine OD
of bushing &
cup Assy

140
Repair bearing
bore lock ring
Groove.

150
Repair cracked
wheel weight hole

155
Repair cracked
time counter hole

160
Pre Inspect clean

160A
FPI Inspection

170
Clean wheel
half

180
Shot Peen
wheel half

270
Install bushing
and cup Assy
into bearing
bore

280
Install cup
into bearing
bore lock ring
bushing

285
Machine O.D.
of bushing
and cup Assy

290
Install bushing
and cup Assy
into bearing
bore.

330
Install thread
inserts

350
Inspect, check paperwork
and load on oven
conveyor

190
A, B, C, D, E, F
G, H, I, J, K
Anodize Process
Type II Class I

200
Install tie bolt
bushing

204
Install cup in
bearing bore bushing

208
Machine OD of
bushing and cup Assy

210
Install Bushing and
cup Assy into bearing
bore

212
Install cup into
bearing bore lock
ring bushing

355
Heat wheel
halves in
oven

355A
Install bearing
race in wheel
half

355B
move part to
unloading conveyor

360
LOAD Paint
line

360A
Trichloroethane
wash wheel
half

360B
MASK AS Req.

360-C
Prime wheel
half

216
machine OD of
bushing & Cup Assy

220
Install Bushing &
Cup Assy into bearing
bore

225
machine key bolt
hole bushing

230
Install key bolt
hole bushing

235
machine drive key
Index hole bushing

240
Install Drive key
index hole bushing

270
move, check paperwork
load onto bearing oven
conveyor

360D
Mandatory Dry
time

360E
1st Coat Paint

360F
2nd Coat Paint

360G
mandatory dry
time

360H
Strip Masking
and plugs

360I
unload from
paint line

380 (390,400)
Assemble Seals,
Check paperwork
Inspect.

275
Heat wheel
half

275A
Install bearing
race into wheel
half

275B
unload onto
conveyor that feeds
paint line

280
Load paint line

280A
trichloroethane
wash

280B
MASK & Plug

280C
Prime wheel
halves

280 D
Mandatory Dry
Time

280 E
1st Coat Paint

280 F
2nd Coat paint

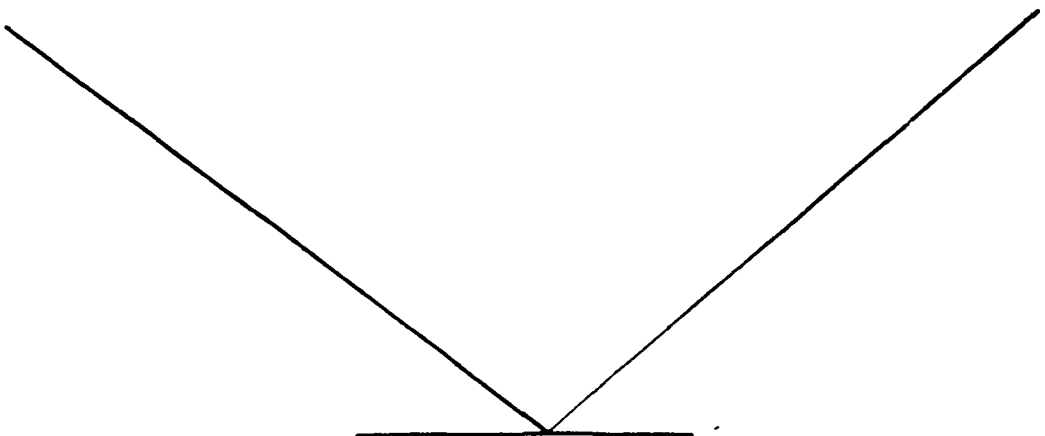
280 G
Minimum dry
time

280 H
Remove masking
and Plugs

280 I
LOAD onto wheel
balance Conveyor

290
Balance

295
Assemble seals
Check paper work
Visual Inspection



WCD 16106N

¹⁰
Match-up

¹⁵
Assembly

²⁰
Touch up paint

⁹⁹⁷
Final paperwork
check

⁹⁹⁸
Final Visual
Inspection

⁹⁹⁹⁹
SELL

16106N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88245

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO
		6W-1-61 101-7-1		

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
101-7-1		
13. SERIAL NUMBER	14. NOUN	
	APPLICABLE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
17N		1630009009739 15139A 1630012286043 69595A2			
3-1192					
3-1192-1					

*****UNIT COST \$2000.00****
GOVERNING DIRECTIVES: AFLOR 65-51
HANOI 65-2

*****ALUMINUM*****

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

*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (O/F MOVED) FOR MOVED BETWEEN OPERATIONS/ALLOCATION STATIONS.

*****"W A R N I N G"*****
MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.

REQD (MANDATORY REQUIREMENTS) IN (CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16106N
		B	D	

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1 DATE 88245

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		OCCLUR 18 IS EQUIVALENT TO DELTA STAMP.			
	001	3-1192 3-1192-1			
13	010 *REQD*	*MATCH-UP* ROUTED COMPONENTS NEW/SERVICEABLE REWORK NO RWORK		001 MATCH-UP 002 07 003 MOD 2	
		WHEEL HALF SUBASSY (D.B.) 16102N WHEEL HALF SUBASSY (I.B.) 16105N			
13	015 *REQD*	ASSEMBLE *O/P. MOVES*		001 ASSEMB 002 07 003 WAB 3	
13	020 *REQD*	FINAL TOUCH UP PAINT *O/P. MOVES*		001 BRUSH 002 09 003 TOUCH	
13	997 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 98		001 BRUSH 002 09 003 TOUCH	
13	998 *REQD*	FINAL PRODUCT VISUAL INSPECTION		001 BRUSH 002 09 003 TOUCH	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16-000N
		B	D	

15102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89201

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC REPAIR		5. DATE SCHED		6. DATE COMPLETED				
7. PART NUMBER				8. TECH DATA AD-1-01 AD-1-01				9. ITEM SERIAL NO.				
10. MODEL-DESIGN-SERIES 15102N			11. STOCK NUMBER			12. OPTIONAL 15139A						
13. SERIAL NUMBER			14. NOUN WHEEL HALF OUTBOARD									
15. DISPATCH STATION F/A		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED NBR 179 300-255 O.E. ASSY N.S.L. 15102A 300-255-1 DB ASSY 1630011112990 69595A			18. MECHANIC		19. "P"		20. "Q"	
				GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3								
				FPI IAW MIL-STD-6864								
				SHOT PEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625								
				*****2014-T6 ALUMINUM*****								
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.								
				COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (O/P ROVE) - MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.								
				WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.								
				*EEDS (MANDATORY REQUIREMENTS) - DELTA 16 IS EQUIVALENT TO DELTA (CONTINUED)								
21. FINAL DESTINATION DISPATCH FUNCTIONAL CODE			22. COORDINATION/INITIATING RCC SIGNATURE/DATE A C B D						23. DOCUMENT/SM			

101020 WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
		001		300-255 300-255-1						
34D		005		DISASSEMBLE					001 300-255 002 02 003 003	
		REQD								
34D		006		REMOVE LINK FROM WHEEL BUSH					001 300-255 002 02 003 003	
		REQD								
34C		007		OIL CLEAN					001 300-255 002 02 003 003	
		REQD								
34B		009		BLAST					001 300-255 002 02 003 003	
		REQD								
34C		010		REMOVE BUSHING FROM WHEEL BUSH					001 300-255 002 02 003 003	
		01								
34B		011		BLAST BUSHING REMOVAL WHEEL					001 300-255 002 02 003 003	
		01								
34C		012		ANODIZE STRIP					001 300-255 002 02 003 003	
		REQD								
				WEIGHT HOLE CRACKED COUNTER HOLE CRACKED (CONTINUED)					001 300-255 002 02 003 003	
		REQD								

FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	101 020	
		B	D		

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL HALF OUTBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	019 *REPAIR*	NICK & BURR *C/P MOVE*		001 MR: BW 002 04 003 NB04	
34E	040 *REPAIR*	E 3.1 AND RUDE BEARING BORE 7.980 MIN TO 7.992 MAX *C/P MOVE*		001 MR: BW 002 04 003 01 2	
	060	MACHINE RATING SUPPLY LAG 601 65H82291 *C/P MOVE*		001 MR: BW 002 01 003 LE05	
	070	VALVE STEM GLE REPAIR OUTBOARD IAW 65H82291 *C/P MOVE*		001 MR: BW 002 01 003 01 2	
	090	TIE BOLT HOLE REPAIR IAW 65H82291 65P22394, 65H82292 *C/P MOVE*		001 MR: BW 002 01 003 01 2	
		NDI NOTE	M	001 MR: BW 002 05 003 2Y05	
	150	BEARING BORE SEAT REPAIR OUTBOARD IAW 65B31152 *C/P MOVE*		001 MR: BW 002 01 003 MR: A	
	160	BEARING BORE REPAIR IAW 65B31152-30 *C/P MOVE*		001 MR: BW 002 01 003 MR: A	
	180	BEARING BORE LOCK REPAIR (OUTBOARD) *C/P MOVE*		001 MR: BW 002 01 003 MR: A	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	161000
		B	D	

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1 DATE 88281

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN WHEEL HOLE REPAIR

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

✓ 69 Y	190 .01	CRACKED WHEEL WEIGHT HOLE REPAIR *C/P MOVE*		001 2000 002 01 003 6812	

✓ 69 1	210 .01	CRACKED TIME COUNTER HOLE REPAIR *C/P MOVE*		001 2000 002 01 003 DR02	

✓ 69 1	220 .01	CRACKED TIME COUNTER AND WEIGHT HOLE AFTER REPAIR *C/P MOVE* NDI NOTE	M	001 2000 002 05 003 ZY05	

✓ 26	225 *REQD*	CLEAN WHEEL *C/P MOVE*		001 2000 002 02 003 1001	

✓ 69	230 *REQD*	SHOT PEEN CW-26 SIZE 12 BALL BEARING 0.012 TO 0.014 A2 *C/P MOVE*		001 2000 002 01 003 SP02	

✓ 26	240 *REQD*	ANDSIZE TYPE 11 CLAVE 1 *C/P MOVE*		001 2000 002 02 003 AS02	

✓ 69 1	250 .04	INSTALL TIE BOLT HOLE BEARING FOR FINISH IAW 65H22291, 65H22292, 65H22293 PRESS FIT 1000/1001 *C/P MOVE*		001 2000 002 01 003 BE01	

✓ 69 1	260 .04	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVE* P/N 67324 P/N 42021152-33		001 2000 002 01 003 BE01	

✓ 69 1	265 .04	MACHINE O.D. OF BUSHING & CUP ASSY P/N N.P.L.		001 2000 002 01 003 LE09	

✓ 69 1	270 .04	INS ALL BUSHING & CUP ASSEMBLY INTO BEARING BORE *C/P MOVE* P/N N.P.L.		001 2000 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	16102N	
		B	D		

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

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

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

13. SERIAL NUMBER	14. NOUN WHEEL HALL OUTBOARD

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

69	200 .04	INSTALL CUP INTO BEARING BORE LIKE RING BUSHING P/N 67324 P/N 00		001 BR KH 002 01 003 BE01	

69	205 .01	MACHINE O.D. OF BUSHING AND CUP ASS P/N N.P.L.		001 BR KH 002 01 003 LE09	

69	290	INSTALL BUSHING & CUP ASSEMBLY INTO BEARING BORE *C/P COVER*		001 BR KH 002 01 003 BE01	

70	200 *RECU*	INSTALL HELICAILS *C/P COVER*		001 BR KH 002 01 003 BE01	

70	350 *RECU*	PRE-FINAL INSPECTION AND ADJUSTABLE *C/P COVER*		001 BR KH 002 07 003 PF05	

70	355 .47	RACE INSTALLATION P/N 67324 *C/P COVER*		001 BR KH 002 07 003 R106	

70	360 *RECU*	PAINT *C/P COVER*		001 BR KH 002 09 003 BE02	

70	370 *RECU*	BALANCE *C/P COVER*		001 BR KH 002 07 003 WE01	

70	380 *RECU*	INSTALL SEALS & RETAINERS *C/P COVER*		001 BR KH 002 07 003 WA03	

70	390 *RECU*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS PS		001 BR KH 002 07 003 WA03	

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

DISPATCH	FUNCTIONAL CODE	A	C	16102N
		B	D	

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1 DATE 22281

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF OUTBOARD						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
✓ 23	A 20 *READY*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVER*					001 100 01 002 07 003 WAUS		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
		B		D					

16105N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC MNFOW		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 4W-1-61 4W-7-1-41				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES BL 1 MAIN			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF INSECT			15139A			
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
PZ		NSN 15139A							
300-254	I.B. ASSY N.S.L.	1630011119667				69595A			
300-254	-1 IB ASSY								
		GOVERNING DIRECTIVES: AFLOK 66-51 MANUL 66-2							
		FPT IAW MIL-STD-8836							
		SHOT PEEN IAW MIL-S-13163							
		ANODIZE IAW MIL-A-8625							
		*****2014-T6 ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (EPA MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		REDD (MANDATORY REMOVAL) IN COLUMN 16 IS EQUIVALENT TO DELTA (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				16105N			
		B							

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1 DATE 88081

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF INBOARD						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		START							
	001	300-254 300-254-1							
34D	005	DISASSEMBLE *C/P MOVE*					001 MNR SW 002 02 003 WD03		
	REQD								
34D	006	REMOVE CUP FROM WHEEL HALF *C/P MOVE*					001 MNR SW 002 02 003 WD03		
	REQD								
34C	007	CHEM CLEAN *C/P MOVE*					001 MNR SW 002 03 003 AC02		
	REQD								
34B	009	BLAST *C/P MOVE*					001 MNR SW 002 03 003 BL01		
	REQD								
69	010	REMOVE DRIVE KEY UNDER BUSHING IF REQUIRED *C/P MOVE*					001 MNR SW 002 01 003 BK02		
	08								
69	011	REMOVE BEARING BORE BUSHING IF REQD *C/P MOVE*					001 MNR SW 002 01 003 BK01		
	01								
34B	012	BLAST BUSHING REMOVAL AREA *C/P MOVE*					001 MNR SW 002 03 003 BL01		
	04								
34C	013	GRINDING FINISH *C/P MOVE*					001 MNR SW 002 03 003 BK03		
	REQD								

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16105N
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16105N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88281

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF INBOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WEIGHT HOLE CRACKED COUNTER HOLE CRACKED *REQD*		001 000000 002 00 003 ZY05	
34E	019 *REQD*	NICK & BURR *C/P MOVE*		001 000000 002 04 003 NB04	
34E	040 *REQD*	E & I AND ROUTE DRIVE KEY INDEX HOLE .628 MIN .630 MAX BEARING BORE 7.903 MIN 7.992 MAX *C/P MOVE*		001 000000 002 04 003 EI02	
67 ✓	050 .01	FUSE PLUG HOLE REPAIR INBOARD IAW FIG 1A *C/P MOVE*		001 000000 002 01 003 0002	
67 ✓	060 .01	MACHINE MATING SURFACE IAW DWG 65H32391 *C/P MOVE*		001 000000 002 01 003 LE05	
67 ✓	070 .01	TIE BOLT HOLE BOSS FACE REPAIR IAW 65H32391 *C/P MOVE*		001 000000 002 01 003 BR02	
67 ✓	080 .01	TIE BOLT HOLE REPAIR IAW 65H32391, 65B32394, 65B32392 *C/P MOVE*		001 000000 002 01 003 BR02	
		NDI NOTE *C/P MOVE*	N	001 000000 002 05 003 ZY05	
67 ✓	087 .01	BEARING BORE SEAT REPAIR (INBOARD) IAW 63B31152 *C/P MOVE*		001 000000 002 01 003 MV04	
67 ✓	090 .01	BEARING BORE REPAIR (INBOARD) IAW FIG DWG 63B31152-00 *C/P MOVE*		001 000000 002 01 003 LV02	

1. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	16105N
		B	D	

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	100	MACHINE KEY BOLT HOLES INBOARD IAW 68402291, 68102093 *C/P MOVE*		001 000000 002 01 003 DR02	
69	110	MACHINE DRIVE KEY INDEX HOLES INBOARD IAW FIG 4 *C/P MOVE*		001 000000 002 01 003 DR02	
69	120	MACHINE INBOARD WHEEL ID KEY SEAT AREA TO REMOVE CORROSION IAW DWG CONCLOT1 *C/P MOVE*		001 000000 002 01 003 LY02	
69	140	BEARING BOLT LOCK RING GROOVE (WHEEL INBOARD) *C/P MOVE*		001 000000 002 01 003 MV04	
69	150	CRACKED WHEEL MOUNT HOLE REPAIR FILE 1200 *C/P MOVE*		001 000000 002 01 003 DR02	
69	160	CRACKED LINE COUNTER HOLE REPAIR HOLE #10 *C/P MOVE*		001 000000 002 01 003 DR02	
69	170	WHEEL WHEEL HOLE LINE COUNTER HOLES AFTER REPAIR *C/P MOVE*	M	001 000000 002 01 003 ZY05	
69	180	CLEAN WHEEL *C/P MOVE*		001 000000 002 01 003 BE01	
69	190	SHOT PEEN WHEEL GLE TO INTENSITY OF 0.012 TO 0.014 A2 *C/P MOVE*		001 000000 002 01 003 SP01	
69	190	ANODIZE WHEEL *C/P MOVE*		001 000000 002 01 003 AD03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16105N
		B	D	

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69 ✓	200	INSTALL TIE BOLT BUSHINGS 1ST REPAIR IAW 65B32391, 65B32393, 65H32391 *C/P MOVE*					001 MMRA 002 01 003 BE01		
69 ✓	204	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVE* P/N 67324 P/N 48R31152-23					001 MMRA 002 01 003 BE01		
69 ✓	208	MACHINE O.D. OF BUSHING AND CUP ASSY *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 LE09		
69 ✓	210	INSTALL BUSHING & CUP ASSY INTO BEARING BORE *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 BE01		
69 ✓	212	INSTALL CUP INTO BEARING BORE LOCK RING BUSHING *C/P MOVE* P/N 67324 P/N 001					001 MMRA 002 01 003 BE01		
69 ✓	216	MACHINE O.D. OF BUSHING & CUP ASSY *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 LE09		
69 ✓	220	INSTALL BUSHING & CUP ASSY INTO BEARING BORE *C/P MOVE* P/N N.P.L.					001 MMRA 002 01 003 BE01		
69 ✓	225	MACHINE KEY BOLT HOLE BUSHINGS P/N 65B32393-01 (INBOARD) IAW DWG 65H32391 & 65B32393					001 MMRA 002 01 003 LE02		
69 ✓	230	INSTALL KEY BOLT HOLE BUSHINGS IAW 65H32391 & 65B32393 INBOARD PRESS FIT .001/.001 *C/P MOVE*					001 MMRA 002 01 003 LE01		
69 ✓	235	MACHINE DRIVE KEY INOX HOLE BUSHING P/N 65B32393-03 (INBOARD) FINISH TO .6267/.625 IAW FIG 3 & 4					001 MMRA 002 01 003 LE02		

1. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	16105N	
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1 DATE 880801

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN BUSHING - 1 IN BOARD						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	240	INSTALL DRIVE KEY INDEX TUBE BUSHING JAW FIG 2 & 4 INBOARD .003 PRESS FIT *C/P MOVE*					001 TR 06 002 01 003 0501		
✓ 18	270	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVE*					001 TR 07 002 07 003 PF 15		
✓ 16	275	RADE INSTALLATION P/N 67024					001 TR 06 002 07 003 R106		
✓ 11	280	PAINT *C/P MOVE*					001 TR 07 002 09 003 B002		
✓ 10	290	BALANCE *C/P MOVE*					001 TR 07 002 07 003 0501		
✓ 10	295	INSTALL SEALS & RETAINERS *C/P MOVE*					001 TR 07 002 07 003 WA 13		
✓ 10	300	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY INBOARD OF ALL PRECEDING OPERATIONS THIS 958					001 TR 07 002 07 003 WA 13		
✓ 13	310	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE*					001 TR 07 002 07 003 WA 13		
FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16105h			
		B		D					

16106N WORK CONTROL DOCUMENT (MEDS)				1 DATE 28006		PAGE 1 OF 1 PAGES	
2 JOB ORDER NO 69575 A		3 QUANTITY 1 ea		4 PRODUCTION SEC RCC MNEGW		5 DATE SCHED	
6 DATE COMPLET_D		7 PART NUMBER		8 TECH DATA 4W-1-01		9 ITEM SERIAL NO 5805-5167	
10 MODEL DESIGN SERIES B02 MAIN		11 STOCK NUMBER 4W-1-01		12 FUNCTIONAL PAC			
13 SERIAL NUMBER		14 NOUN WHEEL ASSY					
15 DISPATCH STATION		16 PERF RCC OP NO		17 WORK TO BE ACCOMPLISHED		18 MECHANIC	
19 P		20 Q					
P/N 3-1192 3-1192-1		NSN 1630009009739 1630012286043		C/N 15139A 69595A			
		*****UNIT COST \$2500.00*****		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3			
		*****ALUMINUM*****					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
		*****WARNING***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE DATE		23 DOCUMENT/SN			
DISPATCH		FUNCTIONAL CODE		A		C	
				B		D	
						16106N	

16106N WORK CONTROL DOCUMENT (MEDS)

1 DATE

FEB 80

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES		11 STOCK NUMBER			12 OPTIONAL				
13 SERIAL NUMBER		14 NOUN							
		WHEEL ASSY							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
13	005	RECORD WHEEL S/N _____ P/N _____							
		****ROUTED COMPONENTS****							
		NEW/ REWORKED NO SERVICABLE 95E REWORK							
		WHL INBOARD 16105N WHL OUTBOARD 15102N							
13	010 *REQD*	ASSEMBLE *C/P MOVE				15102N 71152			
13	020 *REQD*	FINAL TOUCH UP PAINT *C/P MOVE				09 JUN 1988 700			
13	997	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95E				09 JUN 1988 700			
13	998	FINAL PRODUCT VISUAL INSPECTION				09 JUN 1988 700			
		COORDINATED BY: PLANNING: LARRY PRICE WF MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16105N			
		B		D					

2 JOB ORDER NO 395A/83A		3 QUANTITY 1EA		4 PRODUCTION SEC RCC MNPGW		5 DATE SCHED MAY 09 1980		6 DATE COMPLETED					
7 PART NUMBER				8 TECH DATA 4W-1-61 4W1-7-1143				9 ITEM SERIAL NO 5805 (6)					
10 MODEL DESIGN SERIES B52 MAIN				11 STOCK NUMBER				12 OPTIONAL					
13 SERIAL NUMBER				14 NOUN WHEEL HALF OUTBOARD									
15 DISPATCH STATION		16 PERF RCC OP NO		17 WORK TO BE ACCOMPLISHED				18 MECHANIC		19 P		20 "Q"	
P/N				NSN C/N									
3-1192 ASSY				1630009009739 15139A									
10-1062 (O/B)				NSL 15139A									
3-1192-1 ASSY				1630012286043 69595A									
10-1062-1 (O/B)				1630011112990 69595A									
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3									
				FPI IAW MIL-STD-6866									
				SHOT PEEN IAW MIL-S-13165									
				ANODIZE IAW MIL-A-8625									
				*****2014-T6 ALUMINUM*****									
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.									
				*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.									
				WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)									
21 FINAL DESTINATION				22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN					
DISPATCH		FUNCTIONAL CODE		A		C						16102N	
				B		D							

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DATE 8E063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCT:ON SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
34D	001	DISASSEMBLE *REQD* *C/P MOVE							
		MAY 09 1988							
34C	002	CLEAN AS REQ'D *REQD* *C/P MOVE							
		10 MAY 1988							
69	005	REMOVE FAERING BORE BUSHING IF REQD *C/P MOVE*							
34C	007	BLAST PUSHING REMOVAL AREA *REQD* *C/P MOVE*							
		10 MAY 1988							
34	010	YPI WEIGHT HOLE CRACKED YES/NO COUNTER HOLE CRACKED *REQD* *C/P MOVE							
		10 MAY 1988							
34	030	NICK & BURR *REQD* *C/P MOVE							
		10 MAY 1988							
34	040	E & I AND ROUTE BEARING BORE 7.988 MIN TO 7.992 MAX *REQD* *C/P MOVE							
		10 MAY 1988							
69	060	MACHINE MATING SURFACE IAW DWG 65H32391 *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
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DATE 66063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	070	VALVE STEM HOLE REPAIR OUTBOARD IAW 65H32391 *C/P MOVE					M		
69	090	TIE BOLT HOLE REPAIR IAW 65H32391, 65B32394, 65B32392 *C/P MOVE							
34	095	FPI *C/P MOVE				M	K		
69	150	BEARING BORE SEAT REPAIR (OUTBOARD) IAW 65B31152 *C/P MOVE*							
69	160	BEARING BORE REPAIR (OUTBOARD) IAW 63B31152-33 *C/P MOVE							
69	180	BEARING BORE & LOCK RING GROOVE REPAIR (OUTBOARD) *C/P MOVE							
69	190	CRACKED WHEEL WEIGHT HOLE REPAIR *C/P MOVE							
69	210	CRACKED TIME COUNTER HOLE REPAIR *C/P MOVE							
69	220	FPI TIME COUNTER AND WEIGHT HOLE AFTER REPAIR *C/P MOVE				M	K		
26	225 *REQD*	CLEAN WHEEL *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
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16102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 86063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES				11 STOCK NUMBER				12 OPTIONAL	
13 SERIAL NUMBER				14 NOUN WHEEL HALF OUTBOARD					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
26	230	SHOT PEEN CW-28 SIZE TO INTENSITY OF 0.012 TO 0.014 A2 *REQD* *C/P MOVE				70344			
26	240	ANODIZE TYPE II CLASS I *C/P MOVE *REQD*				71097			
69	250	INSTALL TIE BOLT HOLE BUSHING AND MACHINE IAW 65H32391 65P32393 65H32591 PRESS FIT .000/.001 *C/P MOVE					M		
69	270	MFG & INSTALL BEARING BORE BUSHING AND CUP (OUTBOARD) IAW DWG 63B31152 PRESS FIT .007/.012 *C/P MOVE					M		
69	290	MFG & INSTALL BEARING BORE & LOCK RING BUSHING WITH CUP (OUTBOARD) PRESS FIT .007/.012 *C/P MOVE					M		
69	330	INSTALL HELICOILS *C/P MOVE *REQD*				70629			
13	350	OK TO ASSEMBLE *C/P MOVE *REQD*					M		
13	360	PAINT *C/P MOVE *REQD*							
13	370	BALANCE *C/P MOVE *REQD*							
13	380	INSTALL SEALS & RETAINERS *C/P MOVE *REQD*							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
		B		D					

16102N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88063

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF OUTBOARD						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
13	390 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958				7115	71152		
13	400 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE JUN 9 1988					M		
		COORDINATED BY: PLANNING: LARRY PRICE WK MEASURE: DOUGLAS JENSEN SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		16102N			
		B		D					

15125A WORK CONTROL DOCUMENT (MEDS)				DATE	PAGE	OF	PAGES
2 JOB ORDER NO		3 QUANTITY		4. PRODUCTION SEE RCC		5 DATESCHED	
69595A/83A		1ea				11 APR. 1988	
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO			
		4w-1-61		5167			
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL			
102 MAIN							
13 SERIAL NUMBER		14 NOUN					
		WHEEL HALF INNOA-D					
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED		18 MECHANIC	19 P	20	
I/N		NSN					
3-1192	ASSY	1632229079739		1513950			
12-1261	(I/P)	NSL		15139A			
3-1192-1	ASSY	1632212083243		69095A			
12-1261-1	(I/P)	1632311119667		69095A			
		GOVERNING DIRECTIVES: AFMCR 65-51					
		NANCI 66-3					
		PPI		IAW MIL-STD-883C			
		SHOT PEEN		IAW MIL-3-13165			
		ANODIZE		IAW MIL-A-8625			
		*****2214-16 ALUMIUM*****					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS THEREON. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
		COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
		WARNING					
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO					
		(CONTINUED)					
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT'S			
DISPATCH	FUNCTIONAL CODE	A	C	16105N			
		B	D				

1512EN WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 200

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN						
			WHEEL HALL INDOARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
31D	221	DISASSEMBLE *C/P MOVE 11 APR 1988				71438	71438		
34C	222	CLEAN AS REQ'D *C/P MOVE APR 11 1988				70025	70025		
66	5326	REMOVE BEARING BORE BUSHINGS IF REQUIRED *C/P MOVE 11 APR 1988				70339	70339		
66	225	REMOVE DRIVE KEY INDEX BUSHINGS IF REQUIRED *C/P MOVE*							
34	210	EPI *REQD* WEIGHT HOLE CRACKED COUNTER HOLE CRACKED *C/P MOVE YES NO				70298	70298		
34	232	NICK & BUFF *C/P MOVE 13 APR 1988				70298	70298		
34	242	E & I AND ROUTE *REQD* FIVE #1 INDEX HOLE .628 MIN .632 MAX BEARING BORE 7.985 MIN 7.992 MAX *C/P MOVE APR 12 1988				70298	70298		
66	252	FUSE PLUG HOLE REPAIR INDOARD IAW FIG 1A *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT'SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						1512EN			

