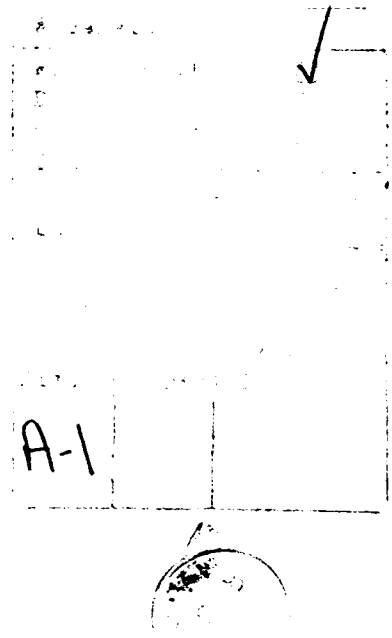
AD-A237 394

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

DATABASE DOCUMENTATION BOOK
BOOK 1 OF 2

OC-ALC

MATPCB



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11 SEPTEMBER 1989

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CDRL SEQUENCE NO. B008

MCDONNELL DOUGLAS
McDonnell Douglas Missile Systems Company
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Technology Insertion (TI)/Industrial Process Improvement (IPI) Data Base Documentation Book Volume, for OC-ALC/MATPCB (Manifolds, Nozzles & Pumps) This document contains detailed information about layouts equipment and processes for this RCC.

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1.0 IDENTIFICATION OF RCC AND GENERAL INFORMATION

OC-ALC, RCC, MATPCB is responsible for the overhaul and testing of Jet Engine Fuel Manifolds, Fuel Nozzles and various fuel and hydraulic pumps. The overhaul area is primarily located in contiguous shops in the south side of Building 3001. Leak and pressure testing is completed in Building 3108. The two work areas are linked via an overhead conveyer chain system, for transporting parts between shop areas. The total area of MATPCB covers approximately 29313 feet for production and 5993 feet for support.

1.1 MANIFOLDS

The sub-unit overhauling and servicing Manifolds is basically arranged according to the sequence of operations and are also basically in line. With the exception of required Manifold Welding (MATPIW) and Machine shop (MATPCM) operations, all overhaul and test operations are performed by MATPCB. Although laid out in an orderly manner, the area is cluttered with parts stacked on the floor or on mobile shelf racks, awaiting processing.

The work areas are normally small, with equipment and benches located in a somewhat cramped arrangement.

1.2 FUEL NOZZLES

The Fuel Nozzle overhaul area is the smallest of the MATPCB areas. It is located immediately adjacent to the Manifold area providing minimal transit distance and time. The work benches are somewhat cluttered because the area is small and close-quartered. The low smoke nozzle overhaul area is near the Manifold final assembly area.

1.3 FUEL PUMPS

The Fuel and Hydraulic Pump sub-unit is arranged in an east/west orientation with activities located basically in-line.

Since there are many types of pumps overhauled, there is no assembly line arrangement. Except for cleaning, test and when applicable, machining, all overhaul activities are performed at a single work station. Work stations (Benches) have pump-unique fixtures attached to them. These work benches are not arranged in catagories of pumps, but are scattered throughout the overhaul sub-unit area. The cleaning tank, on which work is performed by the overhaul mechanics, are co-located within the overhaul area. This reduces transit time. NDI on the pumps is also performed by NDI personnel dedicated within the sub-unit overhaul area.

1.4 MATPCB TEST AREA

The MATPCB test area is located in Building 3108 which is located adjacent to (west of) building 3001, at the southwest corner. Building 3108, used for test, has increased safety and fire suppression systems. These added safety precautions are needed because of the nature of the test operations including the use of high pressure Hydraulic fluids, and fuel. The MATPCB area of Building 3108 covers approximately 21,126 square feet. Both pumps and completed manifolds (with nozzles) are sent to and from the test area from the sub-units by way of a conveyer chain system. Pumps are placed in suspended trays (3 1/2 X 2 1/2') where as manifolds are suspended by two-hooks.

The test stations are widely scattered throughout Building 3108 and are interspersed with other RCC test stations. No family grouping apparently exsist. The conveyer is slow but effective. It takes between 15 to 45 minutes for parts to be conveyed between one station and another. If not picked off the line on arrival it may take up to 1.5 hours to complete the loop. The only signal system used between stations is a phone line. It is used primarily for "Hot" items only. Otherwise both ends "clear the line" daily at the beginning of first shift.

2.1 FACILITY LAYOUT DRAWING

The most current Facility Layout Drawing available have been updated by MDMSC personnel and reflects current conditions as of June 5, 1989. Two sets of drawings have been included representing layouts in both Building 3001 and 3108. Bins and cabinets included in the drawings are used primarily for the storage of spare parts, holding areas and miscellaneous tools and technical books. The facility layout drawings provided by the ALC are contained in the attached expanding file.

2.2 EQUIPMENT

The Equipment used in MATPCB varies from common and specialized hand tools to integrated test stands. Most of the equipment is between five and twenty five years old. Besides routine preventative maintenance there is very little down time due to machine breakdowns. A detailed listing of major non-controlled and OC controlled equipment is detailed in the Equipment Profile section.

WORKFORCE

Linda Dowdy/MATPCB OC-ALC June 1989

MATPCB has a stable workforce consisting of Direct and Indirect labor. The Direct Labor is comprised of 63 mechanics and the Indirect consist of 6 Supervisors. The following is a breakdown of the direct labor for MATPCB:

SKILL CODE	SKILL LEVEL	QUANITY	YEARS OF AVG. EXPERIENCE
BP	WG-10	7	12-25
	WG-09	15	4-25
	WG-05	1	4
BI	WG-09	2	10-15
AP	WG-09	15	4-20
	WG-07	1	5
	WG-05	2	5-7
DP	WG-09	20	4-25

DEPARTMENT HEAD COUNT BY WORK CLASSIFICATION

Chief Foreman	WS8255-13	1
Foreman	WS8255-09	5
Pneudraulics Sys. Mech	WG8255-10	6
Work Inspector	WG8255-10	1
Pneudraulics Sys. Mech	WG8255-09	50
NDI	WG5439-09	2
Sandblaster	WG5427-07	1
Forklift Operator	WG5704-05	2
Parts & Tool Attendant	WG6905-05	1
		69 Total

All supporting RCC's are in Building 3001 and 3108.

2.4 REPAIR WORK TECHNOLOGIES

The process technology in MATPOB consist primarily of testing and repair of Jet Engine Fuel Manifolds, Fuel Nozzles and pumps. Parts are inspected, tested for function and specification requirements and overhauled as required. Modifications are made to parts as required by tech order changes.

WORKLOAD VOLUME AND MIX

Workload in MATPCB consist of MISTR (Management of Items Subject to Repair), PDM (Programmed Depot Maintainance-Engine line assets) and temporary. The workload percent mix is as follows:

MISTR	PDM	TEMPORARY
45%	50%	5%

End item to be overhauled in MATPCB are:

1. Fuel Pumps
2. Fuel Nozzles
3. Fuel Manifolds

End items tested by MATPCB

1. Fuel Pumps
2. Fuel Nozzles
3. Fuel Manifolds
4. Regulators
5. Cylinder
6. Valves

Engine Usage

B-52
KC135
A-7 Navy & AF
F4
F106
F111
G141
F11
F16

2.6 MATERIAL HANDLING

In MATPCB Material Handling is accomplished mostly by hand. A conveyer is used between the overhaul and testing areas of MATPCB. parts are sent to and picked up from the overhaul mechanics work bench with the exception of one, two-stage fuel pump, parts are carried by hand to and from NDI located within MATPCB. The large pump is transported on a push cart. Manifold parts (80%) are received in quantities of 25 by a fork lift truck. The other 20% comes directly from the engine tear-down shop usually by mechanized cart.

2.7 STORAGE

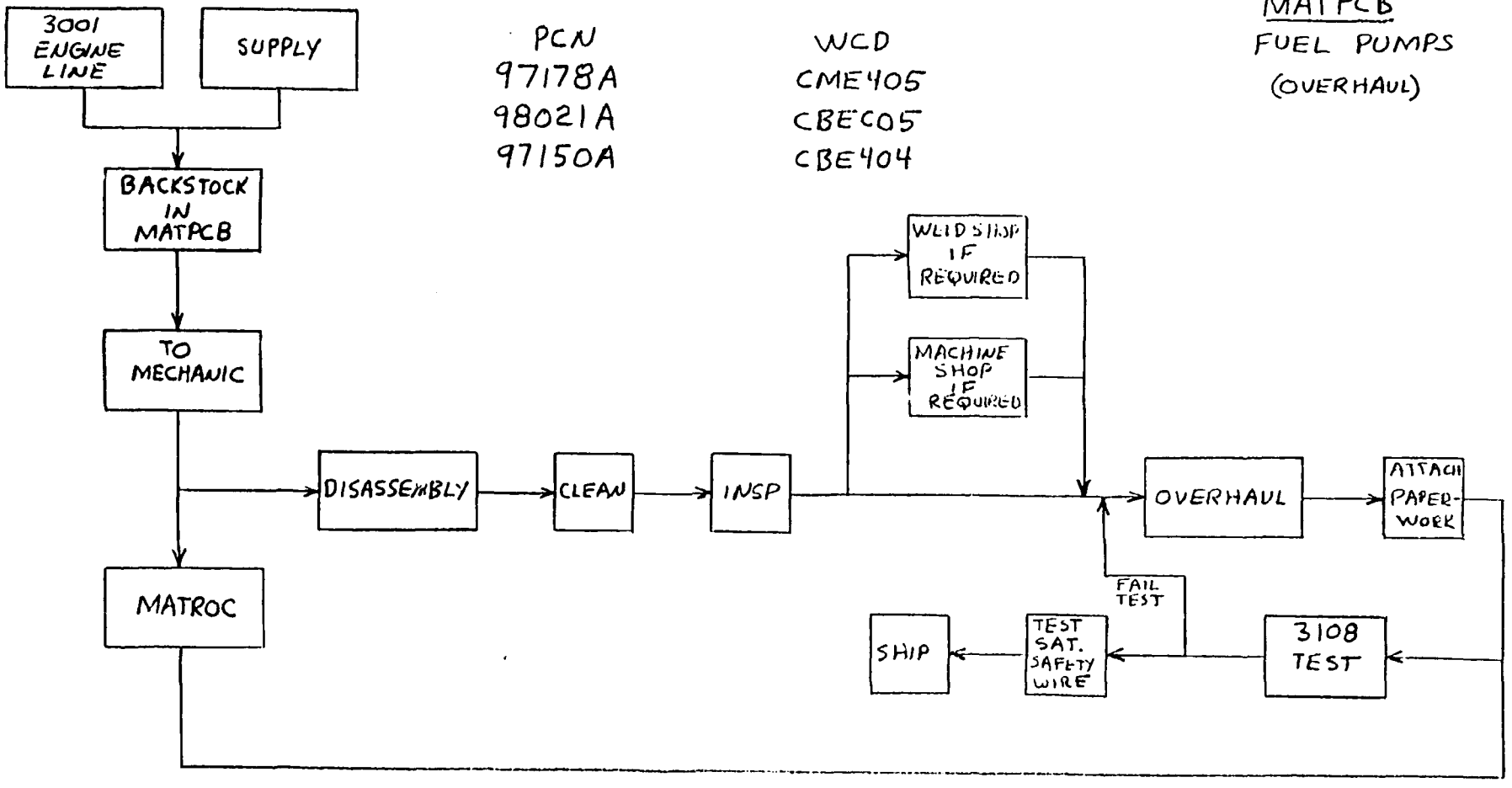
The storage of parts and spares are primarily located in bins near the maintenance work benches. There are no designated storage areas in Building 3108 parts are received for testing one at a time. If more than one part is received per test stand, then parts are put on the test stand work bench until they are tested.

2.8 PROCESS FLOW CHARTS

The Flow Charts which follow are representative of the overhaul/ test operations of various parts worked on by MATPCB. They are divided into Family Part Groups. For more detailed analysis refer to the appropriate PCN/WCD.

MATPCB
FUEL PUMPS
(OVERHAUL)

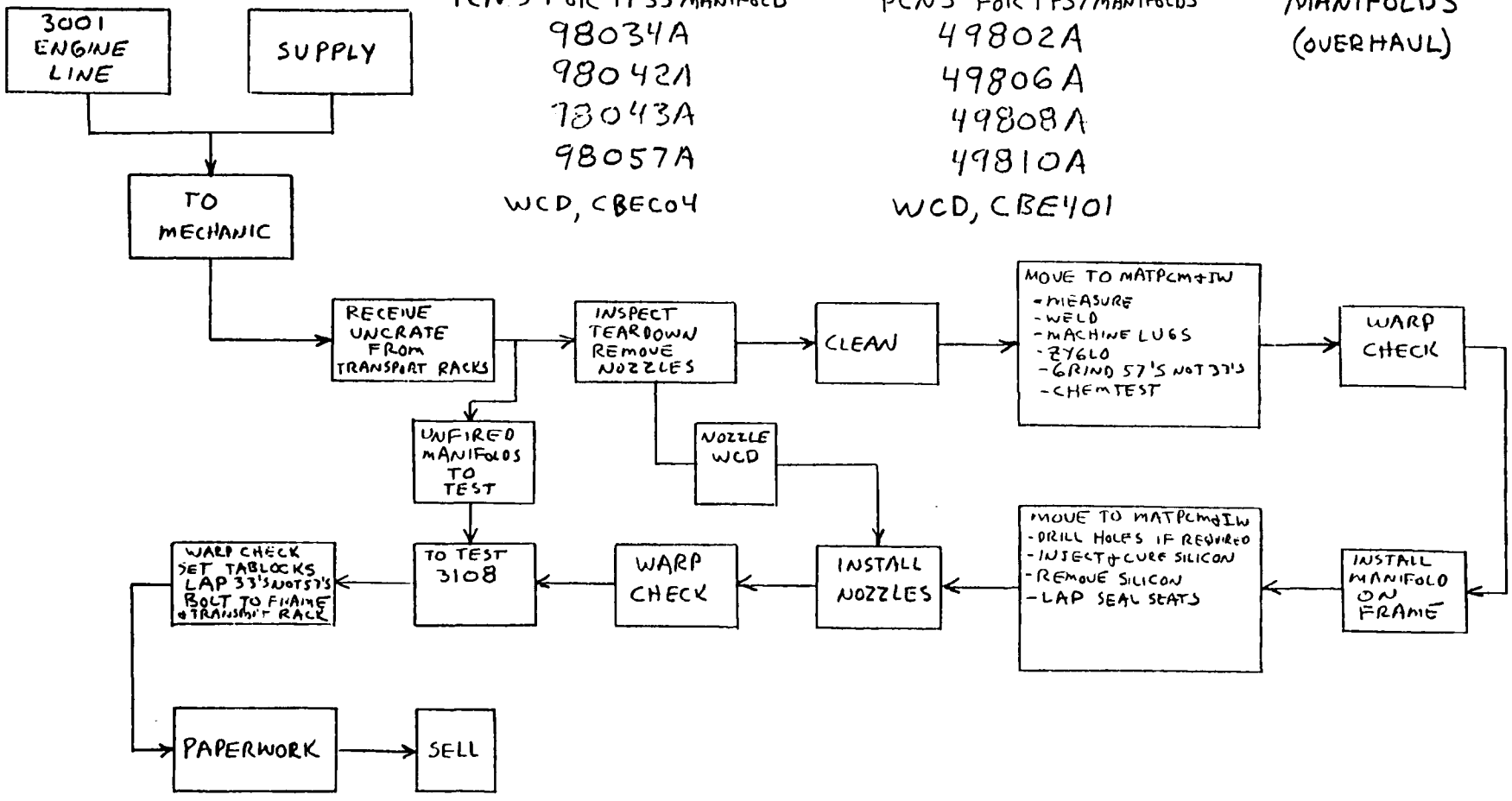
PCN	WCD
97178A	CME405
98021A	CBEC05
97150A	CBE404



MATPCB
MANIFOLDS (OVERHAUL)

PCN'S FOR TF33 MANIFOLD
98034A
98042A
98043A
98057A
WCD, CBEC04

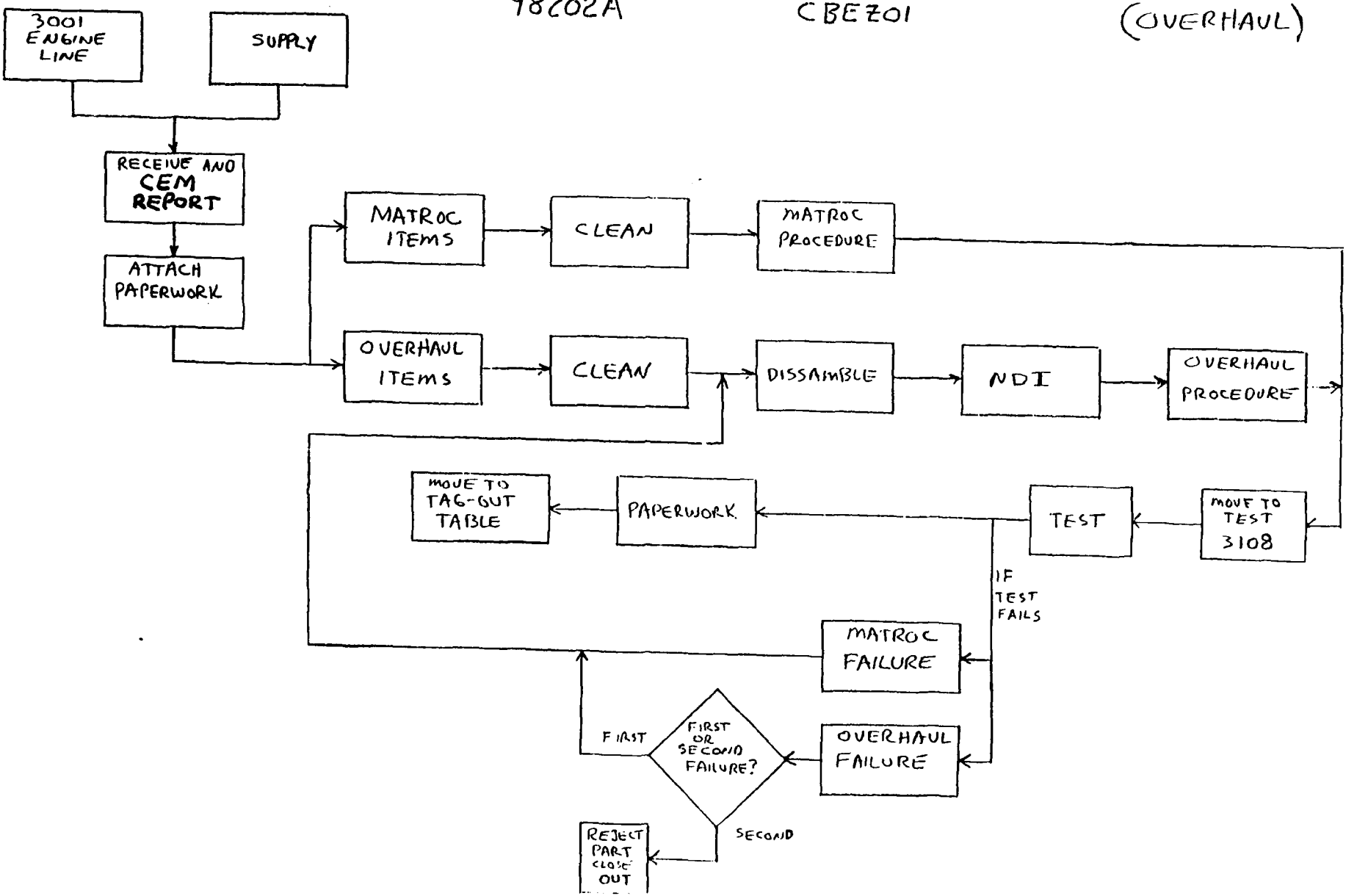
PCN'S FOR TF57 MANIFOLDS
49802A
49806A
49808A
49810A
WCD, CBE401



PCN
98202A

WCD
CBE201

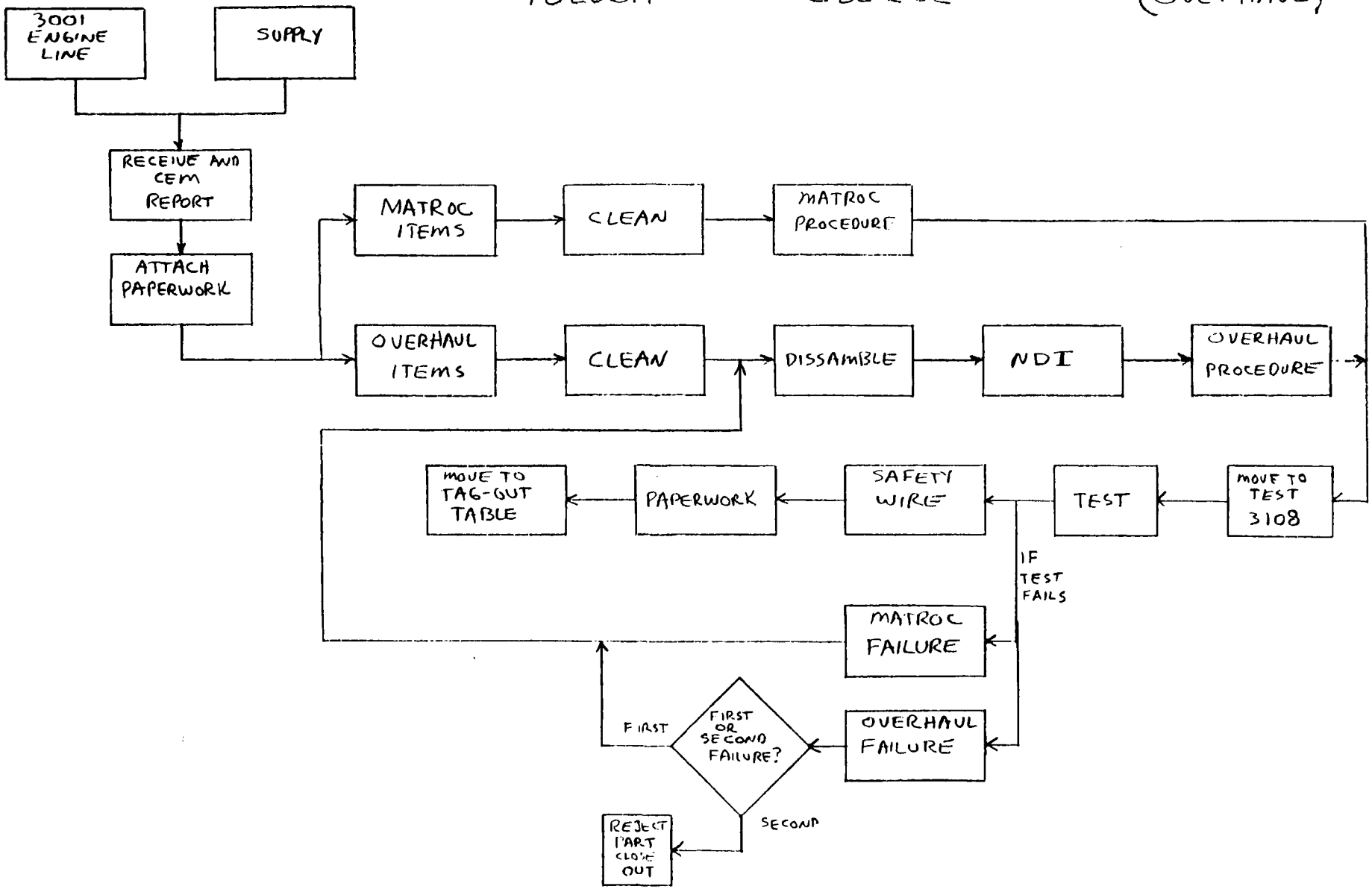
MATPCB
PUMP
(OVERHAUL)