15165N WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 1 OF 1

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SERIAL		5 DATE SHIPPED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN		15					
		WHEEL HALF INFOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 C	
59	260	MACHINE MATING SURFACE IAW DAG 65H32391 *C/P MOVE				58			
69	274	TIE BOLT HOLE LOSS FACE REPAIR IAW 65H32391 *C/P MOVE							
34	275	F.P.I. *C/P MOVE							
69	282	TIE BOLT HOLE REPAIR IAW 65H32391, 65H32394, 65H32392 *C/P MOVE							
34	285	FPI *C/P MOVE							
69	287	BEARING BOLE SEAT REPAIR (INFOARD) IAW 63H31182 *C/P MOVE							
69	294	BEARING BOLE REPAIR (INFOARD) IAW AF DAG 63H31182-33 *C/P MOVE							
69	122	MACHINE KEY BOLT HOLES INFOARD IAW 65H32391, 65H32393 *C/P MOVE							
69	112	MACHINE FIVE KEY INDEX HOLES INFOARD IAW FIC 4 *C/P MOVE							
69	122	MACHINE INFOARD WHEEL ID KEY SEAT AREA TO REMOVE CORROSION IAW DAG 65H32391 (CONTINUED)							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT'S N			
DISPATCH	FUNCTIONAL CODE	A		C		15165N			
		B		D					

15125A WORK CONTROL DOCUMENT (MEDS)

1 DATE

2007

PAGE 501 PAGE

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN			15			
			WHEEL HALL INICARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		*C/P MOVE							
69	142	BEARING HOLE & LOCK RING GROOVE REPAIR (INICARD) *C/P MOVE							
69	150	CRACKED WHEEL WEIGHT HOLE REPAIR HOLE .252 *C/P MOVE*							
69	155	CRACKED TIME COUNTER HOLE REPAIR HOLE #10 *C/P MOVE*							
69	152	FBI WHEEL WEIGHT AND TIME COUNTER HOLES AFTER REPAIR *C/P MOVE					K		
26	170	CLEAN WHEEL *C/P MOVE *RECD*							
26	182	SHOT PEEN CW-22 SIZE 10 INTENSITY OF 0.012 TO 0.014 A2 *RECD* *C/P MOVE							
26	192	ANCLIZE TYPE II CLASS I *C/P MOVE *RECD*							
69	212	INSTALL THE FOLT BUSHINGS 1ST REPAIR IAW 65P32391, 65P32393, 65P32391 *C/P MOVE					M		
69	212	WIG & INSTALL BEARING HOPE BUSHING AND CUP INICARD IAW IAW 65P31152 PRESS FIT .0277/.212 CONTINUED							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						15125A			

16100A WORK CONTROL DOCUMENT (MEDS)

1 DATE

20 JUN 88

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF INBOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 C	
		*C/P MOVE							
09	226	MFG & INSTALL BEARING BORE & LOCK RING BUSHING WITH CUP (INBOARD) PRESS FIT .227/.212 *C/P MOVE							
09	236	MACHINE & INSTALL KEY HOLE BUSHINGS IAW 60832391 & 60832392 INBOARD PRESS FIT .221/.221 *C/P MOVE							
09	242	MACHINE & INSTALL DRIVE KEY INDEX HOLE BUSHINGS IAW FIG 3 & 4 INBOARD .223 PRESS FIT *C/P MOVE				08 JUN 1988 70820	70820		
13	256	OK TO ASSEMBLE *C/P MOVE 08 JUN 1988 *FLOD*				71057	71057		
17	264	PAINT *C/P MOVE 08 JUN 1988 *FLOL*				70466			
13	280	BALANCE *C/P MOVE JUN 9 1988 *FLOL*				70126	70126		
13	298	INSTALL SEALS & RETAINERS *C/P MOVE JUN 9 1988 *FLOD*				70136	70136		
13	312	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY INBOARD OF ALL PRECEDING OPERATIONS THIS SEE *FLOD*				71152	71152		
13	312	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE JUN 9 1988 *FLOD*				71152	71152		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT'S N			
DISPATCH	FUNCTIONAL CODE	A				16100A			
		B				O			

PAGE 2 OF 2 PAGES

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SAME As PCN 69595A

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

RCC MNPW

441-7-1143 900-9739 81043

PER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION -----> BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

0001	S	N	KI	EA 5	J 88298	1.00	PERCENT ENGR 69.4	CLEAN WHEEL B-52	.92		.92		
0001			KI	01	00	.00		PART NO. / N.S.N.	.000	.000	.000	0	
			0010			3-1192		1630009009739					
			0020			3-1192-1		1630012286043					
0007			KI	01	27	1.00		CHEM CLEAN WHEEL	.116	.031	.147	16	
			0010	N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN /	.21200		.134		
			0020	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC/	.01001		.012		
0009			KI	01	27	1.00		BLAST CLEAN WHEEL LGE	.432	.117	.550	59	
			0010	E		RPL-SB-L2	1.00	SANDBLAST LARGE PART - HOIST	.31693		.402		
			0020	N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN	.21200		.134		
			0030	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0012			KI	01	27	.10		BLAST CLEAN WHEEL LGE	.432	.012	.055	6	
			0010	E		RPL-SB-L2	1.00	SANDBLAST LARGE PART - HOIST	.31693		.402		
			0020	N		ZLG-CL-M1	.50	LOAD & UNLOAD CARRIER CLEAN	.21200		.134		
			0030	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0013			KI	01	27	1.00		ANODIZE STRIP WHEEL ALUM	.136	.037	.173	.7	19
			0010	E		ZCD-ST-S1	1.00	ANODIZE STRIP	.12630		.160		
			0030	E		RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
9000			KI	01	27	.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
			0010					28DEC84 2 YEAR REVIEW/NO TIME CHANGE					
			0020					08MAY85 DWN GRD TO N STD (TM WAS .76)					
			0021					18SEPT86 2 YEAR REVIEW CHANGED OCC FACTOR STEP					
			0022					0010 SUBOP 0010 BOTH WHEELS HUNG ON 1 CARRIER					

0023

<OLD STL 2>

0900

KERRY COOP MANEL TECHN 73357

D INTERROGATE LABOR STANDARDS, INPUT

RCC PRO NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNFGW

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
001	S	E	HB	EA 5	J 88300	1.00 PERCENT ENGR 99.9	DISSY. WHEEL B-52 M.	1.52		1.52	
0001			HB	01	00	.00	PART NO. / N.S.N.	.000	.000	.000	0
0010						3-1192	1630009009739				
0020						3-1192-1	1630012286043				
0005			HB	01	25	1.00	DISASSEMBLE	.776	.194	.971	64
0010 E						RWB-JP-W1 1.00 PREP TO DISASSEMBLE WHEEL		.01630		.020	
0030 E						RWB-HT-C3 1.00 HANDLING TOOLS PER END ITEM		.13837		.172	
0040 E						RWB-DW-T1 27.00 REM UNOBSR WHL TIE BOLT 27 EACH		.01056		.356	
50 E						RWB-DW-K4 9.00 DIS WHL (REM MULTI SCW B/K) 9 EACH		.02060		.231	
0060 E						RWB-DW-C2 2.00 REM DATA PLATE & STAMP WHL 2 EACH		.03067		.076	
0070 E						RWB-DW-B1 2.00 REM BEARING (SNAP RING SEC) 2 EACH		.01227		.030	
0090 E						RWB-DW-M1 1.00 DIS WHL (V/L-L & M WHEELS)		.04265		.053	
0100 E						RWB-DW-H1 1.00 REM HEAT SHIELD (SINGLE PC)		.00217		.002	
0120 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC/		.01001		.012	
0130 E						RLG-RS-K1 1.00 /REMOVE TIE BOLT BUSHINGS		.01099		.013	
0006			HB	01	25	1.00	REMOVE BEARING CUPS	.442	.111	.553	.3 36
0010 E						RWB-BC-01 2.00 REMOVE BEARING CUPS		.16346		.408	
0020 E						RWB-MH-02 1.00 LOAD HOOK W/WHEELS F/CLEING		.10532		.131	
0030 E						RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000			HB	01	25	.01	LABOR STD HISTORY	.000	.000	.000	0
0010						26MAR85 2 YEAR REVIEW NO CHNG (OLD 1.01)					
0020						06JUN85 CHANGED SKL CODE NO TM CHNG					
0030						25JUN85 ADDED NICK&BURR TM (TM WAS 1.01)					

0031	20NOV85	LETED STEPS 0020,0115 SUPOP 0010 AND
0032		STEP 0030 SUBOP 0020 WORK NOT DONE IN HB SKILL
3		CODE <OLD STD 1.09>
0034		18SEPT86 2 YEAR REVIEW CHANGED NICK & BURR TIME
0035		<OLD STD .99>
0036		1DEC86 ADADDED STEP 0130 METHODS CHANGE (OLD 1.74)
0900		KERRY COOP MANEAA TECHN 73357

1 INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A B52 M WHEEL 3-1192 RCC MNPBW 4W1-7-1143 900-9739 81043

TECH S S W F PF A/R REV

SUB	T K	#R A FA	SUPPORT	OCC	DESCRIPTION		BASE	PFD	STD	A
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
102	E	N	DI EA 5	J 88302	1.00 PERCENT ENGR 10.2	E&I WHEEL HALF O.B. B-52 M.	.61		.61	
0001		DI	01 00		.00	PART NO. / N.S.N.	.000	.000	.000	0
0010					300-255	N.S.L.				
0020					300-255-1	1630011112770				
0019		DI	01 27		1.00	NICK & BURR WHEEL LGE/HALF	.333	.090	.423	69
0010 E			RLG-RS-NC		1.00	NICK & BURR PTS-CONST F/PREP	.02312		.029	
0020 N					1.00	NICK & BURR WHEEL LGE/HALF	.29987		.380	
0030 E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
		DI	01 15		1.00	E & I AND ROUTE WHEEL	.167	.025	.193	31
0010 N					1.00	E&I AND ROUTE WHEEL HALF	.14919		.171	
0020 E			RWB-OH-W2		1.00	REMV WHL HLF F/PAINT CONVDOR	.00833		.009	
0030 E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000		DI	01 15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010						MOVE N&B TO E&I FROM CLEAN				
0020						26MAR85 2 YEAR REV.NO CHNG (OLD TM .83)				
0021						20NOV85 DELETED STEP 0040 WORK PERFORMED IN HB				
0022						SKILL CODE <OLD STD .83>				
0023						19SEPT86 DELETED STEP 0010 WORK PERFORMED BY KI				
0024						SKILL <OLD STD .40>				
0900						KERRY COOP MANEL TECHN 73357				

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNPBW

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PF	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
105	E	N	DI	EA 5	J 88301	1.00 PERCENT ENGR 10.2	E & I WHEEL HALF INBD.B-S2M.	.61		.61	
0001		DI	01	00		.00	PART NUMBER / N.S.N.	.000	.000	.000	0
0010						300-254	N.S.L.				
0020						300-254-1	1630011119667				
0019		DI	01	27		1.00	NICK & BURR WHEEL LGE/HALF	.333	.090	.423	69
0010	E			RLG-RS-NC		1.00	NICK & BURR PTS-CONST F/PREP	.02312		.029	
0020	N					1.00	NICK & BURR WHEEL LGE/HALF	.29987		.380	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
		DI	01	15		1.00	E & I AND ROUTE WHEEL	.167	.025	.193	31
0010	N					1.00	E&I AND ROUTE WHEEL HALF	.14919		.171	
0020	E			RWB-OH-W2		1.00	REMY WHL HLF F/PAINT CONVOYOR	.00833		.009	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000		DI	01	15		.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							MOVE N&B TO E&I FROM CLEAN				
0020							26MAR85 2 YEAR REV.NO CHNG (OLD TM .83)				
0021							20NOV85 DELETED STEP 0040 WORK PERFORMED IN HB				
0022							SKILL CODE (OLD STD .83)				
0023							19SEPT86 DELETED STEP 0010 WORK PERFORMED BY KI				
0024							SKILL (OLD STD .40)				
0900							KERRY COOP MANEL TECHN 73357				

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHL 3-1192

RCC MNPNA

4W1-7-1143

ER TECH S S W F PF A/R REV

SUB	T K	HR A FA SUPPORT	OCC	DESCRIPTION	BASE	PF	STD	A	
STEP D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

102	S	E DB EA 2	J 88302	1.00 PERCENT ENGR 99.9	NDI WHEEL HALF O.B. B-52M.	.02		.02	
0001		DB 01 00		.00	PART NO. / N.S.M.	.000	.000	.000	0
0010				300-255	N.S.L.				
0020				300-255-1	1630011112990				
0095		DB 01 11		.05	FPI 16102N	.181	.001	.010	50
0010 E		ZLG-ND-23	1.00	ZYGLO INSP LARGE PART BLD507,		.17130		.190	
0020 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
0220		DB 01 11		.05	FPI COUNTER HOLE 16102N	.181	.001	.010	50
10 E		ZLG-ND-23	1.00	ZYGLO INSP LARGE PART BLD507,		.17130		.190	
0020 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
9000		DB 01 00		.01	LABOR STD HISTORY	.000	.000	.000	0
0010				20NOV85 REMOTE STD TO MATCH 958 <OLD STD .96>					
0020				20MAY87-DELETED SUBOP 0085 NOT DONE OLD STD .46					
0900				KERRY COOP MANEAA TECHN 73357					

O INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A B52 M WHL 3-1192

RCC MNPNA

4W1-7-1143

ER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
4105	S	E	DB EA 2	J 88301	1.00 PERCENT ENGR 99.9	NDI WHEEL HALF INBD. B-52M.	.01		.01	
0001			DB 01 00		.00	PART NO. / N.S.N.	.000	.000	.000	0
0010					300-254	N.S.L.				
0020					300-254-1	1630010009667				
0085			DB 01 11		.05	FPI	.171	.001	.010	.8 50
0010 E			ZLG-ND-23	1.00	ZYGLD INSP LARGE PART BLD507		.17130		.190	
0160			DB 01 11		.05	FPI	.171	.001	.010	.8 50
0010 E			ZLG-ND-23	1.00	ZYGLD INSP LARGE PART BLD507		.17130		.190	
			DB 01 00		.01	LABOR STD HISTORY	.000	.000	.000	0
0010					20NOV85 REWROTE STD TO MATCH 958 <OLD STD .96>					
0020					20MAY87-DELETED SUBOP 0085 NOT DONE OLD STD .46					
0900					KERRY COOP MANEAA TECHN 73357					

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MNPNA

02/01/89
4W1-7-1143

A-E0468-MH1-DY-M45 PAGE 0001

OPER	TECH	S	S	W	F	P	F	A/R	REV	STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
15139A	B52	M	WHL	3-1192																				
0015	DB	01	11																					
0020	DB	01	11																					
0010	E																							
0010	E																							
2000	DB	01	00																					
0010																								
0020																								
0030																								
0040																								
2001	DB	01	11																					
0010	E																							
9000	DB	01	00																					
0010																								
0900																								

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRG MROP NR

<---><---><--->

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15139A B52 M WHEEL 3-1192

RCC MPRA

4M1-7-1143 900-9739

ER TECH S S W F PF A/R REV

SUB	T K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A				
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C
102	S	E	JA	EA	1	J 88302	1.00 PERCENT ENGR 99.9	MACH. B52M. WHL. OUTBOARD		1.34		1.34			
0001			JA	01	00		.00	PART NO. / N.S.N.		.000	.000	.000		0	
0010							300-255	N.S.L.							
0020							300-255-1	1630011112990							
0010			JA	01	15		.07	REM BEARING BORE BUSH, LARGE		.846	.009	.068		5	
0010	E					RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 8 PARTS		1.03687		.298			
0020	E					RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	JIG BORE		.15776		.181			
0030	E					RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146			
0040	E					RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087			
0050	E					KMM-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1			.21626		.248			
0060	E					RJP-PW-R1	1.00 REM RPL PAPR MARK SIGN OFF DOC			.01001		.011			
0060			JA	01	15		.05	MACHINE MATTING SURFACE		.263	.002	.015		1	
0010	E					RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143			
0020	E					RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011			
0030	E					KML-TA-JC	1.00 DIA 5.00-6.00 REM .033-.250			.09193		.105			
0040	E					KML-TA-JD	1.00 DIA 6.0 REM .250 ADD INCH			.02665		.030			
0050	E					RJP-PW-R1	1.00 REM RPL PAPR MARK SIGN OFF DOC			.01001		.011			
0070			JA	01	15		.05	VALVE STEM HOLE REP RAD DR		.459	.003	.026		2	
0010	E					RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 8 PARTS		.56378		.162			
0020	E					RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL			.30463		.350			
0030	E					RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004			
0040	E					RJP-PW-R1	1.00 REM RPL PAPR MARK SIGN OFF DOC			.01001		.011			
0090			JA	01	15		.05	REP TIE BOLT HOLE, RAD DRILL		4.658	.035	.268		20	

0010 E	RDR-SU-R1	.25 S/U TO O.S. BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RDR-BO-A2	26.00 O/S ADNL BOSS STP RMR RAD DROCCURRANCE = NUMBER OF HOLES	.14687	4.391	
0040 E	KAL-SM-31	27.00 SPOT-FACE OR COUNTERBORE OCC.FOR NO.OF HOLES	.00423	.131	
0050 E	RBN-DB-A1	27.00 DEBUR HOLE/CUTOUT BOTH SIDES OCC. FOR NO. OF HOLES	.01001	.310	
0060 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0150	JA 01 15	.05 BEARING BORE SEAT REP,MED	.812	.006	.047 3
0010 E	RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 8 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP JIG BORE	.15776	.181	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1	.24122	.277	
0060 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0160	JA 01 15	.07 BEARING BORE REP - JIG BORE	.812	.009	.065 5
0010 E	RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1	.24122	.277	
0060 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0180	JA 01 15	.07 BRNG.BORE LK.RG.GROOVE	.597	.006	.048 4
0010 E	RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	KML-TA-JD	1.00 DIA 6.0 REM .250 ADD INCH	.02665	.030	
0060 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0190	JA 01 15	.05 CRACKED WHEEL W. HOLE	.459	.003	.026 2
0010 E	RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL	.30463	.350	

0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
JA 01 15		.05	CRACKED TIME C. HOLE	.459	.003	.026 2
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0250 JA 01 15		.05	INST TIE BOLT BUSHING	.613	.005	.035 3
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669	.053	
0020 E	RBW-BU-A4	27.00	INSTALL ONE STRAIGHT BUSHING OCC. FOR NO. OF BUSHINGS	.02062	.640	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0260 JA 01 15		.61	INST CUP INTO BUSHING	.077	.007	.054 4
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
JA 01 15		.61	MACH BEARING BORE BUSHING	.236	.022	.166 12
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 8 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0270 JA 01 15		.61	INST BEARING BORE BUSH & CUP	.077	.007	.054 4
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0280 JA 01 15		.05	INST CUP INTO BUSHING	.077	.001	.004 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0285 JA 01 15		.05	MACH.OD OF BUSH. CUP ASSY.	.547	.004	.031 2
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	

0020 E	RLA-HP-C1	1.00	1ST PART ...-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250	.40208	.462	
40 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0290	JA 01	15	.05 INST BEARING BORE BUSH & CUP	.077	.001	.004 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0330	JA 01	15	1.00 INSTALL HELICOILS	.348	.052	.401 30
0010 E	RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS	.31093	.357	
0020 E	RBW-TR-H1	1.00	INSTALL HELICOIL INSERT	.02763	.031	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
9000	JA 00	15	.00 LABOR STANDARD HISTORY	.000	.000	.000 0
0001			06MAY85 MATCHED WITH 958 FOR OUTBD HALF			
0002			AND AS PER OCC.FACT.STUDY.NEW OP NO.			
0003			AUG85 ADDED PF&D TIME TO E STDS. (TM WAS 2.26)			
0004			21OCT85 2 YEAR REVIEW			
0005			BAUG86 IMPLEMENTED TIME STUDIES COMPLETED ON			
0006			SUBOP 0110/ WORK PREVIOUSLY WORKED ON OPERATION			
0007			M0010 (OLD STD 2.38)			
0008			LDEC86 CHANGED SUB-OPP0090 DUEPTO A METHODS			
0009			IMPROVEMENT (OLD STD 1.66)			
0010			20MAY87-DELETED SUBOP'S 0080/0110 OLD STD 1.59			
0011			6 NEW SUBOPPS ADDED OLD TIME WAS 1.10			
0900			KERRY COOP MANEL TECHN 73357			

TO " PROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

15139A BS2 M WHEEL 3-1192

RCC MPRA

4M1-7-1143 900-9739

PER TECH S S W F PF A/R REV

SUB	T K	#R A	FA SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

RA105	S	E	JA	EA 1	J 88300	.65 PERCENT ENGR 92.6	MACH. B-52M. WHEEL INBD.	2.19	1.42		
0001			JA	01	00	.00	PART NUMBER / N.S.N.	.000	.000	.000	0
			0010			300-254	N.S.L.				
			0020			300-254-1	1630011119667				
0010			JA	01	15	.05	REMV DR. KEY INDEX BUSHING	.669	.005	.039	2
0010	E				GJP-TL-A1	1.00 JOB PREPARATION GENERAL		.11960		.137	
0020	N					9.00	REMOVE KEY BUSH. OCC. 9EA.	.06000		.621	
0030	E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01	15	.46	REM BEARING BORE BUSH, LARGE	.863	.060	.457	21
0010	E				RML-SU-V3	.25 S/U VERT MIL BORE FXTR HOIST PRORATE OVER 8 PARTS		1.03687		.298	
0020	E				RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP JIG BORE		.15776		.181	
0030	E				RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E				RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E				KPM-BA-LB	1.00 BORE HOLE 6 X 1 GROUP 1 USE PROPER ELEMENT/TABLE		.23311		.268	
0060	E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0050			JA	01	15	.05	FUSE PLUG HOLE REPAIR	.753	.006	.043	2
0010	E				RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS		.56378		.162	
0020	E				RDR-BO-A1	1.00 O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E				RDR-BO-A2	2.00 O/S ADML BOSS STP RMR RAD DROCCURRANCE = NUMBER OF HOLES		.14687		.337	
0040	E				RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15	.05	MACH. MATTING SURFACE	.459	.003	.026	1
0010	E				RDR-SU-R1	.25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS		.56378		.162	

0020 E	RDR-B0-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350			
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004			
40 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011			
0070	JA 01	15	.05	SPOT FACE TIE BOLT HOLES	.722	.005	.042	2
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162			
0020 E	RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP,	.03068	.035			
0030 E	KAL-SM-J1	27.00	SPOT-FACE OR COUNTERBORE OCC. FOR 27 FACES	.02004	.622			
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC,	.01001	.011			
0080	JA 01	15	.05	REP TIE BOLT HOLE,RAD DRILL	4.278	.032	.246	11
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162			
0020 E	RDR-B0-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350			
0030 E	RDR-B0-A2	26.00	O/S ADML BOSS STP RMR RAD DROCC. FOR 26 HOLES	.14687	4.391			
0040 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004			
0050 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011			
0087	JA 01	15	.05	BEARING BORE SEAT REP,LARGE	.846	.006	.049	2
0010 E	RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOISTPRORATE OVER 8 PARTS	1.03687	.298			
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE	.15776	.181			
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146			
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087			
0050 E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250	.21626	.248			
0060 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011			
0090	JA 01	15	.46	BEARING BORE REP,PENSOTTI	.508	.035	.269	12
0010 N		1.00	SET UP PENSOTTI	.16700	.192			
0020 E		1.00	4 .26 MACHINE BEARING BORE	.29333	.337			
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC/	.01001	.011			
0040 E	RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815	.043			
0100	JA 01	15	.05	DRIVE KEY HOLE REP RAD DRL	2.930	.022	.169	8
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162			
0020 E	RDR-B0-A1	9.00	O/S BOSS W/STEP RMR RAD DRL OCC. = 9 HOLES	.30463	3.152			
0030 E	RBW-DB-A1	9.00	DEBUR HOLE/CUTOUT BOTH SIDES OCC. = 9 HOLES	.00423	.043			

0040 E	RJP-PW-R1	1.00	REM RPL F. MARK SIGN OFF DOC	.01001	.011	
0110	JA 01 15	.07	MACH. DVE. KEY INDEX HOLES	2.930	.031	.236 11
.0 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 8 PARTS	.56378	.162	
0020 E	RDR-BO-A1	9.00	O/S BOSS W/STEP RMR RAD DRL OCC. = 9 HOLES	.30463	3.152	
0030 E	RBW-DB-A1	9.00	DEBUR HOLE/CUTOUT BOTH SIDES OCC. = 9 HOLES	.00423	.043	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0120	JA 01 15	.46	MACHINE ID KEY SEAT AREA TO	.487	.034	.258 12
0001			REMOVE CORROSSION			
0010 N		1.00	SET UP PENSOTTI	.08000	.092	
0020 E		2.50 3	.53 B52 MLG MHL HLF KEY SEAT	.14383	.413	
0021			REPAIR 1 CUT PENSOTTI/OCC AT 2.50/1 TO 4 CUTS/			
0030 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC/	.01001	.011	
0040 E	RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815	.043	
0140	JA 01 15	.05	BRNG. BORE LOCK RING GROOVE	.787	.006	.045 2
0010 E	RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS	.80167	.230	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	.15776	.181	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	KML-TA-JD	1.00	DIA 6.0 REM .250 ADD INCH	.21626	.248	
0060 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0150	JA 01 15	.05	CRACKED WHEEL W. HOLE	.459	.003	.026 1
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	
0155	JA 01 15	.05	CRACKED TIME C. HOLE	.459	.003	.026 1
0010 E	RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS	.56378	.162	
0020 E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463	.350	
0030 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.011	

0200	JA 01	15	.05	INST TIE BOLT HOLE BUSHINGS	.677	.005	.039	2
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020 E	RBW-BU-A2	27.00	INSTALL SET STRAIGHT BUSHING OCC. FOR 27 BUSHINGS		.02299		.713	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0204	JA 01	15	.05	INST CUP INTO BUSHING	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0208	JA 01	15	.05	MACH BEARING BORE BUSHING	.236	.002	.014	1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 8 PARTS	.49962		.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250		.09193		.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0210	JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0212	JA 01	15	.05	INST CUP INTO BUSHING	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0216	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	.547	.004	.031	1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250		.40208		.462	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0220	JA 01	15	.05	INST BEARING BORE BUSH & CUP	.077	.001	.004	0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 8 PARTS	.18669		.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	

1225	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	1.206	.009	.069	3
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	9.00	1ST PART IN-OUT SCROLL CHUCK OCC. FOR 9 BUSHINGS		.01006		.104	
0030 E	KML-TD-CC	9.00	DIA .501-1.00 REM .033-.250 OCC. FOR 9 BUSHINGS		.10898		1.127	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
1230	JA 01	15	.05	INSTALL KEY B.HOLE BUSH.	.242	.002	.014	1
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	9.00	INSTALL ONE STRAIGHT BUSHING OCC FOR 9 BUSHINGS		.02062		.213	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
1235	JA 01	15	.05	TURN BUSHING GROUP 4/STEEL	1.206	.009	.069	3
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E	RLA-HP-C1	9.00	1ST PART IN-OUT SCROLL CHUCK OCC. FOR 9 BUSHINGS		.01006		.104	
0030 E	KML-TD-CC	9.00	DIA .501-1.00 REM .033-.250 OCC. FOR 9 BUSHINGS		.10898		1.127	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
1240	JA 01	15	.05	INST STRAIGHT BUSH NO POLISH	.242	.002	.014	1
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E	RBW-BU-A4	9.00	INSTALL ONE STRAIGHT BUSHING OCC. FOR 9 BUSHINGS		.02062		.213	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
000	JA 00	15	.00		.000	.000	.000	0

0001 07MAY85 DIV WHL INTO 2 OP.&MATCHED WITH

0002 958 AND C/W OCC FAC STUDY (TH WAS 5.80)

0003 13MAY85 DELETED SUB OPS 10,20,30,40,DHPL

0004 AUG85 ADDED PF&D TIME TO E STDS (TH WAS 1.28)

0005 21OCT85 2 YEAR REVIEW

0006 BAUG86 IMPLEMENTED TIME STUDIES COMPLETED ON

0007 SUBOPS 0100 & 0140/ WORK PREVIOUSLY WORKED ON

0008 OPERATION M0020/ (OLD STD 1.21)

0009 1DEC86 CHANGED SUB-OP 0070 DUE TO A METHODS

0010 IMPROVEMENT (OLD STD 1.41)

0011 NEW SUBOPPS ADDED 0010/0011REMOVE BUSHINGS

0012

OCC.FAC: RELEASED FOR 27 BUSH. &

0900

KERRY COOP MANEL TECHN 73357

INTERROGATE LABOR STANDARDS, INPUT

CC PRD NRDP NR

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34567890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A BS2 MLG WHL 3-1192

RCC MNPRC

4W1-7-1143 900-9739 81157

PER TECH S S W F PF A/R REV

SUB	T K	HR A FA	SUPPORT	DCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
C102	S	E	UP	EA B	J 88302	1.00 PERCENT ENGR 96.8	B-52M.WHEEL HALF OUTBOARD	1.98	1.98	
0001		UP	01	00		.00	PART NO. / N.S.N.	.000	.000	.000 0
0010						300-255	N.S.L.			
0020						300-255-1	1630011112990			
0225		UP	01	24		1.00	DEGREASE	.150	.036	.187 9
0010 E					RPL-DE-L1	1.00	DEGREASE LARGE PART OR BASKT	.14095	.174	
0020 E					RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.012	
0230		UP	01	24		1.00	SHOTPEEN LARGE PART/MASK	.848	.204	1.052 53
0010 E					ZMA-CL-04	1.00	MASK V/LRG CYL TYPE PART	.32667	.405	
0020 E					RPL-SP-L1	1.00	SHOT PEEN LARGE PART	.46073	.571	
0030 N					ZUM-CL-02	1.00	UNMASK MEDIUM SIZE CYL PART	.05067	.062	
0040 E					RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.012	
0240		UP	01	24		1.00	ANODIZE LARGE PART	.604	.145	.749 .8 38
0010 E					RWB-CV-D1	1.00	VAPOR CL (DEGR)HOOK/BASKET	.08709	.107	
0020 E					ZPL-AN-L1	1.00	ANODIZE LARGE SIZE PART	.50714	.628	
0030 E					RJP-PW-R1	1.00	REM RPL PAPRMRK SIGN OFF DOC	.01001	.012	
9000		UP	01	24		.01	LABOR STD HISTORY	.000	.000	.000 0
0010							ZONOV85 WROTE STD TO MATCH 958 (NEW STD)			
0900							KERRY COOP MANEAA TECHN 73357			

TO INTERROGATE LABOR STANDARDS, INPUT

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34567890123456 ELSE PUT IN END

ARC105

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

15139A B52 MLG WHL 3-1192

RCC MNPAC

4W1-7-1143 900-9739 81157

PER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION -----> BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

C105	S	E	UP	EA	B	J	88301	1.00	PERCENT ENGR 96.8	B-52 MAIN WHL.HALF INBD.	1.98		1.98		
0001			UP	01	00			.00		PART NO. / N.S.N.	.000	.000	.000		0
0010									300-254	N.S.L.					
0020									300-254-1	1630011119667					
0170			UP	01	24			1.00		DEGREASE	.150	.036	.187		9
0180	E								RPL-DE-L1	1.00 DEGREASE LARGE PART OR BASKT	.14095		.174		
0020	E								RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0180			UP	01	24			1.00		SHOTPEEN LARGE PART/MASK	.848	.204	1.052		53
0010	E								ZMA-CL-04	1.00 MASK V/LRG CYL TYPE PART	.32667		.405		
0020	E								RPL-SP-L1	1.00 SHOT PEEN LARGE PART	.46073		.571		
0030	N								ZUM-CL-02	1.00 UNMASK MEDIUM SIZE CYL PART	.05067		.062		
0040	E								RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
0190			UP	01	24			1.00		ANODIZE LARGE PART	.604	.145	.749	.8	38
0010	E								RWB-CV-D1	1.00 VAPOR CL (DEGR)HOOK/BASKET	.08709		.107		
0020	E								ZPL-AN-L1	1.00 ANODIZE LARGE SIZE PART	.50714		.628		
0030	E								RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012		
9000			UP	01	24			.01		LABOR STD HISTORY	.000	.000	.000		0
0010										20NDV85 WROTE STD TO MATCH 958 <NEW STD>					
00										KERRY COOP MANEAA TECHN 73357					

139A BS2 M WHEEL 3-1192

RCC MNPGP

4W1-7-1143 900-9739 81043

3 TECH S S W F PF A/R REV

SUB	T K	#R A FA SUPPORT	OCC	DESCRIPTION	BASE	PF0	STD	A	
STEP D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

10	S	E YH EA 5	J 88300	1.00 PERCENT ENGR 99.9	ASSY. WHEEL 8-52 M.	2.00		2.00	
0001		YH 01 00		.00	PART NO. / N.S.N.	.000	.000	.000	0
		0010		3-1192	1630009009739				
		0020		3-1192-1	1630012286043				
0015		YH 01 21		1.00	ASSEMBLE WHEEL	1.654	.348	2.002	100
	0005	E	RWB-QH-W2	2.00	REMY WHL HLF F/PAINT CONVEYOR WHEEL HALVES	.00833		.020	
	0010	E	RWB-JP-W2	1.00	PREP TO ASSY DR DISSY WHEEL	.00442		.005	
	0011	E	RWB-FW-S3	1.00	FINAL CK-INSP PARTS	.19577		.236	
	0020	E	RWB-BC-03	2.00	INSTALL BEARING CUPS	.16838		.407	
	0030	E	RWB-BB-01	2.00	BALANCE WHEEL HALF	.07734		.187	
	0040	E	RWB-UP-P8	1.00	UNPK PARTS-BK KEY-TIE BOLT	.08482		.102	
	0050	E	RWB-AW-T1	27.00	INSTL UNOBSTRUCTED TIE BOLT	.00975		.318	
	0060	E	RWB-AW-K2	9.00	INSTL BRAKE KEY/MULTI-SCREW	.01642		.178	
	0070	E	RWB-AW-TF	3.00	REPLACE THERMAL FUSES	.06162		.223	
	0080	E	RWB-AW-B1	2.00	INSTL BEARNG/SNAP RING SECURD	.02459		.059	
	0100	E	RWB-AW-H3	1.00	INSTL SINGLE PC HEAT SHIELD	.00360		.004	
	0110	E	RWB-NB-02	2.00	PROC TIME NCK / BUR LG PART	.04733		.114	
	0120	E	RWB-FT-01	1.60	FINAL & TUCH UP V/L LRG WHEL	.10838		.131	
	0130	E	RJP-PW-R1	1.00	REM RPL PAPRMK SIGN OFF DOC	.01001		.012	
9000		YH 01 21		.00	LABOR STANDARD HISTORY	.000	.000	.000	0

0010 06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD> 1.85

0020 26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)

0021 3MAR86 CHANGED SKILL CODE FROM Y6 TO YH

0022

NO TIME CHANGE

0023

20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP

24

0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>

0900

KERRY COOP MANEL TECHN 73357

0 INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MMI-DY-M45 PAGE 0001

.5139A B52 M WHEEL 3-1192

RCC MNPGR

4W1-7-1145 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

1106	S	E	YH	EA 5	J 88300	1.00 PERCENT ENGR 84.5	MATCH UP WHEEL B52M.	.13		.13	
0001			YH	01	00	.00	PARTS NO. / N.S.N.	.000	.000	.000	0
0010						3-1192	1630009009739				
0020						3-1192-1	1630012286043				
0010			YH	01	21	1.00	WHEEL MATCH UP	.110	.023	.134	100
0010	E					MGT-EE-24	1.00 GET EASY AND PLACE EXACT	.00097		.001	
0020	E					RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAP RING	.08237		.099	
0030	M						1.00 MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040	E					RJP-PW-R1	1.00 REM RPL FAPRWRK SIGN OFF DOC	.01001		.012	
9000			YH	01	21	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD> 1.85				
0020							26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)				
0021							3MAR86 CHANGED SKILL CODE FROM Y6 TO YH				
0022							NO TIME CHANGE				
0023							20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP				
0024							0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>				
0900							KERRY COOP MANEL TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

7MPPGP15139APP106

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 04/26/89 A-E046B-MM1-DY-M45 PAGE 0001
RCC MPPGP 4M1-7-1143 900-9739 81043

15139A B52 M WHEEL 3-1192										RCC MPPGP		4W1-7-1143 900-9739		81043					
TECH S S W F PF A/R REV																			
T K #R A FA SUPPORT OCC <----- DESCRIPTION ----->										BASE		PFD		STD		A			
STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL										HOURS		TIME		HOURS		DLY PCT C			
PP106 S E 3S EA 5 J 89116 1.00 PERCENT ENGR 99.9										TOUCH-UP PAINT B-52M WHL		.07				.07			
0001 3S 01 00 .00										PARTS NO. / N.S.N.		.000		.000		.000		0	
0010 3-1192										1630009009739									
0020 3-1192-1										1630012286043									
0020 3S 01 25 1.00										PAINT TOUCH UP SM & MED		.063		.016		.080		100	
0010 E RNB-FT-02 1.00 FINAL & TUCH UP MED/SM L WHEL												.05395				.067			
0020 E RJP-PW-R1 1.00 REM RPL PAPMARK SIGN OFF DOC												.01001				.012			
9000 3S 01 00 .00										LABOR STANDARD HISTORY		.000		.000		.000		0	
0010 26 APR 89 INITIAL INPUT MRP11																			
0900 BOB ROSS MANEL-1 77126																			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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15139A B52 M WHEEL 3-1102

RCC MNPGP

4W1-7-1143 900-9739 81043

PER TECH S S W F PF A/R REV

SUB	T K	NR	A	FA	SUPPORT	QCC	DESCRIPTION	BASE	PFD	STD	A				
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C
P102	S	E	3S	EA	5	J 88302	1.00 PERCENT ENGR 99.9	PAINT WHEEL HALF 8-52M.		.33		.33			
0001			3S	01	00		.00	PART NO. / N.S.N.		.000	.000	.000		0	
0010							300-255	N.S.L.							
0020							300-255-1	1630011112990							
0360			3S	01	25		1.00	PAINT WHEEL		.267	.067	.334	4.0	100	
0010 E						GPL-PA-01	4.00 INST NONTHEADED PLSTC PLUG			.00093		.004			
0020 E						GIG-SP-M1	1.00 MASK & UNMASK MEDIUM PART			.01242		.015			
0030 E						RWB-OH-W1	1.00 HANG WHL HLF ON PAINT CONVYR			.02336		.029			
0040 E						RWB-SC-02	1.00 PNT WHL HALF-ZINC CHROMATE			.11574		.144			
0050 E						RWB-SC-P3	1.00 PNT WHL HALF (2ND COAT)	POLY 2 COATS		.10214		.127			
0060 E						RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC			.01001		.012			
9000			3S	01	25		.00	LABOR STANDARD HISTORY		.000	.000	.000		0	
0010								06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD>	.57						
0020								26MAR85 2 YEAR REV.NO CHNG (OLD TM .55)							
0021								20CT86 2 YEAR REVIEW DELETED STEP 0060 WORK							
0022								PERFORMED BY DS PERSONNEL <OLD STD .55>							
0900								KERRY COOP MANEL TECHN 73357							

TO PROPGATE LABOR STANDARDS, INPUT

RCC PRO NROP NR

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNPGP

4M1-7-1143 900-9739 81043

JR TECH S S W F PF A/R REV

SUB	T K	NR	A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
105	S	E	3S	EA 5	J 88301	1.00 PERCENT ENGR 99.9	PAINT WHEEL HALF B-52M	.33		.33	
0001			3S	01	00	.00	PART NO. / N.S.N.	.000	.000	.000	0
0010						300-254	N.S.L.				
0020						300-254-1	1630010009667				
0280			3S	01	25	1.00	PAINT WHEEL	.267	.067	.334	4.0 100
0010 E						6PL-PA-01	4.00 INST NONTHEADED PLSTC PLUG	.00093		.004	
0020 E						GIG-SP-M1	1.00 MASK & UNMASK MEDIUM PART	.01242		.015	
0030 E						RWB-OH-W1	1.00 HANG WHL HLF ON PAINT CONVR	.02336		.029	
40 E						RWB-SC-02	1.00 PNT WHL HALF-ZINC CHROMATE	.11574		.144	
0050 E						RWB-SC-P3	1.00 PNT WHL HALF (2ND COAT) POLY 2 COATS	.10214		.127	
0060 E						RJP-PW-R1	1.00 REM RPL PAPMRK SIGN OFF DOC	.01001		.012	
9000			3S	01	25	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010							06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57				
0020							26MAR85 2 YEAR REV.NO CHNG (OLD TM .55)				
0021							20OCT86 2 YEAR REVIEW DELETED STEP 0060 WORK				
0022							PERFORMED BY DS PERSONNEL <OLD STD .55>				
0900							KERRY COOP MANEL TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 11/01/88 A-E046B-MM1-DY-M45 PAGE 0001

5139A B52 M WHEEL 3-1192

RCC MNP6P

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA SUPPORT	DDC	DESCRIPTION	BASE	PFD	STD	A
STEP D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
106	E	N 3S	EA 5	J 88300	1.00 PFRCENT ENGR 46.6	PAINT WHEEL B-52M	.48	.48	
0001		3S 01	00		.00	PART NO. / N.S.N.	.000	.000	.000
0010				3-1192	1630009009739				
0020				3-1192-1	1630012286043				
0020		3S 01	25		1.00	PAINT TOUCH UP V/L LGE	.118	.030	.148
0010 E				RWB-FT-01	1.00 FINAL & TUCH UP V/L LRG WHEL		.10838	.135	
0020 E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.012	
0997		3S 01	25		1.00	FINAL ACCEPTANCE OF W.C.D.	.132	.033	.166
0010 N					1.00	FINAL	.08000	.100	
0020 E				GJP-FP-85	1.00	FILL OUT FORM 424 & ATTACH	.05255	.065	
0998		3S 01	25		1.00	FINAL VISUAL INSPECTION	.137	.034	.171
0010 N					1.00	FINAL VISUAL INSPECTION	.12700	.158	
0020 E				RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.012	
9000		3S 01	25		.00	LABOR STANDARD HISTORY	.000	.000	.000
0010					06JUN84 REMOVE UNLOADING PAINT LINE <OLD STD> .57				
0020					26MAR85 2 YEAR REV.NO CHNG (OLD TH .55)				
0021					20CT86 2 YEAR REVIEW DELETED STEP 0060 WORK				
0022					PERFORMED BY DS PERSONNEL <OLD STD .55>				
0900					KERRY COOP MANEL TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

15139A B52 M WHEEL 3-1192

RCC MNPSP

4W1-7-1143 900-9739 81043

PER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	DOC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
S102	S	E	YH	EA 5	J 88302	1.00 PERCENT ENGR 95.9	PRE. INSP. & ASSY. WHL. HLF. B52M.	.50		.50	
0001		YH	01	00		.00	PART NO. / N.S.L.	.000	.000	.000	0
0010						300-255	N.S.L.				
0020						300-255-1	1630011112990				
0350		YH	01	21		1.00	PREINSPECTION WHEEL HALF	.015	.003	.019	4
0010 E					RWB-JP-W2	1.00 PREP TO ASSY OR DISSY WHEEL		.00442		.005	
0020 E					KAL-GC-46	1.00 INSPECT VISUAL		.00115		.001	
0030 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
		YH	01	21		1.00	RACE INSTALLATION WHL/HALF	.178	.037	.216	43
0010 E					RWB-BC-03	1.00 INSTALL BEARING CUPS		.16838		.203	
0020 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0370		YH	01	21		1.00	BALANCE WHEEL HALF	.111	.023	.134	27
0010 E					GPL-PD-01	4.00 REM NONTHEADED PLASTIC PLUG		.00339		.016	
0020 E					GMC-MT-D1	1.00 REMOVE MASKING TAPE		.00191		.002	
0030 E					RWB-DH-W2	1.00 REMV WHL HLF F/PAINT CONVOYOR		.00833		.010	
0040 E					RWB-BB-01	1.00 BALANCE WHEEL HALF		.07734		.093	
0050 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0380		YH	01	21		1.00	WHEEL MATCH UP	.110	.023	.134	27
0010 E					MST-EE-24	1.00 GET EASY AND PLACE EXACT		.00097		.001	
0020 E					RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
0030 N						1.00	MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040 E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000		YH	01	21		.00	LABOR STANDARD HISTORY	.000	.000	.000	0

0010 06JUN84 SUB OP 0001 &UNLOAD LINE<OLD STD> 1.85
0020 26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)
21 3MAR86 CHANGED SKILL CODE FROM Y6 TO YH
0022 NO TIME CHANGE
0023 20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP
0024 0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>
0900 KERRY COOP MANEL TECHN 73357

J INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

--X--X-->

.234567890123456 ELSE PUT IN END

.5139A B52 M WHEEL 3-1192

RCC MNPBP

4W1-7-1143 900-9739 81043

ER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	QCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
3105	S	E	YH	EA 5	J 88301	1.00 PERCENT ENGR 95.9	PRE.INSPECT&ASSY WHL.H.B52M	.50		.50	
0001		YH	01	00		.00	PART NO. / N.S.N.	.000	.000	.000	0
0010						300-254	N.S.L.				
0020						300-254-1	1630010009667				
0270		YH	01	21		1.00	PREINSPECTION WHEEL HALF	.015	.003	.019	4
0010 E					RWB-JP-W2	1.00 PREP TO ASSY OR DISSY WHEEL		.00442		.005	
0020 E					KAL-GC-46	1.00 INSPECT VISUAL		.00115		.001	
0030 E					RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
		YH	01	21		1.00	RACE INSTALLATION WHL/HALF	.178	.037	.216	43
0010 E					RWB-BC-03	1.00 INSTALL BEARING CUPS		.16838		.203	
0020 E					RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0290		YH	01	21		1.00	BALANCE WHEEL HALF	.111	.023	.134	27
0010 E					GPL-PD-01	4.00 REM NONTHEADED PLASTIC PLUG		.00339		.016	
0020 E					GMC-MT-D1	1.00 REMOVE MASKING TAPE		.00191		.002	
0030 E					RWB-OH-W2	1.00 REMV WHL HLF F/PAINT CONVOYOR		.00833		.010	
0040 E					RWB-BB-01	1.00 BALANCE WHEEL HALF		.07734		.093	
0050 E					RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0295		YH	01	21		1.00	WHEEL MATCH UP	.110	.023	.134	27
0010 E					MST-EE-24	1.00 GET EASY AND PLACE EXACT		.00097		.001	
0020 E					RWB-UP-P7	1.00 UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
0030 N						1.00	MATCH WHEEL HALFS 2 HALFS	.01700		.020	
0040 E					RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000		YH	01	21		.00	LABOR STANDARD HISTORY	.000	.000	.000	0

0010 06JUN84 SUB OP 0001 UNLOAD LINE<OLD STD> 1.85
0020 26MAR85 2 YEAR REV NO CHNG (OLD TM 1.93)
21 3MAR86 CHANGED SKILL CODE FROM Y6 TO YH
0022 NO TIME CHANGE
0023 20CT86 2 YEAR REVIEW, DELETED STEP 0140 SUBOP
0024 0010 WORK DONE BY DS PERSONNEL <OLD STD 1.93>
0900 KERRY COOP MANEL TECHN 73357

J INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

—X—X—>

.234567890123456 ELSE PUT IN END

BLDG 505/507

C-58 MAIN WHEEL
BILL OF MATERIALS
90101A

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[illegible]

5/2/11

16-May-80

BLD6 505/507

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

C-3B MAIN WHEEL
BILL OF MATERIALS

90101A

* = MFI

ROUTED ITEMS	ILON LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	YIELD OF IRATE MEAS	SCRAP FACTOR	PART TYPE (R,D,C)	IMC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH DRG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	1.0.4	2391-30N0285	5340010979226	726344	INSERT (HELICOID, OUTER) (LIST REP:1)	1	1EA									
	1.0.4	2391-30N0254	IN.S.L.		INSERT (HELICOID, INNER) (LIST REP:1)	1	1EA									
	1.0.3	MS35914-108	5340010366016	96906	INSERT (ROZAM) (REPAIR)	19	AR1EA				INT					
	1.0.3	110-1144-1	IN.S.L.		WHEEL HALF (INBOARD)	11	1									
	1.0.2	MS20364-1032C	5310002752025	96906	NUT (HEIGHT)	12	AR1EA									
	1.0.2	197-74	11630000556302	97153	WEIGHT (BALANCE) (.0502)	12	AR1EA									
	1.0.2	197-33	11630008263028	97153	WEIGHT (BALANCE) (102)	12	AR1EA				ALT					
	1.0.2	MS33207-268	53050009953442	96906	SCREEN (HEIGHT)	12	AR1EA									
	1.0.2	19P60-10L	5310001670834	188044	WASHER (HEIGHT)	12	AR1EA									
STL	1.0.2	110236710A	5310002251917	160038	CLIP (BEARING)	11	AR1EA									
	1.0.2	138-105-14-13	5320001757605	94222	RIVET (PLATE)	16	1EA									
	1.0.2	150-242	IN.S.L.		PLATE (INSTRUCTION)	11	1									
	1.0.2	150-243	9905004583116	97153	PLATE (COUNTER)	11	1EA									
	1.0.2	150-282	IN.S.L.		PLATE (IDENTIFICATION)	11	1									
SYN	1.0.2	168-893	5330001465371	97153	SEAL (GREASE) (INNER)	11	1EA									
SS	1.0.2	1245-168	5330001275744	97153	RING (SEALING)	11	1EA									
	1.1	1752-03	12640007267896	79934	VALVE ASSY	11	1EA									
	1.0.2	1VCS	11650002224525	79934	CAP (VALVE)	11	1EA									
	1.0.2	MS20813-1	11650002224525	96906	CAP (VALVE)	11	1EA				INT					
	1.0.2	1CA	12640008105861	79934	VALVE	11	1EA									
STL	1.0.2	1752	IN.S.L.		STEM (VALVE)	11	1									
	1.0.2	18E30	53300005797548	73842	PACKING, O-RING (VALVE)	11	1EA									
STL	1.1	MS27436-3	12640001166208	79934	VALVE ASSY (OVERSIZE)	11	AR1EA				ALT					
	1.0.2	1VCS	11650002224525	79934	CAP (VALVE)	11	1EA									
	1.0.2	MS20813-1	11650002224525	96906	CAP (VALVE)	11	1EA				INT					
	1.0.2	1CA	12640008105861	79934	VALVE	11	1EA									
	1.0.2	1752	IN.S.L.		STEM (VALVE)	11	1									
	1.0.2	MS9048-011	5330000712204	96906	PACKING, O-RING (VALVE) (OVERSIZE)	11	1EA									
	1.1	MS110253-8	IN.S.L.		SCREEN (DRIVE KEY)	19	1									
	1.1	MS110253-8	53050015975556	180205	SCREEN (DRIVE KEY)	19	1EA				INT					
SS	1.1	1170-112	534000452910	97153	DRIVE KEY	19	1EA									
	1.1	149-139	11630009871828	97153	PLUG ASSY	13	1EA									
AL	1.0.2	149-138	IN.S.L.		PLUG (THERMAL RELIEF)	11	1									
	1.0.2	MS28775-006	5330002920580	105589	PACKING (THERMAL PLUG)	11	1EA									
SS	1.1	172-283	11630012203847	97153	HEAT SHIELD	19	1EA									
STL	1.1	114874377	5310004582846	72962	NUT (TIE)	18	1EA									
STL	1.1	16N267	5310009045253	25500	NUT (TIE)	18	1EA				INT					
STL	1.1	16N272-720	5310009481256	156878	NUT (TIE)	18	1EA				INT					
STL	1.1	180-513	5310001344152	97153	WASHER (TIE)	132	1EA									
STL	1.1	143-761	5305007958694	97153	BOLT (TIE)	18	1EA									
	1.1	148-649	5330004537564	97153	PACKING (O-RING)	11	1EA									
SYN	1.1	148-650	5330004533360	97153	GASKET	11	1EA									

161

								FACTORED
PROD	REL	OPER	TPP	SK	FAC	STAND	OCC	STAND
NBR		NBR	STD			HOURS	FAC	HOURS
-----	-----	-----	-----	-----	-----	-----	-----	-----
90101A	MNPCE	H0010	N	M2	3	1.33	1.00	1.33

								1.33

	MNPGP	00010	E	YH	5	.57	1.00	57
		PM101	E	YH	5	.13	1.00	13
		PP101	N	3S	5	.42	1.00	42
		PP103	E	3S	5	.33	1.00	33
		PP104	E	3S	5	.33	1.00	33
		PS103	E	YH	5	.42	1.00	42
		PS104	N	YH	5	.81	1.00	81

								3.01

	MNPGW	WC001	N	KI	5	.60	1.00	60
		WD001	E	HB	5	.97	1.00	97
		WE103	N	DI	5	.51	1.00	51
		WE104	N	DI	5	.51	1.00	51

								2.59

	MNPMG	XNPMG	X	JB	1	.25	1.00	25

								25

	MNPNA	XNPNA	X	DB	2	.32	1.00	32

								32

	MNPRA	RA103	E	JA	1	2.19	1.00	2.19
		RA104	N	JA	1	1.81	1.00	1.81

								4.00

	MNPRC	RC103	E	UP	8	.94	1.00	94
		RC104	E	UP	8	.94	1.00	94

								1.88

								13.38

IN CONTROL JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	6019 FLOW DAYS
NUMBER DESC						
DELE	74972A	B-52	BOOSTER ROTARY	1005-00-724-2862	28 OCTOBER 86	11W1-3-10-3
MART SHEL	74973A		DRIVE ASSY DRUM	1005-00-494-4583	101D4452	11W1-7-11-3 8
MART SHEL	74974A -6	F-4E	UNLOAD UNIT	1005-00-484-2745	175F981	11W1-7-11-3 6
MART SHEL	74975A -6	B-52	BOOSTER ASSY	1005-00-300-5135	102450-1	11F46-16-3 8
MART SHEL	74976A	A-7	DRIVE ASSY	1005-00-102-7987	175F705	
MART SHEL	74977A	F-4	CONTROL UNIT	1005-00-018-0825	A05A0089-4	1F-4E-2-18 8
MART SHEL	74978A -6	F-4C	FEEDER ASSY	1005-00-852-1898	175F449	11W1-31-2-2 12
MART SHEL	74979A	F-4	SWITCH CENTRIFUGE	1005-00-908-3828	822D80961	11W1-31-2-2 4
MART SHEL	74981A		FEEDER DELINKER	1005-00-921-6241	11701120	11W1-7-12-3 5
DELE	74983A -6		MINI GUN 5.56 MM	1005-00-973-5685	28 OCTOBER 86	11W3-5-5-1-1
MART SHEL	75175A -6		LAUNCHER LE-6	1440-00-483-5478AA	169605	11L1-3-14-3 20
DELE	75177G		LD-5	1440-00-673-7278AA	11 JULY 86	AFLCR 74-2
MART SHEL	75225A	F-111	EXIT UNIT SUU-16	1005-00-908-3825	721E72761	11W1-31-2-2 10
MART SHEL	75227A -6	F-111	DRIVE ASSY SUU-23	1005-00-908-3827	822D99661	11W1-31-2-2 10
MART SHEL	75228A	F-111	PANEL ASSY SUU-23	1005-00-836-5570	175F123	11W1-31-2-2 6
MART SHEL	75229A		GUN MOUNT PALLET ASSY	1005-00-054-3185	905D574	11W1-7-11-3 0
MART SHEL	75231A	F-4	SUU-20 B/A	1095-00-152-3360	69D6070	11B29-3-28-1 28
DELE	75232A		FEEDER M2A1	1005-00-473-6152	28 OCTOBER 86	11W1-7-9-2
DELE	75235A	F-111	EXIT UNIT	1005-00-111-4648	28 OCTOBER 86	11W1-29-6-2
MART SHEL	75236A -6	F-4	SUU20/A	1095-00-111-4657	SP245-1030	11B29-3-28-1 28
MART SHEL	75237A	F-4	SUU20	1095-00-984-1786	5712-503-1	11B29-3-28-1 28
MART SHEL	75247A		GUN M-39 A/2	1005-00-566-0044	8410950	11W1-12-3-14 20
MART SHEL	75254A -6		GUN M39/A3	1005-00-930-7787	8436501	11W1-12-3-22 20
MART SHEL	75265A	B-52	SWITCH ASSY	1005-00-733-1301	25-8598	11F8-3-0-2 8
MART SHEL	75267A -6		CYL GAS	1005-00-948-5311	11699885	11W1-12-7-2 7
MART SHEL	75269A	B-52	BOOSTER	1005-00-341-8559	199-2100-9	11W1-1-3-6-3 7
DELE	75272A		GAU-SA G	1005-00-933-7672	28 OCT 86	11W3-5-5-1
MART SHEL	75292A	B-52	BOOSTER	1005-00-604-0258	ABA400AB1	11W1-3-1-1 5
MART SHEL	75293A	F-4E	EXIT UNIT	1005-00-934-1432	175F138	11W1-7-11-3 2
CALD TOLM	77261A	B-52 ML6	CAM ASSY	1620-00-733-0993	25-4214	451-57-3 421
POLL POLL	78048A	C-141	DRAG BRACE	1620-00-943-8754	3F31004-119	4SA6-19-3 0
FRED FRED	79580A		PYRD TECHNIC PISTOL	1095-00-726-5657	7265657	11W2-9-2-31&34 8
MART SHEL	81466A	A-10	GAU-8 DRUM ASSY	1005-01-234-0764	218F504	11W1-7-14-3 20
COOP COOP	83317A	F-16	DRAG BRACE ASSY	1620-01-162-7542	2006500-111	452-00-13 30
MART SHEL	88425A	A-10	GAU-8 SCOOP DISC.	1005-01-234-0762	218F385	11W1-7-14-3 10
RIGB RIGB	89257A	F-4 M	PRESSURE PLATE	1630-00-498-3225	5000254	4B1-2-1093 16
JENS RIGB	89377A	F-16 M	BRAKE ASSY	1630-01-202-6584	50072714	4B1-2-1163 30
BENT PRIC	90101A	C-58	WHEEL ASSY	1630-01-182-6267	3-1268-3	4W1-4-493 20
COOP TOLM	90400A	B52	LINK IN BOARD	1620-00-609-9886	25-4211	451-57-3 40
MART SHEL	94118A	A-10	GAU-8 DRUM ASSY	1005-01-234-0763	218F966	11W1-7-14-3 29
RIGB RIGB	97414A	F-16 M	HEAT STACK	1630-01-252-4702	8631424-30	4B1-2-1163 20
RIGB RIGB	99020A	F-16 M	HEAT STACK	1630-01-252-4703	8631424-10	4B1-2-1163 20

C-5 MAIN WHEEL

WHEEL ASSY
PCN 90101A
WCD 21101N

WHEEL HALF
INBOARD
PCN 90101A
WCD 21103N

WHEEL HALF
OUTBOARD
PCN 90101A
WCD 21104N

* C-5 A MAIN WHEEL *

WCD# 21101N
Assy/DisAssy

OP# IN
INDUCT

OP# 01B
LOAD

OP# 02C
DisAssy
HALVES

WCD# 21104N
OUTER

WCD# 21103N
INNER

OP# 006
REMOVE CUP FROM
WHEEL HALF

OP# 006
REMOVE CUP FROM
WHEEL HALF

OP# 006A
LINE TRANSFER
CONV. → CRANE

OP# 006A
LINE TRANSFER
CONV. → CRANE

OP# 007
CHEM. CLEAN

OP# 007
CHEM. CLEAN

OP# 007
BLAST CLEAN

OP# 011
ANODIZE STRIP

OP# 015 & 015A
F.P.I.