PCN
98206A

WCD
CBEZ02

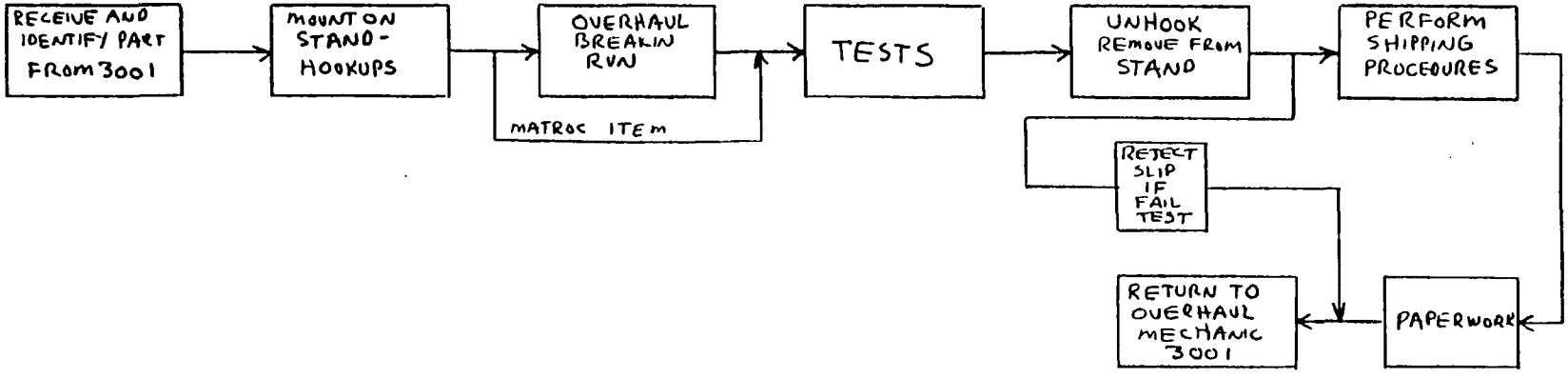
MATPCB
PUMP
(OVERHAUL)



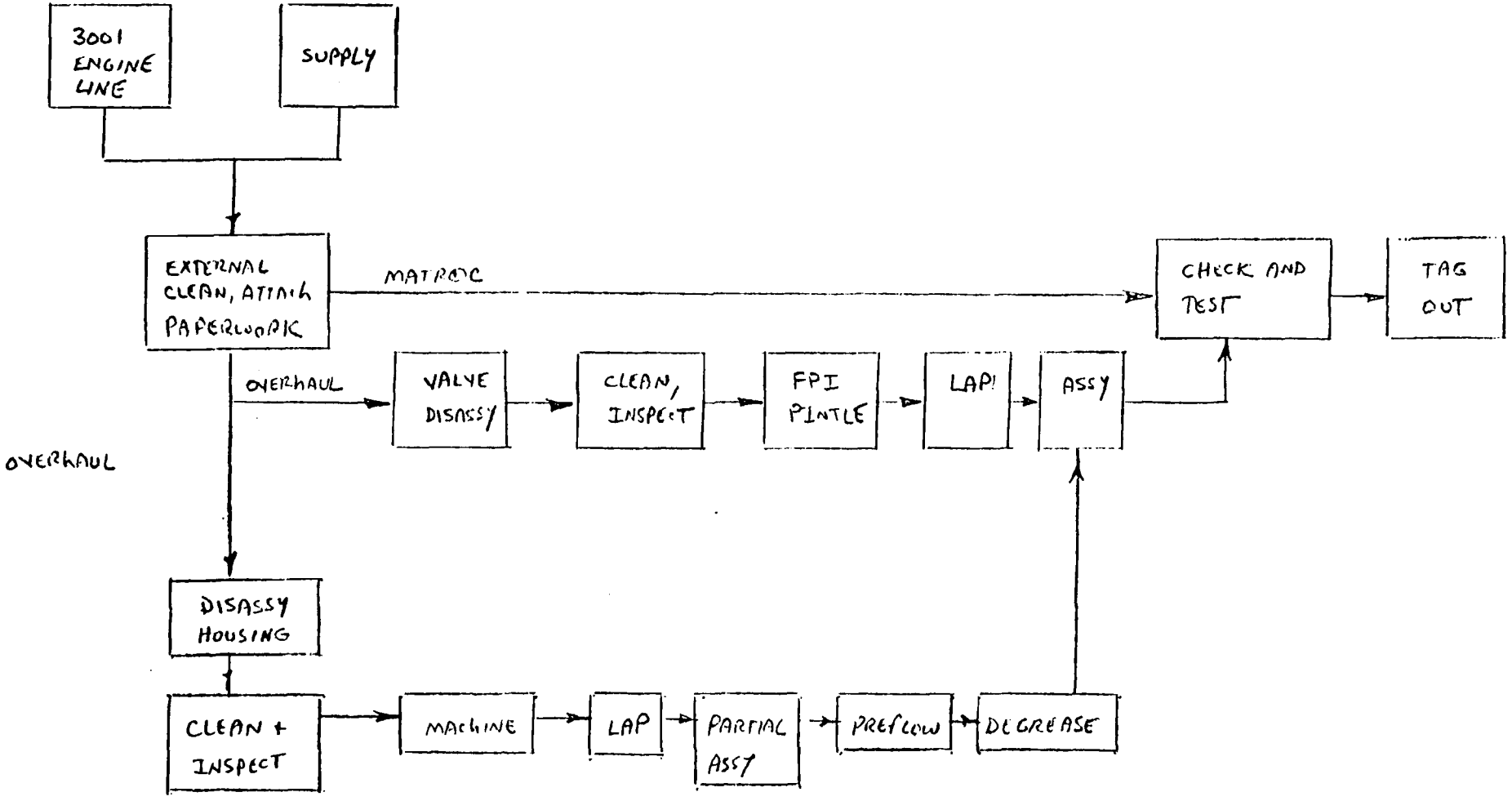
PCN
98206A

WCD
CBEZ94

MATPCB
FUEL PUMP
(TEST)



PCN	WCD	MAT PCB
38644A	CBEM 19, CBEM 20	NOZZLES
50067A	CBEM 29, CBEM 30, CBEM 31	



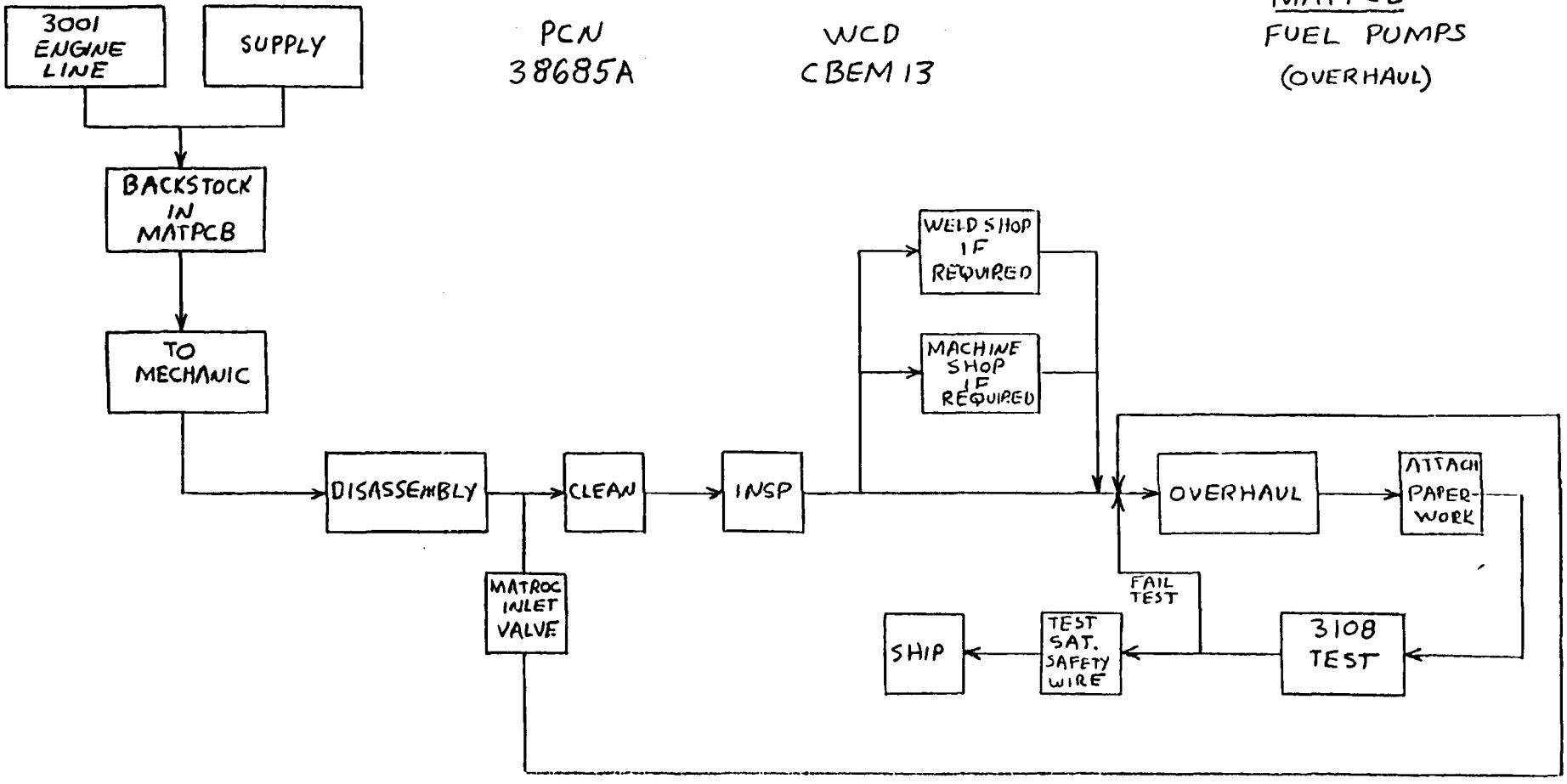
MATPCB

FUEL PUMPS

(OVERHAUL)

PCN 38685A

WCD CBEM 13

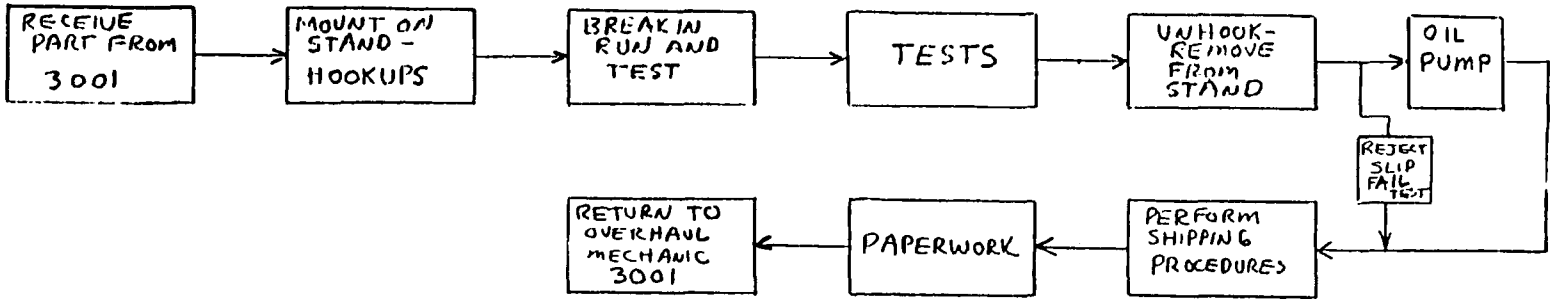


MATPCB

FUEL PUMPS

(TEST)

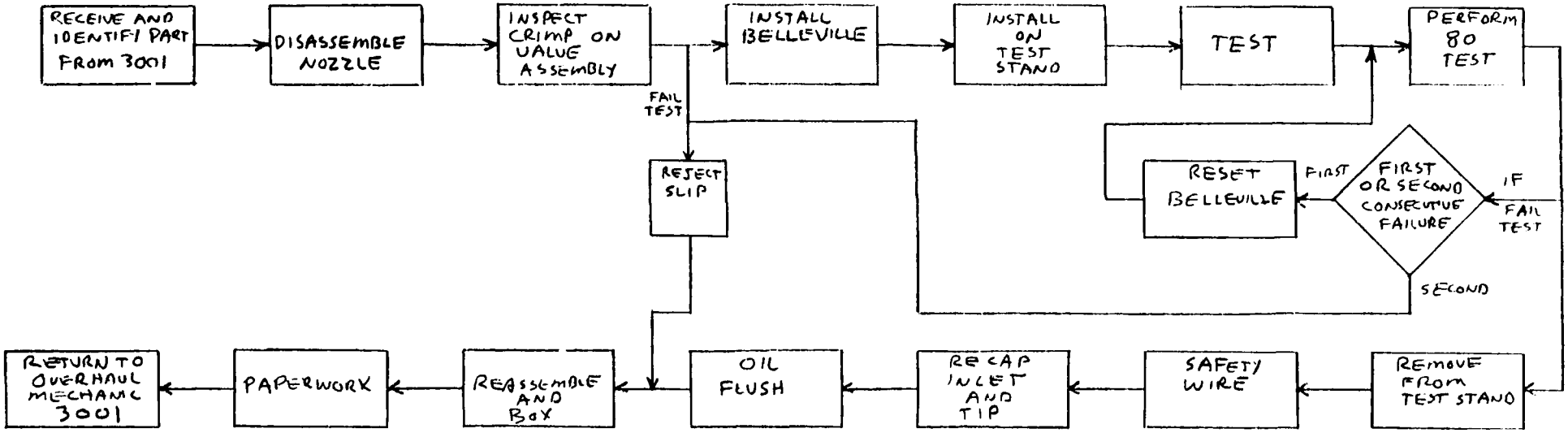
PCN	WCD
38685A	CBEM14
98202A	CBEZ01
96515A	CBEY07
96555A	CBEY17



PCN
38644A
50067A

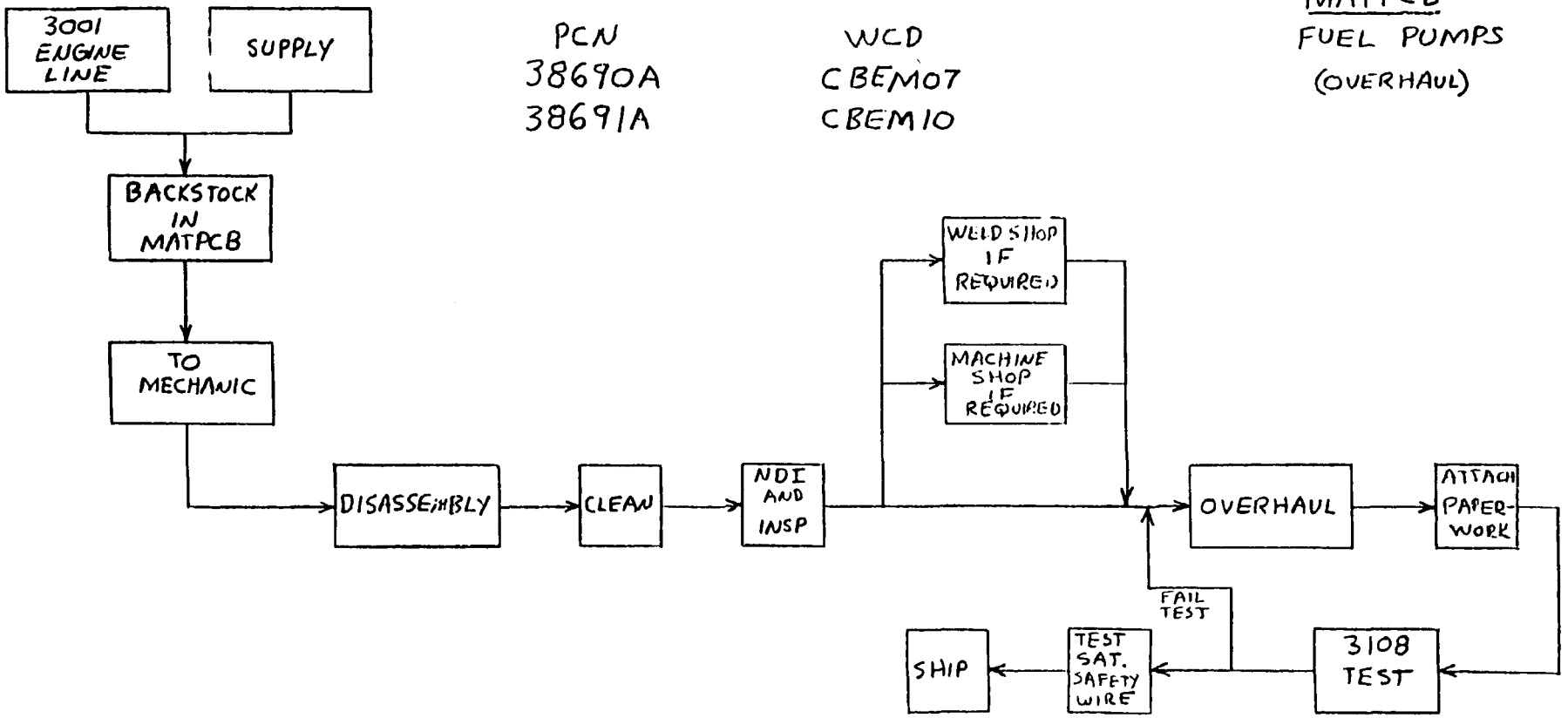
WCD
CMEM20
CBEM31 + CBEM30

MATPLB
NOZZLE
(TEST)



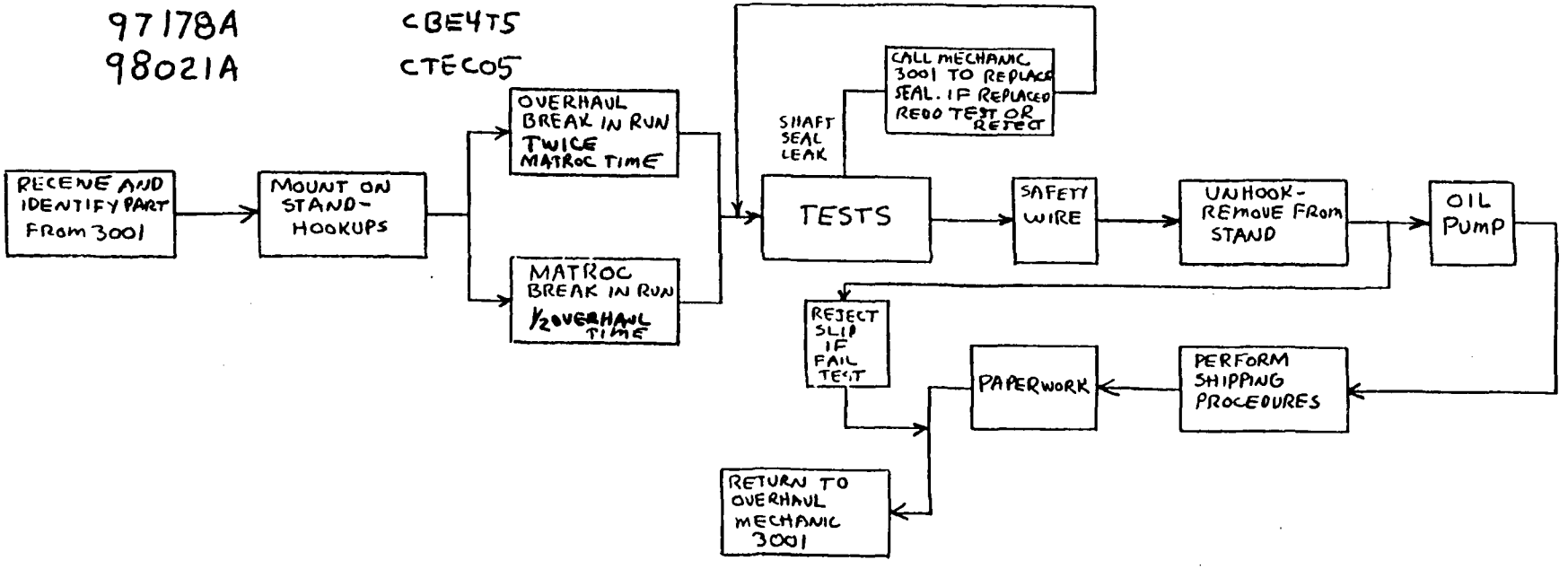
MATPCB
FUEL PUMPS
(OVERHAUL)

PCN	WCD
38690A	CBEM07
38691A	CBEM10



MATPCB
FUEL PUMPS (TEST)

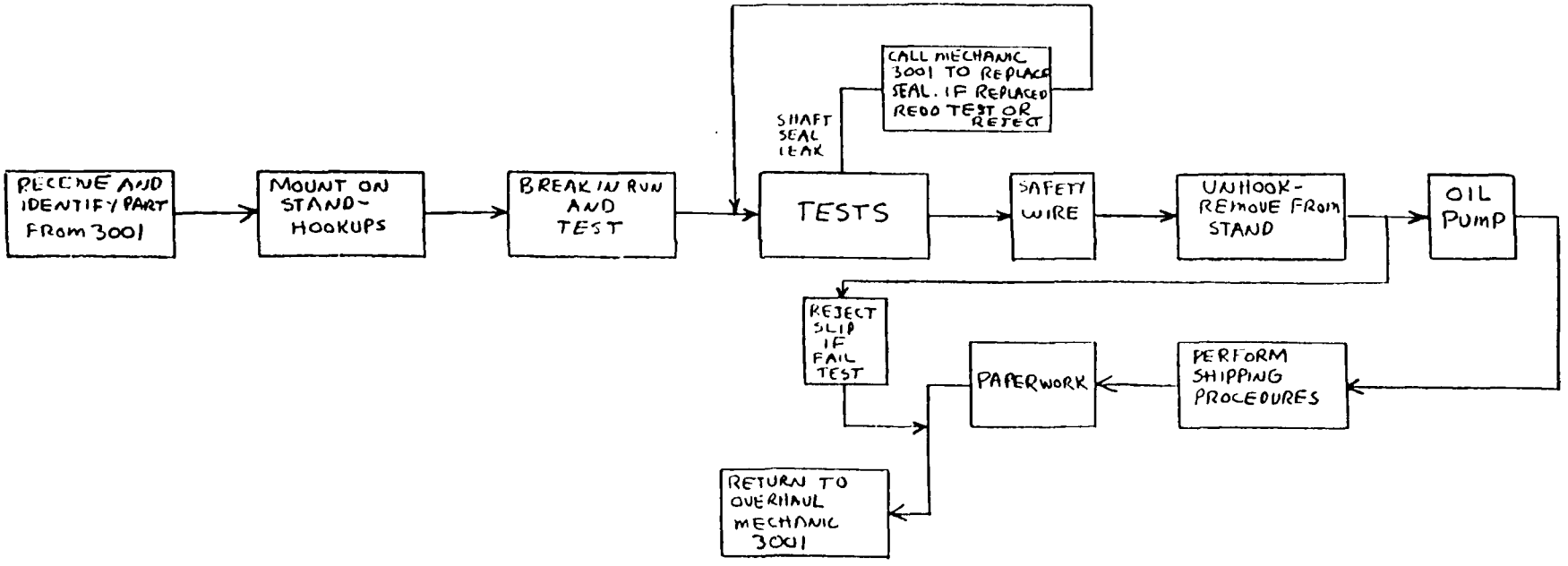
PCN	WCD
38690A	CBEM08
38691A	CBEM12
97150A	CBE4T4
97178A	CBE4T5
98021A	CTEC05



PCN
50134A

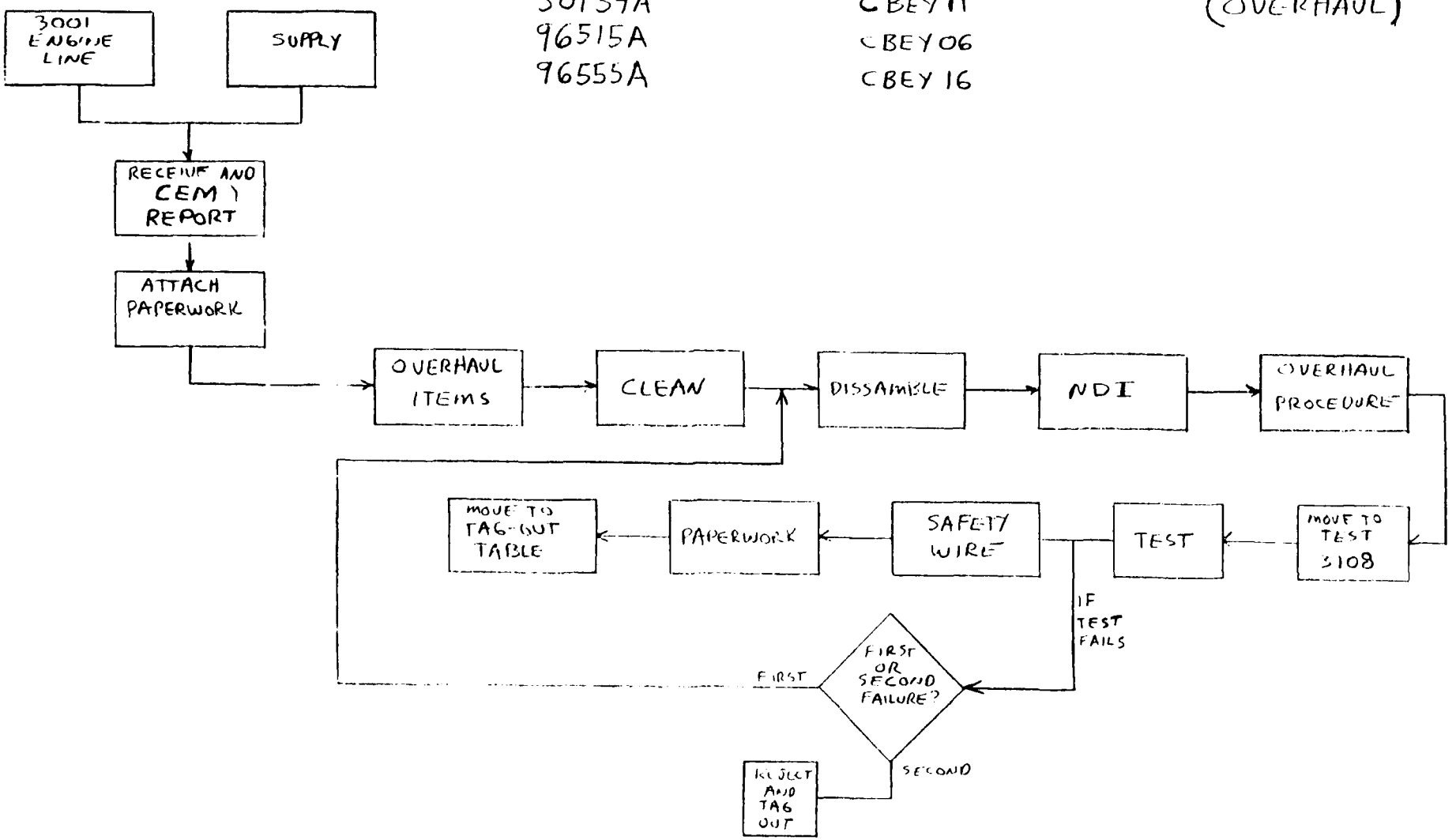
WCD
CBEY10

MATPCB
HYDRAULIC PUMP
(TEST)



MATPCB
PUMP
(OVERHAUL)

PCN	WCD
50134A	CBEY11
96515A	CBEY06
96555A	CBEY16

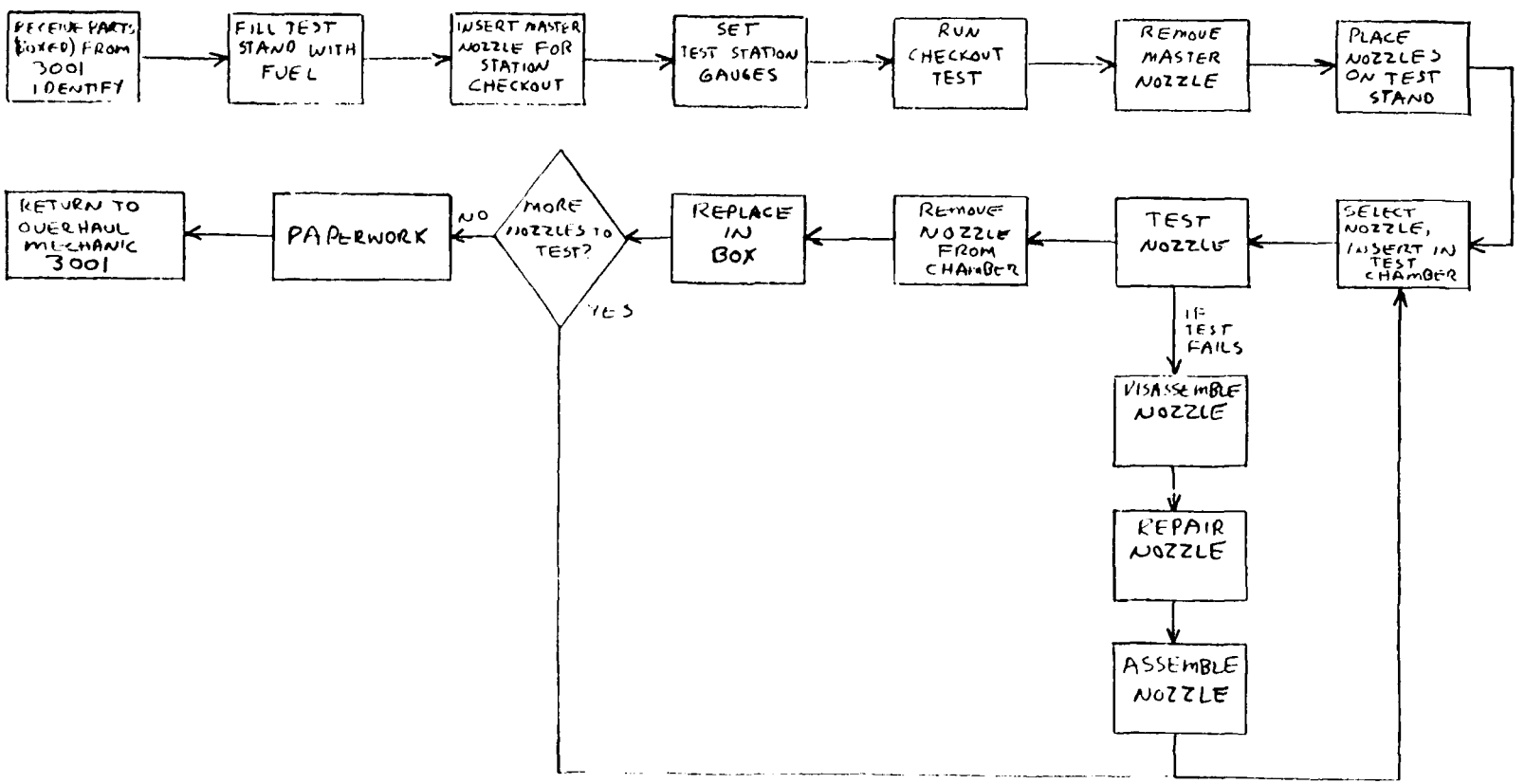


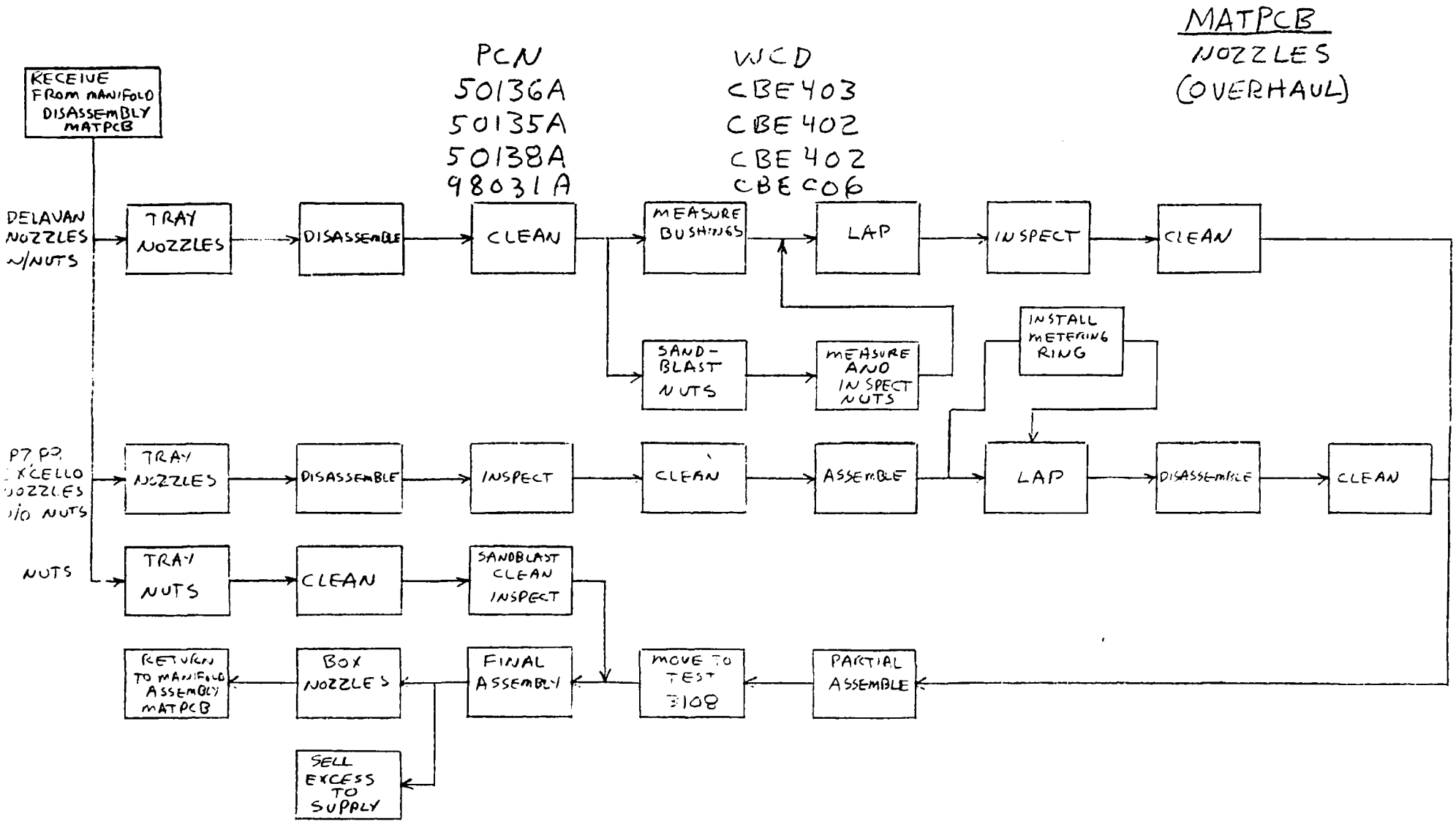
MATPCB

NOZZLES

(TEST)

PCN	WCD
50135A	CBE 4T2
50138A	CBE 4T2
50136A	CBE 4T3
98031A	CTE C06

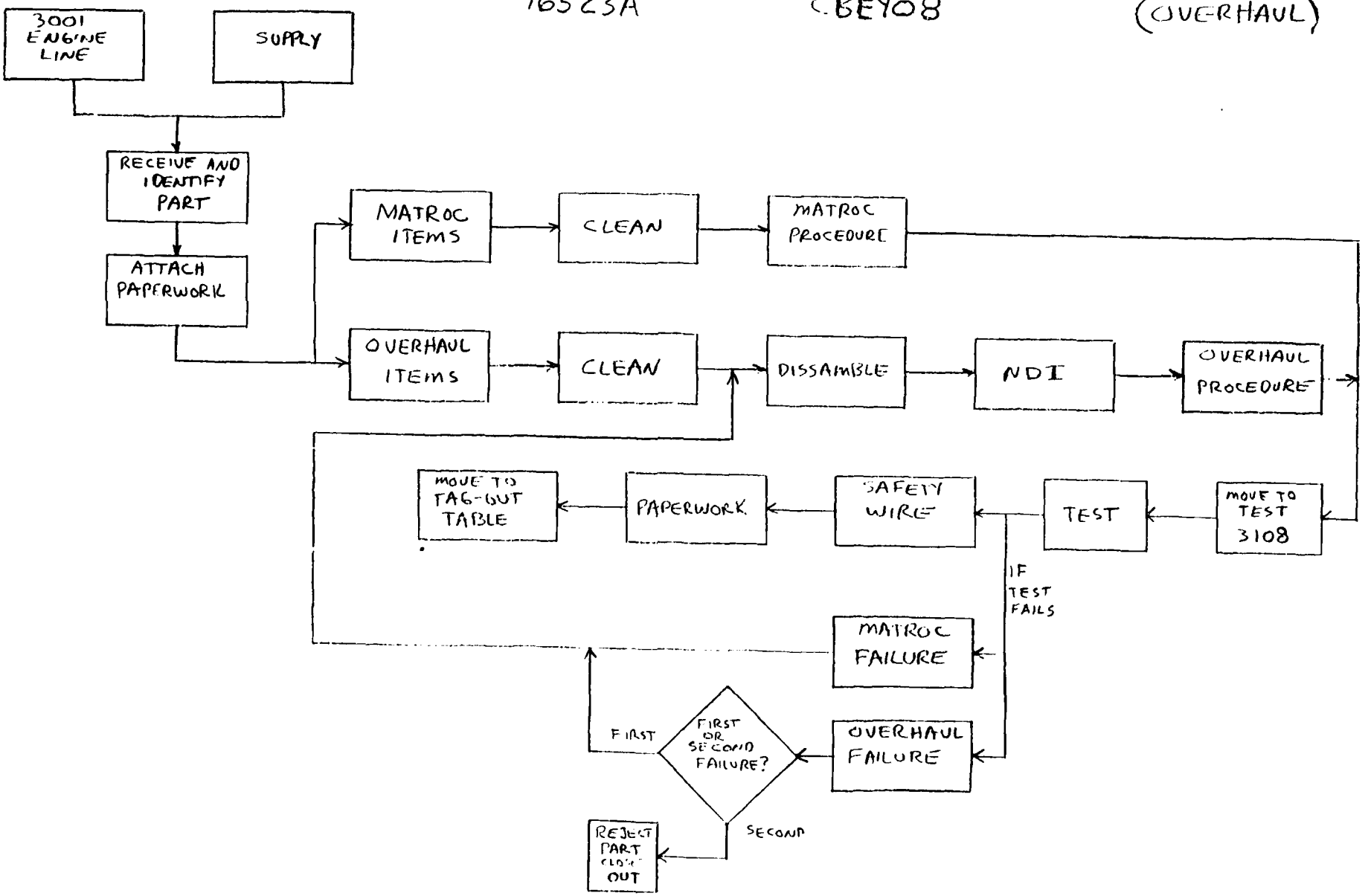



MATPCB
NOZZLES
(OVERHAUL)
PCN
50136A
50135A
50138A
98031A
WCD
CBE403
CBE402
CBE402
CBE606
RECEIVE FROM MANIFOLD DISASSEMBLY MATPCB
DELAVAN NOZZLES W/NUTS
TRAY NOZZLES
DISASSEMBLE
CLEAN
MEASURE BUSHINGS
LAP
INSPECT
CLEAN
SAND-BLAST NUTS
MEASURE AND INSPECT NUTS
INSTALL METERING RING
P7 P9 XCELLO NOZZLES W/O NUTS
TRAY NOZZLES
DISASSEMBLE
INSPECT
CLEAN
ASSEMBLE
LAP
DISASSEMBLE
CLEAN
NUTS
TRAY NUTS
CLEAN
SANDBLAST CLEAN INSPECT
RETURN TO MANIFOLD ASSEMBLY MATPCB
BOX NOZZLES
FINAL ASSEMBLY
MOVE TO TEST 3108
PARTIAL ASSEMBLE
SELL EXCESS TO SUPPLY

PCN
96523A

WCD
CBEY08

MATPCB
PUMP
(OVERHAUL)

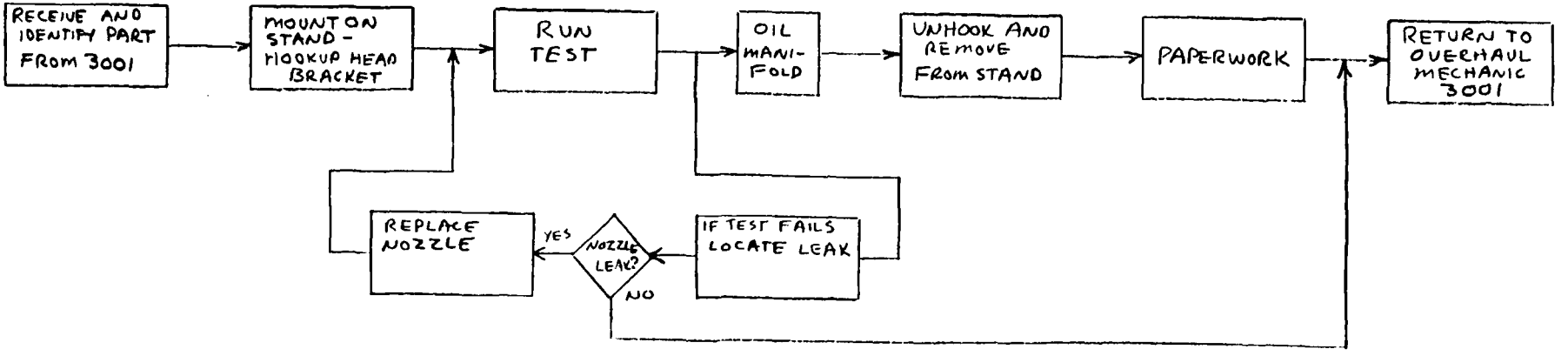


MATPCB

MANIFOLDS

(TEST)

PCN	WCD
49802A	CBE4T1
49806A	CBE4T1
49808A	CBE4T1
49810A	CBE4T1
98057A	CTEC04
98034A	CTEC04
98042A	CTEC04
98043A	CTEC04



3.0 80/20 WORKLOAD ANALYSIS

An 80/20 Workload Analysis for MATPCB was performed by MDMSC using information obtained from OC-ALC Analysis reports. Using the earned hours reported by control number, a list was generated that represented 80% of the workload. An updated list was formed by reviewing the recent history of items processed and replacing those PCN'S that were no longer relevant with presently processed items of equal or greater earned hours. The following is an updated list of PCN'S and WCD'S representing 80% of MATPCB'S workload:

PNC'S	WCD'S	PCN'S	WCD'S
38644A	CBEM19 CBEM20	38685	CBEM13 CBEM14
38690A	CBEM07 CBEM08	38691A	CBEM10 CBEM11
49802A	CBE401 CBE4T1	49806A	CBE401 CBE4T1
49808A	CBE401 CBE4T1	49810A	CBE401 CBE4T1
50067A	CBEM29 CBEM30 CBEM31	50134A	CBEY10 CBEY11
50135A	CBE402 CBE4T2	50138A	CBE402 CBE4T2
50136A	CBE403 CBE4T3	96515A	CBEY06 CBEY07
96523A	CBEY08 CBEY09	96555A	CBEY16 CBEY17
97150A	CBE404 CBE4T4	97178A	CBE405 CBE4T5
98021A	CBEC05 CTEC05	98031A	CBEC06 CTEC06

3.0 80/20 WORKLOAD ANALYSIS (CON'T)

PCN'S	WCD'S	PCN'S	WCD'S
98034A	CBEC04 CTEC04	98042A	CBEC04 CTEC04
98043A	CBEC04 CTEC04	98057A	CBEC04 CTEC04
98202A	CREZ01	98206A	CBEZ02 CBEZ94

3.1 VALIDATION

During the assessment the 80/20 control numbers were determined to be fairly representative of the workload. Included is a copy of the 80/20 list.

9034.4

MATPCB

	50136A	29150059101O6	NOZZLE	TF33J57-A11	15	0	0.44	00
	50138A	291500019 2754	NOZZLE	TF33J57ALL	15	0	0.54	00
	98031A	29150084977 57	NOZZLE		0	—	1.00	—
	50135A	29150032812 92	NOZZLE	TF 33J57-A11	15	0	—	—

4.0 DATA COLLECTION

The following Data sheets used for th collection of data were found applicable to MATPCB:

- .Operation Profile
- .Manpower Profile
- .Assembly/Disassembly Profile
- .Equipment Profile
- .Envelop Profile

Parallel Process Profiles were found not to be applicable to this RCC. While the Manifolds and Nozzles were seperated and worked on seperately. The same nozzles that were removed from the manifold did not have to be reinstalled into the same manifold. There are enough reworked nozzles available for immediate replacement in the manifolds at the appropiate time. Therefore a Parallel Process Profile was not needed. Operation Profiles were developed primarily from shop interviews. The other profiles were developed by MATPCB supervisors through coordination with the General Foreperson.

4.1 DATA COLLECTION PROCESS

An Operation Profile sheet was developed for each WCD identified from the PCN'S listed on the 80/20 Analysis. Most PCN'S had two or three WCD'S. In most cases one WCD was the repair/overhaul WCD and the second WCD was the test WCD. In all cases the part was not considered complete until the complete repair/overhaul WCD was filled out, stamped and signed. The General Foreperson identified the appropiate MATPCB supervisor who advised which shop personnel were responsible for each WCD. MDMSC personnel then conducted the Operation Profile interview with the appropiate shop personnel. The shop mechanics provided the necessary information and data for the Operation Profiles.

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

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

EQUIPMENT PRO[illegible]LE

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

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC 0945	TEST STAND TF30 NB Pump	2	2	2	30	1	4	15	4	0	1 / 1	5139	
OC 0975	TEST STAND Pump	2	2	2	30	1	4	25	4	0	1 / 1	0889	
OC 5139	Test Stand TF30 NB Pump	2	2	2	30	1	4	15	4	0	1 / 1	0945	
OC 0934	TEST STAND	2	2	2	30	1	4	30	4	0	1 / 1		

OC 3024	NOZ CLNR	1	1	1	30	1	4	60	1	0	1 / 48		
OC 4275	TEST STND	2	2	2	30	1	4	45	4	0	1 / 1		

OC 4133	AIR INK	1	1	1	30	1	1	NA	NA	0	1 / 20		
OC 4134	AIR INK	1	1	1	30	1	1	NA	NA	0	1 / 20		
OC 4136	AIR DRIER	1	1	1	30	1	1	NA	NA	0	1 / 20		

EQUIPMENT PRO _E

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

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
BEN 60	WORKBENCH	1	1	1									
BEN 12	WORKBENCH	1	1	1									
BEN 48	WORKBENCH	1	1	1									
BEN 40	WORKBENCH	1	1	1									
BEN 410	WORKBENCH	1	1	1									
BEN 444	WORKBENCH	1	1	1									
BEN 49	WORKBENCH	1	1	1									
BEN 50	WORK BENCH	1	1	1									
BEN 46	WORKBENCH	1	1	1									
BEN 44	WORKBENCH	1	1	1									
BEN 43	WORKBENCH	1	1	1									
BEN 45	WORKBENCH	1	1	1									

EQUIPMENT PRO[illegible]LE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET ____ OF ____

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME			MIN / MAX			
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR					
BEN 1	WORK BENCH													
BEN 42	WORK BENCH Manifold area													
BEN 21	WORK BENCH												BEN 22	
BEN 22	WORK BENCH												BEN 21	
BEN 14	WORK BENCH													
BEN 433	WORK BENCH													
BEN 436	WORK BENCH													
BEN 419	WORK BENCH													
BEN 53	WORK BENCH													
BEN 55	WORK BENCH													
BEN 56	WORK BENCH													
BEN 434	WORK BENCH													

OC 4 xxx

EQUIPMENT PROFILE

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPCB SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME			MIN / MAX		
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR				
OC 4278	TEST STAND Nozzle test stand	2	2	2	30	1	1	180	8	0	1 / 1	4743	Christenberry
OC 4132	WTRTANK Rinse, Cold	1	1	0	1	1,2		365	0,5	0	10 / 30	4133 4134 4144	Collins
OC 4147	VDGRSR Vapor Degreaser	1	1		1	1,2		90	48	10	1 / 30		Collins
OC 4137	USFRNTNK Ultrasonic Freon Tank	1	1	0	1	1,2		180	1,5	0	10 / 20		Collins
OC 4561	WTRPMP Deep Water Pump												
OC 4602	ALGNFIXT Aligning Fixture												
OC 4140	CHMTANK Ultrasonic Rinse	1	1	0	1	1,2		180	1,5	10	10 / 30		Collins

Y= 0, SPS Program
NOT ORIG. EQUIPMENT

EQUIPMENT PRO LE

OC XXX

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPCR SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC 0972	TEST STAND	2	2	2	3	1	1	30	4	0	1 / 1	0283	M.C.
OC 0701	TEST STAND Nozzle test stand	4	4	4	30	1	4	30	8	0	1 / 1	0702, 0703, 0705	
OC 0702	TEST STAND Nozzle test stand	4	4	4	30	1	4	30	8	0	1 / 1	0701, 0703, 0705	
OC 0703	TEST STAND Nozzle test stand	4	4	4	30	1	4	30	8	0	1 / 1	0701, 0702, 0705	
OC 0705	TEST STAND Nozzle test stand	5	5	5	30	1	1	14	1	0	1 / 1	0701, 0702, 0703	M.C.
OC 0952	TEST STAND Static pressure test	1	1	1	30	1	1	180	1	0	1 / 1		
OC 0947	TEST STAND	1	1	1	3	1	1	180	1	0	1 / 1	NONE	MONA CHRISTENBERRY =M.C.
OC 0229	PROOF TEST FPI Booth ?	1	1	1	0	1	0	30	4	0	1 / 1	Ø	
OC 0889	TEST STAND for pumps	2	2	2	30	1	2	30	4	0	1 / 1	0975	
OC 0973	TEST STAND	1	1	1	3	1	1	45	16	0	1 / 1	NONE	MONA Christenberry
OC 0883	TEST STAND	2	2	2	30	1	1	30	4	0	1 / 1	0972	
OC 0948	TEST STAND Hydraulic	1	1	1	3	1	1	180	1	0	1 / 1	NONE	M.C.