OP# 19
NICK & BURR

OP# 030
E & I & ROUTE

OP# 040
THREADED INSERT
REPAIR

OP# 043
REMOVE BROKEN
SCREWS

OP# 045
SAFETY VALVE HOLE
REPAIR

OP# 048
VALVE STEM HOLE
REPAIR

OP# 008
BLAST CLEAN

OP# 009
REMOVE BROKEN
SCREWS

OP# 010
E.D.M. BROKEN TAPS
& SCREWS

OP# 011
ANODIZE STRIP

OP# 015 & 015A
F.P.I.

OP# 019
NICK & BURR

OP# 030
E & I & ROUTE

OP# 044
POLISH OR MACHINE
BASE OF DRIVE
KEY BOSS

OP# 045
REMOVE HELICOLS

OP# 055
BEARING BORE
REPAIR

OP# 058
BEARING BORE SEAT
REPAIR

OP# 060
SHOT PEEN

OP# 70A, 70B, 70C, 70D
70E, 70F, 70G, 70H,
70I, 70J, 70K, 70L } ANODIZE

OP# 072
INSTALL CUP INTO
BEARING BORE

OP# 074
MACHINE O.D. OF CUP
& BUSHING ASSY

OP# 076
INSTALL CUP & BUSHING
INTO BEARING BORE

OP# 077
INSTALL CUP INTO BEARING
BORE & SEAL BUSHING

OP# 056
BEARING BORE
REPAIR

OP# 056
BEARING BORE REPAIR

OP# 057
BEARING BORE SEAT
REPAIR

OP# 59
BEARING & SEAL
GROOVE REPAIR

OP# 060
SHOT PEEN

ANODIZE { OP# 70A, 70B, 70C, 70D,
70E, 70F, 70G, 70H,
70I, 70J, 70K, 70L

OP# 073
INSTALL CUP INTO
BEARING BORE

OP# 074
MACHINE O.D. OF
BUSHING & CUP ASSY

OP# 078
MACHINE O.D. OF CUP
& BUSHING ASSY

OP# 075
INSTALL CUP &
BUSHING ASSY

OP# 079
INSTALL BUSHING & CUP
ASSY INTO BEARING
BORE

OP# 077
INSTALL CUP INTO
BEARING BORE & SEAL
BUSHING

OP# 080
INSTALL INSERTS

OP# 078
MACHINE O.D. OF
CUP & BUSHING ASSY

OP# 095
MOVE TO PRE-FINAL
INSP & ASSY &
LOAD ROLLER CONV.

OP# 079
INSTALL CUP &
BUSHING ASSY

OP# 098
RAKE INSTALLATION

OP# 080
INSTALL HELICOLS

OP# 098A
UNLOAD ROLLER CONV.

OP# 095
MOVE TO PRE-FINAL
INSP & ASSY &
LOAD ROLLER CONV.

OP# 100
LOAD OVERHEAD CONV.

OP# 098
RAKE INSTALLATION

OP# 100A
WASH

OP# 098A
UNLOAD ROLLER CONV.

OP# 100B
MASK

OP# 100C
PRIME

OP# 100
LOAD CEMENT CON.

OP# 100D
DRY

OP# 100A
WASH

OP# 100E
1ST PAINT

OP# 100B
MASK

OP# 100F
2ND PAINT

OP# 100C
PRIME

OP# 100G
DRY

OP# 100D
DRY

OP# 100H
STRIP

OP# 100E
1ST PAINT

OP# 100I
UNLOAD OVERHEAD
CONV.

OP# 100F
2ND PAINT

OP# 110
INSTALL SAFETY
VALVE

OP# 100G
DRY

OP# 120
TEST SAFETY
VALVE

OP# 100H
STRIP

OP# 100I
UNLOAD OVERHEAD
CONV.

OP# 122
BALANCE

OP# 122
BALANCE

OP# 130
INSTALL SEALS
& RETAINERS
FINAL INSP.

OP# 130
INSTALL SEALS
& RETAINERS
FINAL INSP

WCD# 21101N
ASSY/DISASSY

OP# 10
MATCH-UP

OP# 20
ASSY WHEEL HALVES

OP# 30
TOUCH-UP PAINT

OP# 40
FINAL ACCEPT.

OP# 50
FINAL PROD. VISUAL

OP# 9999
SELL

21101N WORK CONTROL DOCUMENT (MEDS)

1 DATE 00354

1
PAGE OF PAGES

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

7 PART NUMBER	8 TECH DATA 4W-1-61 4W1-4-493	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES C-5 MAIN	11 STOCK NUMBER	12 OPTIONAL 90101A 72899A
13 SERIAL NUMBER	14 NOUN WHEEL ASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G94000-117C 3-1268-2		NSN C/N 1630011826267 90101A 1630001884084 72899A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. "WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001 *REQD*	3-1268-3 4G94000-117C			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH FUNCTIONAL CODE	A C	21101N
	B D	171

21101N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88354

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

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

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

13. SERIAL NUMBER	14. NOUN WHEEL ASSEMBLY

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

13	010 *REQD*	*MATCH-UP* ROUTED COMPONENTS NEW/SERVICEABLE REWORK NO REWORK		001 MNFGP 002 07 003 MU02	

		WHEEL HALF SUBASSY (I.B.) 21103N WHEEL HALF SUBASSY (O.B.) 21104N			

13	020 *REQD*	ASSEMBLE *C/P MOVE*		001 MNFGP 002 07 003 WA03	

13	030 *REQD*	FINAL TOUCH-UP PAINT *C/P MOVE*		001 MNFGP 002 09 003 TU04	

13	040 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFGP 002 09 003 TU04	

13	050 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE*		001 MNFGP 002 09 003 TU04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SH	
DISPATCH	FUNCTIONAL CODE	A	C	21101N	
		B	D		

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

7 PART NUMBER	8 TECH DATA 4W-1-61 4M1-4-493	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES C-5 MAIN	11 STOCK NUMBER	12 OPTIONAL 72899A 90101A
13 SERIAL NUMBER	14 NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
300-329-1		1630011084044 72899A			
300-329-1		1630011084044 90101A			
		***** UNIT COST: \$1953.91 *****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-6866			
		SHOT PEEN IAW MIL-S-13165			
		ANODIZE IAW MIL-A-8625			
		*****2014-T6 ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		(CONTINUED)			

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	A	21103N
FUNCTIONAL CODE	C	
	D	

21103N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

3 PAGE 3 OF 3 PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	019 *REQD*	NICK AND BURR *C/P MOVE*		001 MNFGW 002 04 003 NB04	
34E	030 *REQD*	E & I AND ROUTE *C/P MOVE*		001 MNFGW 002 04 003 EI02	
69	044 .34	LOCAL POLISH OR MACH AT BASE OF DRIVE KEY BOSS IAW PAR 5.1.1 K.A. .060 DEEP BY 2.5 INCHES MAX 63 RMS FINISH *C/P MOVE*		001 MNFGW 002 01 003 BE01	
69	045 *REQD*	REMOVE HELICOILS *C/P MOVE*		001 MNFGW 002 01 003 BE01	
69	050 .02	RETAINER GROOVE REPAIR IAW PAGE 1-7 PARA J (2) *C/P MOVE*		001 MNFGW 002 01 003 MV04	
69	056 .01	BEARING BORE REPAIR (INBOARD) IAW FIG 5-5 *C/P MOVE*		001 MNFGW 002 01 003 MV04	
69	057 .01	BEARING BORE SEAT REPAIR (INBOARD) *C/P MOVE*		001 MNFGW 002 01 003 MV04	
69	059 .01	BEARING AND SEAL GROOVE REPAIR IAW FIG 5-6 & 5-7 *C/P MOVE*		001 MNFGW 002 01 003 MV04	
26	060 *REQD*	SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH 200% COVERAGE *C/P MOVE*		001 MNFGW 002 01 003 SP01	
26	070 *REQD*	ANODIZE TYPE II CLASS I *C/P MOVE*		001 MNFGW 002 03 003 AS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21103N
		B	D	

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN WHEEL HALF - INNER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
✓ 69	073 .02	INSTALL CUP INTO BEARING BORE BUSHING (1ST REPAIR) P/N LM236710A P/N 63B31152 C/P MOVE			
✓ 69	074 .01	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY (1ST) REPAIR C/P MOVE			
✓ 69	075 .01	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (1ST REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 BE01	
✓ 69	077 .01	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N LM236710A P/N 66C330D1-121		001 MNFRA 002 01 003 BE01	
✓ 69	078 .01	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE*		001 MNFRA 002 01 003 LE09	
✓ 69	079 .01	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (2ND REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 BE01	
✓ 69	080 *REQD*	INSTALL HELICOILS 100% REQUIREMENT *C/P MOVE*		001 MNFRA 002 01 003 BE01	
✓ 13	095 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE*		001 MNFRA 002 07 003 PF05	
✓ 13	098 1.0	RACE INSTALLATION *C/P MOVE* P/N LM236710A		001 MNFRA 002 07 003 RI06	
✓ 13	100 *REQD*	PAINT *C/P MOVE*		001 MNFRA 002 09 003 BS02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21103N
		B	D	

21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

1
PAGE OF PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC MNPOM		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA 4W-1-61 4M1-A-493			9 ITEM SERIAL NO.			
10 MODEL-DESIGN-SERIES C-5 MAIN			11 STOCK NUMBER			12 OPTIONAL 90101A 72899A			
13 SERIAL NUMBER		14 NOUN WHEEL HALF - OUTER							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N		NSN C/N							
300-328-1		1630011084043 90101A							
300-328-1		1630011084043 72899A							
		***** UNIT COST: \$672 *****							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3							
		FPI IAW MIL-STD-6866							
		SHOT PEEN IAW MIL-S-13165							
		ANODIZE IAW MIL-A-8625							
		*****2014-T6 ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY							
		PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER (T.O.) AND							
		T.O. SUPPLEMENTS REFERENCED. THE							
		APPLICABLE T.O.'S AND SUPPLEMENTS							
		WILL ALWAYS BE USED IN CONJUNCTION							
		WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY							
		CLEANED & PROTECTED (C/P MOVE) FOR							
		MOVES BETWEEN OPERATIONS/DISPATCH							
		STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR							
		PROCEDURES REQUIRE THE USE OF							
		EQUIPMENT, PROCESSES & CHEMICALS							
		WHICH ARE POTENTIALLY DANGEROUS TO							
		PERSONNEL. ADEQUATE SAFEGUARDS AND							
		PRECAUTIONS MUST BE EMPLOYED TO							
		PRECLUDE INJURIES.							
		REQD (MANDATORY REQUIREMENT) IN							
		COLUMN 16 IS EQUIVALENT TO DELTA							
		STAMP.							
	001	300-328-1							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

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21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 20237

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF - OUTER	

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
34D	005 *REQD*	DISASSEMBLE *C/P MOVE*		001 MNFGW 002 02 003 WD03	
34D	006 *REQD*	REMOVE COP FROM WHEEL HALF *C/P MOVE*		001 MNFGW 002 02 003 WD03	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE*		001 MNFGW 002 03 003 AC02	
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE*		001 MNFGW 002 03 003 BL01	
34C	011 *REQD*	ANODIZE STRIP *C/P MOVE*		001 MNFGW 002 03 003 AN03	
		C/P MOVE	M	001 MNFNA 002 05 003 ZY05	
34E	019 *REQD*	NICK AND BURR *C/P MOVE*		001 MNFGW 002 04 003 NB04	
34E	030 *REQD*	E & I AND ROUTE *C/P MOVE*		001 MNFGW 002 04 003 EI02	
69	040 *REQD*	THREADED INSERT REPAIR (41) IAW PG 1-6 PARA 5-1.1(1) THRU (5) *C/P MOVE*		001 MNFRA 002 01 003 BE01	
69	043 .01	REMOVE BROKEN SCREWS *C/P MOVE*		001 MNFRA 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21104N
		B	D	

21104N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF - OUTER						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69	045 .50	SAFETY VALVE HOLE REPAIR IAW FIG 5-4 *C/P MOVE*					001 MNFRA 002 01 003 MV04		
69	048 .01	VALVE STEM HOLE REPAIR IAW MS33649-03 *C/P MOVE*					001 MNFRA 002 01 003 DR02		
69	055 .02	BEARING BORE REPAIR (OUTBOARD) IAW FIG 5-5, 5-6, 5-7 *C/P MOVE*					001 MNFRA 002 01 003 LE09		
69	058 .01	BEARING BORE SEAT REPAIR (OUTBOARD) *C/P MOVE*					001 MNFRA 002 01 003 LE09		
26	060 *REQD*	SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH 200% COVERAGE *C/P MOVE*					001 MNFRC 002 01 003 SP01		
26	070 *REQD*	ANDDIZE TYPE II *C/P MOVE*					001 MNFRC 002 03 003 AS03		
69	072 .03	INSTALL CUP INTO BEARING BORE BUSHING (1ST REPAIR) P/N L6630310 P/N 63B31152 *C/P MOVE*							
69	074 .02	MACHINE O.D. OF BUSHING AND CUP ASSY (1ST REPAIR) P/N N.P.L. *C/P MOVE*					001 MNFRA 002 01 003 LE09		
69	076 .02	INSTALL BUSH AND CUP ASSY INTO BEARING BORE (1ST REPAIR)*C/P MOVE* P/N N.P.L.					001 MNFRA 002 01 003 BE01		
69	077 .01	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N L6630310 (CONTINUED)					001 MNFRA 002 01 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

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21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 08287

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 66C33001-119			
✓ 69	078 .01	MACHINE D.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 LE09	
✓ 69	079 .02	INSTALL BUSHING AND CUP ASSEMBLY INTO BEARING BORE (2ND REPAIR) *C/P MOVE* P/N N.P.L.		001 MNFRA 002 01 003 BE01	
✓ 69	080 *REQD*	INSTALL INSERTS IAW PAGE 6-1 PARA 5-1.1 (1) THRU (5) *C/P MOVE*		001 MNFRA 002 01 003 BE01	
✓ 13	095 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE*		001 MNFRA 002 07 003 PF05	
✓ 13	098 .99	RACE INSTALLATION *C/P MOVE* P/N L663010		001 MNFRA 002 07 003 RI06	
✓ 13	100 *REQD*	PAINT *C/P MOVE*		001 MNFRA 002 09 003 BS02	
✓ 13	110 *REQD*	INSTALL SAFETY VALVE *C/P MOVE* P/N 195-93		001 MNFRA 002 07 003 WE01	
✓ 13	120 *REQD*	TEST SAFETY VALVE HOLE AT 90-100 PSI *C/P MOVE*		001 MNFRA 002 07 003 WE01	
✓ 13	122 *REQD*	BALANCE *C/P MOVE*		001 MNFRA 002 07 003 WE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21104N
		B	D	

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN WHEEL HALF - OUTER					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
13	123 *REQD*	INSTALL SEALS & RETAINERS *C/P MOVE*					001 MNPBP 002 07 003 WA03		
13	125 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPBP 002 07 003 WA03		
13	130 *REQD*	FINAL PRODUCTION VISUAL INSPECTION *C/P MOVE*					001 MNPBP 002 07 003 WA03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

21121N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88222

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 90101A	3 QUANTITY <i>1ea</i>	4 PRODUCTION SEC RCC MPCGW	5 DATE SCHED	6 DATE COMPLETED 15 APR 88

7 PART NUMBER 3-1268-3	8 TECH DATA 4W-1-61 4W1-4-493	9 ITEM SERIAL NO 4276/5478

10 MODEL DESIGN SERIES C-5B MAIN	11 STOCK NUMBER 1630211826267	12 OPTION PAC

13 SERIAL NUMBER	14 NAME WHEEL ASSEMBLY

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

GOVERNING DIRECTIVES: AFLCR 66-61
MANCI 66-3
ALL PERSONNEL INVOLVED IN THE WORK
PROCESSES SPECIFIED IN THIS DOCUMENT
HAVE BEEN THOROUGHLY TRAINED AND ARE
FAMILIAR WITH ALL PERTINENT SAFETY
PRACTICES AND HAZARDS CONTAINED IN
THE BASIC TECHNICAL ORDER AND T.O.
SUPPLEMENTS REFERENCED IN BLOCK 8
OF THIS AFLC FORM 958. THE APPLIC-
ABLE T.O.'S AND SUPPLEMENTS WILL
ALWAYS BE USED IN CONJUNCTION WITH
THIS DOCUMENT.

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

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

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

13	020 *REQD*	REASSEMBLE WHEEL HALVES *C/P MOVE			
13	230 *REQD*	FINAL TOUCH-UP PAINT *C/P MOVE			

21 FINAL DESTINATION DISPATCH	22 COORDINATION/INITIATING RCC SIGNATURE/DATE A <i>Frank H. Rigby</i> C <i>James H. Murray</i> B <i>Steve MARISMB</i> D <i>Edward J. Cundick</i>	23 DOCUMENT/SN 21121N

21101N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88222

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCT/ON SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL ASSEMBLY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 DATE	20 TIME	
13	040 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958				1805 70750	1886		
13	250 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE				1805 70750	M 1986		
		COORDINATED BY: PLANNING: FRANK RIGBY WK MEASURE: FRANK RIGBY SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIER							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21101N			
		B		D					

MANPROTILE

21104N WORK CONTROL DOCUMENT (MEDS)

DATE 88237

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2 JOB ORDER NO 90101A	3 QUANTITY 1	4 PRODUCTION SEC RCC MNP GW	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER 300-328-1	8 TECH DATA 4W-1 4W1-4-493	9 ITEM SERIAL 4276

10 MODEL-DESIGN SERIES C 5B MAIN	11 STOCK NUMBER 1630011084043	12 OPTIONAL

13 SERIAL NUMBER E29266	14 NOUN WHEEL HALF - OUTER

15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 Q
		***** UNIT COST: \$672 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 FPI IAW MIL-STD-6866 SHOT PEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625 *****2014-T6 ALUMINUM*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	300-328-1			

21 FINAL DESTINATION DISPATCH	22 COORDINATION/INITIATING RCC SIGNATURE/DATE A. Thomas G. [Signature] MANEL 31 Aug 88 [Signature] MAN SM 31 AUG 88	23 DOCUMENTATION 80 AUG 1988 [Signature] 30 Aug 88 [Signature] MANEL

21104N WORK CONTROL DOCUMENT (MEDS)

DATE 88237

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SIGNATURE		5 DATE SCHED		6 DATE COMPLETE	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN WHEEL HALF - OUTER					
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
34D	005	DISASSEMBLE *C/P MOVE*					M		
	REQD								
34D	006	REMOVE CUP FROM WHEEL HALF *C/P MOVE*					M		
	REQD								
34C	007	CHEM CLEAN *C/P MOVE*					M		
	REQD	20 MAR 1989							
34B	009	BLAST CLEAN ONLY *C/P MOVE*					M		
	REQD	22 MAR 1989							
34C	011	ANODIZE STRIP *C/P MOVE*					M		
	REQD	22 MAR 1989							
34Z	015	FPI *C/P MOVE*					M		
	REQD								
34E	019	NICK AND BURR *C/P MOVE*					M		
	REQD								
34E	030	E & I AND ROUTE *C/P MOVE*					M		
	REQD								
69	040	THREADED INSERT REPAIR (41) IAW PG 1-6 PARA 5-1.1(1) THRU (5) *C/P MOVE*					M		
	REQD								
69	043	REMOVE BROKEN SCREWS *C/P MOVE*					M		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21104N			
		B							
		C							
		D							

21104N WORK CONTROL DOCUMENT (MEDS)

DATE 98237

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7. JOB ORDER NO.		8. QUANTITY		9. PROJECT OR SEC. NO.		10. DATE SCHEDULED		11. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN SERIES				11. STOCK NUMBER				12. OPTIONAL	
13. SERIAL NUMBER				14. NOUN WHEEL HALF - OUTER					
15. DISPATCH STATION	16. PERF RCC OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20.	
69	045	SAFETY VALVE HOLE REPAIR IAW FIG 5-4 *C/P MOVE*					M		
69	048	VALVE STEM HOLE REPAIR IAW MS33649-03 *C/P MOVE*					M		
69	055	BEARING BORE REPAIR (OUTBOARD) IAW FIG 5-5, 5-6, 5-7 *C/P MOVE*							
69	058	BEARING BORE SEAT REPAIR (OUTBOARD) *C/P MOVE*							
26	060	SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH *REQD* 200% COVERAGE *C/P MOVE*				MAR 23 1989 70944			
26	070	ANODIZE TYPE II *REQD* *C/P MOVE*				MAR 23 1989 70944			
69	072	INSTALL CUP INTO BEARING BORE BUSHING (1ST REPAIR) P/N L6630310 P/N 63B31152 *C/P MOVE*					M		
69	074	MACHINE O.D. OF BUSHING AND CUP ASSY (1ST REPAIR) P/N N.P.L. *C/P MOVE*					M		
69	076	INSTALL BUSH AND CUP ASSY INTO BEARING BORE (1ST REPAIR)*C/P MOVE* P/N N.P.L.							
69	077	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N L6630310 (CONTINUED)					M		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT S.			
DISPATCH	FUNCTIONAL CODE	A		C		21104N			
		B		D					

21104N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

PAGE 4

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC		5 DATE SCHED		6 DATE SHIPPED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF - OUTER							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20	
		P/N 66C33001-119							
69	078	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE* P/N N.P.L.					M		
69	079	INSTALL BUSHING AND CUP ASSEMBLY INTO BEARING BORE (2ND REPAIR) *C/P MOVE* P/N N.P.L.					M		
69	080	INSTALL INSERTS IAW PAGE 6-1 PARA 5-1.1 (1) THRU (5) *C/P MOVE*				70207	70207		
13	095	PRE-FINAL INSPECTION AND ASSEMBLE *C/P MOVE* 10 3 APR 1989				71057			
13	098	RACE INSTALLATION *C/P MOVE* P/N L663010 10 3 APR 1989				71057			
13	100	PAINT *C/P MOVE* *REQD* 4 APR 1989				70725	70725		
13	110	INSTALL SAFETY VALVE *C/P MOVE* P/N 195-93 APR 04 1989				71057	71057		
13	120	TEST SAFETY VALVE HOLE AT 90-100 PSI *C/P MOVE* APR 04 1989							
13	122	BALANCE *C/P MOVE* *REQD* APR 04 1989							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21104N			

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PREVIOUS EDITION WILL BE USED

2 JOB ORDER NO 90101A		3 QUANTITY 92A1 EA		4 PRODUCTION SEC-RCC MNPGR		5 DATE SCHED MAR 28 1988		6 DATE COMPLETED	
8 PART NUMBER				9 TECH DATA 4W-1-51 4W1-4-493				10 ITEM SERIAL NO 5472	
11 MODEL-DESIGN-SERIES C 5B MAIN				12 STOCK NUMBER DMMIS/WIP				13 OPTIONAL	
14 SERIAL NUMBER E30218				15 NOUN WHEEL HALF - INNER					
16 DISPATCH STATION P/N 300-329-1 300-329-1		17 PERF RCC/OP NO		18 WORK TO BE ACCOMPLISHED NSN C/N 1630011084044 25323A 1630011084044 90101A				19 MECHANIC	
				***** UNIT COST: \$1953.91 *****					
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3					
				FPI IAW MIL-STD-6866					
				SHOT PEEN IAW MIL-S-13165					
				ANODIZE IAW MIL-A-8625					
				*****2014-T6 ALUMINUM*****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED; THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				WARNING					
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
1 FINAL DESTINATION DISPATCH		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN					
FUNCTIONAL CODE		31 AUG 88 31 AUG 88 31 AUG 88		30 AUG 1993 30 AUG 88 30 AUG 88		21103N			

21103N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 38237

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2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF - INNER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
	001	300-329-1							
34D	005 *REQD*	DISASSEMBLE *C/P MOVE* MAR 28 1989				70288	70288		
34D	006 *REQD*	REMOVE CUP FROM WHEEL HALF *C/P MOVE* MAR 28 1989				70288	70288		
34C	007 *REQD*	CHEM CLEAN *C/P MOVE* MAR 28 1989				70288	70288		
34B	008 *REQD*	BLAST CLEAN *C/P MOVE*				70288	70288		
69	009	REMOVE BROKEN SCREWS *C/P MOVE*							
68	010	EDM BROKEN SCREWS & TAPS *C/P MOVE*							
34C	011 *REQD*	ANODIZE STRIP *C/P MOVE*				71399			
34Z	015 *REQD*	FPI *C/P MOVE*							
34E	019 *REQD*	WICK AND BURR *C/P MOVE*				71030			
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21103N			
		B							
		C							
		D							

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN WHEEL HALF - INNER							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
34E		030 *REQD*		E & I AND ROUTE *C/P MOVE*			M			
69		044		LOCAL POLISH OR MACH AT BASE OF DRIVE KEY BOSS IAW PAR 5.1.1 K.A. .060 DEEP BY 2.5 INCHES MAX 63 RMS FINISH *C/P MOVE*			M			
69		045 *REQD*		REMOVE HELICOILS *C/P MOVE*			M			
69		050		RETAINER GROOVE REPAIR IAW PAGE 1-7 PARA J (2) *C/P MOVE*			M			
69		056		BEARING BORE REPAIR (INBOARD) IAW FIG 5-5 *C/P MOVE*			M			
69		057		BEARING BORE SEAT REPAIR (INBOARD) *C/P MOVE*			M			
69		059		BEARING AND SEAL GROOVE REPAIR IAW FIG 5-6 & 5-7 *C/P MOVE*			M			
26		060 *REQD*		SHOT PEEN MIL-S-13165 INTENSITY OF .08 TO .012 A2 SHOT SIZE CCW 28 WITH 200% COVERAGE *C/P MOVE*			M			
26		070 *REQD*		ANODIZE TYPE II CLASS 1 *C/P MOVE*			M			
69		075		INSTALL COP INTO BEARING BORE BUSHING (1ST REPAIR) P/N LM236710A (CONTINUED)			M			
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH		FUNCTIONAL CODE		A		C		21103N		
				B		D				

2. JCB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF - INNER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		P/N 63B31152 C/P MOVE							
69	074	MACHINE O.D OF BUSHING AND CUP ASSEMBLY (1ST) REPAIR C/P MOVE							
69	075	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (1ST REPAIR) *C/P MOVE* P/N N.P.L.					M		
69	077	INSTALL CUP INTO BEARING BORE AND SEAL BUSHING (2ND REPAIR)*C/P MOVE* P/N LM236710A P/N 66C330D1-121					M		
9	078	MACHINE O.D. OF BUSHING AND CUP ASSY (2ND REPAIR) *C/P MOVE*					M		
69	079	INSTALL CUP AND BUSHING ASSEMBLY INTO BEARING BORE (2ND REPAIR). *C/P MOVE* P/N N.P.L.					M		
69	080 *REQD*	INSTALL HELICOILS 100% REQUIREMENT *C/P MOVE*				70207	70207		
13	095 *REQD*	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVE* 10 4 APR 1989				70207	70207		
13	096 WCO 135	RACE INSTALLATION *C/P MOVE* P/N LM236710A 10 4 APR 1989				7080	7080		
13	100 *REQD*	PAINT *C/P MOVE* 10 4 APR 1989				7072	7072		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C 21103N			
		B				D			

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2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN WHEEL HALF - INNER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
15	122 *REQD*	BALANCE APR 04 1965 *C/P MOVE*				10V01 71019	10V01 71019		
13	123 *REQD*	INSTALL SEALS AND RETAINERS APR 04 1965 *C/P MOVE*							
13	125 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS 4115 958 APR 04 1965				10V01 71152			
13	130 *REQD*	FINAL PRODUCTION VISUAL INSPECTION *C/P MOVE* APR 04 1965				10V01 71152			
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
						21103N			
		B				D			

90101A C-5 M WHL ASSY.