EQUIPMENT PR ILE

OC 5 xxx

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPCB SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3d	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC 3338	CHMTANK Acid bath	1	1		90	1	0.1	30	4	0	1 / 1		JONES ? BURROWS ?
OC 3349	CHMTANK Alkaline ?	1	1		0	0	0	30	4	0	1 / 1		BURROWS
OC 3348	CHMTANK Alkaline [illegible]	1	1		90	1	0.1	30	4	0	1 / 1		JONES ? BURROWS ?
OC 3346	CHMTANK Alkaline Permanganate	1	1		90	1	0.1	30	4	0	1 / 1		JONES
OC 3351	CHMTANK Alkaline Permanganate	1	1		90	1	0.1	30	4	0	1 / 1		JONES
OC 3350	CHMTANK Alkaline	1	1		0	0	0	30	4	0	1 / 1		BURROWS
OC 3028	LAPPMACH Lap seals + [illegible]	1	1	1	1	1	2	8	12	0	1 / 1		
OC 3020	CHMTANK Permanganate	1	1		0	0	0	30	8	10	1 / 96		BURROWS
OC 3022	CHMTANK Cleaning tank	1	1	0	1	1,2		90	24	10	1 / 96	3024	Collins
OC 3015	[illegible] Filter Press	1	1					30	8	10	1 / 96		BURROWS
OC 3391	LAPPMACH Lapping Machine	1	1	1	1	1	2	8	12	0	1 / 1		

EQUIPMENT PR ILE

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPCB SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3d	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC 6025	PENBOOTH Floor penetrant												

OC 7- XXX

LSC-20004B

EQUIPMENT PR .FILE

OC 7 XXX

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPCB SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3d	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC 2887	TEST STAND TF41 HP Pump	2	2	2	30	1	2	45	8	0	1 / 1	1941	

LSC-20094B

EQUIPMENT P OFILE

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPCB SHEET ____ OF ____

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC 5035	BALANCE Dino Shaft	1	1	1	0	0	0	30	4	0	1 / 1	0	BURROWS
OC 5139	~~TESTAND~~ Pump TF30 NB Pump	2	2	2								NC 0945	
OC 5121	OVEN												

LSC-20094B

EQUIPMENT P. FILE

OC 9 XXX

NAME _____ ALC _____ DATE 29 JUN 89 RCC MATPC8 SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME			MIN / MAX		
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR				
OC 1178	PD680 TNK Degreaser	1	1		1	1,2		365	24	10	1 / 96		Collins
OC 1132	TEST STAND Manifold	2	2	2	30	1	1	180	8	0	1 / 1	1133	Christenberry
OC 1133	TEST STAND Manifold	2	2	2	30	1	1	180	8	0	1 / 1	1132	Christenberry
OC 1188	TEST STAND TF41 LP Pump	1	1	1	30	1	1	180	40	0	1 / 1		Christenberry
OC 1941	TEST STAND TF41 HP Pump	2	2	2	30	1	2	45	8	0	1 / 1	2887	
OC 1174	SNDBLSTR Sandblaster												

EQUIPMENT PROFILE

REVISED EQUIPMENT PROFILE, ONLY REFLECTS THOSE ON OPERATION PROFILES.

NAME Christenberry ALC OC DATE 5-15-89 RCC MATPCB SHEET 1 OF 1

SHOP

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 4777	J79 Nozzle (L/S) Test Stand	002	002	002	030	1	001.0	180	0008.0	X	0001 / 0001	OC 4743	Christenberry
OC 4779	J79 Nozzle (Key) Test Stand	002	002	002	030	1	001.0	180	0008.0	X	0001 / 0001	OC 4743	Christenberry
OC N705	J57/TF33 Nozzle Test Stand	005	005	005	030	1	001.0	014	0001.0	X	0001 / 0001	5701 5702 5703 1NEF	Christenberry
OC 1133	Manifold Test Stand	002	002	002	030	1	001.0	180	0008.0	X	0001 / 0001	OC 1133	Christenberry
OC 1741	TF41 HP Pump Test Stand	002	002	002	030	1	001.0	015	0001.0	X	0001 / 0001	OC 2771	Christenberry
OC 1178	TF41 LP Pump Test Stand	001	001	001	030	1	001.0	180	0040.0	X	0001 / 0001	none	Christenberry
OC 5139	TF33 MB Pump Test Stand	002	002	002	030	1	001.0	180	0016.0	X	0001 / 0001	OC 4745	Christenberry
OC 1775	J57/TF33 MF Pump Test Stand	002	002	002	030	1	001.0	030	0004.0	X	0001 / 0001	OC 1147	Christenberry
OC 1275	J79 MB Pump Test Stand	002	002	002	030	1	001.0	030	0004.0	X	0001 / 0001	OC 4734	Christenberry
OC 0972	J79 MF Pump Test Stand	002	002	002	030	1	001.0	030	0004.0	X	0001 / 0001	OC 0773	Christenberry
OC 1946	TF30 Hydraulic Pump Test Stand	001	001	001	030	1	001.0	180	00040.0	X	0001 / 0001	none	Christenberry
OC 1947	J79 Nozzle Oil Flush Stand	001	001	001	030	1	001.0	180	0001.0	X	0001 / 0001	none	Christenberry
OC 0973	TF30 Manifold Pump Test Stand	001	001	001	030	1	001.0	045	0016.0	X	0001 / 0001	none	Christenberry

ORIGINAL INPUT SOURCE UNKNOWN. IT SHOWS MANY, MANY HOURS OF EQUIPMENT WHICH IS NOT SHOWN ON ANY OPERATION PROFILES.

LSC-2009-H

EQUIPMENT PROFILE

NAME _____ ALC _____ DATE _____ MCC _____ SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
	T-14756 Doweling Fixtures	1	1	1	0	0	0	1825	Repair 1.4	0	1/1	0	Collins
	T-14758 Drill Jig	1	1	1	0	0	0	1825	Replace	0	1/1	0	Collins
	T-14759 Drill Jig	1	1	1	0	0	0	1825	Repair 1.4	0	1/1	0	Collins
	~~T-690-E~~ Adapter												
	~~FT-1217-E~~ ~~Plug-Pistol valve~~												
	~~T-13835~~ ~~Fitting-Tool~~												
	F-D-680												
0C1178	Cleaning tank Vapor Degreaser	1	1		1	1.2		90	24.0	0	1/2	0	Collins
0C 17117	cleaning tank	1	1		1	1.2		30	18.0	0	1/3	0	Collins

EQUIPMENT PROFILE

NAME _____ ALC _____ DATE _____ HCC _____ SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER HCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MEAN	MAX		MIN / MAX		
OC 4147	Degreaser	1	1	0	1	1-2		30	48.0	0	10/30	0	Collins
OC 2848	P-D-680	1	1	0	1	1-2		90	2.1.0	0	10/30	0	Collins
OC 3022	Permanganate	1	1	0	1	1-2		90	2.1.0	0	10/30	OC 3024	Collins
OC 4139	Alkaline ultra sonic cleaner	1	1	0	1	1-2		180	2.1.0	0	10/30	0	Collins
OC 4132	Cold water Rinse	1	1	0	1	1-2		365	.4	0	10/30	OC 4133 OC 4134	Collins
OC 4137	Trichlorotrifluoroethane ultra sonic cleaner	1	1	0	1	1-2		180	1.4	0	10/20	0	Collins
OC 4140	Hot water ultra sonic cleaner	1	1	0	1	1-2		180	1.4	0	10/30	0	Collins
OC 4131	Hot Air Dryer	1	1	0	1	1-2		365	1.4	0	10/30	OC 4135 OC 4136	Collins
OC 4082	Sandblaster	1	1	0	1	1-2		90	1.4	0	1/1	0	Collins

50067A Test

EQUIPMENT PROFILE

NAME _____ ALC _____ DATE _____ MCC _____ SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME			MIN	MAX		
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR					
	107-3-563 Proof test Fixture	1	1	0	0	0	0	—	—	0	1	1	—	
	107-3-741 + Seal Plug	1	1	0	0	0	0	—	—	0	1	1	—	
	9424M49G01 Pattern ation spray chamber	1	1	0	0	0	0	—	—	0	1	1	—	
OC4277	IC3596	1	1	0	0	0	0	—	—	0	1	1	—	
OC1743	Test Stand													

4

EQUIPMENT PROFILE

NAME Delaware (M) 50136 ALC OC-ALC DATE _____ MCC MATPCB SHEET 4 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME FREQ OF	MTTR	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 3032	Tank #5 Hydroxide Potassium Permanganate	1	1	0	0	0	0	0	0	0	1/96	0	
OC 3034	Tank #7 Hydroxide Potassium Permanganate	1	1			1					1/96	0	
OC 3031	Tank #4 Sodium Hydroxide	1	1								1/96	0	
OC 3030	Tank #3 Sodium Hydroxide	1	1								1/96	0	
OC 3019	Tank #2 Hot Water	1	1								1/96	0	
OC 3023	Tank #6 Hot Water	1	1								1/96	0	
OC 4947	Di-Grease Trichloroethylene	1	1								1/96	0	
OC 1178	PD680 Chemical Tank	1	1								1/96	0	
	Turn Table	1	1								1/96	0	
OC 4135 4186 4131	Tank #14-15-16 Hot Air Tanks	1	1								1/96	0	
OC 4132	Tank #13 Cold Water Tank	1	1								1/96	0	
OC 4134	Tank #11 & 9 Cold Water Tank	1	1	0	0	0	0	0	0	0	1/96	0	

Under 3165

18
5

EQUIPMENT PROFILE

NAME Tinker AFB ALC OC-ALC DATE _____ MCC MATPCS SHEET 3 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. TIME/O.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MEAN	MAX	PERCENT USED FOR OTHER MCC (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC	Tank #5												
3022	Hydraulic Pressure Permanganate	1	1	0	0	0	0	30	8.0	10 %	1 / 96		Collins
OC	Tank #7												
3034	Hydraulic Pressure Permanganate	1	1					30	8.0	10 %	1 / 96		Collins
OC	Tank #4												
3031	Sodium Hydroxide	1	1					30	8.0	10 %	1 / 96		Collins
OC	Tank #3												
3030	Sodium Hydroxide	1	1					30	8.0	10 %	1 / 96		Collins
OC	Tank #2												
3019	H-L Water	1	1					30	8.0	10 %	1 / 96		Collins
OC	Tank #6												
3023	H-L Water	1	1					30	8.0	10 %	1 / 96		Collins
OC	OC-Greaser												
4747	Lubrication	1	1					90	48.0	10 %	1 / 96		Collins
OC	PD 680 Chemical Tank												
1178		1	1					90	6.0	10 %	1 / 96		Collins
OC	Tanks #14-15-16												
4135 ~~4136~~ ~~4137~~	H-L Air Dryer Tanks	1	1					90	6.0	10 %	1 / 96	OC-4136 OC-4131	Collins
OC	Tanks #13-11-9												
4132 ~~4133~~ ~~4134~~	Cold Water Rinse Tanks	1	1					90	6.0	0	1 / 96	OC-4133 OC-4134	Collins
OC	Tank #12												
4140	H-L Water Rinse	1	1	0	0	0	0				/		
OC											/		

EQUIPMENT PROFILE

NAME TF 33-P9 CN50138 ALC OC-ALC DATE _____ MDS MATFCB SHEET 1 OF 2

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MEAN	MEDIAN	PERCENT USED FOR OTHER NEEDS (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 3022	Tank #5 Hydroxide Potassium Permanganate	1	1	0	0	0	0	30	8.0	10%	1/96	—	
OC 3024	Tank # 7 Hydroxide Potassium Permanganate	1	1					30	8.0	10%	1/96	—	
OC 3021	Tank # 4 Sodium Hydroxide	1	1					30	8.0	10%	1/96	—	
OC 3030	Tank #3 Sodium Hydroxide	1	1					30	8.0	10%	1/96	—	
OC 3019	Tank # 2 Hot Water	1	1					30	8.0	10%	1/96	—	
OC 3023	Tank # 6 Hot Water	1	1					30	8.0	10%	1/96	—	
OC 4947	Oil-grease Recirculating	1	1					90	4.8	10%	1/96	—	
OC 1178	LD680 Chemical Tank	1	1					90	6.0	10%	1/96	—	
OC 4135 ~~4136~~ ~~4137~~	Tank # 14-15-16 Hot air Tanks	1	1					90	6.0	0	1/96	OC-U136 U131	~~COLLINS~~ COLLINS
	Test Fluid												
OC 4132	Tank # 13 Cold Water Tank	1	1	0	0	0	0	180	6.0	10%	1/96		COLLINS

Circled 3108

EQUIPMENT PROFILE

NAME TF33-P7 CN 98031 ALC OC-ALC DATE ____ MCC MATPCB SHEET 2 OF 2

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MEAN	MAX	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC	Tank #5												
3022	Hydroxide Potassium Permanganate	1	1	0	0	0	0	0	0	0	1/96		Collins
OC	Tank #7												
3024	Hydroxide Potassium Permanganate	1	1								1/96		Collins
OC	Tank #4												
3021	Sodium Hydroxide	1	1								1/96		Collins
OC	Tank #3												
3020	Sodium Hydroxide	1	1								1/96		Collins
OC	Tank #2												
3019	Hot Water	1	1								1/96		Collins
OC	Tank #6												
3023	Hot Water	1	1								1/96		Collins
OC	DK - grease												
4947	Lubrication	1	1								1/96		Collins
OC	PD680												
1178	Chemical Tank	1	1								1/96		Collins
OC													
4135	Tank #14-15-16	1	1								1/96	OC-4131	
~~4134~~	Hot Water											OC-4136	Collins
OC													
4932	Tank #13-11-9	1	1								1/96	OC-4133	
~~4933~~	Cold Water											OC-4144	Collins
~~4944~~	Tank												
OC													
	Test Fluid	1	1										
OC	Tank #12												
1141	Hot Water	1	1	0	0	0	0	0	0	0			Collins

97.. & 98021..

EQUIPMENT FILE

SHOP

NAME _____ ALC OC 4608 DATE June 8, 1989 RCC MATPCB SHEET 1 OF —

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 4608	STD 62258 Bearing Lapping Tool	1	1		0	0	0	1825	Replace	0	1/1	0	Collins
OC 4608	STD 62257 Bearing Lapping Tool	1	1					1825	Replace	0	1/1		Collins
OC 4608	STD 62901 Bearing Puller	1	1					1825	Replace	0	1/1		Collins
OC 4608	STD 62902 Valve Puller	1	1					1825	Replace	0	1/1		Collins
OC 4608	STD 63343 "A" Valve Clamp	1	1					1825	Replace	0	1/1		Collins
OC 1178	PD-680 Tank For Cleaning	1	1					365	8.0	0	1/2		Collins
OC 4947	Degreaser Tank For Cleaning	1	1		0	0	0	30	24	10%	1/2		Collins
OC 4608	STD-62220 Drive Shaft Torque Adapter	1	1		0	0	0	1825	Replace	0	1/1	0	Collins

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EQUIPMENT PROFILE

NAME RAY Jones ALC OC DATE 1 MAY 89 MCC MATTC B SHEET 5 OF 6

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
Do	PWA 35529												
NOT USE	Block												
	PWA 35530												
	Gasket												
	PWA 35531												
	Fixture												
Do	PWA 35809												
NOT USE	Block												
OC	PWA 6984												
4600	Stand												
D	PWA 6580												
NOT USE	SLING												
OC	ALKALINE Permagante												
6560	VAT, Reservior	1	1		090	001	0001	30	4	0	1/1	0	Jones
OC	Alkaline Permagante												
3338	VAT, Cleaning	1	1		090	001	0001	30	4	0	1/1	0	Jones
OC	ALKALINE Permagante												
3348	VAT, Cleaning	1	1		090	001	0001	30	4	0	1/1	0	Jones
OC	ALKALINE Permagante												
3346	VAT, Cleaning	1	1		090	001	0001	30	4	0	1/1	0	Jones
OC	ALKALINE												
6561	VAT, Reservior	1	1		090	001	0001	30	4	0	1/1	0	Jones
OC	ALKALINE												
3351	VAT, Cleaning	1	1		090	001	0001	30	4	0	1/1	0	Jones

Cleaning Procedure

LSC-2009 UB

EQUIPMENT PROFILE

NAME RAY Jones ALC OC DATE 1 MAY 89 RCC MAT & B SHEET 6 OF 6

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME: PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 3350	ALKALINE VAT, Cleaning	1	1	0	0	0	0	30	4	0	1 / 1	ø	Bussmans
OC 3349	ALKALINE + VAT, Cleaning	1	1	1	1	1	1	30	4	0	1 / 1	ø	Bussmans
OC 2848	PD680 Flush TANK	1	1	1	1	1	1	30	4	0	1 / 1	ø	Bussmans
OC 3125	Oven	1	1	1	1	1	1	365	36	0	1 / 1	ø	Bussmans
OC 4600	DRILL Mach.	1	1	0	0	0	0	365	Replace	0	1 / 1	ø	Bussmans

EQUIPMENT PROFILE

NAME Ray Jones ALC OC DATE 8 MAY '89 MCC MAT PC B SHEET 4 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3d	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC	HD 752												
4608	Vise, Bench	4	4	4	0	0	0	182	R/A	0	1/1	3	Bussens
OC	MST-250												
4608	Spring Tester	1	1	1				180	36	0	1/1	0	
OC	PD680												
1178	VAT, Cleaning	3	3	3				30	4	0	1/1	2	
OC	MODEL CT-60-S												
	Degreaser	1	1	1				30	4	0	1/1	0	
OC	128												
0229	Line, Fluorescent Penetrant	1	1	1				30	4	0	1/1	0	
OC	MODEL 37000												
0229	Booth, Fluorescent Penetrant	1	1	1				30	4	0	1/1	0	
OC	MODEL G610M												
6025	Magnetic Particle	1	1	1				30	4	0	1/1	0	
OC	PWA 15505-100												
5319	Test Stand	1	1	1									
OC	PWA 15505												
[illegible]	Test Stand	1	1	1									
OC	8-115												
4608	Arbor, Press	3	3	3				182	R/A	0	1/1	2	
OC	MODEL TP-121												
4608	HYD Press	2	2	2				182	R/A	0	1/1	1	
OC	7/01/5/0907												
5035	Balance Mach.	1	1	1	0	0	0	30	4	0	1/1	0	Bussens

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EQUIPMENT PROFILE

NAME RAY JONES ALC OC DATE 9 MAY '89 NCC MATRES SHEET 3 OF 3

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3d	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN/REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER NCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC	SF-102-1156-04-F1												
4608	Piston Ring Assembler	1	1	1	0	0	0	1825	Replace	0	1 / 1	ϕ	JONES BURROWS
OC	SF-102-1162-06-F1												
4608	Fixture	1	1	1	0	0	0	(	(	0	1 / 1	ϕ	JONES BURROWS
OC	SF-102-1190-01-M1												
4608	Holding Block and Arbor	1	1	1	0	0	0			0	1 / 1	ϕ	JONES BURROWS
OC	SF-102-1192-01-F1												
4608	Fixture and Arbor	1	1	1	0	0	0			0	1 / 1	ϕ	JONES BURROWS
OC	8-115												
4608	Arbor Press	3	3	3	0	0	0	1825		0	1 / 1	2	JONES BURROWS
OC	D-J25U65												
2846	Drill Press	1	1	1	0	PPI	0	365		0	1 / 1	ϕ	JONES BURROWS
OC	2054												
4608	Gage Blocks	1	1	1	0	0	0	1825	Replace	0	1 / 1	ϕ	JONES BURROWS
OC	PD680												
1178	VAT, Cleaning	3	3	3	0	PPI	0	30	4	0	1 / 1	2	JONES BURROWS
OC	MODEL CT-60-S												
4512	Degreaser	1	1	1	0	PPI	0	30	4	0	1 / 1	ϕ	JONES BURROWS
OC	MODEL G610M												
6025	MAGNETIC PARTICLE	1	1	1	0	PPI	0	30	4	0	1 / 1	ϕ	JONES BURROWS
OC	128												
0229	Line, Fluorescent Penetrant	1	1	1	0	PPI	0	30	4	0	1 / 1	ϕ	JONES BURROWS
OC	MODEL 37000												
0229	Booth, Fluorescent Penetrant	1	1	1	0	PPI	0	30	4	0	1 / 1	ϕ	JONES BURROWS

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98202

EQUIPMENT PROFILE

NAME RAY JONES ALC OC DATE 5 MAY '89 MCC MATRC B SHEET 1 OF 2

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 4608	558-2-01352 SPANNER	2	2	0	0	0	0	1825	Replace	NONE	1 / 1	1	BUSSMANS
OC 4608	558-2-01355 SPANNER	2	2							NONE	1 / 1	1	
OC 4608	558-2-01358 SLEEVE	2	2							NONE	1 / 1	1	
OC 4608	558-1-01351 TOOL, INSERTION	1	1							NONE	1 / 1	0	
OC 4608	558-1-01353 TOOL, CRIMPING	2	2							NONE	1 / 1	1	
OC 4608	558-1-01354 SERRATED, KEY	2	2							NONE	1 / 1	1	
OC 4608	558-1-01356 TOOL, CRIMPING	2	2							NONE	1 / 1	1	
OC 4608	558-1-01357 SERRATED, KEY	2	2							NONE	1 / 1	1	
OC 4608	6873047 GAGE	1	1					1825	Replace	NONE	1 / 1	0	
OC 1178	CM48 PD680, VAT	3	3					30	4	TIME NOT AVAILABLE	1 / 1	2	
OC 4612	COMACO TYPE 1 SPRING TESTER	1	1	0	0	0	0	180	3½	NONE	1 / 1	0	BUSSMANS
OC 1188	558-1-01318 FIXTURE, TEST	1	1							NONE	/		

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76523

EQUIPMENT PROFILE

NAME RAY Jones ALC OC DATE 4 MAY 89 MCC MATPCB SHEET 1 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME						
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN	MAX		
OC 4608	STD67017 Fixture	2	2		0	0	0	1825	Replace	0	1	1	1	Previous
OC 0973	PWA15501 TEST STAND	1	1		1	1	1			0	1	1	0	
OC 0897	TEST STAND	1	1		1	1	1							
OC 0947	PWA15512 Flush Stand	1	1	1	1	1	1			0	1	1	0	
OC 4788	STD62542 TEST Cover	1	1	1	1	1	1			0	1	1	0	
OC 4788	STD62543 Adapter	1	1	1	1	1	1			0	1	1	0	
OC 4788	STD65385 Adapter	1	1	1	1	1	1			0	1	1	0	
OC 4788	STD65386 Adapter	1	1		1	1	1			0	1	1	0	
OC 4788	STD62496 Adapter, Inlet	1	1		1	1	1			0	1	1	0	
OC 4788	STD61431 Filter	1	1		1	1	1			0	1	1	0	
OC 4788	STD67003 Fixture	1	1		1	1	1			0	1	1	0	
OC 4788	STD62531 Adapter	1	1	1	0	0	0	182	Replace	0	1	1	0	Previous

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EQUIPMENT PROFILE

NAME RAY Jones ALC OC DATE 4 MAY 89 MCC MAT Pc B SHEET 3 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 4788	STD65263 Adapter	1	1		0	0	0	1825	Rarely	0	1 / 1	0	Assessment
OC 1175	PD680	1	1					30	4	0	/	0	
OC 4947	MODEL CT-60-S DEGREASER	1	1					30	4	0	1 / 1	0	
OC 0229	MODEL 37000 Penetrant Booth	1	1					30	4	0	1 / 1	0	
OC 0229	128 Penetrant Line	1	1					30	4	0	1 / 1	0	
OC 6025	MODEL G610M Magnetic Particle Booth	1	1					30	4	0	1 / 1	0	
OC 5171	OVEN	1	1		0	0	0	60	4	0	1 / 1	0	
OC 4512	~~DEGREASER~~	1	1					30	4	0	/	0	
OC ~~4767~~	MODEL SG-2 ULTRASONIC CLEANER	1	1					30	4	0	/ 10	0	
OC 3069	Rinse, Spray Rinse	1	1					30	4	0	1 / 10	0	
OC 03069	OVEN	1	1							0	/ 20	0	
OC 3020	ALKALINE TANK	1	1					30	4	0	1 / 20	0	

EQUIPMENT PROFILE

NAME RAY JONES ALC OC DATE 4 MAY 89 MCC MATPCS SHEET 4 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME			MIN	MAX		
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR					
OC 3021	ALKALINE TANK	1	1		0	0	0	30	4		1	20		
OC 3019	HOT WATER TANK	1	1					30	4		1	20		
OC 3023	HOT WATER TANK	1	1					30	4		1	20		
OC 4612	COMACO TYPE I SPRING TESTER	1	1					180	36		1	1		
OC 4608	MSI-250 SPRING TESTER	1	1	1				180	36					
OC 4608	X8036722 STAND, DIAL IND.	1	1	1				180	Replace					
OC 3026	ALKALINE TANK	1	1		0	0	0	30	4		1	1		