RCC NRCP

401-40-497

STORE

DEER TECH S B W P FT AYR REV

SLB T A R A FA EFFORT DDC

STEP D L K C CD ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURSPFC
TIMESTD
HOURS

DLY PCT C

00010	S	E	YH	EA	E	1	EST06	1.00	PERCENT ENGR 99.9	DEB MAIN WHEEL ASSEMBLY	.56		.56	
0001			YH	01	00			1.00		PART NUMBER/VER	.000	.000	.000	0
0010									3-1266-3	1670011626267				
0020									4594000-1170	1670011626267				
0020			YH	01	21			1.00		FINAL WHEEL ASSEMBLY MED/BRK	.467	.096	.566	100
0010	E								RWE-AW-TF	4.00 REPLACE THERMAL FUSES	.06162		.296	
0020	E								RWE-AW-H2	1.00 INSTL SEGMENTED HEAT SHIELD	.02429		.029	
0030	E								RWE-AW-K2	9.00 INSTL BRAKE KEY/MULTI-SCREW	.01642		.176	
0040	E								RWE-AW-T1	4.00 INSTL UNOBSTRUCTED TIE BOLT	.00975		.047	
0050	E								RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DDC	.01001		.012	
9000			YH	01	25			1.00		LABOR STANDARDS HISTORY	.000	.000	.000	0
0900										LLOYD A.HARGIS MANEL 73357				

TO INTERROGATE LABCR STANDARDS, INPUT

RCC FRD NRCP NR

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4-10462-MM1-TV-V43 143 1001
37:31

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100

1999

REFERENCES

SUPPLEMENTAL

EASE
HOURS

250
251

10
1005

52 53 54

SM101	S	E	YH	EA	E	J	SSZ08	1.00	PERCENT ENGR 64.5	OSB MAIN WHEEL ASSEMBLY	.13	.13		
0001			YH	01		00		1.00		PART NUMBER/ASN	.000	.000	.000	0
			0010						J-1258-3	1630011826257				
			0020						4594000-117C	1630011826257				
0010			YH	01		21		1.00		WHEEL MATCH UP	.110	.023	.134	100
			0010	E				1.00	GET EASY AND PLACE EXACT		.00097		.001	
			0020	E				1.00	UNPK PARTS-BK KEY-SNAP RING		.08237		.099	
			0030	N				1.00		MATCH WHEEL HALFS 2 HALFS	.01700		.020	
			0040	E				1.00	REM RPL PAPERWRK SIGN OFF DOC		.01001		.012	
9000			YH	01		25		1.00		LABOR STANDARDS HISTORY	.000	.000	.000	0
			0900						LLOYD A.HARGIS MANEL 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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501014 CHE Y WHL ASBY.

OPER TECH-318 W F FR AVR REV

SLR 714 48 1 PA SUPPORT 000

STEP 2 L 40 00 ELEMENT FACT

		DESCRIPTION		STAGE	STC	STC	
		STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	ELY POT C
FRONT	TS	E 08 BA 5	3 85006	1.00	PERCENT ENGR 89.9	05A MAIN WHEEL INNER	.00
0001	TS	01 00	1.00		PART NUMBER/NEW	.000	.000
0010			300-10P-1	1670011084044		.000	.000
0100	TS	01 25	1.00		PAINT WHEEL	.267	.067
0010	E		GPL-PA-01	4.00	INST NONTHEADED PLSTD PLUS	.00067	.004
0020	E		BIG-SP-M1	1.00	MASK & UNMASK MEDIUM PART	.01242	.01E
0030	E		RWB-DH-W1	1.00	HANG WHL HLF ON PAINT CONVYR	.02336	.02F
0040	E		RWS-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE	.11374	.144
0050	E		RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT) POLY 2 COATS	.10214	.127
0060	E		RJP-PW-R1	1.00	REM RFL PAPRWK SIGN OFF DOC	.01001	.012
9000	TS	01 25	.01		LABOR STANDARD HISTORY	.000	.000
0010					06FEB85 NEW REQUIREMENT/INITIAL INPUT		
0900					N MONROE/MANEAA		

TO INTERROGATE LABOR STANDARDS. INPUT

RCC FRD KROF NR

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901014 0-5 M WEL ASBY.

TECH 8 B W F PP ARE REV

ELC 0 0 45 A PA SUPPORT

STEP 0 L K 0 00 ELEMENT FACT

DESCRIPTION
STORED SUPPLEMENTAL
SABE EFF STD
HOURS TIME HOURS DLY PCT C

PP104	S	E	35	EA	5	J	88308	1.00	PERCENT ENGR 99.9	005 MAIN WHEEL OUTER	.33		.33		
0001			35	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
			0010						300-328-1	1630011084043					
0100			35	01	25			1.00		PAINT WHEEL	.267	.067	.334	4.0	100
	0010	E					SPL-PA-01	4.00	INST NONTHEADED PLSTD PLUG		.00093		.004		
	0020	E					SIG-SF-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015		
	0030	E					RWB-QH-W1	1.00	HANG WEL HLF ON PAINT CONVR		.02336		.029		
	0040	E					RWB-SC-02	1.00	PNT WEL HALF-ZINC CHROMATE		.11574		.144		
	0050	E					RWB-SC-P3	1.00	PNT WEL HALF (2ND COAT)	POLY 2 COATS	.10214		.127		
	0060	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DDC		.01001		.012		
9000			35	01	00			.00		LABOR STANDRD HISTORY	.000	.000	.000		0
0900									8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRPP NR

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901014 CHS M WHL ASSY.

OPER TECH S B W F 55 A/R REV

EUS T K 48 4 FA SUPPORT EDC

STEP D L K O DO ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURSSTD
TIMESTD
HOURS

PLY PCT C

PS104	S	N	YH	EA	5	J	92008	1.00	PERCENT ENGR 54.9	055 MAIN WHEEL OUTER	.80		.80	
0001			YH	01	00			1.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						300-323-1	1630011084043				
0095			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019	2
			0010	E			RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005	
			0020	E			KAL-BC-46	1.00	INSPECT VISUAL		.00115		.001	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0095			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.216	27
			0010	E			RWB-BC-03	1.00	INSTALL BEARING CUPS		.16338		.203	
			0020	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0110			YH	01	21			1.00		INSTALL SAFETY VALVE	.260	.055	.315	39
			0010	N				1.00		INSTALL SAFETY VALVE	.25000		.302	
			0020	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0120			YH	01	21			1.00		TEST SAFETY VALVE	.060	.013	.073	9
			0010	N				1.00		TEST SAFETY VALVE	.05000		.060	
			0020	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0122			YH	01	21			1.00		BALANCE WHEEL HALF	.111	.023	.134	17
			0010	E			GPL-PD-01	4.00	REM NONTHEADED PLASTIC PLUG		.00339		.016	
			0020	E			GMC-MT-D1	1.00	REMOVE MASKING TAPE		.00191		.002	
			0030	E			RWB-CH-W2	1.00	REMOV WHL HLF F/PAINT CONVOYOR		.00833		.010	
			0040	E			RWB-BB-01	1.00	BALANCE WHEEL HALF		.07734		.093	
			0050	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
0123			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050	6
			0010	E			RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURED		.02459		.029	
			0020	E			RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00672		.008	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPRWK SIGN OFF DOC		.01001		.012	
9000			YH	01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0900									8 APR. 1988 RICHARD B. MARTIN MANEL-73357-MRP11					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRDP NR

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90101A C-5 M WPL ASSY.

OPER TECH E S W F FF A/R REV

315 T L #R A RA SUPPORT

STEP D L K C DO ELEMENT

DOO

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

FFD

TIME

STD

HOURS

4

DLY POT

RP101	E	N	3S	EA	5	K	85306	1.00	PERCENT ENGR 37.9	CSB MAIN WHEEL ASSEMBLY	.41		.41		
0001			3S	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		6
									3-1269-3	1630011826267					
									4894000-1170	1630011826267					
0030			3S	01	25			1.00		PAINT TOUCH UP SM & MED	.063	.016	.080		19
0010	E						RWB-FT-02	1.00	FINAL & TUCH UP MED/SML WHEL		.05395		.067		
0020	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOO		.01001		.012		
0040			3S	01	25			1.00		FINAL ACCEPTANCE OF W.C.D.	.132	.033	.166		40
										FINAL	.08000		.100		
							GJP-FF-35	1.00	FILL OUT FORM 424 & ATTACH		.05255		.065		
0050			3S	01	25			1.00		FINAL VISUAL INSPECTION	.137	.034	.171		41
										FINAL VISUAL INSPECTION	.12700		.159		
							RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOO		.01001		.012		
9000			3S	01	25			1.00		LABOR STANDARDS HISTORY	.000	.000	.000		0
0900									LLOYD A.HARGIS MANEL 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRGP NR

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2MNPRA90101ARA103

FORM 14 C-5 * WML ASSY.

RDC MNPRA

451-4-450

37192

OPER TECH 6 B A F F REV

STEP	TIME	DESCRIPTION	BASE	FFD	STD	PLY	FOOT
NO	EL	NO	HOURS	TIME	HOURS	NO	NO

RA103	S	E	JA	EA	1	J	83308	1.00	PERCENT ENGR 99.9	MACH WHEEL HALF INNER C-55	2.18		2.18		
0001			JA	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									300-329-1	1630011064044					
0009			JA	01	15			.05		REMOVE BROKEN SCREWS	.235	.002	.014		1
0010	E						RBW-SU-B1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
0020	E						RSG-JP-03	1.00	PREP HAND DRILL FOR USE		.00561		.009		
0030	E						GTL-SE-A1	2.00	DRILL & EASYOUT SCR TO .25IN2 SCREWS		.02540		.053		
0040	E						GTL-TH-A1	2.00	TAP HOLE TO 0.25 IN THRD DIA2 HOLES		.01427		.032		
0050	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0044			JA	01	15			1.00		POLISH BASE DRV KEY HOLES	.300	.045	.345		16
0010	E						RBW-SU-B1	.50	S/U FOR BENCH WORK GENERAL	PRO RATE 2 PARTS	.27525		.158		
0020	E						ZPG-JP-S1	1.00	PREP TO POLISH BASE HOLES		.00495		.005		
0030	E						RHY-RC-F2	9.00		POLISH BASE HOLES	.01582		.163		
0050	E						GCL-CA-A4	4.00	CLEAN BLIND HOLE WITH AIR		.00126		.005		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0045			JA	01	15			1.00		REMOVE INSERTS	.176	.027	.203		9
0010	E						RBW-SU-B1	.50	S/U FOR BENCH WORK GENERAL	PRO RATE 2 PARTS	.27525		.158		
0020	E						JLR-AS-D5	1.00	RMVE SMALL SPRING W/TWEEZERS	8 OCCUR	.01232		.014		
0030	E						GTL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.016		
0040	E						KTL-TT-03	1.00	TAP EACH ADDITIONAL THREAD		.00130		.001		
0050	E						GCL-CA-A4	1.00	CLEAN BLIND HOLE WITH AIR		.00126		.001		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0050			JA	01	15			.07		O/S HOLE ON MILL/MED PART	.835	.009	.067		3
0010	E						RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230		
0020	E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						KMM-BA-LC	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.26418		.303		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0056			JA	01	15			.05		BEARING BORE REP - JIG BORE	.835	.006	.048		2
0010	E						RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230		
0020	E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						KMM-BA-LC	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.26418		.303		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0057			JA	01	15			1.00		BEARING BORE SEAT REP, MED	.773	.116	.889		41
0010	E						RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230		
0020	E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP	JIG BORE	.15776		.181		
0030	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						KMM-BA-LA	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.20205		.232		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0059			JA	01	15			.07		O/S HOLE ON MILL/LARGE PART	.894	.009	.072		3
0010	E						RML-SU-V3	.25	S/U VERT MIL BORE FXTR	HOISTPRORATE OVER 4 PARTS	1.03687		.298		
0020	E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						KMM-BA-LC	1.00	BORE HOLE 6 X 1 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.26418		.303		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DDC		.01001		.011		
0073			JA	01	15			.07		INST BEARING BORE BUSH & CLF	.077	.001	.006		0
0010	E						RBW-SU-B1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E						RBW-SU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		

00070 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0074	JA 01	15	.05	MACH BEARING BORE BUSHING	.236	.002
0010 E	RLA-BU-ST	.25	SET UP SMALL MEDIUM LATHE	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0075	JA 01	15	.07	INST BEARING BORE BUSH & CUP	.077	.001
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0077	JA 01	15	.10	INST BEARING BORE BUSH & CUP	.077	.001
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0079	JA 01	15	.05	MACH BEARING BORE BUSHING	.236	.002
0010 E	RLA-BU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250	.09193	.105	
0040 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0079	JA 01	15	.07	INST BEARING BORE BUSH & CUP	.077	.001
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
0080	JA 01	15	1.00	INSTALL HELICOILS	.431	.065
0010 E	RBW-BU-H1	1.00	SET UP TO INSTALL HELICOILS	.31093	.357	
0020 E	RBW-TR-H1	4.00	INSTALL HELICOIL INSERT	.02763	.127	
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC	.01001	.011	
9000	JA 00	15	.00	LABOR STANDARD HISTORY	.000	.000
0010						
0011						
0012						
0900						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRJP NR

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FORM 12-1-88

TECH 5 B W F FF A/S REV

SLR T W AS A FA SUPPORT

STEP D L K O DO ELEMENT

DOC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

FFD

TIME

STD

HOURS

BLV FOT C

RA104	S	N	JA	EA	1	7	88308	1.00	PERCENT ENGR 70.3	MACH WHEEL HALF OUTER C-5B	1.90		1.90	
0001			JA	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	0
									300-325-1	1630011094043				
0040			JA	01		15		.05		THREAD INSERT REPAIR	.835	.006	.048	3
0010	E						RBW-SU-S1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E						RSW-TR-S1	8.00	DRILL TAP & INSTALL SLIMERT4 SCREWS-4 HOLES		.06579		.632	
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0043			JA	01		15		.05		REMOVE BROKEN SCREWS	.338	.003	.019	1
0010	E						RBW-SU-S1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E						RSG-JP-03	1.00	PREP HAND DRILL FOR USE		.00861		.009	
0030	E						GAE-TL-02	2.00	DRILL W/HND DRILL TO 1/4 IN DRILL 2 HOLES		.00871		.020	
0040	E						JLR-AS-DB	2.00		REMV 2 SCREWS EASYOUT	.01232		.028	
0050	E						GCL-CA-A4	2.00	CLEAN BLIND HOLE WITH AIR 2 HOLES		.00126		.002	
0060	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0045			JA	01		15		.93		SAFETY VLVE HOLE REP	.983	.137	1.052	58
0010	N							.50		S/U BORE FXTR(RML-SU-V2)	.98400		.565	
0020	E						RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP		.03068		.035	
0030	E						RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.06265		.072	
0040	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0050	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0060	E						RML-BA-AB	1.00	BORE HOLE 1 X 1 GROUP 1		.18482		.212	
0070	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0046			JA	01		15		.09		VALVE STEM HOLE REPAIR	.642	.009	.066	4
0010	E						RDR-SU-R1	1.00	S/U TO D/S BOSSES RAD DRILL		.56378		.648	
0020	E						KML-DR-KB	1.00	DRILL HOLE 1/2 DIA 1 DEEP		.06857		.078	
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0055			JA	01		15		.05		BEARING BORE REP,PENSOTTI	.508	.004	.029	2
0010	N							1.00		SET UP PENSOTTI	.16700		.192	
0020	E							1.00	4 .26 MACHINE BEARING BORE		.29333		.337	
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC/		.01001		.011	
0040	E						RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/		.03815		.043	
0058			JA	01		15		.05		BEARING BORE SEAT REP,MED	.787	.006	.045	3
0010	E						RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR PRORATE OVER 4 PARTS		.80167		.230	
0020	E						RML-TP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE		.15776		.181	
0030	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E						RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE		.21626		.248	
0060	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0072			JA	01		15		.05		INST STRAIGHT BUSH NO POLISH	.077	.001	.004	0
0010	E						RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	
0020	E						RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0074			JA	01		15		.05		MACH BEARING BORE BUSHING	.236	.002	.014	1
0010	E						RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS		.49962		.143	
0020	E						RLA-TP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E						KML-TA-JC	1.00	DIA 5.00-6.00 REM .033-.250		.09193		.105	
0040	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0076			JA	01		15		.05		INST BEARING BORE BUSH & CLP	.077	.001	.004	0
0010	E						RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	
0020	E						RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0077			JA	01		15		.10		INST STRAIGHT BUSH NO POLISH	.077	.001	.009	0
0010	E						RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	

TIME	CODE	DESCRIPTION	UNIT	QUANTITY	UNIT PRICE	TOTAL	REMARKS
0020	E	RBW-BU-A4	1.00	1.00	.02062	.020	INSTALL ONE STRAIGHT BUSHING
0070	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
0075	JA 01	15	1.00	1.00	.078	.002	MACH BEARING BORE BUSHING
0010	E	RJP-SU-S3	.25	.25	.48962	.147	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS
0020	E	RCA-HF-D1	1.00	1.00	.01006	.011	1ST PART IN-OLT SCROLL CHUCK
0030	E	MML-TP-JC	1.00	1.00	.09193	.105	DIA 5.00-6.00 REM .033-.250
0040	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
0079	JA 01	15	1.00	1.00	.077	.001	INST BEARING BORE BUSH & CUP
0010	E	RBW-BU-B1	.25	.25	.12669	.033	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS
0020	E	RBW-BU-A4	1.00	1.00	.02062	.023	INSTALL ONE STRAIGHT BUSHING
0030	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
0080	JA 01	15	1.00	1.00	.431	.065	INSTALL HELICOILS
0010	E	RBW-SU-H1	1.00	1.00	.31093	.337	SET UP TO INSTALL HELICOILS
0020	E	RBW-TR-H1	4.00	4.00	.02763	.127	INSTALL HELICOIL INSERT
0030	E	RJP-PW-R1	1.00	1.00	.01001	.011	REM RPL PAPRAWK SIGN OFF DOC
9000	JA 01	15	.01	.01	.000	.000	LABOR STD HISTORY
0010							21MAY85 DWN GRD TO N STD (TM WAS 2.40)
0020							09 APRIL 87 RM SUBOPS 0044-0110 NLD OLD STD 2.
0900							D.PARKER TECHN MANEAA

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NRDP NR

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MMFR090101ARD103

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MMFR

11/14/88
481-4-483

4-ED483-MM1-DV-M4E PAGE 0001
87188

90101A D-S M WHL ASBY.

OPER TECH S S W P FF A/R REV

SUB T N #R A PA SUPPORT

STEP D L N D DO ELEMENT FACT

DESCRIPTION

STORED

SUPPLEMENTAL

BASE
HOURS

FFD
TIME

STD
HOURS

PLY POT C

RD103	S	E	UP	EA	S	J	88308	1.00	PERCENT ENGR 99.9	PLT. OSBM WHEEL HALF, INNER	.94		.94	
0001			UP	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						300-329-1	1630011084044				
0050			UP	01		24		1.00		SHOT PEEN MED PART/MASK	.301	.072	.374	40
			0010	E			RPL-MA-AA	1.00	MASK UNMASK EXT PLATE AREA		.12999		.161	
			0020	E			RPL-SF-M1	1.00	SHOT PEEN SMALL/MED PART		.16131		.200	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0070			UP	01		24		1.00		ANDDIZE MED PART	.460	.111	.571	.9 50
			0010	E			RWB-CV-D1	1.00	VAPOR CL (DEBR)HOOK/BASKET		.08709		.107	
			0020	E			ZPL-AN-M1	1.00	ANDDIZE MEDIUM SIZE PART		.36341		.450	
			0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
9000			UP	01		00		.00		LABOR STANDRD HISTORY	.000	.000	.000	0
0500									8 APR. 1988 RICHARD B. MARTIN MANEL-73357-MRP11					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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RD104 S E UP EA B J 83308
0001 UP 01 00
0010
0030 UP 01 24
0010 E RPL-M4-AA
0020 E RPL-SP-M1
0030 E RJP-PW-R1
0070 UP 01 24
0010 E RWR-CV-D1
0020 E ZPL-AN-M1
0030 E RJP-PW-R1
9000 UP 01 24
0010
0011
0900

DESCRIPTION
STORED
SUPPLEMENTAL
PAGE
HOURS
TIME
STC
HOURS
DLY FCT C

RD104	S	E	UP	EA	B	J	83308	1.00	PERCENT ENGR 99.9	PLT 058 M WHEEL HALF OUTER	.94		.54		
0001			UP	01	00			1.00		PART NUMBER/SEN	.000	.000	.000		0
0010									300-328-1	1630011084043					
0030			UP	01	24			1.00		SHOT FEEN MED PART/MASK	.301	.072	.374		40
0010 E								1.00	MASK UNMASK EXT PLATE AREA		.12999		.161		
0020 E								1.00	SHOT FEEN SMALL/MED PART		.16131		.200		
0030 E								1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
0070			UP	01	24			1.00		ANODIZE MED PART	.460	.111	.571	.8	60
0010 E								1.00	VAPOR CL (DEGR)HOOK/BASKET		.08709		.107		
0020 E								1.00	ANODIZE MEDIUM SIZE PART		.36341		.450		
0030 E								1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012		
9000			UP	01	24			.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									3JUN66 REWROTE STD TO MATCH 958 WORK PREVIOUSLY						
0011									DONE ON OPERATION XNPRC <OLD STD .425>						
0900									KERRY CDDP MANEL TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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90101A C-5 N WHL 488Y.
CUBS TEL 8 6 4 7 7 5/3 REV

06	78	95-4-76	SUBJECT	FACT	(-----)	RECAPTION	(-----)	PAGE	770	870		2
06	81	95-4-76	ELEMENT	FACT	STORED		SUPPLEMENTAL	10560	TUNE	HOURS	2-4-77	

W2001	S	N	KI	EA	5	J	86306	1.00	PERCENT ENGR 54.9	OSB MAIN WHEEL INNER	.59	.59		
0001			KI	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	
							0010		J-1269-3	1630011826267				
							0020		4894000-1170	1630011526267				
0007			KI	01		27		1.00		CHEM CLEAN WHEEL ALUM	.116	.031	.147	2.6 35
							0010 N		ZLG-CL-M1	.50 LOAD & UNLOAD CARRIER CLEAN	.21200		.134	
							0020 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
0008			KI	01		27		1.00		BLAST CLEAN WHEEL MED	.217	.059	.277	46
							0010 E		RPL-SB-M2	1.00 SANDBLAST MED PART WALK-IN B	.10180		.129	
							0020 N		ZLG-CL-M1	.50 LOAD & UNLOAD CARRIER CLEAN	.21200		.134	
							0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
0011			KI	01		27		1.00		ANODIZE STRIP WHEEL ALUM	.136	.037	.173	.7 29
							0010 E		ZCD-ST-S1	1.00 ANODIZE STRIP	.12630		.160	
							0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.012	
9000			KI	01		27		.01		LABOR STD HISTORY	.000	.000	.000	0
							0010		18JUL85 MOVED N&B TO HB SKL (TM WAS .66)					
							0900		D.PARKER TECHN MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROD NR

 $\langle \text{---} X \text{---} X \text{---} \rangle$

1234567290123456 ELSE PUT IN END

90101A 2-5 F WHL ASSY.

OPER TECH 8 5 W 5 FF A/R REV

SLB T Y HA 4 FA SUPPORT

STEP 3 L K O DO ELEMENT

DESCRIPTION
STORED SUPPLEMENTAL
BASE HOURS
PFD TIME
STD HOURS
DLY PCT D

W0001	S	E	HE	EA	5	J	BZ300	1.00	PERCENT ENGR 99.9	DISSY WHEEL CSA M	211E	.97		.97	
0001			HE	01	00			.00		PART NUMBER/NSN		.000	.000	.000	0
0010									4894000-1170	1630011826267					
0005			HE	01	25			1.00		DISASSEMBLE		.606	.152	.758	75
0010	E					RWB-JP-W1		1.00	PREP TO DISASSEMBLE WHEEL			.01630		.020	
0020	E					RWB-HP-EB		1.00	HNDL E/I PARTS (ALL WHEELS)EA			.02265		.023	
0030	E					RWB-HT-C3		1.00	HANDLING TOOLS PER END ITEM			.13837		.172	
0040	E					RWB-DW-T1	18.00	REM UNDBSTR WHL TIE BOLT	18 EACH			.01056		.237	
0050	E					RWB-DW-K1	9.00	REM BRAKE KEY (ONE RET SCW)	8 EACH			.01091		.122	
0060	E					RWB-DW-C2	2.00	REM DATA PLATE & STAMP WHL	2 EACH			.03067		.076	
0070	E					RWB-DW-B1	2.00	REM BEARING (SNAP RING SEC)	2 EACH			.01227		.030	
0080	E					RWB-DW-M1	1.00	DTS WHL (V/L-L & M WHEELS)				.04265		.053	
0090	E					RWB-DW-H1	1.00	REM HEAT SHIELD (SINGLE PC)				.00217		.062	
0100	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.012	
0006			HE	01	25			1.00		REMOVE BEARING CUP		.171	.043	.214	22
0010	E					RWB-BC-R1	2.00	REMOVE BEARING CUP				.02811		.070	
0020	E					RWB-MH-02	1.00	LOAD HOOK W/WHEELS F/CLENING				.10532		.131	
0030	E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC				.01001		.012	
9000			HE	01	25			.01		LABOR STD HISTORY		.000	.000	.000	0
0010									10JUN85 CHANGED SKL CODE NO TM CHNG						
0020									OLD STANDARD .91						
0900									26 SEPT 1989 MRPII RICHARD G. MARTIN MANEL 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NR0P NR

<---X---X--->

1234567890123456 ELSE PUT IN END

901014 C-E Y WEL ASBY

OPER TECH S S W F RF AVE REV

SUB T N #R A FA SUPPORT

STEP D L K C D2 ELEMENT

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

RFI
TIME

STD
HOURS

SLY PCT C

WE100	E	N	D1	EA	5	J	89308	1.00	PERCENT ENGR 12.3	CEE MAIN WHEEL INNER	.51		.51	
0001			D1	01	00			1.00		PART NUMBER/NO	.000	.000	.000	0
			0010						300-129-1	1630011034044				
0019			D1	01	27			1.00		NICK & BURR WHEEL MED/HALF	.250	.068	.318	82
0010	E					RLB-RS-NJ		1.00	NICK & BURR FTS-CONST F/PREP		.02312		.025	
0020	N							1.00		NICK & BURR WHEEL MED/HALF	.21687		.275	
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.012	
0030			D1	01	15			1.00		E & I AND ROUTE WHEEL	.167	.025	.193	38
0010	N							1.00		E&I AND ROUTE WHEEL HALF	.14919		.171	
0020	E					RWB-CH-W2		1.00	REMY WHL HLF F/PAINT CONVOYOR		.00833		.009	
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DOC		.01001		.011	
9000			D1	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									28FEB85 NEW REQUIREMENT/INITIAL INPUT					
0900									N MONROE MANEAA 73.37					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRO NRDP NR

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2MNF34

R01004 CHE M WEL REBN.