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EQUIPMENT PROFILE

NAME RAY JONES ALC OC DATE 1 MAY 89 MCC MATRIX SHEET 3 OF 6

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME						
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTOF	MTTR		MIN	MAX		
OC 4600	PWA8575 LAP	1	1	0	0	0	ϕ	1825	Replace	ϕ	1	1	ϕ	Kilgas
OC 1038	PWA15708A Test Stand	1	1								1			
OC 4780	PWA16666 Plug	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16667 Fixture	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16669 Locator	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16670	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16671 Cutter	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16673 Jig	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16675 Drift	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16677 Squeezer	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	PWA16672 Cutter	1	1				ϕ			ϕ	1	1	ϕ	
OC 4705	70CD76 Fixture	1	1	0	0	0	ϕ	1825	Replace	ϕ	1	1	ϕ	Kilgas

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EQUIPMENT PROFILE

NAME Ray Jones ALC OC DATE 1 MAY 89 MCC MATRCB SHEET 6 OF 6

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME			MIN / MAX			
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR					
NOT USE	SLING	1	1											
OC 6560	ALKALINE Permaganate VAT, Reservior	1	1	0	0	0	ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3338	ALKALINE Permaganate VAT, Cleaning	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3348	ALKALINE Permaganate VAT, Cleaning	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3346	ALKALINE Permaganate VAT, Cleaning	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 6561	ALKALINE VAT, Reservior	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3351	ALKALINE VAT, Cleaning	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3350	ALKALINE VAT, Cleaning	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3349	ALKALINE VAT, Cleaning	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 2848	PD680 Flush Tank	1	1				ϕ	30	4	ϕ	1	1	ϕ	Burroughs
OC 3125	Oven	1	1				ϕ	365	36	ϕ	1	1	ϕ	Burroughs
OC 4600	Drill Machine	1	1	0	0	0	ϕ	365	8	ϕ	1	1	ϕ	Burroughs

EQUIPMENT PROFILE

NAME Ray Jones ALC OC DATE 11 MAY '89 MCC MAT-AB SHEET 1 OF 1

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3rd	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER MCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 0229	128 Line, Fluorescent Penetrant	1	1		0	0	10	40	4	0	1 / 1	0	Manuals
OC 0229	Model 37000 Booth, Fluorescent Penetrant	1	1		/	/	/	30	4	0	1 / 1	0	
OC 6025	Model LG610M Magnetic Particle	1	1		/	/	/	30	4	0	1 / 1	0	
OC 1178	PD680 VAT, Cleaning	3	3		/	/	/	30	4	0	1 / 1	0	
OC 4512	Model CT-60-5 Degreaser	1	1		/	/	/	30	4	0	1 / 1	0	
OC 2846	D-525 U65 Drill Press	1	1		/	/	/	365	Repair	0	1 / 1	0	
OC 4608	MST-250 Spring Tester	1	1		0	0	0	180	36	0	1 / 1	0	Manuals
											/		
											/		
											/		
											/		
											/		
											/		

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EQUIPMENT PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET ___ OF ___ 21

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
OC1178	PD680 CLEANING TANK	1	1		1	1½	4	90	24.0	0	1/2	0	COLLINS
OC4947	VAPOR DEG CLEANING TANK	1	1		1	1½	4	30	48.0	0	1/3	0	COLLINS
OC4602	DEGREASER	1	1		1	1	4	30	48.0	0	1/3	0	COLLINS
OC4278	TEST STAND	2	2	2	1	3	6	30	41	0	1/1	0	CHRISTENSEN
OC4968	TEST STAND	2	2	2	1	3	6	30	40	0	1/1	0	CHRISTENSEN
OC3391	LAPPING MACHINE	1	1	1	1	1	2	8	12	0	1/1	0	—
OC3028	LAPPING MACHINE	1	1	1	1	1	2	8	12	0	1/1	0	—
OC5421	FILTER TESTER	1	1	1	1	1	2	8	12	0	1/1	0	—
OC4132	COLD WATER TANK	1	1	1	1	1	1	2	2	0	1/1	0	—
OC4133	COLD WATER TANK	1	1	1	1	1	1	2	2	0	1/1	0	—

EQUIPMENT PROFILE

NAME _____ ALC OC DATE 62789 RCC (MATPJA) SHEET ___ OF ___ 22

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER ACCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
BEN40	WORK BNCH	1	1	1	NA						1 / 1	NA	OP. PROFILES
BEN41		1	1	1							1 / 1		
BEN42		1	1	1							1 / 1		
BEN43		1	1	1							1 / 1		
BEN44		1	1	1							1 / 1		
BEN45		1	1	1							1 / 1		
BEN47		1	1	1							1 / 1		
BEN49		1	1	1							1 / 1		
BEN50		1	1	1							1 / 1		
BEN51		1	1	1							1 / 1		
BEN53		1	1	1							1 / 1		
BEN55		1	1	1							1 / 1		

EQUIPMENT PROFILE

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NAME _____ ALC OC DATE 62789 RCC MATPLA SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
					PREVENTIVE MAINT.			UNSCHEDULED BREAKDOWN REPAIR TIME					
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN / MAX		
BEN99	WORK BENCH	1	1	1	NA						1 / 1	NA	OP PROFILES

LSC-2009-4B

MANPOWER PROFILE

NAME Linda Doody ALC Tinker DATE June 85 RCC MATRICC SHEET 1 OF 2

SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE: WORK WEEK 1	2	3	WEEKEND 1	2	3	HOLIDAYS 1	2	3	MANPOWER AVAILABLE (HOURS): WORK WEEK 1	2	3	WEEKEND 1	2	3	HOLIDAYS 1	2	3	ALTERNATE SKILL CODE/LEVEL
BP 8255-10	Pneudraulic Work Inspector. Inspects TDR's. Reports findings. overhauls TF41 H.P. Pumps	1 88	1	0	0	0	0	0	0	0	0	428									NONE
		2	1	0	0	0	0	0	0	0	0	434									
		3	1	0	0	0	0	0	0	0	0	428									
		4 88	1	0	0	0	0	0	0	0	0	414									
BP 8255-10	Pneudraulic Mech. overhaul & test TF41 HP pumps	1 88	4									1712			107			0			NONE
		2	4									1739			107			0			
		3	6									2569			107			0			
		4 88	4									1685			107			0			
BP 6905-5	Tool & Parts Attendant Maintains PME equip. disassembles assets	1 88	1									428			0			0			NONE
		2	1									434			0			0			
		3	1									428			0			0			
		4 88	1									414			0			0			
BI 5439-9	NDI FP Inspection MAG Inspection of parts	1 88	2									856			0			0			NONE
		2	2									1168			0			0			
		3	2									856			0			0			
		4 88	2									843			0			0			
BP 5255-9	Pneudraulic Mech. Overhauls pumps + manifolds	1 88	11			4						4709 1712			107						NONE
		2	11			4						4783 1739			107						
		3	11			4						4709 1712			107						
		4 88	17			4						7164 1685			107						

LSC-2(XX)3

MANPOWER PROFILE

NAME Linda Dandy ALC Tinker DATE June 89 RCC MATPCP SHEET 2 OF 2

SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE									MANPOWER AVAILABLE (HOURS)									ALTERNATE SKILL CODE/LEVEL
			WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK			WEEKEND			HOLIDAYS			
			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	
HP 8255-9	Pneudraulic Mech. Overhaul nozzles & fuel pumps	1	11	4	-	-	-	-	-	-	-	4209	1739	-	-	-	-	-	-	-	MAINT
		2	11	4	-	-	-	-	-	-	-	4383	1739	-	-	-	-	-	-	-	
		3	12	3	-	-	-	-	-	-	-	5138	1264	-	-	-	-	-	-	-	
		4	12	3	-	-	-	-	-	-	-	5057	1264	-	-	-	-	-	-	-	
HP 5427-7	Sandblaster Operates sandblasting [illegible] vapor hone vapor blast.	1	0	1								0	428								MAINT
		2	0	1								0	434								
		3	1	0								428									
		4	1	0								414									
HP 5704-5	Forklift Operator Maintain & delivers chemicals. Operates forklift for transport of material	1	2									856									MAINT
		2	2									869									
		3	2									856									
		4	2									843									
DP 8255 9	Pneud Mech test various end items	1	10	10								4281	428		107						MAINT
		2	10	10								4348	4348		107						
		3	10	10								4281	4281		107						
		4	10	10								4214	4214		107						
		1																			
		2																			
		3																			
		4																			

WORKLOAD PROFILE Scheduled

NAME TOTTEN ALC _____ DATE _____ RCC MTPCB 88-1-88-4 SHEET 1 OF 1

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER 1	2	3	4	NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
PCN (MTPC9T) NSN 38644A P/N	J79 15-17	CBEM19 CBEM20	4	Ø	97	59	261	151		44	1.4
PCN (MTPC9E) NSN 96515A P/N	TF30 P100	CBEY06 CBEY07	11		21	17	17	10		5	16.5
PCN (MTPC9E) NSN 96523A P/N	TF30 P100	CBEY08 CBEY09	11		10	14	15	5		5	15.7
PCN (MTPC9E) NSN 96555A P/N	TF30 7-9	CBEY16 CBEY17	11		11	6	6	14		5	16.5
PCN (MTPC9T) NSN 97150A P/N	TF30 ALL	CBE404 CBE4T4	11		26	34	43	60		10	23.6
PCN (MTPC9T) NSN 98021A P/N	TF33 35	CBE C05 CTEC05	11		41	30	42	25		10	10.6
PCN (MTPC9E) NSN 98202A P/N	TF41 A1	CBEZ01	11		18	15	26	20		6	10.3
PCN (MTPC9T) NSN 50135A P/N	TF33 J57 ALL	CBE402 CBE4T2	11		0	0	0	0		15	.3
PCN (MTPC9T) NSN 50138A P/N	TF33 J57 ALL	CBE402 CBE4T2	11		0	0	0	0		15	.5
PCN (MTPC9T) NSN 50136A P/N	TF33 J57 ALL	CBE403 CBE4T3	11		192	384	336	530		90	.5
PCN (MTPC9T) NSN 98031A P/N	TF33 7	CBEC06 CTEC06	11		192	384	336	530		90	1.0
PCN NSN P/N											
PCN NSN P/N											

LSC-200968

WORKLOAD PROFILE Scheduled

NAME TOTTEN ALC OCALC DATE 1 MAY 89 RCC MIPC B 88-1-88-4 SHEET 1 OF 2

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER 1	2	3	4	NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
PCN NSN P/N 49802A	J57 ALL	CBE401 CBE4T1	4	Ø	148	161	137	159		26	22.7
PCN NSN P/N 49806A	J57 ALL	CBE401 CBE4T1	11		166	115	163	175		26	22.7
PCN NSN P/N 49808A	J57 ALL	CBE401 CBE4T1	11		81	71	100	91		17	22.7
PCN NSN P/N 49810A	J57 ALL	CBE401 CBE4T1	11		95	107	69	83		17	22.7
PCN NSN P/N 98034A	TF0033 009	CBEC04 CTEC04	11		60	58	40	46		10	18.6
PCN NSN P/N 98042A	TF33-7	CBEC04 CTEC04	11		81	105	63	46		15	19.4
PCN NSN P/N 98043A	TF33-7	CBEC04 CTEC04	11		87	81	77	54		13	19.4
PCN NSN P/N 98057A	TF0033 009	CBEC04 CTEC04	11		52	50	40	42		8	18.7
PCN NSN P/N 50134A	TF30 103,7,9	CBEC04 CTEC04	11		37	43	108	90		18	10.7
PCN NSN P/N 98206A	TF41A1	CBEZ02 CBEZ94	11		27	25	42	45		6	42.0
PCN NSN P/N 50067A	J-19-15/ 17EG	CBEM29 CBEM30 CBEM51	11		1100	1035	870	730		170	2.2
PCN NSN P/N 38685A	J79+15 +17	CBEM13 CBEM14	11		92	98	76	118		19	16.6
PCN NSN P/N 38690A	J-19 +15	CBEM07 CBEM08	11		32	40	21	15		7	17.7

LSC-200968

WORKLOAD PRO[illegible]LE (Scheduling)

NAME TOTTEN ALC OCALC DATE 1 MAY 89 RCC MTPCB 88-1-88-4 SHEET 2 OF 2

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER 1	2	3	4	NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
PCN 38691A NSN P/N	J79 +17	CBEM10 CBEM11 CBEM12	4	Ø	47	57	66	110		18	16.7
PCN 97178A NSN P/N	[redacted] 1929 4359	CBE405 CBE475	11	∫	25	18	24	10		5	9.8
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											

LSC-200968

ENVELO
(For Internal Use, Not a Model Input)

Sample

1 SHOP

ALC OC NCC MAT PCB EQUIPMENT CODE UC-1178 (PD68C)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 36.113

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCII NSN P/N 92207	.485	638	1	2	
PCII NSN P/N 98206	.895	1178	1	1	
PCII NSN P/N 3[illegible]84	.319	420	1	5	
PCII NSN P/N 96515	.335	441	1	5	
PCII NSN P/N 96553	1.86	2448		5	
PCII NSN P/N 96523	1.052	1384		5	
PCII NSN P/N 97150	.561	738		5	
PCII NSN P/N 97178	.481	633		5	
PCII NSN P/N 98021	.481	633		5	
PCII NSN P/N 38625	.565	744		6	
PCII NSN P/N 38690	.908	1195		5	
PCII NSN P/N 3[illegible]91	.908	1195	1	5	

ENV[illegible]OP
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ALC OC RCC MATSB EQUIPMENT CODE OC-1178
PDGC TOTAL VOLUME OF EQUIPMENT IN CU. FT. 36 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37	1	20	
PCN NSN P/N 50067	.05	66	1	20	
PCN NSN P/N 50135	.00076	1	1	48	MIN. VALUE
PCN NSN P/N 50138	.00076	1	1	48	
PCN NSN P/N 50136	.00076	1	1	48	
PCN NSN P/N 98031	.00076	1	1	48	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENVELOP
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ALC OC RCC WATER EQUIPMENT CODE OC 3019 (10" WL)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5493

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37	1	30	
PCN NSN P/N ~~50064~~	"	—	~~1~~	~~30~~	
PCN NSN P/N 5013[illegible]	.00076	1	48	192	
PCN NSN P/N [illegible]136	.00076	1	48	192	
PCN NSN P/N 5013[illegible]	.00076	1	48	192	
PCN NSN P/N 9503[illegible]	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

ENVELO

(For Internal Use, Not a Model Input)

ALC OC RCC MAT PCB EQUIPMENT CODE OC 3020 (ALKaline)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCII NSN P/N 96523	1.052	1364	1	20	
PCII NSN P/N 38644	.028	37	1	30	
PCII NSN P/N 50067	.05	66	1	30	
PCII NSN P/N 50135	.00076	1	48	192	
PCII NSN P/N 0136	.00076	1	48	192	
PCII NSN P/N 0135	.00076	1	48	192	
PCII NSN P/N [illegible]	.00076	1	48	192	
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					

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ENVELO

(For Internal Use, Not a Model Input)

~~Sentry~~ / 1
SHOP
5

ALC 8C RCC MAT PCB EQUIPMENT CODE CC-30.01 (ALKALINE)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5 FT³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCII NSN P/N 96523	1.052	1384	1	20	
PCII NSN P/N 50004	.028	37	1	30	
PCII NSN P/N 50007	.050	608	1	30	
PCII NSN P/N 50[illegible]	.00076	1	48	192	
PCII NSN P/N 50136	.00076	1	48	192	
PCII NSN P/N 50138	.00076	1	48	192	
PCII NSN P/N 78031	.00076	1	48	192	
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					

LSC-20106A

ENVELO

(For Internal Use, Not a Model Input)

Scrub
SHOP
-6

ALC OC RCC MAT PCH EQUIPMENT CODE OC-3022 (PC MANUFACTURE)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5 FT3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCH NSN P/N 28644	.028	1384	1	30	
PCH NSN P/N 50067	.05	658	1	30	
PCH NSN P/N 59135	.00076	1	48	192	
PCH NSN P/N 136	.00076	1	48	192	
PCH NSN P/N 138	.00076	1	48	192	
PCH NSN P/N 15031	.00076	1	48	192	
PCH NSN P/N					
PCH NSN P/N					
PCH NSN P/N					
PCH NSN P/N					
PCH NSN P/N					
PCH NSN P/N					

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ENVELOP

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ALC OC RCC MATRL EQUIPMENT CODE OC 3022 (SET WITH)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5ft3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1384	1	30	
PCN NSN P/N 50067	.105	658	1	30	
PCN NSN P/N 5035	.00076	1	48	192	
PCN NSN P/N 5036	.00076	1	48	192	
PCN NSN P/N 5038	.00076	1	48	192	
PCN NSN P/N 98031	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENV[illegible]OP
(For Internal Use, Not a Model Input)

8

ALC OC RCC MATRCS EQUIPMENT CODE OC 3024 (Permangate

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5 FT3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1384	1	30	
PCN NSN P/N 50067	.105	658	1	30	
PCN NSN P/N 50135	.00076	1	48	192	
PCN NSN P/N 50138	.00076	1	48	192	
PCN NSN P/N 50136	.00076	1	48	192	
PCN NSN P/N 98031	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOPE
(For Internal Use, Not a Model Input)

9

ALC OC RCC WATER EQUIPMENT CODE OC3330 (REMINGTON)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 ft3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1	1	40	
PCN NSN P/N 50067	.05	2	1	40	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOPE
(For Internal Use, Not a Model Input)

ALC OC RCC MATR.B EQUIPMENT CODE OC 3371 (PERMANENT)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 ft-3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1	1	40	
PCN NSN P/N 50067	11 .05	2	1	40	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010GA

ENVELOP
(For Internal Use, No. a Model Input)

ALC OC RCC MATE 2 EQUIPMENT CODE OC 3332 (Terminal a/c)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 ft 3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 35644	.078	1	1	40	
PCN NSN P/N 35667	.05	2	1	40	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOP

(For Internal Use, Not a Model Input)

12

ALC OC RCC MATSCB EQUIPMENT CODE OC3333 ALKALINE

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 ft3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1		40	
PCN NSN P/N 50057	.05	2	1	40	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOP

(For Internal Use, Not a Model Input)

13

ALC OC RCC MHTPCB EQUIPMENT CODE C3337 (CONTAINER)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72.93

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1	1	40	
PCN NSN P/N 50067	.05	2	1	40	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOP
(For Internal Use, Not a Model Input)

14

ALC OC RCC MATRIX EQUIPMENT CODE OC 3338 (PERMANENCE)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 ft3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49602	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1	1	2	
PCN NSN P/N 49808	2.48	1	1	2	
PCN NSN P/N [illegible]10	2.48	1		2	
PCN NSN P/N [illegible]	2.48	1		2	
PCN NSN P/N ~~98032~~		1		2	
PCN NSN P/N 98043	2.48	1		2	
PCN NSN P/N 98057	2.48	1		2	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOP
(For Internal Use, Not a Model Input)

15

ALC OC RCC 11.97 EQUIPMENT CODE OC 3346 (Terminator)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49802	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1	1	2	
PCN NSN P/N 49808	2.48	1	1	2	
PCN NSN P/N [illegible]	2.48	1		2	
PCN NSN P/N [illegible]		1		2	
PCN NSN P/N [illegible]	2.48	1		2	
PCN NSN P/N [illegible]	2.48	1		2	
PCN NSN P/N [illegible]	2.48	1		2	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOPE

(For Internal Use, Not a Model Input)

16

ALC OC RCC MATCOM EQUIPMENT CODE OC3347 (ALKALINE)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1	1	40	
PCN NSN P/N 50067	.05	2	1	40	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010GA

ENVELOP

(For Internal Use, Not a Model Input)

17

ALC OC RCC PATRIOT EQUIPMENT CODE OC 3348 (PORTABLE)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49802	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1		2	
PCN NSN P/N 49808	2.48	1		2	
PCN NSN P/N 49810	2.48	1			
PCN NSN P/N 98034	2.48	1			
PCN NSN P/N ~~98032~~					
PCN NSN P/N 98043	2.48	1			
PCN NSN P/N 98057	2.48	1			
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

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ENVELOP

(For Internal Use, Not a Model Input)

18

ALC OC RCC DHTPCB EQUIPMENT CODE OC3349 (Cableline)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49802	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1	1	2	
PCN NSN P/N 49808	2.48	1	1	2	
PCN NSN P/N 49810	2.48	1	1	2	
PCN NSN P/N 98032					
PCN NSN P/N 98034	2.48	1	1	2	
PCN NSN P/N 98045	2.48			2	
PCN NSN P/N 98057	2.48				
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010GA

ENVELOP
(For Internal Use, Not a Model Input)

19

ALC OC RCC MATRB EQUIPMENT CODE OC 3350 (Bare Tube Line)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49802	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1	1	2	
PCN NSN P/N 49808	2.48	1	1	2	
PCN NSN P/N 49810	2.48				
PCN NSN P/N ~~98032~~					
PCN NSN P/N 98034	2.48				
PCN NSN P/N 98043	2.48				
PCN NSN P/N 98057	2.48				
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENVELOP
(For Internal Use, Not a Model Input)

20

ALC OC RCC MAINBASE EQUIPMENT CODE OC3351 (illegible)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49802	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1	1	2	
PCN NSN P/N 49808	2.48	1	1	2	
PCN NSN P/N 49810	2.48	1	1	2	
PCN NSN P/N 98[illegible]					
PCN NSN P/N 98034	2.48	1	1	2	
PCN NSN P/N 98043	2.48	1	1	2	
PCN NSN P/N 9805[illegible]	2.48	1	1	2	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010KA

ENVELOP

(For Internal Use, Not a Model Input)

ALC DC RCC 2M Pad EQUIPMENT CODE DC 4132 Cold WATER

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 3.5 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37		20ea	
PCN NSN P/N 50064	.055	66	1	20ea	
PCN NSN P/N 50135	.00076	1	48	192	
PCN NSN P/N 50138	.00076	1	48	192	
PCN NSN P/N 50136	.00076	1	48	192	
PCN NSN P/N 98031	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENVELOP
(For Internal Use, Not a Model Input)

22

ALC OC RCC WPTCB EQUIPMENT CODE OC 4133 (Cold Water)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 3.5 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37	1	200	
PCN NSN P/N 50064	X	—	—	—	
PCN NSN P/N 50135	.00076	1	48	192	
PCN NSN P/N 50138	.00076	1	48	192	
PCN NSN P/N 50136	.00076	1	48	192	
PCN NSN P/N 98731	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENVELOP
(For Internal Use, No. a Model Input)

ALC OC RCC 220716 EQUIPMENT CODE OC 4134 (GUIDANCE)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 3.5 ft3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37	1	20	
PCN NSN P/N ~~50064~~	.00076	1	1	20	
PCN NSN P/N 35	.00076	1	48	192	
PCN NSN P/N 5038	.00076	1	48	192	
PCN NSN P/N 5036	.00076	1	48	192	
PCN NSN P/N 98031	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENVELOP
(For Internal Use, No. a Model Input)

24

ALC _____ RCC _____ EQUIPMENT CODE 02 4137 (Truck)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 3.5 FT3

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	1		20	
PCN NSN P/N 50067	.05	2		20	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENVELO

(For Internal Use, Not a Model Input)

ALC OC RCC MAT PCB EQUIPMENT CODE OC 4137 (OL 7[illegible])

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 3.5[illegible]

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCII NSN P/N 96523	1.052	38	1	20	
PCII NSN P/N 38644	.028	1	1	20	
PCII NSN P/N 50[illegible]1	.05	2	1	20	
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					
PCII NSN P/N					

LSC-20106A

ENVELOP
(For Internal Use, Not a Model Input)

26

ALC OC RCC MATER B EQUIPMENT CODE OC 4140 HOT WATER

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 31.5 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37	1	20	
PCN NSN P/N 50067	.05	66	1	20	
PCN NSN P/N 50135	.00076	1	48	192	
PCN NSN P/N [illegible]	.00076	1	48	192	
PCN NSN P/N [illegible]	.00076	1	48	192	
PCN NSN P/N 78031	.00076	1	48	192	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010GA

ENVELO

(For Internal Use, Not a Model Input)

ALC OC RCC MAT PCB EQUIPMENT CODE OC - 4947

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 15.13

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCII IISH P/N 39594	.908	1194	1	1	
PCII IISH P/N 38591	.908	1194	1	2	
PCII IISH P/N 38585	.565	743	1	2	
PCII IISH P/N 96134	.319	420	1	2	
PCII IISH P/N 96515	.335	441	1	2	
PCII IISH P/N 96533	1.052	1384		2	
PCII IISH P/N 96555	1.86	2435		2	
PCII IISH P/N 9750	.561	738		2	
PCII IISH P/N 72	.481	633		2	
PCII IISH P/N 98021	.481	633	1		
PCII IISH P/N 97206	.895	1178		1	
PCII IISH P/N					

LSC-20106A

ENV OP
(For Internal Use, not a Model Input)

28

ALC OC RCC MATCR EQUIPMENT CODE OC 4947 dispenser

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 75 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38644	.028	37	1	40	
PCN NSN P/N 50067	.05	66	1	40	
PCN NSN P/N 50135	.00076	1	1	96	
PCN NSN P/N 50138	.00076	1	1	96	
PCN NSN P/N 50136	.00076	1	1	96	
PCN NSN P/N 98031	.00076	1	1	96	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENV OP

(For Internal Use, not a Model Input)

NDI 29

ALC OC RCC MATCB EQUIPMENT CODE OC 6025 (Mag.)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 10.47 ft³

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38685	.565	11	1	5	
PCN NSN P/N 38690	.908	18	1	5	
PCN NSN P/N 38691	.908	18	1	5	
PCN NSN P/N 50067	.05	1	1	60	Visual
PCN NSN P/N 50134	.319	6	1	5	
PCN NSN P/N 96515	.335	7	1	5	
PCN NSN P/N 96523	.335	7	1	5	
PCN NSN P/N 96555	1.86	37	1	5	
PCN NSN P/N 98202	.485	10	1	5	
PCN NSN P/N 98206	.895	18	1	5	
PCN NSN P/N					
PCN NSN P/N					

ENV[illegible]OP
(For Internal Use, not a Model Input)

NOT 30

ALC QL RCC MHTPCB EQUIPMENT CODE QL 0229 (3 Dr.)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 13.23

1 of 2

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38685	.565	11	1	(suppliers) 60	
PCN NSN P/N 38690	.908	18	1	60	
PCN NSN P/N 38691	.908	18	1	(60)	
PCN NSN P/N 49802	2.48	~~50~~	1	2	
PCN NSN P/N 49806	2.48	50	1	2	
PCN NSN P/N 49808	2.48	50	1	2	
PCN NSN P/N 49810	2.48	50	1	2	
PCN NSN P/N 50067	.05	1	1	60	
PCN NSN P/N 98042	2.48	50	1	2	
PCN NSN P/N 98043	2.48	50	1	2	
PCN NSN P/N 98057	2.48	50	1	2	
PCN NSN P/N [illegible]	.[illegible]	18	1	[illegible]	

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ENV OP
(For Internal Use, not a Model Input)

31

ALC OC RCC MATRCB EQUIPMENT CODE 00029

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 2 of 2

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 50134	.319	6	1	6	
PCN NSN P/N 96523	1,052	21	1	6	
PCN NSN P/N 98034	2.48	50	1	2	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010KA

ENV[illegible]OP
(For Internal Use, Not a Model Input)

ALC OC-ALC RCC MATCB EQUIPMENT CODE OC 3338, 3748, 3346, 3751, 3350, 3349

TOTAL VOLUME OF EQUIPMENT IN CU. FT.

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN [redacted] NSN [redacted] P/N 98057A			1	2	POTASSIUM CHROMATE AND SODIUM HYDROXIDE TANKS USED IN CLEANING MANIFOLDS
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

ENV[illegible]OP
(For Internal Use, Not a Model Input)

ALC OC-ALC RCC MATCB EQUIPMENT CODE OC 3338, 3348, 3346, 3351, 3350, 3349

TOTAL VOLUME OF EQUIPMENT IN CU. FT.

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN [redacted] NSN 98043M P/N [redacted]			1	2	POTASSIUM CHROMATE AND SODIUM HYDROXIDE TANKS USED IN CLEANING MANIFOLDS
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010KA

ENV .OP
(For Internal Use, Not a Model Input)

ALC OC-ALC RCC MATCB EQUIPMENT CODE OC 3338, 3348, 3316, 3351, 3350, 3349

TOTAL VOLUME OF EQUIPMENT IN CU. FT.

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN 98034A NSN ~~4804EA~~ P/N ~~98047M~~ ~~98057A~~			1	2	POTASSIUM HYDROXIDE AND SODIUM HYDROXIDE TANKS USED INCLEANING MANIFOLDS
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-2010GA

OPERATION PROFILE

NAME E. Toten ALC OC DATE 5/2/89 RCC MAT PCB SHEET 1 OF 6

PCN
WSN 38644A
PIN

WCD CREM19 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24									
1		REC	.70	TRANSIT											uncrate, pw
				SETUP											
				PROCESS	—	—	APO9	1	1.0	2.0	BEN 1	1	1.0	2.0	
10		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.25	BEN 1	1	1.0	.25	
15		CLN	1.0	TRANSIT											degrease
				SETUP											
				PROCESS	—	—		1	1.0	.10	OC 4947	1	1.0	.10	
16		PROC	1.0	TRANSIT											cool
				SETUP											
				PROCESS	1.0	.40		1	1.0	.10	OC 4947	1	1.0	.10	

OPERATION PROFILE

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

PCN
NSN
PN _____ WCD CBEM19 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
17	MAT PCB	CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	.50	OC 4137	1	1.0	.50	
18		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	OC 4561	1	1.0	.10	
19		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	OC 1174	1	1.0	.10	
20		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	BEN 1	1	1.0	.10	
30		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.01	OC 4602	1	1.0	.01	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ NCC _____ SHEET 3 OF 6

PCN
NSN
P/N _____ WCD CBEM19 ✓ WCD DATE _____

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
40	MAT PCB	INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	AP09	1	1.0	.01	Ben 1	1	1.0	.01	
50		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.01	Ben 1	1	1.0	.01	
150		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.01	Ben 1	1	1.0	.01	
160	MAT PCM	PRO	.70	[illegible]											
				[illegible]											
				PROCESS	1.0	1.0									
170	MAT PCB	CLN	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	AP09	1	1.0	.10	OC 4137	1	1.0	.10	

OPERATION PRC LE

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

PCN
NSN
PIN _____ WCD CBEM 19 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
180	MAT PIW	PROC	1.0	[illegible]											
				SETUP											
				PROCESS	1.0	1.0									
190	MAT PCB	PROC	1.0	[illegible]											
				SETUP											
				PROCESS	-	-	AP09	1	1.0	.10	OC 4602	1	1.0	.10	
200	MAT PCM	PROC	.01	[illegible]											
				SETUP											
				PROCESS	1.0	.50									
210	MAT PIW	NDI	1.0	[illegible]											
				SETUP											
				PROCESS	1.0	.30									
220		INSP	.001	[illegible]											
				[illegible]											
				PROCESS	1	.10									

OPERATION PROFILE

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

PCN
NSN
PN _____ WCD CBEM19 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
230	MAT PIW	REP	.001	[redacted]											
				[redacted]											
				PROCESS	1.0	.10									
240		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	.10									
245	MAT PCB	INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	.01	BEN 1	1	1.0	.01	
251	MAT PCB	TEST	1.0	[redacted]											This is a backshop test area
				[redacted]											
				PROCESS	1.0	21.0									
260		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	.20	BEN 1	1	1.0	.20	

DOME

FLOW PROCESS CHART

SUBJECT J79-15/17 MAIN FUEL NOZZLE, REGULAR CHECK/TEST DATE 5/2/89

ITEM CODE
PCN [X]
NSN [ ]
P/N [ ] 38644 A

WCD CBEM19 WCD DATE 88180

J79 JET ENGINE MAIN FUEL NOZZLE, REGULAR
SOURCE: DAVID MYRICK

(CHART BEGINS) 1

(CHART ENDS) 295

PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
1		●▷D□▽	RECEIVE NOZZLES IN BLDG 3123 FM SUPPLY			○▷D□▽	
5		○▶D□▽	MOVE NOZZLES FROM BLDG 3123 TO 3041 SHOP			○▷D□▽	
10	10	●▷D□▽	RECEIVE NOZZLES IN SHOP SEPARATE TRAY.			○▷D□▽	
15	15	●▷D□▽	CLEAN NOZZLES IN DEGREASER			○▷D□▽	
16		○▷▶□▽	WAIT FOR NOZZLES TO COOL AFTER DEGREASING			○▷D□▽	
17		●▷D□▽	CLEAN NOZZLES IN FREON TANK			○▷D□▽	
18		●▷D□▽	PURGE NOZ. HOUSING OF FUEL W/N2 UNDER PRESS			○▷D□▽	
19		●▷D□▽	CLEAN NOZZLE W/ GLASS BEAD SAND BLASTER			○▷D□▽	
20	20	○▷D■▽	INSPECT NOZZLE SHROUD COVER, ETC.			○▷D□▽	
30	30	○▷D■▽	INSPECT NOZZLE ALIGNMENT			○▷D□▽	
40	40	○▷D■▽	MEASURE AIR GAP BETWEEN SHROUD & PRIMARY NOZZLE			○▷D□▽	
50	50	○▷D■▽	VISUALLY INSPECT HOUSING SUB ASSY			○▷D□▽	
150	150	○▷D■▽	VISUALLY INSPECT AROUND CAST INLET FOR GALLING			○▷D□▽	
B/S 160	160	●▷D□▽	REMOVE SHROUDS OR END NOZZLES			○▷D□▽	
170	170	●▷D□▽	CLEAN FUEL FLOW NOZZLES IN FREON			○▷D□▽	
B/S 180	180	●▷D□▽	WELD SHROUDS			○▷D□▽	
190	190	○▷D■▽	INSPECT SHROUD W/AIR GAUGE			○▷D□▽	
B/S 200	200	●▷D□▽	GRIND BURR EXPOSED WELD IF REQ.			○▷D□▽	
B/S 210	210	○▷D■▽	VISUALLY INSPECT WELDS			○▷D□▽	
B/S 220	220	○▷D■▽	PERFORM DYE PEN. INSPECTION IF REQ.			○▷D□▽	
B/S 230	230	●▷D□▽	REPAIR CRACKS AS NECESSARY.			○▷D□▽	
B/S 240	240	●▷D□▽	CLEAN NOZZLE ASY AFTER WELDING			○▷D□▽	
245		○▷D■▽	INSPECT NOZZLE ALIGNMENT			○▷D□▽	
250	250	○▶D□▽	MOVE NOZZLES TO BLDG 3108 FOR TEST			○▷D□▽	
251		●▷D□▽	PERFORM FLOW TEST. SAFETY WIRE			○▷D□▽	
[redacted]	[redacted]	[redacted]	[redacted]			○▷D□▽	
260	260	●▷D□▽	ARCHIVE FLOW TEST. SEPARATE NOZZLES BY DISP.			○▷D□▽	
265	265	●▷D□▽	PAINT ORANGE OR YELLOW SPOT ON PART NO.			○▷D□▽	
275	275	●▷D□▽	COMPLETE AFTO 349			○▷D□▽	
280	280	●▷D□▽	PAPERWORK SIGN OFF			○▷D□▽	
290	290	●▷D□▽	PAPERWORK SIGNOFF			○▷D□▽	
295	295	●▷D□▽	PAPERWORK - SELL			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PRO[illegible]LE

NAME _____ ALC OC-ALC DATE 31MA189 NCC MTPCB SHEET 1 OF 1

PCII/ISII PIN 38644A ✓ PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (~~DAYS~~ HRS)
1	8333	8333	0
2	8333	8334	24
3	8334	8334	0
4	8347	8348	24
5	9009	9009	0
6	9009	9009	0
7	9009	9010	24
8	9020	9020	0
9	9020	9023	72
10	9020	9023	72
			27 22

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

LSC-20107A

"OUT" DATES PRO. LE

NAME _____ ALC OC ALC DATE 31 MAY 89 NCC M+F 15 SHEET 1 OF 1

PCN
NSN
P/N 38644A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS A TIME (~~DAYS~~)
1	8334	8334	0
2	8334	8334	0
3	8340	8341	24
4	8349	8350	24
5	9011	9011	0
6	9012	9013	24
7	9012	9013	24
8	9023	9025	48
9	9024	9025	24
10	9031	9031	0

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

LSC-20108A

OPERATION PROFILE

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

PCN
NSN
PIN _____ WCD CBEM19 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
265	MAT PCB	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	APO9	1	1.0	.10	BENI	1	1.0	.10	
299		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.60	BENI	1	1.0	.60	
9999		OUT	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

LSC-700926

OPERATION PROFILE

STA-15/17 REGULAR MAIN NOZZLE
SOURCE: PATRICIA MINUTES ✓

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MATPCB SHEET 1 OF 5

PCN
NSN
PIN 38644A WCD CB6M20 WCD DATE 89180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
1N	MAT PCB	IN DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	100	24									
10	↓	REC	1	~~TRANSIT~~											REMOVE NOZZLES FROM CART. PLACE 5 OF 10 ON BENCH & 1 BOX OF TEST STAND
				~~SETUP~~											
				PROCESS			DP09	1	100	.1	OC4278	1	100	.1	
15	↓	PROC	1	~~TRANSIT~~			↓	↓	↓				↓		WORKED IN BATCH OF 10
				~~SETUP~~											REM CRIMS ONLY SECOND PER NOZZLE.
				PROCESS						.05	OC4278	1		.05	
20	↓	QIS	1	~~TRANSIT~~											TIME IS FOR BATCH OF 10
				~~SETUP~~											
				PROCESS						.2	OC4278	1		.2	
25	↓	INSP	1	~~TRANSIT~~											INSP. CRIMP QUALITY BATCH OF 10
				~~SETUP~~											
				PROCESS			↓	↓		.1	OC4278	1	↓	.1	

LSC-200220

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MATRCB SHEET 2 OF 5

PCN/NSN 38644A WCD CBFM 20 WCD DATE 8/89

PIN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
20	INAT PCB	ASSY	1	~~TRANSIT~~											BATCH OF 10
				~~SETUP~~											REINSTALL ELECTRICAL SPRING AND METAL COVER
				PROCESS			0B09	1	100	.2	OC4278	1	100	.2	
30		LOAD	1	~~TRANSIT~~											NOTE: TIME TESTS INDIVIDUALLY INSTALL IN STAND-
				~~SETUP~~						.2	OC4278	1		.2	TIME IS FOR BATCH OF 10 NOZZLES
				PROCESS											ALL TESTS UP TO LEAK TEST ARE DONE IN SEQUENCE FOR EA. OC
40		TEST	1	~~TRANSIT~~											PRESSURE TEST BATCH 10
				~~SETUP~~											
				PROCESS						.33	OC4278	1		.33	
50		TEST	1	~~TRANSIT~~											BATCH 10 FLOW TESTS
				~~SETUP~~											
				PROCESS						.5	OC4278	1		.5	
60		TEST	1	~~TRANSIT~~											BATCH 10 SPRAY PATTERNATOR TEST
				~~SETUP~~											
				PROCESS						.75	OC4278	1		.75	

LSC-20012C

OPERATION PROFILE

NAME E. TOTTEN ALC BC DATE 5/16/89 RCC MAT PCB SHEET 3 OF 5

(PCN) NSN 38644A P/N WCD CBEM20 WCD DATE 8/89

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
70	MAT PCB	TEST	1	~~TRANSIT~~											SPRAY ANGLE TEST
				~~SETUP~~											
				PROCESS			OP09	1	100	.33	OC4278	1	100	.33	BATCH 10
80	↓	↓	1	~~TRANSIT~~											INSPECT SPRAY QUALITY FOR STREAKS.
				~~SETUP~~											
				PROCESS						.1	OC4278	1		.1	
82			1	~~TRANSIT~~											STATIC PRESSURE (LEAK) TEST
				~~SETUP~~											
				PROCESS						1	OC4252	1		1	
90		↓	1	~~TRANSIT~~											INSTALL IN TEST STAND - "80" CHECK (FLOW DIVIDER METER VALVE)
				~~SETUP~~											
				PROCESS						.33	OC4278	1		.33	
95	↓	MOVE	1	~~TRANSIT~~											REMOVE NOZ. FM TEST STAND INSTALL IN VISE ON BENCH
				~~SETUP~~											
				PROCESS			↓	↓	L	.1	TBEM1	1		.1	

LSC-20020C

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MATFAB SHEET 4 OF 5

PCN
NSN 38644A WCD CBEM 20 WCD DATE 88160
PIN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT FAB	PROC	1	TRANSIT											SAFETY WIRE
				SETUP											(NOT USING IN O/H STEP 250 OF WCD CBEM19) BATCH 10
				PROCESS			0809	1	100	.5	CBEM 1	1	100	.5	
101		PROC	1	TRANSIT											REMOVE FROM VISE. OIC FLUSH W/ 1010 OIL
				SETUP											
				PROCESS						.2	OC#941	1		.2	N1 MIN EA. TO FLUSH X 10 HR.
102		PROC	1	TRANSIT											RECAP INLET & TIP. PLACE IN NOZZLES IN SHIPPING BOX.
				SETUP											
				PROCESS						.1	CBEM 1	1		.1	
120		PN	1	TRANSIT											PAPERWORK CHECKOFF
				SETUP											
				PROCESS						.1	CBEM 1	1		.1	
130		PN	1	TRANSIT											PWORK
				SETUP											
				PROCESS			V	V		.01	CBEM 1	1		.01	

LSC-200926

OPERATION PROFILE

NAME E. Turten ALC OC DATE 5/14/89 RCC MATPCB SHEET 5 OF 5

PCN
NSN 38644A
P/N
WCD CBEM20 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
135	MAT PCB	PW	1	~~TRANSIT~~											PW
				~~SETUP~~											
				PROCESS			OP09	1	100	.05					
140	↓	PW	1	~~TRANSIT~~			↓	↓							PW
				~~SETUP~~											
				PROCESS					100	.02					
150	↓	MOVE	1	TRANSIT			↓	↓	100	.1				~~X~~	ROUTE TO CB 0/4 FOR PAINT SPOT APPLICATION
				~~SETUP~~											
				~~PROCESS~~			↓	↓							
TGT	↓	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	100	24									
				TRANSIT											
				SETUP											
				PROCESS											

LSC 200220

SOURCE PATRICIA NIARRA 15 DONE

FLOW PROCESS CHART

SUBJECT J79-15/17 REGULAR MAN NOZZLE CHECK & TEST DATE 5/12/87

ITEM CODE PCN ☒ NSN ☐ P/N ☐ 38644A

WCD CBEM20 WCD DATE 84180

CHART BEGINS 10

CHART ENDS 150 PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	● ▷ D □ ▽	RECEIVE IN 2103 AT NOZZ STATION			○ ▷ D □ ▽	
15		● ▷ D □ ▽	REMOVE PROTECTIVE CAPS			○ ▷ D □ ▽	
20	81	● ▷ D □ ▽	REMOVE COVER AND BELLEVILLE SPRING			○ ▷ D □ ▽	
25	81	○ ▷ D ■ ▽	INSPECT FOR QUALITY			○ ▷ D □ ▽	
28		● ▷ D □ ▽	REINSTALL BELLEVILLE SPRING AND COVER			○ ▷ D □ ▽	
30	30	● ▷ D □ ▽	INSTALL NOZZLE IN TEST STAND			○ ▷ D □ ▽	
40	40	● ▷ D □ ▽	PERFORM NOZZLE PRESSURE TEST			○ ▷ D □ ▽	
50	50	● ▷ D □ ▽	PERFORM NOZZLE FLOW TEST			○ ▷ D □ ▽	
60	60	● ▷ D □ ▽	PERFORM SPRAY PATTERNATOR TEST			○ ▷ D □ ▽	
70	70	● ▷ D □ ▽	PERFORM SPRAY ANGLE TEST			○ ▷ D □ ▽	
80	80	● ▷ D □ ▽	INSPECT NOZZLE SPRAY QUALITY FOR STREAKS			○ ▷ D □ ▽	
82	82	● ▷ D □ ▽	PERFORM STATIC PRESSURE (LEAK) TEST			○ ▷ D □ ▽	
90	90	● ▷ D □ ▽	INSTALL IN TEST STAND PERFORM "80" TEST			○ ▷ D □ ▽	
95		○ ▶ D □ ▽	REMOVE FROM TEST STAND & MOVE TO VISE			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	INSTALL SAFETY WIRE			○ ▷ D □ ▽	
101	100	● ▷ D □ ▽	REMOVE FROM VISE, OIL FLUSH W/1010 OIL			○ ▷ D □ ▽	
102		● ▷ D □ ▽	RECAP INLET STEM & BOX UP			○ ▷ D □ ▽	
120	120	● ▷ D □ ▽	PAPERWORK			○ ▷ D □ ▽	
130	130	● ▷ D □ ▽	COMPLY WITH MAOI GC-36 FY 13			○ ▷ D □ ▽	
135	135	● ▷ D □ ▽	COMPLY WITH TCTO J58-16-579			○ ▷ D □ ▽	
140	140	● ▷ D □ ▽	FINAL INSPECTION SIGNOFF			○ ▷ D □ ▽	
150	110	○ ▶ D □ ▽	MOVE TO C15 O/H IN 3001 FOR MAINT STOR			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME RANDY W HARRIS ALC OC DATE 5/31/89 RCC HNTPCB SHEET 1 OF 8

PCN
NSN
PIN 38685A WCD CREM13 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAP CR	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		.24									
010	MAP CR	REC	1.0	TRANSIT	—		—	—			—	—			BEN 22 ALT
				SETUP	—		—	—			—	—			
				PROCESS	—		BP09	1	100	.50	BEN 21	1	100	.50	
020	"	OIS	1.0	TRANSIT	—		—	—			—	—			BEN 22 ALT
				SETUP	—		—	—			—	—			
				PROCESS	—		BP09	1		.50	BEN 21	1		.50	
040	"	TEST	1.0	TRANSIT	—		—	—			—	—			IF VALVE TESTED,
				SETUP	—		—	—				—			
				PROCESS	—		BP09	1		.25	BEN 21	1		.25	
045	"	OIS	.75	TRANSIT	—		—	—			—	—			BEN 22 ALT
				SETUP	—		—	—			—	—			
				PROCESS	—		BP09	1		.50	BEN 21	1		.50	

OPERATION PROFILE

NAME RANDY - HARRIS ALC OC DATE 1/31/89 RCC MAIPCB SHEET 2 OF 8

PCN
NSN
PIN 38685A WCD CREMIB WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MATP CB	DIS	1.0	TRANSIT			-	-			-	-			BCN 22 A/T
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.50	[illegible]	1		.50	
060	11	CLN	1.0	TRANSIT			-	-			-	-			WILL USE TO LOAD AND UNLOAD SEMI IN CLEAN
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.08 .25	[illegible] OC4-41	1 1		.25	
070	11	INSP	1.0	TRANSIT			-	-			-	-			BCN 22 A/T
				SETUP							-	-			
				PROCESS			BP09	1		2.0	BCN21	1		2.0	
075	MATP CM	MACH	.10	TRANSIT			-	-			-	-			MOVE PLANES AS NECESSARY TO MOVE FROM TO HAVE TOOLS TO MAINTAIN AREA OR LOAD AS NECESSARY
				SETUP			-	-			-	-			
				PROCESS		24	-	-			-	-			
080	MATP CB	INSP	1.0	TRANSIT			-	-			-	-			INSP DONE IN MATRB BY JOINT PERSONNEL, 2 IN EACH TEAM INVOLVED FOR TIME COVERED HERE FOR ENGINEERING
				SETUP			-	-			-	-			
				PROCESS			BI09	1		1.5	OC0229	1		1.5	

OPERATION ..OFILE

NAME RANDY HARRIS ALC OC DATE 5/31/89 RCC MATPCB SHEET 3 OF 8

PCN
NSN
PIN 38685A WCD CBEM13 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
090	MATP CB	INSP	1.0	TRANSIT	–		–	–			–	–			
				SETUP	–		–	–			–	–			
				PROCESS	–		BI09	1		.15	QC6025	1		.15	
092	11	INSP	1.0	TRANSIT	–		–	–			–	–			
				SETUP	–		–	–			–	–			
				PROCESS	–		BI09	1		.08	QC6025	1		.08	
095	11	INSP	1.0	TRANSIT	–		–	–			–	–			
				SETUP	–		–	–			–	–			
				PROCESS	–		BI09	1		.08	QC6025	1		.08	
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME EARL HARRIS ALC JC DATE 5/31/89 RCC _____ SHEET 4 OF 8