RCC MRPGW

4W1-4-497

87168

OPER TECH E B

W F AF 4/R REV

SUB

STEP 3 L

W F AF SUPPORT

DOC

W F AF ELEMENT

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

AFD

STD

HOURS

TIME

HOURS

OLY FOT C

WE104	E	N	DI	EA	E	J	85308	1.00	PERCENT ENGR 12.0	CSB MAIN WHEEL OUTER	.51		.01	
0001			DI	01		00		1.00		PART NUMBER/NSN	.000	.000	.000	0
									300 725-1	1830011084 43				
0015			DI	01		27		1.00		NICK & BURR WHEEL MED/HALF	.250	.066	.316	82
									RLG-RB-NC	1.00 NICK & BURR PTS-CONST F/PRP	.02312		.029	
										1.00 NICK & BURR WHEEL MED/HALF	.21687		.275	
									RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.012	
0030			DI	01		15		1.00		E & I AND ROUTE WHEEL	.167	.025	.193	38
										1.00 E&I AND ROUTE WHEEL HALF	.14919		.171	
									RWB-CH-W2	1.00 REMV WHL HLF F/PAINT CONYOR	.00833		.009	
									RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000			DI	01		00		1.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0900										8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRP11				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/01/89

A-E046B-MM1-DY-M45 PAGE 0001

90101A C-S M WHL ASSY.

RCC MNPNA

4B1-4-493

87198

OPER TECH S S W F FF A/R REV

SUB	STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
MNPNA	S	X	DB	EA	2	J 88308	1.00	PERCENT ENGR 99.9	CSB MAIN WHEEL INNER	.31		.31	
0015			DB	01	11		.13	NDI TIE BOLTS 1ST TIME		1.005	.014	.145	46
0010	E				ZLG-ND-M6	11.00	MAGNAGLO INSP SHALL OBJECT			.09138		1.115	
0020			DB	01	11		.13	NDI DRIVE KEYS 1ST TIME		.822	.012	.119	37
0010	E				ZLG-ND-M6	9.00	MAGNAGLO INSP SHALL OBJECT			.09138		.912	
2000			DB	01	00		1.00	PART NUMBER/NSN		.000	.000	.000	0
0010							3-1268-3	1630011826267					
0020							4694000-117C	1630011826267					
2001			DB	01	11		1.00	ZYGLO WHEEL MED		.273	.030	.304	.7 96
0010	E				ZLG-ND-Z2			ZYGLO INSP MED PART BLD 507		.13177		.292	
0020	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011	
9000			DB	01	00		.00	LABOR STANDARD HISTORY		.000	.000	.000	0
0900								21 MAR. 1988 MRP11-RICHARD G. MARTIN-MANEL-73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

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BLDG 505/507

F-4 NOSE WHEEL

STAIRS AND MATERIALS

STAIRS AND MATERIALS

16267A

16267A

五二

ROUTED	LOW LEVEL	PART	STOCK	VENDOR	DESCRIPTION	UNITS	PER	OF	YIELD	TECH	REV	EFFECTIVITY	CONTROL	PENDING	PENDING	PENDING
ITEM	CODE	NUMBER	NUMBER	CODE		ASSY	MEAS				DATE					
10	Z20A123		163000821432	23233	IF-4 NOSE WHEEL ASSEMBLY	11	1EA									
1.1	Z20A282		1630011611191	23233	1..WHEEL HALF ASSEMBLY (INBOARD)	11	1EA									
1.2	1L305610		13110002770372	160038	1..CUP, BEARING	11	AR1EA									
1AL	Z20A284		153300093606201E	73808	1..RAFFLE, GREASE RETAINER	11	1EA									
1.2	219A189-1		1630009153183	73808	1..WEIGHT, BALANCE .75oz	11	AR1EA									
1.2	219A189-2		1630009153184	73808	1..WEIGHT, BALANCE .50 oz	11	AR1EA									
1.2	219A189-3		1630009153185	73808	1..WEIGHT, BALANCE .75oz	11	AR1EA									
1.2	219A189-4		1630009173110	73808	1..WEIGHT, BALANCE 1oz	11	AR1EA									
1.2	1A620-10R14		15305007716012	88044	1..SCREEN, WEIGHT	11	AR1EA									
1.2	1A620-10L		15310001670834	88044	1..WASHER, WEIGHT	11	AR1EA									
1.2	1A620-10S32C		15310002732025	196906	1..NUT, WEIGHT	11	AR1EA									
1.2	Z20A286		153300093606231E	73808	1..SEAL, GREASE (I.B.)	11	1EA									
1.2	Z20A247		15365005346651	73808	1..RING RETAINING (I.B.)	11	1EA									
1.2	IN.P.L.		IN.S.L.		1..WHEEL HALF SUBASSY (INBOARD)	11	1									
1.3	IN.P.L.		IN.S.L.		1..SLEEVE & CUP ASSY (PSEUDO)	11	AR1									
1.4	Z20A401		131200048870911E	73808	1..SLEEVE, BEARING CUP	11	1EA									
1.4	1L305610		13110002770372	160038	1....CUP, BEARING	11	1EA									
1.3	Z20A282		IN.S.L.	23233	1..WHEEL HALF (INBOARD)	11	1									
1.1	Z20A283		1630011532016	23233	1..WHEEL HALF ASSEMBLY (OUTBOARD)	11	1EA									
1.2	1L102810		13110001861114	160038	1..CUP, BEARING	11	AR1EA									
1.2	219A189-1		1630009153183	73808	1..WEIGHT, BALANCE .75oz	11	AR1EA									
1.2	219A189-2		1630009153184	73808	1..WEIGHT, BALANCE .50 oz	11	AR1EA									
1.2	219A189-3		1630009153185	73808	1..WEIGHT, BALANCE .75oz	11	AR1EA									
1.2	219A189-4		1630009173110	73808	1..WEIGHT, BALANCE 1oz	11	AR1EA									
1.2	1A620-10R14		15305007716012	88044	1..SCREEN, WEIGHT	11	AR1EA									
1.2	1A620-10L		15310001670834	88044	1..WASHER, WEIGHT	11	AR1EA									
1.2	1A620-10S32C		15310002732025	196906	1..NUT, WEIGHT	11	AR1EA									
1AL	Z20A285		153300093606211E	73808	1..RAFFLE, GREASE RETAINER	11	1EA									
1.2	Z20A287		153650053466241E	73808	1..RING, RETAINING (O.B.)	12	1EA									
1.2	IN.P.L.		IN.S.L.		1..SEAL, GREASE (O.B.)	11	1EA									
1.3	IN.P.L.		IN.S.L.		1..WHEEL HALF SUBASSY (OUTBOARD)	11	1									
1.4	Z20A403		131200022519361E	73808	1....SLEEVE & CUP ASSY (PSEUDO)	11	AR1									
1.4	1L102810		13110001861114	160038	1....CUP, BEARING	11	1EA									
1.3	Z20A283		IN.S.L.	23233	1..WHEEL HALF (OUTBOARD)	11	1									
1.2	1A62002-5		153100020900026	196906	1..WASHER TIE BOLT (ADD 1 IF REPAIRED)	110	AR1EA									
1.1	1A62002-3		126400017261896	79934	1..VALVE ASSEMBLY, CHARGING	11	1EA									
1.2	1A62002-1		1165000224525	79934	1..CAP, VALVE	11	1EA									
1.2	1A62002-2		126400008105861	79934	1..VALVE, CORE	11	1EA									
1.2	1A62002-4		1533000041978711M	53477	1..PACKING, O-RING	11	1EA									
1.2	1A62002-6		IN.S.L.	79934	1..STEM, VALVE	11	1									
1.1	IN.P.L.		IN.S.L.		1..VALVE & PACKING ASSY (PSEUDO)	11	AR1									
1.2	1A62002-3		12640001166208	196906	1..VALVE ASSEMBLY, OVERSIZE	11	1EA									

16-May-58

BLDG 505/507

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

F-4 NOSE WHEEL
BILL OF MATERIALS
16267A

* = MM

ROUTED	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	UNIT	YIELD	SCRAP	PART	MTC	REV	EFFECTIVITY	TECH	ORD	PENDING	PENDING	PENDING	PENDING
ITEM	CODE					PER	OF	IRATE	FACTOR	TYPE	CODE	LEVEL	CONTROL	CNG	103	252	ACTION	ACTION	ACTION
						ASSY	MEAS			R, D, C			DATE	NUMBER					
	1.1	22A288	5330005992735	23233	PACKING O-RING	1	EA												
	1.1	MS29561-262	5330008924263	96906	PACKING O-RING	1	EA					SUB							

(6402A-TIP001)

LA FOR STD S-VIR 10 APR 89

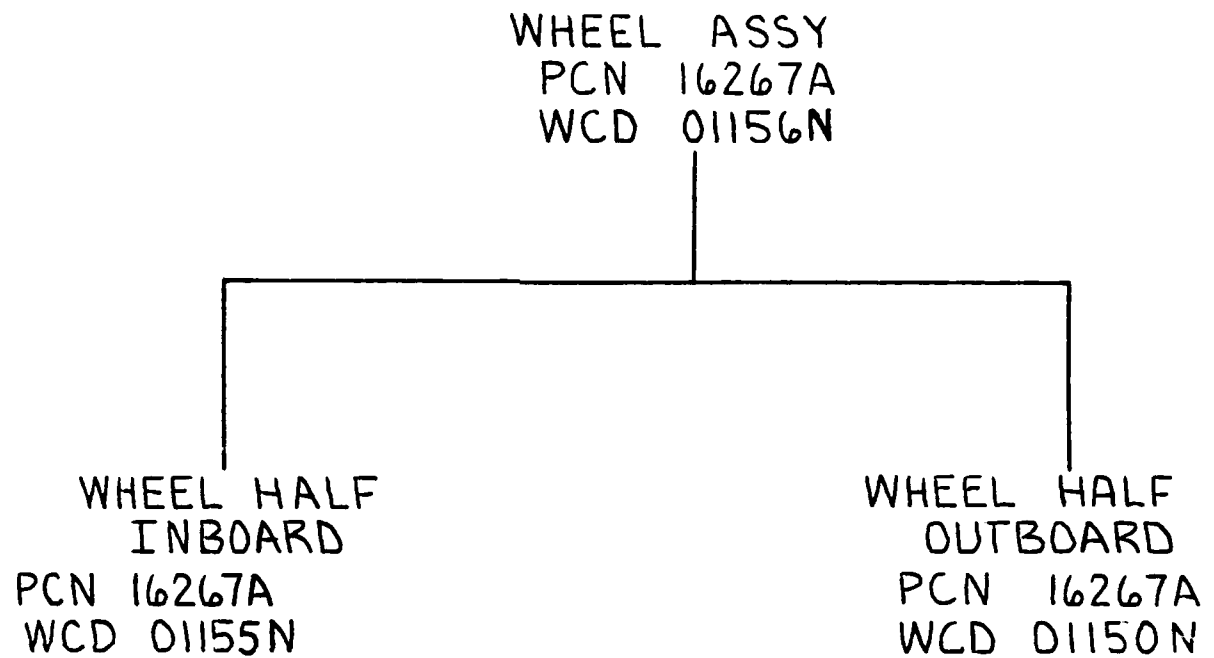
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PROD NBR	REC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
10207A	XKPAW	XKPAW	X	4N	5	.31	1.00	51
								51
	MNPGP	00110	E	YH	5	.01	1.00	5
		PA150	E	YH	5	.28	1.00	28
		PA155	E	YH	5	.28	1.00	28
		PA156	E	YH	5	.13	1.00	13
		PP150	E	SS	5	.33	1.00	33
		PP155	E	SS	5	.33	1.00	33
		PP156	N	SS	5	.42	1.00	42
								1.83
	MNPGW	W0001	N	KI	5	.54	1.00	54
		W0001	E	HE	5	.48	1.00	48
		WE150	N	DI	5	.35	1.00	35
		WE155	N	DI	5	.35	1.00	35
								1.72
	MNPNA	XNPNA	X	DB	2	.12	1.00	12
								12
	MNPRA	R-150	E	JA	1	1.50	1.00	1.50
		RA155	E	JA	1	1.08	1.00	1.08
								2.58
	MNPRC	RC150	E	UP	5	.19	1.00	19
		RC155	E	UP	5	.19	1.00	19
								38
								7.14

SERIAL NUMBER LIST

Q	LAN	CONTROL	JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G019
	CH	NUMBER	DESC						FLOM DAYS
JENS	RIGB	15585A	-J	F-106 MLG	BRAKE ASSY	1630-00-165-1029	151806-2	481-4-223	24
JENS	RIGB	15587A	-G-J	F-111 MLG	BRAKE PRESSURE PLATE	1630-00-264-0752	329-16-1	481-2-483	19
JENS	PRIC	15592A	-G-J	KC-135 MLG	WHEEL	1630-00-421-0319	211A24303	483-2-113	30
JENS	RIGB	15601A	-G-J	T-39 MLG	BRAKE ASSY	1630-00-553-4734	9550338-1	481-2-1073	20
JENS	RIGB	15603A	-G-J	KC-135 MLG	BRAKE BACKING PLATE	1630-00-591-8349	2601844	481-4-263	16
JENS	PIGB	15616A	-J	C-141 MLG	BRAKE BACKING PLATE	1630-00-567-0162	9533668	481-2-373	19
JENS	RIGB	15621A	-J	F-106 MLG	BRAKE PRESSURE PLATE	1630-00-671-2838	151804	481-4-223	16
JENS	RIGB	15639A	-G-J	C-130 MLG	BRAKE PRESSURE PLATE	1630-01-005-4188	5002564	481-2-1003	16
JENS	RIGB	15641A	-J	F-4 MLG	BRAKE HOUSING SUB ASSY	1630-00-276-9849	5001896	481-2-1093	23
JENS	RIGB	15642A	-G-J	C-130 MLG	BRAKE BACKING PLATE	1630-01-005-4189	5000263	481-2-1003	19
DELE		15643A	-G-J	F-15 MLG	WHEEL	1630-00-123-8803	17 OCT 88	481-0-73	22
JENS	RIGB	15644A	-J	F-15 MG A/B	BRAKE HOUSING	1630-00-123-8804	5002269	481-2-1123	16
COOP	PRIC	15651A	-J	F-15 MLG	WHEEL	1630-00-558-2584	5000960-2	483-0-23	20
JENS	PRIC	15652A	-G-J	F-15 MLG	WHEEL	1630-01-005-4262	5000864	481-0-73	20
JENS	COOP	15677A		A-7 MLG	STRUT ASSY	1620-01-174-1655	8121017-30	451-90-3	30
JENS	COOP	15678A		A-7 MLG	STRUT ASSY	1620-01-174-3170	8121017-10	451-90-3	02
JENS	PRIC	15686A	-G-J	A-10 MLG	WHEEL	1630-00-596-9637	3-1358	483-4-433	16
JENS	RIGB	15698A	-G-J	C-5A MLG	BRAKE ASSY	1630-01-041-4570	2-1179-4	481-2-1063	26
JENS	RIGB	15728A	-J	C-130 MLG	BRAKE HOUSING	1630-00-937-6604	9543433	481-2-1003	16
JENS	RIGB	15744A	-J	F-15 MG A/B	BRAKE ASSY	1630-01-050-5274	5000913-12	481-2-1123	13
JENS	RIGB	15746A	-J	C-141 MLG	WHEEL	1630-01-081-6687	3-1095	483-7-1043	20
JENS	RIGB	15747A	-J	F-15 MLG	BRAKE BACKING PLATE	1630-00-132-2821	5002483	481-2-1123	16
JENS	RIGB	15749A	-J	F-5 MLG	BRAKE ASSY	1630-00-227-2000	AA318196	481-2-453	20
JENS	RIGB	15752A	-G-J	A-10 MLG	BRAKE ASSY	1630-01-062-7046	5002372-5	481-2-1143	27
JENS	PRIC	15753A	-J	E-3A MLG	WHEEL	1620-01-009-8474	95605718	481-7-1353	20
JENS	PRIC	15757A	-G-J	C-130 MLG	WHEEL	1630-00-914-1329	219A967	483-4-363	23
MART	SHEL	15803A	-G	A-7	HOUSING TRANSFER UNIT	1005-00-239-2929	175F631	1141-7-1-103	20
MART	SHEL	15819A			BREECH MAU-12	1095-00-911-8407	64H13212-3	11829-3-25-2	12
JENS	PRIC	15822A	-J	F-5 MLG	WHEEL	1630-01-055-5056	250-A-160-C	481-1-43	20
JENS	PRIC	15828A	-J	F-16 MLG	WHEEL	1630-01-030-9239	5003062	481-7-1363	20
JENS	COOP	15834A		F-16 MLG	PIN ASSY	1620-01-071-0536	2006004-103	451-109-3	0
MART	SHEL	15849A		MULTIPLE	AIR FOIL MXU02A/B	1325-00-162-0244	609890-2	11K1-9-3	20
COOP	COOP	15862A		F-16 MLG	PISTON ASSY	1620-01-071-0538	2006602-103	452-00-3	35
COOP	POLL	15865A		C-141 MLG	FORWARD LINK	1620-00-927-2601	3610013-111	451-73-3	21
COOP	COOP	15866A		C-141 MLG	STRUT ASSY H/W	1630-01-103-7747	729965-10	451-07-3	22
DELE		15874A	-G-J	A-37 MLG	BRAKE HOUSING	1630-01-124-2873	10 OCT 88	481-2-1023	20
COOP	COOP	15984A		F-111 MLG	PIN SHOCK STRUT	1620-00-400-1007	12L9519-5	444-15-3	30
JENS	POLL	15998A		C-130 MLG	STRUT ASSY	1620-01-146-5708	7926623-10	452-23-3	65
MONR	ANDE	16019A	-J	F-4 MLG	STRUT ASSY	1620-01-024-8844	53-45400-301	452-57-3	69
MART	SHEL	16039A		F-16	ECM ADAPTER	1560-01-142-6594MF	16S601-819	16N6-35-3-2	15
MART	SHEL	16099A		MULTIPLE	LAU-100 LANCER R/H AIM 9	1440-01-104-0360AB	7839472-60	11L1-3-11	20
PARK	ANDE	16101A		LEM-30	T.E. ACTUATOR	1450-00-009-0946AH	67329921-10	35D3-11-25-13	20
JENS	POLL	16123A	-G-J	C-130	BALLSCREW	1620-00-677-6681	1650E412	1663-2-40-23	20
JENS	RIGB	16136A		E-3A MLG	BRAKE TORQUE TUBE	1630-01-034-5387	9542482	481-2-1153	13
MART	SHEL	16148A		F-4	CENTERLINE ADAPTER ASSY	1095-00-192-5341BF	53-73023-321	1F40-3-1-4	00
MART	SHEL	16228A		MULTIPLE	AIRFOIL MXU 602	1325-00-491-0006	609890-1	11K1-9-3	05
MART	SHEL	16229A		MULTIPLE	AIRFOIL MXU 600	1325-00-491-0007	700924-1	11K1-9-3	10
JENS	POLL	16264A		KC-135 MLG	BRAKE COLLAR	1620-00-670-6602	69-1172-1	444-12-23	45
JENS	PRIC	16266A	-G-J	F-4 MLG	WHEEL	1630-00-730-0126	3-1185	483-7-1103	19
JENS	PRIC	16267A	-G-J	F-4 MLG	WHEEL	1630-00-052-1032	200AL23	483-7-1103	20

F-4 NOSE WHEEL



F-4 NOSE WHEEL PROCESS FLOW

PCN 16267A

WCD 01156N
WHEEL ASSY

IN INDUCT

WCD 01155N
INBOARD HALF

5 SPLIT WHEEL

WCD 01150N
OUTBOARD HAL

5A DISASSEMBLE KEYS,
CHILLS, WEIGHTS, ETC.

5A DISASSEMBLE KEYS,
CHILLS, WEIGHTS, ETC.

6 HEAT TO 150°F -
REMOVE BEARING CUP
& STAMP WCD

6 HEAT TO 150°F -
REMOVE BEARING CUP
& STAMP WCD

7 LOAD ON OVERHEAD
CONVEYER

7 LOAD ON OVERHEAD
CONVEYER

7A CHEMICAL CLEAN

7A CHEMICAL CLEAN

7B UNLOAD FROM
OVERHEAD CONVEYER

7B UNLOAD FROM
OVERHEAD CONVEYER

9 BLAST CLEAN

9 BLAST CLEAN

10 REMOVE BEARING
BORE BUSHING

10 REMOVE BEARING
BORE BUSHING

11 BLAST CLEAN BORE

11 BLAST CLEAN BORE

12 LOAD ON OVERHEAD
CONVEYER

12 LOAD ON OVERHEAD
CONVEYER

12A STRIP ANODIZE

12A STRIP ANODIZE



↓

15 PENETRANT INSPECT

17 UNLOAD FROM
OVERHEAD CONVEYER

19 NICK & BURR GRIND

30 EVALUATE & INSPECT-
DELTA STAMP WCD
AS REQUIRED

45 BEARING BORE
REPAIR

50 TIE BOLT FACE
REPAIR

65 MOVE TO BLDG #505

70-70K SULFURIC ANODIZE

72 MOVE TO BLDG #507

75 INSTALL BEARING CUP

80 MACHINE BUSHING & CUP

85 INSTALL BAFFLE, CUP,
& BUSHING

90 VISUAL INSPECT &
LOAD OVEN

95 HEAT TO 230° F

95A UNLOAD OVEN &
INSTALL BEARING
RACE

↓

↓

15 PENETRANT INSPECT

17 UNLOAD FROM
OVERHEAD CONVEYER

19 NICK & BURR GRIND

30 EVALUATE & INSPECT
DELTA STAMP WCD
AS REQUIRED

45 BEARING BORE
REPAIR

50 TIE BOLT FACE
REPAIR

60 VALVE STEM
HOLE REPAIR

65 MOVE TO BLDG #505

70-70K SULFURIC ANODIZE

72 MOVE TO BLDG #507

75 INSTALL BEARING CUP

80 MACHINE BUSHING & CUP

85 INSTALL BAFFLE, CUP,
& BUSHING

90 VISUAL INSPECT &
LOAD OVEN

95 HEAT TO 230° F

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100 LOAD ON OVERHEAD
CONVEYER

100A WASH

100B PRIMER SPRAY

100C AIR DRY

100D MASK

100E PAINT 1ST COAT

100F PAINT 2ND COAT

100G AIR DRY

100H STRIP MASKING

100I UNLOAD FROM
OVERHEAD CONVEYER

120 INSTALL SEALS &
RETAINERS -
BUY-OFF WCD -
FINAL VISUAL INSPECT

↓

95A UNLOAD OVEN &
INSTALL BEARING RACE

100 LOAD ON OVERHEAD
CONVEYER

100A WASH

100B PRIMER SPRAY

100C AIR DRY

100D MASK

100E PAINT 1ST COAT

100F PAINT 2ND COAT

100G AIR DRY

100H STRIP MASKING

100I UNLOAD FROM
OVERHEAD CONVEYER

120 INSTALL SEALS &
RETAINERS
BUY-OFF WCD -
FINAL VISUAL INSPECT

WCD 01156N
WHEEL ASSY

10 MATCH-UP

15 ASSEMBLE WHEEL
HALVES TOGETHER



20 TOUCH-UP PAINT
997 VERIFY WCD COMPLETENESS
998 FINAL VISUAL INSPECT
9999 SELL

PAGE 1 OF 1 PAGES -

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01154N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89237