PCN
NSN
PIN 38685A WCD CBEM13 WCD DATE 8823

OPERATION NUMBER	ICC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAIP CB	INSP	.75	TRANSIT											INSP IS DONE ONLY IF VALVE WAS BEEN DISASSEMBLED.
				SETUP											
				PROCESS			BP09	1		.08	HN21	1		.08	BEN 22 ACT
110	11	INSP	1.0	TRANSIT											BEN 22 ACT
				SETUP											
				PROCESS			BP09	1		.17	HN21	1		.17	
120	11	INSP	1.0	TRANSIT											BEN 22 ACT
				SETUP											
				PROCESS			BP09	1		.33	HN21	1		.33	
130	11	INSP	1.0	TRANSIT											USE SPRING TESTER BEN 22 ACT
				SETUP											
				PROCESS			BP09	1		.08	HN21	1		.33	
140	MATP CM	MACH	.25	TRANSIT											WILL SEND FOR ITEM (MAP Q/N 0225210128) TO MACH FOR SPECIAL RING AND REMACHD.
				SETUP											
				PROCESS		.24									

OPERATION PROFILE

NAME KANDY HARRIS ALC QC DATE 5/31/89 RCC MATRCB SHEET 5 OF 8

PCN
NSN
P/N 38685A WCD CREM13 WCD DATE 78236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
160	MATP CB	ASSY	1.0	TRANSIT			-	-			-	-			
				SETUP			-	-			-				
				PROCESS			BP09	1		.25	BEN21	1		.25	
170	"	PROC	1.0	TRANSIT			-	-			-	-			
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.25	VCS135	1		.25	
180	"	ASSY	1.0	TRANSIT			-	-			-	-			INTRA. CREW (ALL INVOLVED) FOR EPOXY
				SETUP			-	-			-	-			
				PROCESS		24	BP09	1		.33	BEN21	1		.33	BEN 22 ALT
185 (150)	"	ASSY	1.0	TRANSIT			-	-			-	-			OP 150 IF WCD OCCURS AT THIS POINT
				SETUP			-	-			-	-			
				PROCESS			BP09	1		2.0	BEN21	1		2.0	BEN 22 ALT
190	"	ASSY	1.0	TRANSIT			-	-			-	-			INSTALL SHAFT BEN 22 ALT
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.17	BEN21	1		.17	

OPERATION PROFILE

NAME RANDY HARRIS ALC X DATE 5/31/89 RCC MATP/CB SHEET 6 OF 8

PCN
NSN
P/N 38685D WCD CBEM13 WCD DATE 8828

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
200	MATP CB	ASSY	1.0	TRANSIT			-	-			-	-			BENCH ACT
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.33	BEN21	1		.33	
210	"	ASSY	1.0	TRANSIT			-	-			-	-			BENCH ACT
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.50	BEN21	1		.50	
220	"	INSP	1.0	TRANSIT			-	-			-	-			BENCH ACT
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.08	BEN21	1		.08	
230	"	ASSY	1.0	TRANSIT			-	-			-	-			BENCH ACT
				SETUP			-	-			-	-			
				PROCESS			BP09	1		.08	BEN21	1		.08	
240		TEST	1.0	TRANSIT			-	-			-	-			* SPECIAL BENCH DESIGNATED FOR THIS TEST
				SETUP			-	-			-	-			
				PROCESS			BP09	1			BEN21	1		.17	

LSC-2(X)92C

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/31/89 RCC MATPCB SHEET 7 OF 8

PCN
NSN
PIN 38685 WCD CBEM13 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
250	MNTP CB	ASSY	.75	TRANSIT			–	–			–	–			
				SETUP			–	–			–	–			
				PROCESS			BP09	1		1.0	BEN21	1		1.0	BEN 22 ACT
260	"	TEST	1.0	TRANSIT			–	–			–	–			SAME COMMENTS AS OP 240
				SETUP			–	–			–	–			
				PROCESS			BP09	1		.25	BEN421	1		.25	
270	"	ASSY	1.0	TRANSIT			–	–			–	–			BEN 22 ACT
				SETUP			–	–			–	–			
				PROCESS			BP09	1		.17	BEN21	1		.17	
280	"	INSP	1.0	TRANSIT			–	–			–	–			MOVE TO BLDG 3108 FOR TEST (SEE WCD CBEM14 FOR MARKING) BEN 22 ACT
				SETUP			–	–			–	–			
				PROCESS			BP09	1		.08	BEN21	1		.08	
290	"	INSP	1.0	TRANSIT			–	–			–	–			MOVE TO BLDG 3108 FOR TEST (SEE WCD CBEM14 FOR MARKING)
				SETUP			–	–			–				
				PROCESS		.24	–	–			–	–			

OPERATION ..OFILE

NAME KANDY HARRIS ALC OC DATE 5/31/89 RCC MATPCB SHEET 8 OF 8

PCN
NSN
PIN 3685A WCD CBEM13 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
300	MATP CB	TEST	1.0	TRANSIT		–	–	–			–	–			
				SETUP		–	–	–			–	–			
				PROCESS		–	BP09	1		.25	BEN21	1		.25	BEN22 ALT
310	"	ASSY	1.0	TRANSIT		–	–	–			–				
				SETUP		–	–	–							BEN22 ALT
				PROCESS		–	BP09	1		.25	BEN21	1		.25	
320	"	PW	1.0	TRANSIT		–	–	–			–	–			IMS 320 & 330 OF WCO
				SETUP		–	–	–			–	–			
				PROCESS		–	BP09	1		.08	BEN21	1		.08	BEN22 ALT
340	"	MOVE	1.0	TRANSIT		–	–	–			–	–			MOVE TO SELLOUT
				SETUP		–	–	–			–	–			
				PROCESS		–	BP09	1		.08	–	–			
9999	"	OUT NOTE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									

FLOW PROCESS CHART

SUBJECT A-B FUEL PUMP DATE 5/31/89

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

WCD CBEM13 WCD DATE 88236

CHART BEGINS 010

CHART ENDS

PREPARED BY R MORRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◇D□▽	RECEIVE PUMP	301	300	●◇D□▽	TEST-CLEARANCE
020	020	●◇D□▽	DIS VALVE ASSY	310	310	●◇D□▽	ASSY-COVERS & PARTS
040	040	●◇D□▽	LEAKAGE TEST IN VALVE	320	320 330	●◇D□▽	PU
045	—	●◇D□▽	DIS VALVE IF NEC	340	340	○◆D□▽	MOVE TO SECT
050	050	●◇D□▽	DIS PUMP			○◇D□▽	
060	060	●◇D□▽	CLEAN PUMP PARTS			○◇D□▽	
070	070	○◇D■▽	INSP PARTS			○◇D□▽	
075	—	○◆◆□▽	MOVE TO-CM AS NECESSARY			○◇D□▽	
080	080	○◇D■▽	F.P. INLET INDUCER			○◇D□▽	
090	090(A,C,D)	○◇D■▽	MAG INSP OF PARTS			○◇D□▽	
092	090(B)	○◇D■▽	"			○◇D□▽	
095	090(E)	○◇D■▽	"			○◇D□▽	
100	100	○◇D■▽	INSP ORIFICE			○◇D□▽	
110	110	○◇D■▽	INSP IMPELLER			○◇D□▽	
120	120	○◇D■▽	INSP DRIVE SHAFT			○◇D□▽	
130	130	○◇D■▽	INSP SPRING			○◇D□▽	
140	140	○◆◆□▽	MOVE TO MACH-CM			○◇D□▽	
160	160	●◇D□▽	ASSY ROTATING PARTS			○◇D□▽	
170	170	●◇D□▽	BALANCE PARTS			○◇D□▽	
180	180	●◇D□▽	ASSY PUMP			○◇D□▽	
185	150	○◇D□▽	ASSY OF PARTS			○◇D□▽	
190	190	●◇D□▽	ASSY ROTATING PARTS			○◇D□▽	
200	200	●◇D□▽	INSTL RETAINERS			○◇D□▽	
210	210	●◇D□▽	INSTALL PARTS			○◇D□▽	
220	220	●◇D□▽	CHECK TORQUE			○◇D□▽	
230	230	●◇D□▽	ASSY CHECK VALVE			○◇D□▽	
240	240	●◇D□▽	TEST-LEAK CHECK			○◇D□▽	
250	250	●◇D□▽	ASSY INLET VALVE			○◇D□▽	
260	260	●◇D□▽	TEST-LEAK CHECK			○◇D□▽	
270	270	●◇D□▽	INSTL INLET VALVE			○◇D□▽	
280	280	○◇D■▽	INSP-TORQUE CHECK			○◇D□▽	
290	290	○◆◆□▽	MOVE TO BLDG 3108			○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

DISASSEMBLY/ASSEMBLY PROFILE

NAME RANDY HARRIS ALC QC DATE 5/31/89 RCC MAI PCB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 38685A NSN P/N	CBEM13	88236	140	185	PCN 38685A NSN P/N 023521028	CMEM04	88301	N (25%)
PCN 38685A NSN P/N	CBEM13	88236	050	180	PCN NSN DRILL RETAINER IN PUMP P/N 12-13430	CBEM13M1	88301	Y
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-20005A

PCN 38685 A

(13) Leakage from the booster reference port shall not exceed 1.4 milliliters per minute.

(14) If inlet valve assembly passes test, mark a letter A on flange as indicated in substep (1)(b) above.

c. Inlet Valve Assembly Disassembly. Disassemble inlet valve assembly as follows:

(1) Remove retaining ring (12). Using 97-321 inlet valve puller (figure 3-3) remove inlet eye and valve seat housing from valve body assembly. Do not remove wear ring (13, figure 3-1) from inlet eye and valve seat housing (14) unless inspection reveals that replacement is necessary. Refer to paragraph 4-2 for replacement procedures. Remove seal ring (15) from housing (14).

WARNING

Springs (40 and 41) exert a combined force of approximately 100 pounds. Restrain piston head (25) when removing screws (26) to prevent physical injury or part damage when removing these parts.

(2) Remove all but 2 diametrically opposite screws (26) and washers (27) with T-1470-E-26 wrench. Install 97-289 valve spring compression fixture (figure 3-4). Compress the assembly and springs (40 and 41, figure 3-1) with an arbor press. Remove the 2 remaining screws (26) and washers (27). Slowly release compression of arbor press and remove the piston rod and head assembly from the valve housing.

(3) Hold piston rod (32) with SF-102-1341-M2 piston rod nut wrench (figure 3-5). Remove locknut (17) and washer (18). Remove seal retainer (16), seal ring (19), diaphragm (20), washer (21), diaphragm spring (22), retainer (23), and spacers (24) from end of piston rod (32). Remove piston head (25) and gasket (28). Remove plug (31) from piston head (25) using SF-102-1341-M1 plug removal puller. Remove Kapseal (29) and seal ring (30) from piston head.

(4) Remove inlet valve piston rod assembly and disassemble. Hold piston rod (32) between contoured wood or Micarta blocks and remove locknut (34), washer (35), piston (33), piston seal (36), seal retainer washer (37), seal ring (38), and seal retainer (39) from piston rod. Remove springs (40 and 41) from valve body (59).

Legend for Figure 3-1

1. Seal
2. Bolt
3. Washer
4. Key ring
5. Insert
6. Valve housing
7. Seal ring
8. Valve
9. Spring
10. Bolt
11. Lock-O-Seal
12. Retaining ring
13. Wear ring
14. Inlet eye and valve seat housing
15. Seal ring
16. Seal retainer
17. Locknut
18. Washer
19. Seal ring
20. Diaphragm
21. Washer
22. Diaphragm spring
23. Retainer
24. Spacer
25. Piston head
26. Screw
27. Washer
28. Piston head gasket
29. Kapseal
30. Seal ring
31. Plug
32. Piston rod
33. Inlet valve piston
34. Locknut
35. Washer
36. Piston seal
37. Seal retainer washer
38. Seal ring
39. Seal retainer
40. Inner spring
41. Outer spring
42. Plug
43. Tee tube
44. Nut
45. Gasket
46. Retainer
47. Bolt
48. Washer
49. Seal ring
50. Belleville spring
51. Filter
52. Gasket
53. Signal flow regulator
54. Gasket
55. Seal ring
56. Plug
57. Key ring
58. Insert
59. Valve body
60. Seal ring
61. Diffuser
62. Inducer
63. Locknut
64. Washer
65. Pin
66. Impeller
67. Impeller shim
68. Belleville spring
69. Fuel seal disc
70. Bearing housing
71. Bolt
72. Washer
73. Stop retainer
74. Clamp
75. Nut
76. Spray nozzle
77. Seal ring
78. Seal ring
79. Retaining ring
80. Oil seal disc
81. Seal ring
82. Ball bearing
83. Bearing retainer ring
84. Spacer
85. Belleville spring
86. Ring
87. Spring retainer
88. Ball bearing
89. Drive shaft
90. Valve seat
91. Seal ring
92. Fuel seal retainer
93. Screw
94. Diaphragm assembly
95. Spring
96. Oil seal retainer
97. Screw
98. Diaphragm assembly
99. Key ring
100. Insert
101. Key ring
102. Insert
103. Pin
104. Backup washer stop
105. Body wear ring
106. Body
107. Nameplate
108. Screw
109. Dated decal

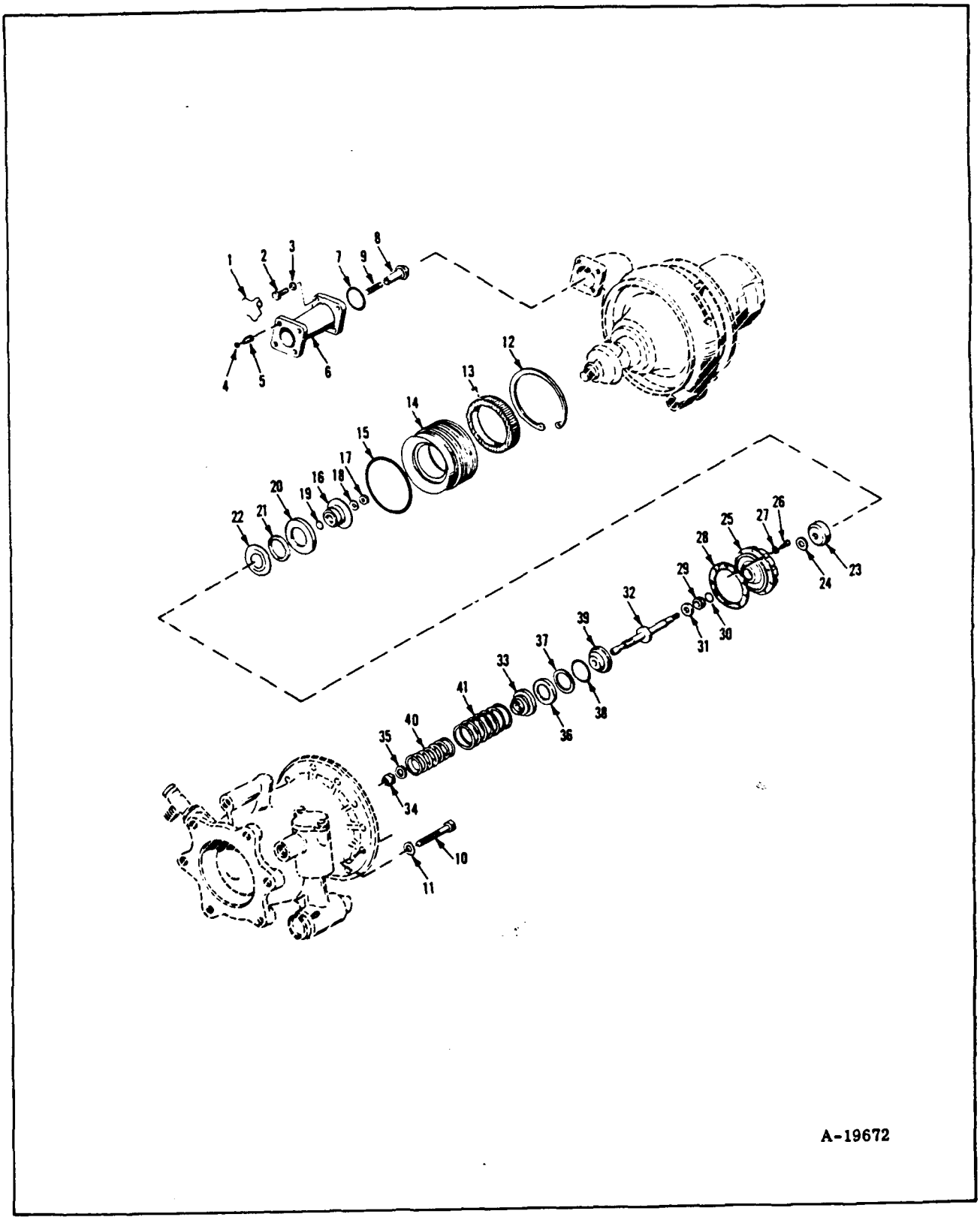

Figure 3-1. Exploded View of Afterburner Fuel Pump Assembly (Sheet 1 of 3)

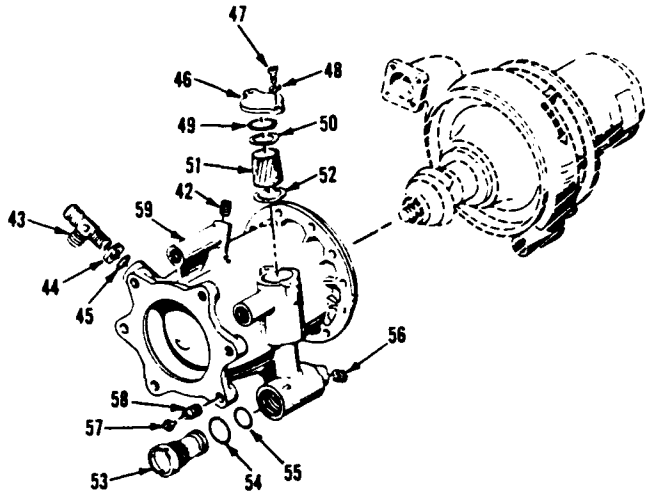

Figure 3-1. Exploded View of Afterburner Fuel Pump Assembly (Sheet 2 of 3)

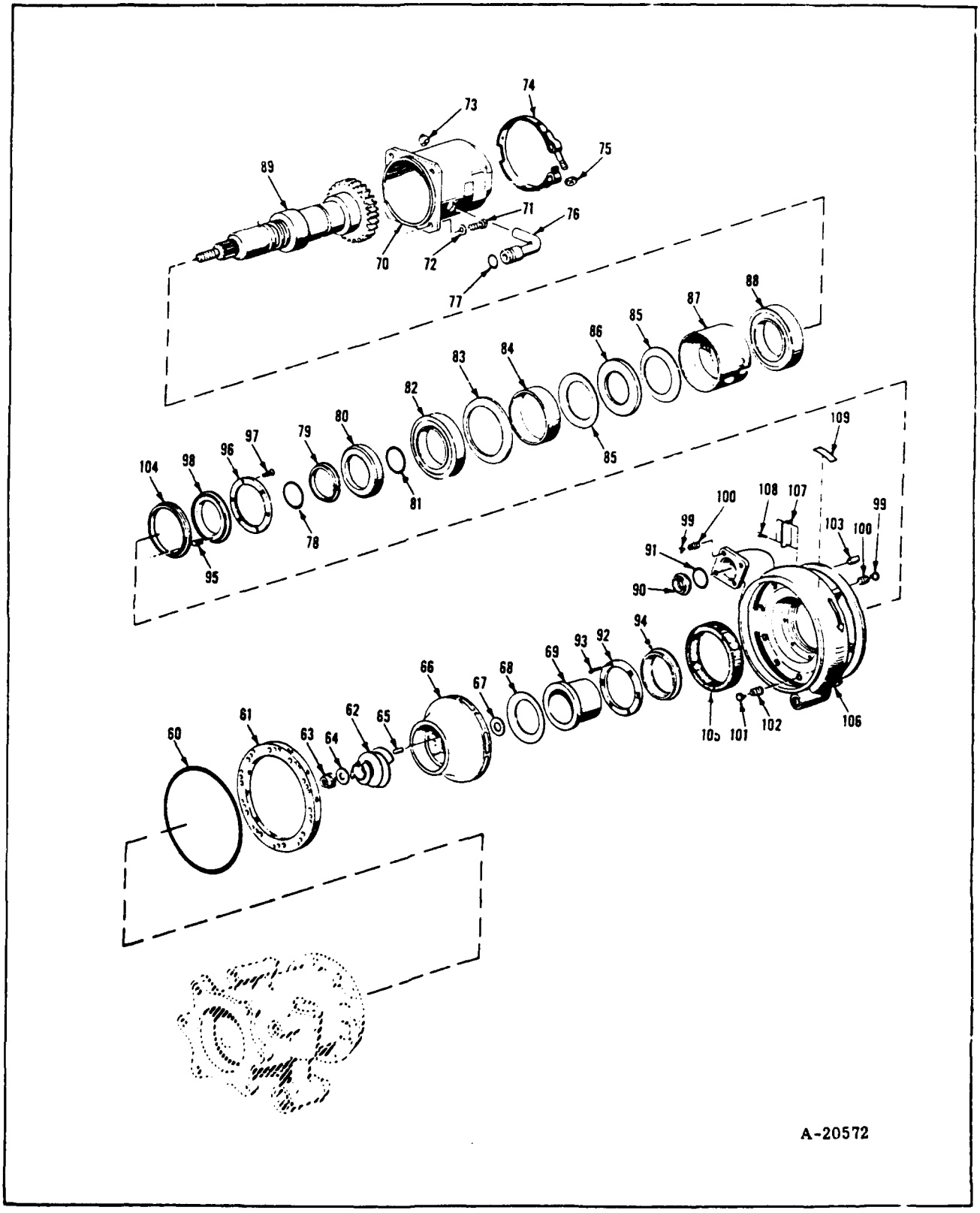

Figure 3-1. Exploded View of Afterburner Fuel Pump Assembly (Sheet 3 of 3)

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 NCC MTPC B SHEET 1 OF 1

PCN
NSN
PIN 3285A PARENT WCD _____ PARENT WCD DATE 11 [illegible]

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	8 [illegible]	[illegible]	24
2	[illegible]	[illegible]	24
3	2 [illegible]	2 [illegible]	24
4	2 [illegible]	[illegible]	24
5	2 [illegible]	2 [illegible]	24
6	2 [illegible]	2 [illegible]	24
			24

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

LSC-20107A

"OUT" DATES PR[illegible]LE

NAME _____ ALC QC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
PN 2[illegible]2-A

PARENT WCD _____

PARENT WCD DATE [illegible]

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
1	8 2 17	2[illegible]	0
2	2[illegible]	[illegible]0	24
3	8 2 05	2[illegible]05	0
4	8312	8312	0
5	8 2 14	8214	0
6	8 2[illegible]	2[illegible]	0
			41

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

LSC-20108A

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/31/89 RCC MATPCB SHEET 1 OF 3

PCN
IISN
PIN 38685A WCD CREM14 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
010	"	REC	1.0	TRANSIT	—	—	—	—			—	—			OC0934 CAN ALSO BE USED FOR THIS PART AS N STAND.
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1	100	.33	OC4275	1	100	.33	
020	"	PROC	1.0	TRANSIT	—	—	—	—			—	—			BEGIN LUBRICATING PROCESS
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.02	OC4275	1		.33	
030	"	TEST	1.0	TRANSIT	—	—	—	—			—	—			
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.50	OC4275	1		.50	
040	"	TEST	1.0	TRANSIT	—	—	—	—			—	—			
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.58	OC4275	1		.58	

OPERATION PROFILE

NAME RANDY HARRIS ALC OC DATE 5/31/89 NCC MATPCB SHEET 2 OF 3

PCN
NSN
PIN 38685A WCD CBEM14 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MNTP CB	TEST	1.0	TRANSIT	—	—	—	—			—	—			
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.25	0C4275	1		.25	
060	11	TEST	1.0	TRANSIT	—	—	—	—			—	—			
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.10	0C4275	1		.10	
070	11	TEST	1.0	TRANSIT	—	—	—	—			—	—			
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.25	0C4275	1		.25	
080	11			TRANSIT											MECHANIC REPORTS THAT THIS MINOR OVERHAUL IS NEVER DONE AND WILL BE DELETED FROM NCO SOON.
				SETUP			N/A								
				PROCESS											
090	11	PROC	1.0	TRANSIT	—	—	—	—			—	—			REMOVE PUMP FROM STAND AND FLUSH WITH OIL.
				SETUP	—	—	—	—			—	—			
				PROCESS	—	—	BI09	1		.10	[illegible]	1		.10	

OPERATION PROFILE

NAME Randy Harris ALC OC DATE 5/31/89 RCC MATPCB SHEET 3 OF 3

PCN
NSN
P/N 38685A WCD CBEM14 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MATP CB	ASSY	1.0	TRANSIT		—	—	—			—	—			INSTALL COVERS ON PUMP TO GO BACK TO ASSEMBLY UNIT
				SETUP		—	—	—			—	—			
				PROCESS		—	BI09	1		.06	—	—			
110 (119 120)	11	PW	1.0	TRANSIT		—	—	—			—	—			OPS 110 & 120 OF UCI INCLUDED HERE.
				SETUP		—	—	—			—	—			
				PROCESS		—	BI09	1		.03	—	—			
130	11	MOVE	1.0	TRANSIT		.10	BI09	1			—	—			MOVE UNIT TO FINAL ASSEMBLY
				SETUP		—	—	—			—	—			
				PROCESS		—	BI09	1		.1	—	—			
9999	11	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT AB FUEL PUMP DATE 5/31/89