2 2
PAGE OF PAGES

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

PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN WHEEL HALF	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	DISPATCH			
	002	WHEEL HALF SUBASSY (0.8.)			
	003	WHEEL HALF SUBASSY (1.2.)			
	004	WHEEL HALF SUBASSY (1.5.)			
	005	WHEEL HALF SUBASSY (1.8.)			
	006	WHEEL HALF SUBASSY (2.1.)			
	007	WHEEL HALF SUBASSY (2.4.)			
	008	WHEEL HALF SUBASSY (2.7.)			
	009	WHEEL HALF SUBASSY (3.0.)			
	010	WHEEL HALF SUBASSY (3.3.)			
	011	WHEEL HALF SUBASSY (3.6.)			
	012	WHEEL HALF SUBASSY (3.9.)			
	013	WHEEL HALF SUBASSY (4.2.)			
	014	WHEEL HALF SUBASSY (4.5.)			
	015	WHEEL HALF SUBASSY (4.8.)			
	016	WHEEL HALF SUBASSY (5.1.)			
	017	WHEEL HALF SUBASSY (5.4.)			
	018	WHEEL HALF SUBASSY (5.7.)			
	019	WHEEL HALF SUBASSY (6.0.)			
	020	WHEEL HALF SUBASSY (6.3.)			
	021	WHEEL HALF SUBASSY (6.6.)			
	022	WHEEL HALF SUBASSY (6.9.)			
	023	WHEEL HALF SUBASSY (7.2.)			
	024	WHEEL HALF SUBASSY (7.5.)			
	025	WHEEL HALF SUBASSY (7.8.)			
	026	WHEEL HALF SUBASSY (8.1.)			
	027	WHEEL HALF SUBASSY (8.4.)			
	028	WHEEL HALF SUBASSY (8.7.)			
	029	WHEEL HALF SUBASSY (9.0.)			
	030	WHEEL HALF SUBASSY (9.3.)			
	031	WHEEL HALF SUBASSY (9.6.)			
	032	WHEEL HALF SUBASSY (9.9.)			
	033	WHEEL HALF SUBASSY (10.2.)			
	034	WHEEL HALF SUBASSY (10.5.)			
	035	WHEEL HALF SUBASSY (10.8.)			
	036	WHEEL HALF SUBASSY (11.1.)			
	037	WHEEL HALF SUBASSY (11.4.)			
	038	WHEEL HALF SUBASSY (11.7.)			
	039	WHEEL HALF SUBASSY (12.0.)			
	040	WHEEL HALF SUBASSY (12.3.)			
	041	WHEEL HALF SUBASSY (12.6.)			
	042	WHEEL HALF SUBASSY (12.9.)			
	043	WHEEL HALF SUBASSY (13.2.)			
	044	WHEEL HALF SUBASSY (13.5.)			
	045	WHEEL HALF SUBASSY (13.8.)			
	046	WHEEL HALF SUBASSY (14.1.)			
	047	WHEEL HALF SUBASSY (14.4.)			
	048	WHEEL HALF SUBASSY (14.7.)			
	049	WHEEL HALF SUBASSY (15.0.)			
	050	WHEEL HALF SUBASSY (15.3.)			
	051	WHEEL HALF SUBASSY (15.6.)			
	052	WHEEL HALF SUBASSY (15.9.)			
	053	WHEEL HALF SUBASSY (16.2.)			
	054	WHEEL HALF SUBASSY (16.5.)			
	055	WHEEL HALF SUBASSY (16.8.)			
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	057	WHEEL HALF SUBASSY (17.4.)			
	058	WHEEL HALF SUBASSY (17.7.)			
	059	WHEEL HALF SUBASSY (18.0.)			
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	062	WHEEL HALF SUBASSY (18.9.)			
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	064	WHEEL HALF SUBASSY (19.5.)			
	065	WHEEL HALF SUBASSY (19.8.)			
	066	WHEEL HALF SUBASSY (20.1.)			
	067	WHEEL HALF SUBASSY (20.4.)			
	068	WHEEL HALF SUBASSY (20.7.)			
	069	WHEEL HALF SUBASSY (21.0.)			
	070	WHEEL HALF SUBASSY (21.3.)			
	071	WHEEL HALF SUBASSY (21.6.)			
	072	WHEEL HALF SUBASSY (21.9.)			
	073	WHEEL HALF SUBASSY (22.2.)			
	074	WHEEL HALF SUBASSY (22.5.)			
	075	WHEEL HALF SUBASSY (22.8.)			
	076	WHEEL HALF SUBASSY (23.1.)			
	077	WHEEL HALF SUBASSY (23.4.)			
	078	WHEEL HALF SUBASSY (23.7.)			
	079	WHEEL HALF SUBASSY (24.0.)			
	080	WHEEL HALF SUBASSY (24.3.)			
	081	WHEEL HALF SUBASSY (24.6.)			
	082	WHEEL HALF SUBASSY (24.9.)			
	083	WHEEL HALF SUBASSY (25.2.)			
	084	WHEEL HALF SUBASSY (25.5.)			
	085	WHEEL HALF SUBASSY (25.8.)			
	086	WHEEL HALF SUBASSY (26.1.)			
	087	WHEEL HALF SUBASSY (26.4.)			
	088	WHEEL HALF SUBASSY (26.7.)			
	089	WHEEL HALF SUBASSY (27.0.)			
	090	WHEEL HALF SUBASSY (27.3.)			
	091	WHEEL HALF SUBASSY (27.6.)			
	092	WHEEL HALF SUBASSY (27.9.)			
	093	WHEEL HALF SUBASSY (28.2.)			
	094	WHEEL HALF SUBASSY (28.5.)			
	095	WHEEL HALF SUBASSY (28.8.)			
	096	WHEEL HALF SUBASSY (29.1.)			
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	098	WHEEL HALF SUBASSY (29.7.)			
	099	WHEEL HALF SUBASSY (30.0.)			
	100	WHEEL HALF SUBASSY (30.3.)			
	101	WHEEL HALF SUBASSY (30.6.)			
	102	WHEEL HALF SUBASSY (30.9.)			
	103	WHEEL HALF SUBASSY (31.2.)			
	104	WHEEL HALF SUBASSY (31.5.)			
	105	WHEEL HALF SUBASSY (31.8.)			
	106	WHEEL HALF SUBASSY (32.1.)			
	107	WHEEL HALF SUBASSY (32.4.)			
	108	WHEEL HALF SUBASSY (32.7.)			
	109	WHEEL HALF SUBASSY (33.0.)			
	110	WHEEL HALF SUBASSY (33.3.)			
	111	WHEEL HALF SUBASSY (33.6.)			
	112	WHEEL HALF SUBASSY (33.9.)			
	113	WHEEL HALF SUBASSY (34.2.)			
	114	WHEEL HALF SUBASSY (34.5.)			
	115	WHEEL HALF SUBASSY (34.8.)			
	116	WHEEL HALF SUBASSY (35.1.)			
	117	WHEEL HALF SUBASSY (35.4.)			
	118	WHEEL HALF SUBASSY (35.7.)			
	119	WHEEL HALF SUBASSY (36.0.)			
	120	WHEEL HALF SUBASSY (36.3.)			
	121	WHEEL HALF SUBASSY (36.6.)			
	122	WHEEL HALF SUBASSY (36.9.)			
	123	WHEEL HALF SUBASSY (37.2.)			
	124	WHEEL HALF SUBASSY (37.5.)			
	125	WHEEL HALF SUBASSY (37.8.)			
	126	WHEEL HALF SUBASSY (38.1.)			
	127	WHEEL HALF SUBASSY (38.4.)			
	128	WHEEL HALF SUBASSY (38.7.)			
	129	WHEEL HALF SUBASSY (39.0.)			
	130	WHEEL HALF SUBASSY (39.3.)			
	131	WHEEL HALF SUBASSY (39.6.)			
	132	WHEEL HALF SUBASSY (39.9.)			
	133	WHEEL HALF SUBASSY (40.2.)			
	134	WHEEL HALF SUBASSY (40.5.)			
	135	WHEEL HALF SUBASSY (40.8.)			
	136	WHEEL HALF SUBASSY (41.1.)			
	137	WHEEL HALF SUBASSY (41.4.)			
	138	WHEEL HALF SUBASSY (41.7.)			
	139	WHEEL HALF SUBASSY (42.0.)			
	140	WHEEL HALF SUBASSY (42.3.)			
	141	WHEEL HALF SUBASSY (42.6.)			
	142	WHEEL HALF SUBASSY (42.9.)			
	143	WHEEL HALF SUBASSY (43.2.)			
	144	WHEEL HALF SUBASSY (43.5.)			
	145	WHEEL HALF SUBASSY (43.8.)			
	146	WHEEL HALF SUBASSY (44.1.)			
	147	WHEEL HALF SUBASSY (44.4.)			
	148	WHEEL HALF SUBASSY (44.7.)			
	149	WHEEL HALF SUBASSY (45.0.)			
	150	WHEEL HALF SUBASSY (45.3.)			
	151	WHEEL HALF SUBASSY (45.6.)			
	152	WHEEL HALF SUBASSY (45.9.)			
	153	WHEEL HALF SUBASSY (46.2.)			
	154	WHEEL HALF SUBASSY (46.5.)			
	155	WHEEL HALF SUBASSY (46.8.)			
	156	WHEEL HALF SUBASSY (47.1.)			
	157	WHEEL HALF SUBASSY (47.4.)			
	158	WHEEL HALF SUBASSY (47.7.)			
	159	WHEEL HALF SUBASSY (48.0.)			
	160	WHEEL HALF SUBASSY (48.3.)			
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	162	WHEEL HALF SUBASSY (48.9.)			
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	165	WHEEL HALF SUBASSY (49.8.)			
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	167	WHEEL HALF SUBASSY (50.4.)			
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	169	WHEEL HALF SUBASSY (51.0.)			
	170	WHEEL HALF SUBASSY (51.3.)			
	171	WHEEL HALF SUBASSY (51.6.)			
	172	WHEEL HALF SUBASSY (51.9.)			
	173	WHEEL HALF SUBASSY (52.2.)			
	174	WHEEL HALF SUBASSY (52.5.)			
	175	WHEEL HALF SUBASSY (52.8.)			
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	177	WHEEL HALF SUBASSY (53.4.)			
	178	WHEEL HALF SUBASSY (53.7.)			
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	180	WHEEL HALF SUBASSY (54.3.)			
	181	WHEEL HALF SUBASSY (54.6.)			
	182	WHEEL HALF SUBASSY (54.9.)			
	183	WHEEL HALF SUBASSY (55.2.)			
	184	WHEEL HALF SUBASSY (55.5.)			
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	186	WHEEL HALF SUBASSY (56.1.)			
	187	WHEEL HALF SUBASSY (56.4.)			
	188	WHEEL HALF SUBASSY (56.7.)			
	189	WHEEL HALF SUBASSY (57.0.)			
	190	WHEEL HALF SUBASSY (57.3.)			
	191	WHEEL HALF SUBASSY (57.6.)			
	192	WHEEL HALF SUBASSY (57.9.)			
	193	WHEEL HALF SUBASSY (58.2.)			
	194	WHEEL HALF SUBASSY (58.5.)			
	195	WHEEL HALF SUBASSY (58.8.)			
	196	WHEEL HALF SUBASSY (59.1.)			
	197	WHEEL HALF SUBASSY (59.4.)			
	198	WHEEL HALF SUBASSY (59.7.)			
	199	WHEEL HALF SUBASSY (60.0.)			
	200	WHEEL HALF SUBASSY (60.3.)			
	201	WHEEL HALF SUBASSY (60.6.)			
	202	WHEEL HALF SUBASSY (60.9.)			
	203	WHEEL HALF SUBASSY (61.2.)			
	204	WHEEL HALF SUBASSY (61.5.)			
	205	WHEEL HALF SUBASSY (61.8.)			
	206	WHEEL HALF SUBASSY (62.1.)			
	207	WHEEL HALF SUBASSY (62.4.)			
	208	WHEEL HALF SUBASSY (62.7.)			
	209	WHEEL HALF SUBASSY (63.0.)			
	210	WHEEL HALF SUBASSY (63.3.)			
	211	WHEEL HALF SUBASSY (63.6.)			
	212	WHEEL HALF SUBASSY (63.9.)			
	213	WHEEL HALF SUBASSY (64.2.)			
	214	WHEEL HALF SUBASSY (64.5.)			
	215	WHEEL HALF SUBASSY (64.8.)			
	216	WHEEL HALF SUBASSY (65.1.)			
	217	WHEEL HALF SUBASSY (65.4.)			
	218	WHEEL HALF SUBASSY (65.7.)			
	219	WHEEL HALF SUBASSY (66.0.)			
	220	WHEEL HALF SUBASSY (66.3.)			
	221	W			

CLISON WORK CONTROL DOCUMENT (MEDS)

1 DATE 89278

1 PAGE OF 1 PAGES

2 JOB ORDER NO 102778	3 QUANTITY	4 PRODUCTION SEC/RCC M0206	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER 2200 183	8 TECH DATA 400-1-01 MIL-STD-6808	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES 1-4 103E	11 STOCK NUMBER 100 01 01 01 01 01	12 OPTIONAL 16267A

13 SERIAL NUMBER	14 NOUN UNREEL FAL NO. 1001 01 1004 01

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DEVELOPING DISCREPANCIES: APLK 66-8 MAN01 66-8 FPI 140 MIL-STD-6808 AN00075 YEM 66-8-8025			
		*****2014-78 ALUMINUM***** ALL PERSONNEL EMPLOYED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PROCEDURES AND WORKING CONDITIONS IN THE WORK AREA.			
		THE WORK IS BEING DONE IN ACCORDANCE WITH THE PROCEDURES REFERENCED IN BLOCK 10 OF THIS AFLO FORM 958. THE APPLICABLE SAFETY AND SUPERVISORY INSTRUCTIONS WILL BE USED IN CONFORMANCE WITH THIS DOCUMENT.			
		COMPONENTS WILL BE THOROUGHLY INSPECTED AND TESTED TO MEET THE REQUIREMENTS OF THE STATEMENT.			

		PART OF THE FOLLOWING WORK PROCESSES REQUIRE THE USE OF EQUIPMENT, PROCESSES, MATERIALS, WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE WARNINGS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REDOX CHARGEANT (CONTAINED IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP).			
	001	2200 183			

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

01150N WORK CONTROL DOCUMENT (MEDS)

1 DATE 08278

PAGE 1 OF 1 PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34D	005 *REQD*	BLAST CLEAN		001 01 002 02 003 03	
34D	006 *REQD*	REMOVE DUP FOOT WHEEL HALF		001 01 002 02 003 03	
34C	007 *REQD*	CHEN CLEAN		001 01 002 02 003 03	
34B	009 *REQD*	BLAST CLEAN		001 01 002 02 003 03	
34B	010 *REQD*	REMOVE BEARING BORE BUSHING		001 01 002 02 003 03	
34B	011 *REQD*	BLAST BEARING BORE WHEEL		001 01 002 02 003 03	
34C	012 *REQD*	AMULINE STRIP		001 01 002 02 003 03	
				001 01 002 02 003 03	
34E	019 *REQD*	MILK & BURR		001 01 002 02 003 03	
34E	030 *REQD*	F & I LAW TABLE 2.6707 MIN 2.6721 MAX		001 01 002 02 003 03	

1. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	01150N
		B	D	

01150N WORK CONTROL DOCUMENT (MEDS)

1 DATE 20/1/79

PAGE 5 OF 5 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL/DESIGN/SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN			15. PART NO.			
16. SERIAL NUMBER			17. NOUN			18. PART NO.			
19. SERIAL NUMBER			20. NOUN			21. PART NO.			
22. SERIAL NUMBER			23. NOUN			24. PART NO.			
25. SERIAL NUMBER			26. NOUN			27. PART NO.			
28. SERIAL NUMBER			29. NOUN			30. PART NO.			
31. SERIAL NUMBER			32. NOUN			33. PART NO.			
34. SERIAL NUMBER			35. NOUN			36. PART NO.			
37. SERIAL NUMBER			38. NOUN			39. PART NO.			
40. SERIAL NUMBER			41. NOUN			42. PART NO.			
43. SERIAL NUMBER			44. NOUN			45. PART NO.			
46. SERIAL NUMBER			47. NOUN			48. PART NO.			
49. SERIAL NUMBER			50. NOUN			51. PART NO.			
52. SERIAL NUMBER			53. NOUN			54. PART NO.			
55. SERIAL NUMBER			56. NOUN			57. PART NO.			
58. SERIAL NUMBER			59. NOUN			60. PART NO.			
61. SERIAL NUMBER			62. NOUN			63. PART NO.			
64. SERIAL NUMBER			65. NOUN			66. PART NO.			
67. SERIAL NUMBER			68. NOUN			69. PART NO.			
70. SERIAL NUMBER			71. NOUN			72. PART NO.			
73. SERIAL NUMBER			74. NOUN			75. PART NO.			
76. SERIAL NUMBER			77. NOUN			78. PART NO.			
79. SERIAL NUMBER			80. NOUN			81. PART NO.			
82. SERIAL NUMBER			83. NOUN			84. PART NO.			
85. SERIAL NUMBER			86. NOUN			87. PART NO.			
88. SERIAL NUMBER			89. NOUN			90. PART NO.			
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01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 8-2-78

PAGE 1 OF 20 PAGES

2. JOB ORDER NO 16267A		3. QUANTITY		4. PRODUCTION SEC/RCC NNDEN		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 220A082			8. TECH DATA 30-1-51 30-1-51-1A7			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES F-4 NOSE		11. STOCK NUMBER 16267A			12. OPTIONAL 16267A				
13. SERIAL NUMBER		14. NOUN WHEEL DRIVE SYSTEM 1.0000							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		ALL WORKING DIRECTIVES: BLOCK 36-51 BLOCK 36-3 MIL-STD-8836 MIL-A-8836							
		BLOCK 2014-T6 ALUMINUM							
		ALL PERSONNEL INVOLVED IN THE WORK MUST BE THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRECAUTIONS AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND P.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFIC FORM 958. THE APPLIC- APPLICABLE SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. ALL WORKS WILL BE THOROUGHLY INSPECTED AND NOTED FOR (170-8000) FOR MOVES BETWEEN OPERATIONS/16PACH STATIONS. "WARNING" PART OF THE FOLLOWING REPAIR PROCESSES REQUIRE THE USE OF THE FOLLOWING PROCESSES & OPERATIONS AND MUST BE EMPLOYED IN ALL CASES. (170-8000)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C		01155N			
		B		D					

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01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 03298

PAGE 2 OF 2 PAGES

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN SHELL HALF SUBASSEMBLY IN BOARD	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAND.			
	001	DISASSEMBLE			
34D	005	DISASSEMBLE *REQD*		001 000 00	
				002 02	
				003 0003	
34D	006	REMOVE OUP FROM WHEEL *REQD*		001 000 00	
				002 02	
				003 0003	
34C	007	CHISEL CLEAN *REQD*		001 000 00	
				002 03	
				003 0002	
34B	009	CHISEL CLEAN *REQD*		001 000 00	
				002 03	
				003 0001	
69	010	REMOVE BEARING BURE BEARING *REQD*		001 000 00	
	01			002 01	
				003 0004	
34B	011	REMOVE BEARING BURE BEARING *REQD*		001 000 00	
	01			002 02	
				003 0007	
34C	012	REMOVE BEARING BURE BEARING *REQD*		001 000 00	
				002 02	
				003 0002	
34B	015	REMOVE BEARING BURE BEARING *REQD*		001 000 00	
				002 05	
				003 0005	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	01155N
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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34E	019 *REDD*	NICK & BURK *C/P MOVER*		001 7000 002 04 003 RD06	
34E	030 *REDD*	E & I IAW TABLE 11 BEARING BORE 3.1327 MIN 3.1343 MAX *C/P MOVER*		001 7000 002 04 003 E102	
69	045 .79	BEARING BORE O.S. INNER IAW FIG 1 *C/P MOVER*		001 7000 002 01 003 L012	
69	050 .01	TIE BOLT FACE REPAIR IAW FIG 2 *C/P MOVER*		001 7000 002 01 003 D912	
	070 *REDD*	ANODIZE TYPE II CLASS 1 *C/P MOVER*		001 7000 002 00 003 AS10	
69	075 .39	INSTALL CUP INTO BEARING BORE BUSHING *C/P MOVER* P/N L305610 P/N 2006601		001 7000 002 01 003 BE01	
69	080 .93	MACHINE O.D. OF BUSHING AND CUP ASSEMBLY *C/P MOVER* P/N N.P.L.		001 7000 002 01 003 LE07	
69	085 .93	INSTALL GREASE BAFFLE AND BUSHING & CUP ASSY P/N 2204204 P/N N.P.L.		001 7000 002 01 003 BE01	
69	090 *REDD*	PRE-FINAL INSPECTION AND ASSEMBLY *C/P MOVER*		001 7000 002 07 003 7415	
	095 1.0	BAFFLE AND RAIL INSTALL - 1.0 *C/P MOVER* P/N 2204204 (FORM 11150)		001 7000 002 07 003 7415	

22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
FINAL DESTINATION		
DISPATCH	FUNCTIONAL CODE	

PAGE__OF__PAGES

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2. JOB ORDER NO 16247A		3. QUANTITY <i>1ea</i>		4. PRODUCTION SEC RCC MNPGW		5. DATE SCHED		6. DATE COMPLETED APR 24 1988	
7. PART NUMBER 220A123				8. TECH DATA 4W-1-61 4W3-7-1143				9. ITEM SERIAL NO 7987	
10. MODEL/DESIGN SERIES F-4 NCSE		11. STOCK NUMBER 1630008521432				12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN WHEEL ASSY				15. MECHANIC			
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED				18. MECHANIC	
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				*****WARNING***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
		001		220A123					
13		010		*MATCH-UP* ROUTED COMPONENTS (CONTINUED)				M 71152	
21. FINAL DESTINATION DISPATCH		FUNCTIONAL CODE		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN	
				A. <i>Tom Nelson</i> MANEL 3 NOV 88 B. <i>John</i> BNOV08 MANSM C. <i>John</i> 9 NOV 88 D. <i>John</i> 9 NOV 88				01156N	

01156N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88237

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL ASSY						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		NEW/SERVICEABLE REWORK NO REWORK WHEEL HALF SUBASSY (O.B.) 01150N WHEEL HALF SUBASSY (I.B.) 01155N							
13	015 *REQD*	ASSEMBLE *C/P MOVE* APR 21 1988					10/01 71152		
13	020 *REQD*	FINAL TOUCH UP PAINT *C/P MOVE* 11 APR 1988					M		
13	997 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					M		
13	998 *REQD*	FINAL PRODUCT VISUAL INSPECTION					M		
		COORDINATED BY: PLANNING/WK MEASURE: TOM WIXOM SCHEDULING: JIM COLVIN PRODUCTION: ROGER MURRY QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01156N			
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01150N WORK CONTROL DOCUMENT (MEDS)					1 DATE 8611E	PAGE 1 OF 1 PAGES	
2 JOB ORDER NO 16287A 84A		3 QUANTITY IEA		4 PRODUCTION SEC REC MNP GW		5 DATE SCHED OCT 11 1988	
7 PART NUMBER 220A283		8 TECH DATA 4W-1-61 4W3-7F1143				9 ITEM SERIAL NO 7987	
10 MODEL DESIGN SERIES F-4 NOSF		11 STOCK NUMBER 1632011532016		12 OPTIONAL DMMND			
13 SERIAL NUMBER E2802		14 NOUN WHEEL HALF OUTBOARD					
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED			18 MECHANIC	19 P	20 Q
		GOVERNING DIRECTIVES: AFMCP 66-51 MANOI 66-3 EPI IAW MIL-STD-8836 ANODIZE IAW MIL-A-8625					
		*****2014-T6 ALUMINUM*****					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 9 OF THIS AFMCP FORM 956. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/ DISPATCH STATIONS.					
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
34L	001	DISASSEMBLE					
		REQD *C/P MOVE					
21 FINAL DESTINATION DISPATCH		22 COORDINATION/INITIATING RCC SIGNATURE/DATE A		23 DOCUMENT/SN 21150N			
		B					
		C					
		D					

21150N WORK CONTROL DOCUMENT (MEDS)

1 DATE

85119

PAGE 2 OF 2 PAGES

1 ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOVIN WHEEL HALF OUTPCARD							
15 DISPATCH STATION	16 PER REC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
34C	203	CLEAN AS REQ'D *REQD* *C/P MOVE				M 71376 12 OCT 1988	N 71375		
69	205	REMOVE BEARING BORE PUSHING *C/P MOVE*							
34C	207	ELAST BEARING FORE AREA *C/P MOVE*					M		
34	212	FPI *C/P MOVE *REQD*				M/C 12 OCT 1988			
34	222	NICK & PUPP *C/P MOVE *REQD*				12 OCT 71307			
34	232	E & I IAW TABLE II BEARING BORE 2.8727 MIN 2.8721 MAX *C/P MOVE *REQD*				OCT 14 1988			
69	245	BEARING BORE O.S. OUTER IAW FIG 1 *C/P MOVE							
69	252	TIE FLT FACE REPAIR IAW FIG 2 *C/P MOVE					M		
69	260	C.S. VALVE STEM ROPE & RE-IDENTIFY IAW FIG 3 *C/P MOVE					M		
26	270	ANODIZE TYPE II CLASS I *C/P MOVE *REQD*				15 OCT 1988			
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21150N			
		B		D					

01150N WORK CONTROL DOCUMENT (MEDS)

1 DATE

86118

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER				12 OPTIONAL			
13 SERIAL NUMBER		14 NOUN WHEEL HALF OUTBOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	075	INSTALL PUSHING & BEARING CUP *C/P MOVE					M		
13	080 *REQD*	OK TO ASSEMBLE *C/P MOVE							
13	090 *REQD*	PAINT *C/P MOVE							
13	120 *REQD*	BALANCE *C/P MOVE							
13	122	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958							
13	132	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE							
		COORDINATED BY: PLANNING: LARRY PRICE WK MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY							
		QUALITY: ED OVERDIEK							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01150N			
		B		D					

01155N WORK CONTROL DOCUMENT (MEDS)

DATE

88111

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 16267A 84A		3 QUANTITY IEA		4 PRODUCTION SEC/RCC MMPGW		5 DATE SCHED OCT 11 1983		6 DATE COMPLETED	
7 PART NUMBER 220A282				8 TECH DATA 4W-1-61 4W3-7-1143				9 ITEM SERIAL NO 7987	
10 MODEL DESIGN SERIES F-4 NOSE			11 STOCK NUMBER 1630211611591			12 OPTIONAL S/WND			
13 SERIAL NUMBER E-2 881			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED				18 MECHANIC	
				GOVERNING DIRECTIVES: AFLCR 66-51 MANCI 66-3 FPI IAW MIL-STD-6866 ANODIZE IAW MIL-A-8625					
				*****2014-T6 ALUMINUM*****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				"WARNING"					
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.					
34D		001		DISASSEMBLE					
		REQD		*C/P MOVE				OCT 11 1983	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN					
DISPATCH		FUNCTIONAL CODE		A		C		01155N	
				B		D			

01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88111

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN WHEEL HALF INBOARD						
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
34C	003	CLEAN AS REQ'D *REQD* *C/P MOVE				M 71376	M 71376		
69	005	REMOVE BEARING BORE BUSHING *C/P MOVE*				12 OCT 1988			
34C	007	BLAST BEARING BORE AREA *C/P MOVE*					M		
34	010	FPI *C/P MOVE *REQD*				M 71307	M 71307		
34	020	NICK & BURR *C/P MOVE *REQD*				14 OCT 1988			
34	030	E & I IAW TABLE II BEARING BORE 3.1827 MIN 3.1843 MAX *REQD* *C/P MOVE				15 OCT 1988			
69	045	BEARING BORE O.S. INNER IAW FIG 1 *C/P MOVE							
69	050	TIE BOLT FACE REPAIR IAW FIG 2 *C/P MOVE					M		
26	070	ANODIZE TYPE II CLASS I *C/P MOVE *REQD*				15 OCT 1988			
69	075	INSTALL BUSHING & BEARING CUP *C/P MOVE					M		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						01155N			

01155N WORK CONTROL DOCUMENT (MEDS)

1 DATE 88111

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOLN WHEEL HALF INBOARD							
15 DISPATCH STATION	16 PERF RCC OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
13	080 *REQD*	OK TO ASSEMBLE *C/P MOVE 30 OCT 1988					M 71174		
13	090 *REQD*	PAINT *C/P MOVE 21 OCT 1988				70725			
13	100 *REQD*	BALANCE *C/P MOVE 70725							
13	120 WOC 25	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					M 71152		
13	130 WOC 25	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE AF 23					M 71152		
		COORDINATED BY: PLANNING: LARRY PRICE WK MEASURE: KERRY COOP SCHEDULING: SUE WARD							
		PRODUCTION: ROGER MURRAY QUALITY: ED OVERDIEK							
1 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		01155N			
		B		D					

NAME: MEL ANDERSON

ALC: 00

PCN: 16267A

RCC: WHEELS

WCD: 01155N

WCD DATE: 88298

OP #	RCC	OP DESC	OP FAC	OP OCCU	OP TYPE	OP MAND	FLOW	SKIL	QTY	TIME REQ	EQUIP	QTY	TIME REQ
005A	MANPGW	D1S	1.00	P				HB09	1	0.10	PM0921	1	0.10
006	MANPGW	REMY	1.00	P				HB09	1	0.02	PM0423	1	0.02
006	MANPGW	REMY	1.00	P							PM0426	1	0.03
007	MANPGW	LOAD	1.00	T				HB09	1		PM0921	1	0.02
007	MANPGW	LOAD	1.00	P				HB10	1	0.02	PM0901	1	0.02
007A	MANPGW	CLN	1.00	P							0901	1	1.50
007A	MANPGW	CLN	1.00	P				HB05	1	0.20	PM0634	1	1.50
007B	MANPGW	UNLD	1.00	P				K109	1	0.20	PM0901	1	0.20
009	MANPGW	BLS	1.00	P				JA07	1	0.06	PM7313	1	0.15
010	MANPRA	REMY	0.50	T				JA10	1	0.80	PM5197	1	0.80
010	MANPRA	REMY	0.50	S				JA10	1	0.79	PM5197	1	0.79
010	MANPRA	REMY	0.50	P				OVHD	1	0.10	FL0002	1	0.10
011	MANPGW	BLST	0.50	T				K109	1	0.05	PM0416	1	0.05
012	MANPGW	LOAD	1.00	P				HB05	1	0.03	PM0901	1	0.03
012A	MANPGW	STRP	1.00	P				HB05	1	0.25	PM0901	1	0.33
012A	MANPGW	STRP	1.00	P							PM0609	1	0.33
015	MANPNA	FPI	0.75	T				DB09	2	0.05	PM0901	1	0.02
015	MANPNA	FPI	0.75	P							PM0901	1	1.05
015	MANPNA	FPI	0.25	T							PM0679E	1	1.05
015A	MANPNA	FPI	0.25	T				DB09	1		PM0901	1	0.02
015A	MANPNA	FPI	0.25	P							PM0901	1	1.05
015A	MANPNA	FPI	0.25	P							PM0679E	1	1.05
017	MANPGW	UNLD	1.00	T				DI07	1		PM0901	1	0.03
017	MANPGW	UNLD	1.00	P							PM0901	1	0.04
019	MANPGW	BURR	1.00	T				DI05	1	0.20	PM0911	1	0.03
019	MANPGW	BURR	1.00	P				DI09	1	0.04	PM0005	1	0.20
030	MANPGW	INSP	1.00	P				JA10	1	0.02	PM0911	1	0.04
045	MANPRA	REPR	0.25	T				JA10	1	0.17	PM7211	1	0.17
045	MANPRA	REPR	0.25	S				JA10	1	0.51	PM7211	1	0.51
045	MANPRA	REPR	0.25	P				JA10	1	0.02			
050	MANPRA	REPR	0.05	T				JA10	1	0.56	PM2577	1	0.56
050	MANPRA	REPR	0.05	S				JA10	1	0.62	PM2577	1	0.62
050	MANPRA	REPR	1.00	P				JA10	1		FL0002	1	0.10
065	MANOUHD	MOVE	1.00	T				UP05	1	0.05	PM4118	1	0.05
070	MANPRC	ANZZ	1.00	T				UP09	1	0.01	PM5681	1	0.01
070	MANPRC	ANZZ	1.00	S							CE20	1	0.01
070	MANPRC	ANZZ	1.00	S							PM5681	1	0.08
070	MANPRC	ANZZ	1.00	S				UP09	1	0.05	CE20	1	0.08
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070A	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070B	MANPRC	ANZZ	1.00	S				UP09	1	0.01	CE20	1	0.01
070B	MANPRC	ANZZ	1.00	S				UP09	1	0.01	CE20	1	0.01
070B	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070B	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070B	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01
070C	MANPRC	ANZZ	1.00	S				UP09	1	0.01	CE20	1	0.01
070C	MANPRC	ANZZ	1.00	S				UP09	1	0.01	CE20	1	0.01
070C	MANPRC	ANZZ	1.00	P				UP09	1	0.01	CE20	1	0.01

070E MANPRC	ANZ2	1.00	P	UP09	PM5698	1	0.01
070F MANPRC	ANZ2	1.00	S	UP09	CE20	1	0.01
070F MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.01
070F MANPRC	ANZ2	1.00	P	UP09	PM5717	1	0.58
0703 MANPRC	ANZ2	1.00	S	UP09	0	0	0.01
0703 MANPRC	ANZ2	1.00	P	UP09	1	1	0.01
0703 MANPRC	ANZ2	1.00	P	UP09	PM5702	1	0.01
0703 MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.01
070H MANPRC	ANZ2	1.00	S	UP09	0.01	1	0.01
070H MANPRC	ANZ2	1.00	S	UP09	0.05	1	0.08
070H MANPRC	ANZ2	1.00	P	UP09	0.10	1	0.25
070H MANPRC	ANZ2	1.00	P	UP09	MIN	1	0.08
070H MANPRC	ANZ2	1.00	P	UP09	MAX	1	0.01
070H MANPRC	ANZ2	1.00	P	UP09	MIN	1	0.01
070I MANPRC	ANZ2	1.00	S	UP09	CE20	1	0.01
070I MANPRC	ANZ2	1.00	S	UP09	CE20	1	0.01
070I MANPRC	ANZ2	1.00	S	UP09	PM5700	1	0.01
070J MANPRC	ANZ2	1.00	S	UP09	0.01	1	0.01
070J MANPRC	ANZ2	1.00	S	UP09	0.01	1	0.01
070J MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.01
070J MANPRC	ANZ2	1.00	P	UP09	PM5676	1	0.01
070K MANPRC	ANZ2	1.00	P	UP09	0.01	1	0.03
070K MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.03
070K MANPRC	ANZ2	1.00	P	UP09	CE20	1	0.03
070K MANPRC	ANZ2	1.00	P	UP09	PM4118	1	0.10
072 MANOVHD	MOVE	1.00	T	UP05	0.10	1	0.50
075 MANPRA	INST	1.00	T	JA08	0.02	1	0.23
075 MANPRA	INST	1.00	S	JA08	0.08	1	0.50
075 MANPRA	INST	1.00	P	JA08	0.19	1	0.23
080 MANPRA	MACH	1.00	P	JA10	0.02	1	0.10
080 MANPRA	MACH	1.00	P	JA10	0.50	1	0.10
080 MANPRA	MACH	1.00	P	JA10	0.23	1	0.10
085 MANPRA	INST	1.00	T	JA09	0.02	1	3.00
085 MANPRA	INST	1.00	S	JA09	0.19	1	0.05
085 MANPRA	INST	1.00	P	JA09	0.08	1	0.01
085 MANPRA	INST	1.00	P	JA09	0.10	1	0.01
090 MANPGP	LOAD	1.00	P	YH09	FL0001	1	0.01
090 MANPGP	LOAD	1.00	P	YH09	PM0931	1	0.01
095 MANPGR	HEAT	1.00	P	YH09	PM0435	1	0.02
095 MANPGR	HEAT	1.00	P	YH09	0.10	1	0.02
095 MANPGR	INST	1.00	P	YH09	0.01	1	0.01
095 MANPGR	UNLD	1.00	P	YH09	PM0936	1	0.01
100 MANPGP	LOAD	1.00	P	3509	PM0936	1	0.02
100A MANPGP	WASH	1.00	P	3509	PM0922	1	0.01
100A MANPGP	WASH	1.00	P	3509	PM0436	1	0.01
100B MANPGP	PRIM	1.00	S	3509	PM0438	1	0.02
100B MANPGP	PRIM	1.00	P	3509	PM0922	1	0.02
100C MANPGP	DRY	1.00	P	3509	PM0922	1	1.00
100D MANPGP	MASK	1.00	P	3509	PM0922	1	0.02
100E MANPGP	PNT1	1.00	S	3509	PM0436	1	0.02
100F MANPGP	PNT2	1.00	S	3509	PM0922	1	0.02
100F MANPGP	PNT2	1.00	P	3509	PM0437	1	0.02
100G MANPGP	DRY	1.00	P	3509	PM0922	1	0.50
100H MANPGP	STRP	1.00	P	YH09	PM0922	1	0.03
100I MANPGP	UNLD	1.00	P	YH09	PM0959	1	0.10
120 MANPGP	INST	1.00	P	YH09	WA0004	1	0.10
					PM0940	1	0.10

FOR S S W F P A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
001	S	E	HB	EA 5	J 88301	1.00	PERCENT ENGR 99.9	DISASSY F4 NOSE WHEEL	.48		.48	
0001			HB	01	00	.00		PART NUMBER/NSN	.000	.000	.000	0
	0010						220A123	1630011532016				
0005			HB	01	25	1.00		DISASSEMBLE WHEEL SM	.150	.040	.201	42
	0010	E			RWB-DW-11	1.00	DIS SM WHL (TIE BOLT TYPE)		.09806		.122	
	0020	E			RWB-DW-71	5.00	REM UNDESTR WHL TIE BOLT	10 TIE BOLTS	.01056		.066	
	0110	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0006			HB	01	25	1.00		REMOVE BEARING CUPS	.226	.057	.283	.3 58
	0010	E			RWB-BC-01	1.00	REMOVE BEARING CUPS		.16346		.204	
	0020	E			RWB-MH-02	.50	LOAD HOOK W/WHEELS F/CLENG		.10532		.065	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0000			HB	01	25	.01		LABOR STD HISTORY	.000	.000	.000	0
	0010						07DEC84 2 YEAR REVIEW/UPGRADE TO ENG STD					
	0011						<OLD STD> .25					
	0020						06JUN85 CHANGED SKL CODE NO TM CHNG					
	0030						26JUN85 ADDED NICK&BURR TM (TM WAS .20)					
	0900						D.FARKER TECHN PANCAA					

2 INTERROGATE LABOR STANDARDS. INPUT

RECEIVED NR

11/02/88

104557890123456 ELSE PUT IN END

16267A F4 N WPL 220A123

RCC MNPGR

4W3-7-1143

81279

OPER TECH S S W F FF A/R REV

T K MR A FA SUPPORT DCC

STEP D L K C DC ELEMENT FACT

DESCRIPTION

STORED

SUPPLEMENTAL

EASE

FFD

STD

A

HOURS

TIME

HOURS

DLY PCT C

0001	S	N	KI	EA	5	J	88101	1.00	PERCENT ENGR 46.7	CLEAN F4 NOSE WHEEL	.54		.54		
0001			KI	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							220A123			1630011532016					
0007			KI	01	27			1.00		CHEM CLEAN WHEEL ALUM	.116	.031	.147	2.8	27
0010	N					ZLG-CL-M1		.50	LOAD & UNLOAD CARRIER CLEAN	.21200			.134		
0020	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
0009			KI	01	27			1.00		BLAST CLEAN WHEEL SM	.152	.041	.194		36
0010	E					RWB-CB-B1		1.00	BLAST SM PT OR BSKT V/SM PTS	.03668			.046		
0020	N					ZLG-CL-M1		.50	LOAD & UNLOAD CARRIER CLEAN	.21200			.134		
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
0011			KI	01	27			.14		BLAST CLEAN WHEEL SM	.152	.006	.027		5
0010	E					RWB-CB-B1		1.00	BLAST SM PT OR BSKT V/SM PTS	.03668			.046		
0020	N					ZLG-CL-M1		.50	LOAD & UNLOAD CARRIER CLEAN	.21200			.134		
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
0012			KI	01	27			1.00		ANODIZE STRIP WHEEL ALUM	.136	.037	.173	.7	32
0010	E					ZCD-ST-S1		1.00		ANODIZE STRIP	.12630			.160	
0030	E					RJP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF DCC	.01001			.012		
9000			KI	01	27			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									2 YEAR REVIEW/NO TIME CHANGE						
0020									18JUL85 MOVED N&B TO HB SKL (TM WAS .29)						
0900									D.PARKER TECHN MANEAA						

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRCR NR

<---<--->X--->

1234567890123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MMFNA

02/01/89
4W3-7-1143

A-E046B-MM1-DY-M45 PAGE 0001
81279

16267A F4 N WHL 220A123

OPER TECH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

PF
TIME

STD
HOURS

A
DLY FCT C

CHPNA	S	X	DB	EA	2	J 88301	1.00	PERCENT ENGR 99.9	NDI F4 NOSE WHEEL	.12		.12		
0015			DB	01	11		.13		NDI TIE BOLTS 1ST TIME	1.005	.014	.145	117	
0010	E					ZLG-ND-M6	11.00	MAGNAGLO INSP SMALL OBJECT		.09138		1.115		
0020			DB	01	11		.13		NDI DRIVE KEYS 1ST TIME	.822	.012	.119	96	
0010	E					ZLG-ND-M6	9.00	MAGNAGLO INSP SMALL OBJECT		.09138		.912		
2000			DB	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0	
0010						220A282			1630011611591					
0020						220A283			1630011532016					
2001			DB	01	11		1.00		ZYGLO WHEEL SM	.099	.011	.110	.7	89
0010	E					ZLG-ND-Z1	2.00	ZYGLO INSP SMALL PART BLD507		.04466		.099		
0020	E					RJP-PW-R1	1.00	REM RPL PAPERWRK SIGN OFF DOC		.01001		.011		
9000			DB	01	00		1.00		LABOR STD HISTORY	.000	.000	.000	0	
0900								LLOYD A. HARGIS MANEL-1 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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16267A F4 N WHL 220A123
ER TECH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
150	E	N	DI	EA 5	J 88301	1.00	PERCENT ENGR 17.5	E&I F4 NOSE WHEEL D/B	.35		.35	
0001		DI	01	00		1.00		PART NUMBER/NSN	.000	.000	.000	0
	0010						220A283	1630011532016				
0019		DI	01	27		1.00		NICK & BURR WHEEL SM/HALF	.125	.034	.159	45
	0010	E			RLS-RS-NC	1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
	0020	N				1.00		NICK & BURR WHEEL SM/HALF	.09187		.116	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
0030		DI	01	15		1.00		E & I AND ROUTE WHEEL	.167	.025	.193	55
	0010	N				1.00		E&I AND ROUTE WHEEL HALF	.14919		.171	
	0020	E			RWS-CH-W2	1.00	REMV WHL HLF F/PAINT CONVDOR		.00833		.009	
	0030	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000		DI	01	15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
	0010						07DEC84 2 YEAR REVIEW/NO TIME CHANGE					
	0900						N MCNRCE/MANEAA					

D INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NRQP NR

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16267A F4 N WHL 220A123
TECH S S W F FF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	EASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
E155	E	N	DI	EA 5	J 29301	1.00	PERCENT ENGR 17.5	E&I F4 NOSE WHEEL 1/B	.75		.75	
0001		DI	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010					220A282			1630011611591				
0019		DI	01	27		1.00	NICK & BURR WHEEL SM/HALF		.125	.024	.159	45
0010	E				RUG-RS-NC	1.00	NICK & BURR PTS-CONST F/PREP		.02312		.029	
0020	N					1.00	NICK & BURR WHEEL SM/HALF		.09187		.116	
0030	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.012	
0030		DI	01	15		1.00	E & I AND ROUTE WHEEL		.167	.025	.193	55
0010	N					1.00	E&I AND ROUTE WHEEL HALF		.14919		.171	
0020	F				RWB-CH-W2	1.00	REMV WHL HLF F/PAINT CONVYGR		.00833		.009	
0030	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000		DI	01	15		.01	LABOR STANDARD HISTORY		.000	.000	.000	0
0010							07DEC84 2 YEAR REVIEW/NO TIME CHANGE					
0900							N MONRCE/MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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16267A WHEEL F4 NOSE

RCC MNPRA

4W3-7-1143

21279

ER TECH S S W F FF A/R REV

STEP	D L	K	U	OC	ELEMENT	FACT	STOR	DESCRIPTION	EASE	FFD	STD	A
								SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

155	S	E	JA	EA	1	J	82301	1.00	PERCENT ENGR 95.5	MACH WHL HALF SUBASSY F4N I.	1.07	1.07	
0001			JA	01	00			.00	PART NUMBER/NSN	.000	.000	.000	0
0010							220A292		1630011611591				
0010			JA	01	15			.50	REM BEARING BORE BUSH.MED.	.787	.059	.453	42
0010	E						RML-SU-V2	.25	S/U VERT MILL BORE LAG FIXTRPRORATE OVER 8 PARTS	.80157		.230	
0020	E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIS BORE	.15776		.181	
0030	E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050	E						RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21626		.248	
0060	E						RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0045			JA	01	15			.25	BEARING BORE REP,PENSOTTI	.508	.019	.146	14
0010	M							1.00	SET UP PENSOTTI	.16700		.192	
0020	E							1.00	4 .26 MACHINE BEARING BORE	.29333		.337	
0030	E						RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC/	.01001		.011	
0040	E						RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815		.043	
0050			JA	01	15			.05	SPOT FACE TIE BOLT HOLES	.524	.005	.036	3
0010	E						RDR-SU-R1	1.00	S/U TO O/S BOSSES RAD DRILL ,	.56378		.648	
0020	E						RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP,	.03068		.035	
0030	E						KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE ,	.02004		.023	
0040	E						RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,	.01001		.011	
0075			JA	01	15			1.00	INST CUP INTO BUSHING	.077	.012	.089	8
0010	E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020	E						REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030	E						RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0080			JA	01	15			1.00	MACH BEARING BORE BUSHING	.229	.034	.264	25
0010	E						RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 8 PARTS	.49962		.143	
0020	E						RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030	E						KML-TA-HC	1.00	DIA 4.00-5.00 REM .033-.250	.08497		.097	
0040	E						RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0085			JA	01	15			1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	8
0010	E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 8 PARTS	.18669		.053	
0020	E						REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030	E						RJP-FW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000			JA	01	15			1.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0900									C. W. RIGBY MANEL-1 73357				

O INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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16267A WHEEL F4 NOSE

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PER TECH S S A F FF A/R REV

STEP	J L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PRD TIME	STD HOURS	A DLY FCT C
150	S	E	JA	EA 1	J	88301	1.00 PERCENT ENGR 96.7	MACH WHL HALF SUBASSY F4N	1.50		1.50	
0001			JA	01	00		.00	PART NUMBER/NSN	.000	.000	.000	0
0010						220A283		1630011532016				
0010			JA	01	15		.50	REM BEARING BORE BUSH, MED.	.787	.059	.450	10
0010 E						RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXT PRGRATE OVER 8 PARTS	.80167		.270	
0020 E						RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP JIG BORE	.15776		.181	
0030 E						RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12599		.146	
0040 E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07509		.087	
0050 E						RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21526		.248	
0060 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0045			JA	01	15		.25	BEARING BORE REP. PENSOTTI	.508	.019	.146	10
0010 N							1.00	SET UP PENSOTTI	.16700		.192	
0020 E							1.00	4 .26 MACHINE BEARING BORE	.29333		.337	
0030 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC/	.01001		.011	
0040 E						RPL-MH-P1	1.00	GET PALLET JACK & MOVE PARTS/	.03815		.043	
0050			JA	01	15		.05	SPOT FACE TIE BOLT HOLES	.624	.005	.036	2
0010 E						RDR-SU-R1	1.00	S/U TO O/S BOSSES RAD DRILL	.56378		.648	
0020 E						RML-HP-H1	1.00	PART ON/OFF MACH HAND NO RAP	.03068		.035	
0030 E						KAL-SM-31	1.00	SPOT-FACE GR COUNTERBORE	.02004		.023	
0040 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0060			JA	01	15		.80	VALVE STEM HOLE REP RAD DR	.459	.055	.423	28
0010 E						RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL PRGRATE OVER 8 PARTS	.56378		.162	
0020 E						RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL	.30463		.350	
0030 E						REW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0040 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0075			JA	01	15		1.00	INST CUP INTO BUSHING	.077	.012	.089	6
0010 E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRGRATE OVER 4 PARTS	.18669		.053	
0020 E						REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0080			JA	01	15		1.00	MACH BEARING BORE BUSHING	.229	.034	.264	18
0010 E						RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRGRATE OVER 8 PARTS	.49962		.143	
0020 E						RLA-HP-C1	1.00	1ST PART IN-GUT SCROLL CHUCK	.01001		.011	
0030 E						KML-TA-HC	1.00	DIA 4.00-5.00 REM .033-.250	.08497		.097	
0040 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0085			JA	01	15		1.00	INST BEARING BORE BUSH & CUP	.077	.012	.089	6
0010 E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES PRGRATE OVER 8 PARTS	.18669		.053	
0020 E						REW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0030 E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000			JA	01	15		1.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0900								C. W. RIGBY MANEL-1 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

11/02/88

A-E046B-MM1-DY-M45

PAGE 0001

16267A FA N WHL 220A123

RCC MNPRC

AWD-7-1142 852-1432

81290

OPER TECH S S W F R A/R REV

T K #R A FA SUPPORT

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DESCRIPTION

BASE

FFD

STD

A

STEP D L

K D CC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DAY FOR C

0010	S	E	UP	EA	B	J	89001	1.00	PERCENT ENGR 99.9	FAN WHEEL HALF SUBASSEMBLY	.19		.19	
0001			UP	01	00			.00		PART NUMBER/SEN	.000	.000	.000	0
0010							220A283			1630011532016				
0070			UP	01	24			1.00		ANDDIZE SMALL PART	.156	.007	.193	18 100
0010	E						FWB-DV-B1	1.00	VAPOR CL (DEGRADATION/BASKET		.03709		.107	
0020	E						ZPL-AN-B1	1.00	ANDDIZE SMALL PART		.05592		.070	
0030	E						RJP-FW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC		.01601		.012	
0000			UP	01	24			.01		LABOR STND HISTORY	.000	.000	.000	0
0010									00JUN86 REWROTE STD TO MATCH 958 WORK PREVIOUSLY					
0011									DONE ON OPERATION XNPRC (OLD STND WAS 1215)					
0900									HARRY COOP MANEL TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FFD NRCP NR

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1626TA FA NWHL 2204107

ACC XNFRG

4W3-7-1147 852-1432 81290

ST TECH B B W F F A/R REV

T K R A FA SUPPORT

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DESCRIPTION

BASE

FFD

STD

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STEP D L K C DO ELEMENT FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

OLY PCT C

0155	B	E	UP	CH	B	0	887001	1.00	PERCENT ENGR 99.9	FA NOSE WHEEL HALF SUBASSY 1	.19		.19		
0001								.00		PART NUMBER/NSN	.000	.000	.000		0
0010									000A282	1630011611591					
0070								1.00		ANODIZE SMALL PART	.156	.037	.193	.8	100
0010	E							1.00	VAPOR CL (DEGR)HOOK/BASKET		.06709		.107		
0001	E							1.00	ANODIZE SMALL PART		.05392		.073		
0000	E							1.00	REM RPL PAPERWORK SIGN OFF DOC		.01001		.012		
0100								.01		LABOR STD HISTORY	.000	.000	.000		0
0010									000UN86	REWROTE STD TO MATCH 958 WORK PREVIOUSLY					
0011										DONE ON OPERATION XNFRG (OLD STD WAS .225)					
0000										KERRY COOP MANEL TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

ACC FFD XNFRG NA

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16267A F4 N WHL 220A123

RCC MMFSP

4W3-7-1143

81279

TECH S S W F PF A/R REV

T K #R A F4 SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

PFD
TIME

STD
HOURS

A
DLY PCT C

PS150	S	E	YH	EA	5	J	88301	1.00	PERCENT ENGR 99.9	PREASSY F4 NOSE WHEEL O/B	.28		.29		
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010							220A283			1630011532016					
0090			YH	01	21			1.00		PREINSPECTION WHEEL HALF	.015	.003	.019	7	
0010	E						RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL		.00442		.005		
0020	E						KAL-EC-46	1.00	INSPECT VISUAL		.00115		.001		
0030	E						RJP-PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
0095			YH	01	21			1.00		RACE INSTALLATION WHL/HALF	.178	.037	.215	76	
0010	E						RWB-BC-03	1.00	INSTALL BEARING CLIPS		.16838		.203		
0020	E						RJP-PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
0115			YH	01	21			1.00		INSTALL SEALS & RETAINERS	.041	.009	.050	18	
0010	E						RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURD		.02459		.029		
0020	E						RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE		.00692		.008		
0030	E						RJP-PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012		
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010									06JUN84 ADD SUB OP 0001 UNLOAD LINE(OLD STD)	.70					
0020									25SEP84 ADD STEPS 0007 & 0008 SUB OP 0010						
0021									(OLD STANDARD).78						
0030									10DEC84 2 REAR REVIEW/NO TIME CHANGE						
0031									7MAR86 CHANGED SKILL CODE FROM Y6 TO YH						
0032									NO TIME CHANGE						
0900									KERRY COOP MANEAA TECHN 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/26/89

A-E046B-MM1-DY-M45

PAGE 0001

16267A F4 N WHL 220A123

RCC MNPGR

4W3-7-1143

81279

TECH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC <

DESCRIPTION

BASE

PFD

STD

A

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

PS155	S	E	YH	EA	5	J	88301	1.00	PERCENT ENGR	99.9	PREASSY F4 NOSE WHEEL I/B	.28		.28	
0001			YH	01	00			.00			PART NUMBER/NSN	.000	.000	.000	0
0010							220A282				163001161159				
0090			YH	01	21			1.00			PREINSPECTION WHEEL HALF	.015	.003	.019	7
0010	E						RWB-JP-W2	1.00	PREP TO ASSY OR DISSY WHEEL			.00442		.005	
0020	E						KAL-6C-46	1.00	INSPECT VISUAL			.00115		.001	
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.012	
0095			YH	01	21			1.00			RACE INSTALLATION WHL/HALF	.178	.037	.216	76
0010	E						RWB-BC-03	1.00	INSTALL BEARING CUPS			.16838		.203	
0020	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.012	
0115			YH	01	21			1.00			INSTALL SEALS & RETAINERS	.041	.009	.050	18
0010	E						RWB-AW-B1	1.00	INSTL BEARING/SNAP RING SECURD			.02459		.029	
0020	E						RWB-AW-C1	1.00	INSTL TIRE CHANGE DATA PLATE			.00692		.008	
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.012	
9000			YH	01	21			.01			LABOR STANDARD HISTORY	.000	.000	.000	0
0010											06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD>			.70	
0020											25SEP84 ADD STEPS 0007 & 0008 SUB OP 0010				
0021											<OLD STANDARD>.78				
0030											10DEC84 2 REAR REVIEW/NO TIME CHANGE				
0031											7MAR86 CHANGED SKILL CODE FROM Y6 TO YH				
0032											NO TIME CHANGE				
0900											KERRY COOP MANEAA TECHN 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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RCC MNPSP

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R TCH S S W F PF A/R REV

S T K NR A FA SUPPORT OCC

DESCRIPTION

BASE

FFD

STD

A

STEP D L K C DC ELEMENT FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

56	S	E	YH	EA	5	J	28301	1.00	PERCENT ENGR 94.5	MATCH UP F4 NOSE WHEEL	.13		.13		
0001			YH	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
									220A123	1630008521432					
0010			YH	01	21			1.00		WHEEL MATCH UP	.110	.023	.134		100
0010	E							1.00	GET EASY AND PLACE EXACT		.00097		.001		
0020	E							1.00	UNFK PARTS-BK KEY-SNAP RING		.08237		.099		
0030	N							1.00		MATCH WHEEL HALFS 2 HALFS	.01700		.020		
0040	E							1.00	REM SPL PAFRWK SIGN OFF OCC		.01001		.012		
9000			YH	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									06JUN84 ADD SUB OP 0001 & UNLOAD LINE<OLD STD>	.70					
0020									25SEP84 ADD STEPS 0007 & 0008 SUB OP 0010						
0021									<OLD STANDARD>.78						
0030									10DEC84 2 REAR REVIEW/NO TIME CHANGE						
0031									7MAR86 CHANGED SKILL CODE FROM YG TO YH						
0032									NO TIME CHANGE						
0900									KERRY COOP MANEAA TECHN 73357						

INTERROGATE LABOR STANDARDS. INPUT

CC 990 NRGP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

11/02/88

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RCC MNPSP

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81279

R TECH S S W F F A/R REV

S	T K	#R A	FA	SUPPORT	CCC	DESCRIPTION	BASE	PRD	STD	A
SEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

10	S	E	YH	EA	5	J 38301	1.00	PERCENT ENGR 99.9	ASSY F4 NOSE WHEEL	.05	.05	
0001			YH	01	00		.00		PART NUMBER/NSN	.000	.000	.000
			0010			220A123			1630008521432			
0015			YH	01	21		1.00		FINAL WHL ASSEMBLY SM/NOERK	.049	.010	.059
			0010	E		RWB-AW-T1	4.00	INSTL UNOBSTRUCTED TIE BOLT		.00975		.047
			0020	E		RJP-FW-R1	1.00	REM RPL PAFSWRK SIGN OFF DOC		.01001		.012
9000			YH	01	21		.01		LABOR STANDARD HISTORY	.000	.000	.000
			0010			06JUN84		ADD SUB OP 0001 UNLOAD LINE(OLD STD)		.70		
			0020			25SEP84		ADD STEPS 0007 & 0008 SUB OP 0010				
			0021					(OLD STANDARD).78				
			0030			10DEC84		2 REAR REVIEW/NO TIME CHANGE				
			0031			7MAR86		CHANGED SKILL CODE FROM YG TO YH				
			0032					NO TIME CHANGE				
			0900					KERRY COOP MANEAA TECHN 73357				

INTERROGATE LABOR STANDARDS. INPUT

CC PRD NROP NR

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24567390123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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16267A F4 N WHL 220A123

RCC MNFGP

4W3-7-1143

81279

ES TECH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	EASE HOURS	FFD TIME	STD HOURS	A DLY PCT C
150	S	E	38	EA 5	J 88001	1.00	PERCENT ENGR 99.9	PAINT F4 NOSE WHEEL D/B	.33		.33	
0001		35	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
	0010						220A283	1630011532016				
0110		35	01	25		1.00		PAINT WHEEL	.267	.067	.334	4.0 100
	0010	E			GPL-PA-01	4.00	INST NONTHEADED PLSTC PLUG		.00093		.004	
	0020	E			GIS-SF-M1	1.00	MASK & UNMASK MEDIUM PART		.01242		.015	
	0030	E			RWB-OH-W1	1.00	HANG WHL HLF ON PAINT CONVYR		.02336		.029	
	0040	E			RWB-SC-02	1.00	PNT WHL HALF-ZINC CHROMATE		.11574		.144	
	0050	E			RWB-SC-P3	1.00	PNT WHL HALF (2ND COAT) POLY 2 COATS		.10214		.127	
	0060	E			RJP-FW-R1	1.00	REM RPL PAPRWK SIGN OFF DCC		.01001		.012	
9000		35	01	25		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
	0010						06JUN84 REMOVE UNLOADING PAINT LINE <GLD STD>	.57				
	0020						25SEP84 ADD STEPS 0005 & 0006 SUB OP 0010					
	0021						<GLD STD>	.55				
	0030						10DEC84 2 YEAR REVIEW/NO TIME CHANGE					
	0900						N MONROE/MANEAA					

J INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NRCP NR

-X--->

J 0123456 ELSE PUT IN END

R TECH S S W F F F A/R REV

STEP	DL	K	C	DC	ELEMENT	FACT	STOR	DESCRIPTION	BASE HOURS	PRD TIME	STD HOURS	A DLY PCT C

55	S	E	JS	EA	E	J	28301	1.00 PERCENT ENGR 99.9	.33		.33	
0001			JS	01	00			PART NUMBER/NSN	.000	.000	.000	0
							220A282	163001161159				
0100			JS	01	25			PAINT WHEEL	.267	.067	.334	4.0 100
0010	E						GFL-PA-01	4.00 INST NONTHEADED PLSTC PLUG	.00093		.004	
0020	E						SIG-SP-M1	1.00 MASK & UNMASK MEDIUM PART	.01242		.015	
0030	E						RWB-CH-W1	1.00 HANG WHL HLF ON PAINT CONVYR	.02336		.029	
0040	E						RWB-SC-02	1.00 PNT WHL HALF-ZINC CHROMATE	.11574		.144	
0050	E						RWB-SC-P3	1.00 PNT WHL HALF (2ND COAT) POLY 2 COATS	.10214		.127	
0060	E						RCP-FW-R1	1.00 REM RPL PAPRWK SIGN OFF BCC	.01001		.012	
9000			JS	01	25			LABOR STANDARD HISTORY	.000	.000	.000	0
0010								06JUN84 REMOVE UNLOADING PAINT LINE (OLD STD) .57				
0020								25SEP84 ADD STEPS 0005 & 0006 SUB OP 0010				
0021								(OLD STD) .55				
0030								10DEC84 2 YEAR REVIEW/NO TIME CHANGE				
0900								N MCRCE/MAEAA				

INTERROGATE LABOR STANDARDS. INPUT

CC PRD NSOP NR

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141 0123456 ELSE PUT IN END

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162572 F4 N WML 220A123 RCC MNPSR 4WS-7-1143 81279

INTERROGATE LABOR STANDARDS. INPUT

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