ITEM CODE
PCN ☒ 36665A - TEST
NSN. ☐
P/N ☐

WCD CREM14 WCD DATE 88236

CHART BEGINS 010

CHART ENDS PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◇D□▽	RECEIVE PUMP			○◇D□▽	
020	020	●◇D□▽	LUBRICATING PROCESS			○◇D□▽	
030	030	●◇D□▽	TEST - BREAK IN RUN			○◇D□▽	
040	040	●◇D□▽	CYCLING TEST			○◇D□▽	
050	050	●◇D□▽	LEAKAGE TEST			○◇D□▽	
060	060	●◇D□▽	PUMP CALIBRATION			○◇D□▽	
070	070	●◇D□▽	HIGH-LOW CYCLING TEST			○◇D□▽	
090	090	●◇D□▽	OIL FLUSH PUMP			○◇D□▽	
100	100	●◇D□▽	INSTALL COVERS, PLUGS			○◇D□▽	
110	110	●◇D□▽	P.W.			○◇D□▽	
130	130	○◆D□▽	MOVE TO FINAL ASSY			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

PARALLEL PROCESS PROFILE

NAME RANDY HARRIS ALC OC DATE 5/31/89 RCC MATPCB SHEET 1 OF 1

ITEM NUMBER	PARENT WCD	PARENT WCD DATE	BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
					ITEM NUMBER	CHILD WCD	CHILD WCD DATE
(PCN) 38685A NSN P/N	CBEM13	88236	070	160	PCN NSN INDUCER P/N 02-14598	CBEM13I	88236
(PCN) 38685A NSN P/N	CBEM13	88236	070	120	PCN NSN DRIVE SHAFT P/N 02-13285-02	CBEM13D	88236
(PCN) 38685A NSN P/N	CBEM13	88236	070	120	PCN NSN IMPELLER P/N 102-1326	CBEM13P	88236
(PCN) 38685A NSN P/N	CBEM13	88236	070	120	PCN NSN BELLEVILLE SPRING P/N 99-3125	CBEM13B	88236
(PCN) 38685A NSN P/N	CBEM13	88236	070	190	PCN NSN BEARING HOUSING P/N 02-13828-01	CBEM13H	88236
(PCN) 38685A NSN P/N	CBEM13	88236	070	250	PCN NSN PISTON ROD P/N 02-13710	CBEM13R	88236
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		
PCN NSN P/N					PCN NSN P/N		

LSC-20103A

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060589 RCC MATPCB SHEET 1 OF 5

PCN MSN PIN 38690 A WCD CBEM07 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		.44									
10	MATP CB	REC	1.0	~~TRANSIT~~											REMOVE, UNCRATE UNIT, FILE CRATE PAPERWORK
				~~SETUP~~											
				PROCESS			AP09	1	100	.93	BEN14	1	100	.93	
15	MATP CB	CLN	1.0	~~TRANSIT~~											CLEAN EXT. PD680
				~~SETUP~~											
				PROCESS			AP09	1	100	.10	OC1178	1	100	.10	
20	MATP CB	DIS	1.0	~~TRANSIT~~											DIS, DISCARD RUBBER, DO SOME MISC
				~~SETUP~~											
				PROCESS			AP09	1	100	.83	BEN14	1	100	.83	
30	MATP. CB	CLN	1.0	TRANSIT			AP09	1	100	.25					DEGREASE UNIT, AIR DRY
				~~SETUP~~											
				PROCESS			P09	1	100	.50	OC4947	1	100	.50	

OPERATION PROFILE

NAME PHUNT ALC OC DATE 060589 RCC MATPCB SHEET 2 OF 5

PCN
IISH
PIN 38690A WCD CBEM07 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
40	MATP CB	INSP	1.0	~~TRANSIT~~											INSPECT, REPAIR & REPLACE AS REQ'D.
				~~SETUP~~											
				PROCESS			AP09	1	100	1.25	BEN14	1	100	1.25	
50	MATP CB	NDI	1.0	TRANSIT			AP09	1	100	.12	[illegible]	1	[illegible]	[illegible]	ONLY GEARS (3) + IMPELLOR ASSY. TO NOT [illegible] MAGNAFLUX
				~~SETUP~~											
				~~PROCESS~~											
60	MATP CB	NDI	1.0	TRANSIT			AP09	1	100	.13	[illegible]	1	[illegible]	[illegible]	FLOR. PEN, 1 NSP.
				~~SETUP~~											
				~~PROCESS~~											
75	MATP CB	REAM	1.0	~~TRANSIT~~											REAME TAPER PIN HOLES.
				~~SETUP~~											
				PROCESS			AP09	1	100	.08	BEN14	1	100	.08	
80	MATP. CB	ASSY	1.0	~~TRANSIT~~											INSPECT BEARINGS
				~~SETUP~~											
				PROCESS			AP09	1	100	.50	BEN14	1	100	.50	

OPERATION PROFILE

NAME PHUNT ALC OC DATE 060589 RCC MATPCB SHEET 3 OF 5

PCN
NSN
PIN 38690A WCD CBEM07 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
85	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY + LUBE GEAR PUMPING ELEMENT
				~~SETUP~~											
				PROCESS			AP09	1	100	.42	BEN14	1	100	.42	
90	MATP CB	INST.	1.0	~~TRANSIT~~											INSTALL TAPER PINS.
				~~SETUP~~											
				PROCESS			AP09	1	100	.05	BEN14	1	100	.05	
100	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY IMPELLER HOUSING
				~~SETUP~~											
				PROCESS			AP09	1	100	.25	BEN14	1	100	.25	
105	MATP CB	MOV	1.0	TRANSIT	100	.75	AP09	1	100	.17					TO OWG 3108 FOR INST
				~~SETUP~~											
				~~PROCESS~~											
110	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY BUSHG, CHK VALVE RETAINER.
				~~SETUP~~											
				PROCESS			AP09	1	100	.33	BEN14	1	100	.33	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060589 RCC MATPCB SHEET 4 OF 5

PCN
IISN
PIN 38690A WCD CBEM07 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
120	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY RELIEF VALVE ASSY
				~~SETUP~~											
				PROCESS			AP09	1	100	.50	BEN14	1	100	.5	
130	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY FILTER
				~~SETUP~~											
				PROCESS			AP09	1	100	.17	BEN14	1	100	.17	
140	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY SEAL
				~~SETUP~~											
				PROCESS			AP.09	1	100	.17	BEN14	1	100	.17	
150	MATP CB	CHK	1.0	TRANSIT											CHK PUMP FOR FREE + EASY ROTATION
				~~SETUP~~											
				PROCESS			AP09	1	100	.05	BEN14	1	100	.05	
160	MATP. CB	MOV	1.0	TRANSIT			AP09	1	100	.95					FUNCTION TEST BENCH
				~~SETUP~~											
				~~PROCESS~~											

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060589 RCC MATPCB SHEET 5 OF 5

PCN
NSN
PN 38690A WCD CBEM07 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
170	MATP CB	WIRE	1.0	~~TRANSIT~~											SAFETY WIRE + CAP ALL PORTS
				~~SETUP~~											
				PROCESS			AP09	1	100	.33	BEN14	1	100	.33	
180	MATP CB	PW	1.0	~~TRANSIT~~											CERTIFY THAT CH IS COMPL.
				~~SETUP~~											
				PROCESS			AP09	1	100	.33	BEN14	1	100	.33	
190	MATP CB	C/W	1.0	~~TRANSIT~~											C/W M701 GG-SC P1.2.13
				~~SETUP~~											
				PROCESS			AP09	1	100	.05	BEN14	1	100	.05	
200	MATP CB	MOV	1.0	TRANSIT			AP09	1	100	.08	—	—	—	—	MOVE TO SCC OUT
				SETUP											
				PROCESS											
9999	MATP. CB	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									

FLOW PROCESS CHART

SUBJECT MAIN FUEL PUMP 306-10A DATE 6-05-89

WCD CBEM07 WCD DATE 88236

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

CHART BEGINS 10 RECEIVE, IDENTIFY + ATTACH PARTS

CHART ENDS 200 MOVE TO SELL OUT PREPARED BY P Hunt

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	RECEIVE PU			○◇D□▽	
15	—	●◇D□▽	CLEAN EXT.			○◇D□▽	
20	20	●◇D□▽	DIS UNIT			○◇D□▽	
30	30	●◇D□▽	CLN			○◇D□▽	
40	40	○◇D■▽	INSP. REPAIR			○◇D□▽	
50	50	○◇D■▽	NDI, GEARS, IMPELLER			○◇D□▽	
60	60	○◇D■▽	NDI REST OF UNIT			○◇D□▽	
75	75	●◇D□▽	REAM PIN HOLE			○◇D□▽	
80	80	●◇D□▽	INSTALL BEARINGS			○◇D□▽	
85	85	●◇D□▽	ASSY TUBE COVERS			○◇D□▽	
90	90	●◇D□▽	INST TAPER PINS			○◇D□▽	
100	100	●◇D□▽	ASSY IMPELLER HSNG			○◇D□▽	
105	105	○●D□▽	MOVE TO BIOE (TEST)			○◇D□▽	
110	110	●◇D□▽	ASSY BOWL NL			○◇D□▽	
120	120	●◇D□▽	ASSY RELIEF VALVE			○◇D□▽	
130	130	●◇D□▽	ASSY FILTER			○◇D□▽	
140	140	●◇D□▽	ASSY SEAL			○◇D□▽	
150	150	○◇D■▽	CHK PUMP ROTATION			○◇D□▽	
160	160	○●D□▽	FROM BIOE			○◇D□▽	
170	170	●◇D□▽	SAFETY WIRE UNIT			○◇D□▽	
180	180	●◇D□▽	PAPER WORK			○◇D□▽	
190	190	●◇D□▽	COMPLY WITH TO			○◇D□▽	
200	200	○●D□▽	MOVE TO SELL OUT			○◇D□▽	
9999	—	●◇D□▽	END.			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

SECTION II

GROUP ASSEMBLY PARTS LIST

Fig. & Index No.	Part No.	Description 1 2 3 4 5 6 7	Units Per Assy	Usable On Code
1-1	024090-019-01	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)	Ref	A
	024090-019-02	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)	Ref	B
	024090-019-05	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)	Ref	C
	024090-019-07	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)	Ref	D
	024090-021-05	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P7; 07482)	Ref	E
	024090-021-07	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P7; 07482)	Ref	F
-2	02-13423	. PLATE, Thrust . . . . . (ATTACHING PARTS)	1	
-3	782-22	. SCREW, Socket head . . . . . ---*---	6	
-4	99-1924	. SPRING	1	
-5	99-1925	. WASHER	1	
-6	02-13424	. STOP	1	
-7	02-11026	. WASHER	1	
-8	02-11027	. GUIDE	1	
-9	102-847	. SEAL ASSY, Diaphragm	1	
-10	02-13407	. SHAFT, Drive	1	
-11	99-3650	. SPRING	1	
	102-829	. COVER ASSY, Front . . . . . (ATTACHING PARTS)	1	
-12	99-1240	. PIN, Taper	2	
-13	AN310-5	. NUT	7	
-14	AN960-516	. WASHER . . . . . ---*---	7	
-15	PS-112-21-0	. . STUD	1	
	PS-112-21-3	. . STUD (0.003 inch oversize)	1	
	PS-112-21-6	. . STUD (0.006 inch oversize)	1	
-16	02-13398	. . COVER, Front	1	
-17	MS29513-240	. RING, Seal	1	
-18	MS29513-125	. RING, Seal	2	A
-19	MS29513-222	. RING, Seal	2	
-20	764-6A	. SPRING	14	
-21	466-12C	. PIN, Seal	1	
-22	02-13655	. BEARING, Cover	1	
-23	02-13654	. BEARING, Cover	1	
	02-13629	. GEARS (matched set)	1	
-24	02-13390	. GEAR, Driven (nonprocurable; see next higher assembly)	1	
-25	02-13389	. . GEAR, Drive (nonprocurable; see next higher assembly)	1	
-26	02-13408	. SHAFT, Booster drive	1	
	02-13628	. BEARINGS, Body (matched set)	1	
-27	02-13396	. . BEARING, Body . . . . . (nonprocurable; see next higher assembly)	1	
-28	02-13395	. . BEARING, Body . . . . . (nonprocurable; see next higher assembly)	1	

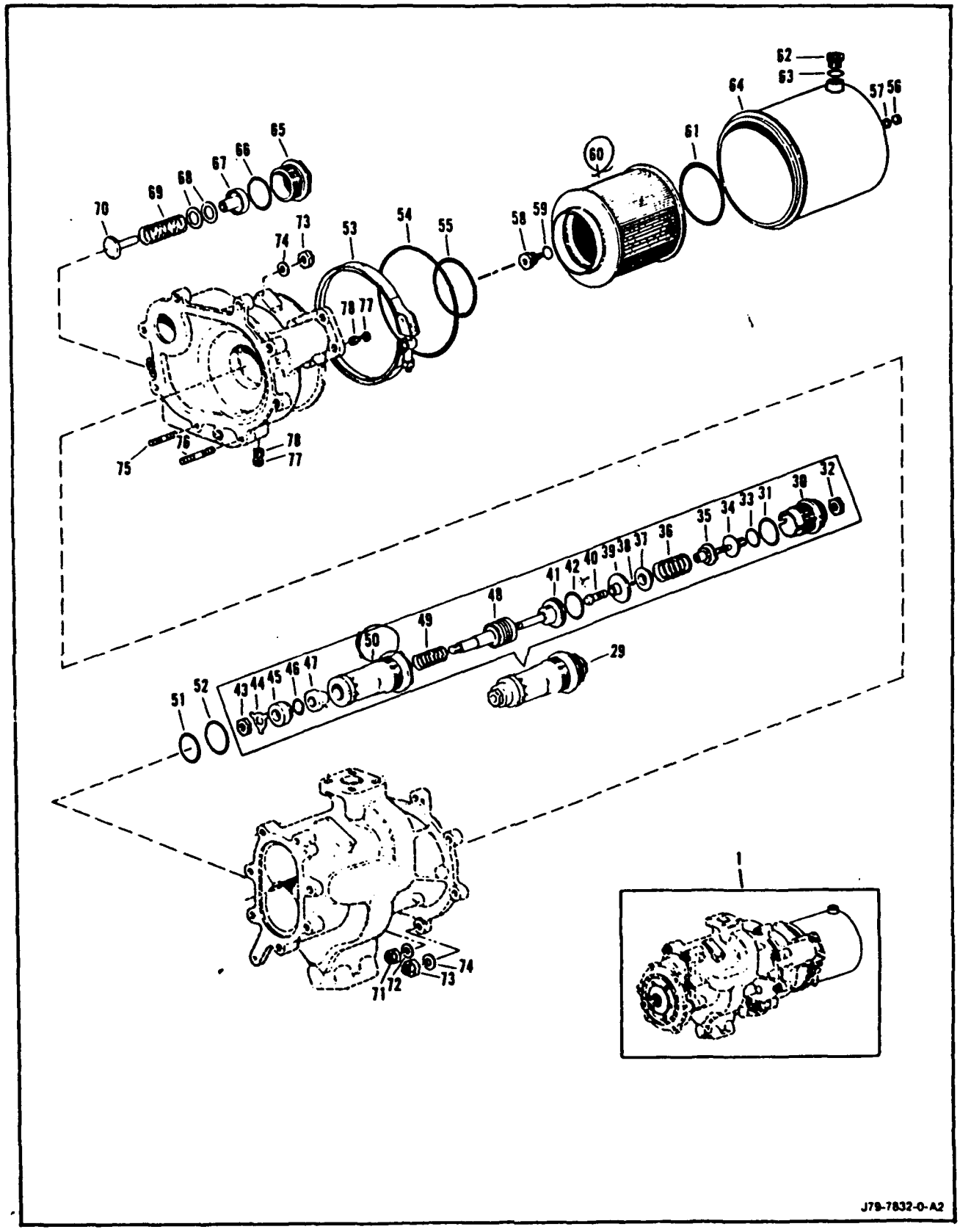

Figure 1. Exploded View of Fuel Pump Assembly (Sheet 2 of 3)

Fig. & Index No.	Part No.	Description 1 2 3 4 5 6 7	Units Per Assy	Usable On Code
1-29	102-542	. VALVE ASSY, Relief	1	
-30	02-12015	. . RETAINER, Spring	1	
-31	MS29513-118	. . RING, Seal	1	
-32	99-2933-01	. . NUT	1	
-33	MS29513-111	. . RING, Seal	1	
-34	02-12233	. . SCREW, Adjusting	1	
-35	02-12231	. . STOP, Spring	1	
-36	99-2697	. . SPRING	1	
-37	02-12232	. . STOP, Spring	1	
-38	MS19060-2	. . BALL	1	
-39	02-12230	. . GUIDE, Pilot valve	1	
-40	02-12229	. . VALVE, Pilot	1	
-41	02-12014	. . SEAT, Pilot valve	1	
-42	MS29513-17	. . RING, Seal	1	
-43	AN316C4R	. . NUT	1	
-44	02-12580	. . WASHER, Lock	1	
-45	02-12016	. . VALVE, Piston	1	
-46	MS29513-11	. . RING, Seal	1	
-47	02-12017	. . SKIRT, Piston valve	1	
-48	02-12013	. . PISTON	1	
-49	99-2394	. . SPRING	1	
(50)	02-12012	. . HOUSING	1	
-51	MS29513-118	. RING, Seal	1	
-52	MS29513-122	. RING, Seal	1	
-53	58473	. CLAMP (98625) (99-4131; 99167)	1	
	58474	. . BOLT (98625)	1	
-54	MS29513-255	. RING, Seal	1	
-55	MS29513-230	. RING, Seal	1	
-56	MS20364-428C	. NUT	1	
-57	AN960-416L	. WASHER	1	
-58	02-13464	. RETAINER, Filter	1	
-59	MS29513-110	. RING, Seal	1	
(60)	02-13652	. FILTER	1	ABCD
	02-13841	. FILTER (C19655; 00736)	1	ABCD
	118244	. FILTER (87405) (02-14982; 99167)	1	EF
	7584682	. FILTER (05228)	ALT	ABCD
	7584315	. FILTER (05228)	ALT	EF
-61	MS29513-230	. RING, Seal	1	
-62	AN814-4DL	. PLUG	1	
-63	MS29512-04	. GASKET	5	
-64	02-13402	. COVER, Filter	1	
-65	02-13409	. RETAINER, Valve	1	
-66	MS29512-16	. GASKET	1	
-67	02-13411	. GUIDE, Valve	1	
-68	AN960C716L	. WASHER	AR	
-69	99-3553	. SPRING	1	
-70	02-13555	. VALVE, Check	1	

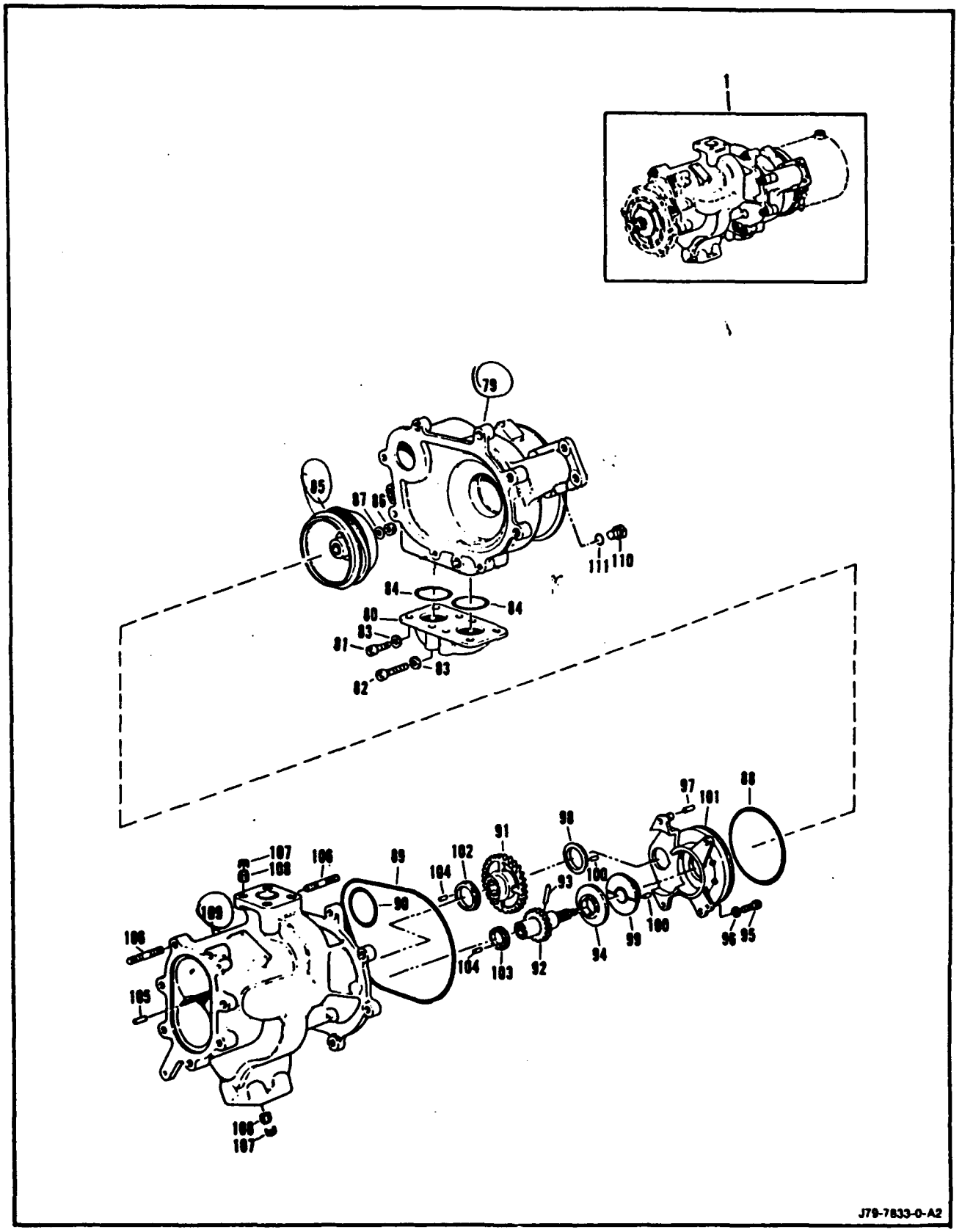

Figure 1. Exploded View of Fuel Pump Assembly (Sheet 3 of 3)

Fig. & Index No.	Part No.	Description	Units Per Assy	Usable On Code
1-	102-910	. HOUSING ASSY, Impeller	1	AB
	102-1233-01	. HOUSING ASSY, Impeller	1	CDEF
		(ATTACHING PARTS)		
-71	AN310-4	. NUT	1	
-72	AN960-416L	. WASHER	1	
-73	AN310-5	. NUT	7	
-74	AN960-516	. WASHER	7	
		---*---		
-75	PS111-19-0	. . STUD	1	
	PS111-19-3	. . STUD (0.003 inch oversize)	AR	
	PS111-19-6	. . STUD (0.006 inch oversize)	AR	
-76	PS112-21-0	. . STUD	6	
	PS112-21-3	. . STUD (0.003 inch oversize)	AR	
	PS112-21-6	. . STUD (0.006 inch oversize)	AR	
-77	99-4011-7	. . RING, Key	12	AB
	99-4011-7	. . RING, Key	4	CDEF
-78	933B4SE0562	. . INSERT (01556) (99-3676; 99167)	12	AB
	933B4SE0562	. . INSERT (01556) (99-36761 99167)	4	CDEF
-79	02-13619	. . HOUSING, Impeller	1	AB
	02-14806-01	. . HOUSING, Impeller	1	CDEF
-80	02-13401	. COVER, Port	1	AB
		(ATTACHING PARTS)		
-81	AN148656	. SCREW	4	AB
-82	AN148675	. SCREW	4	AB
-83	AN960-416L	. WASHER	8	AB
		---*---		
-84	MS29513-126	. RING, Seal	2	AB
-85	02-13650	. IMPELLER, Mixed flow	1	
		(ATTACHING PARTS)		
-86	MS20364-428C	. NUT	1	
-87	AN960-416L	. WASHER	1	
		---*---		
-88	MS29513-234	. RING, Seal	1	
-89	MS29513-257	. RING, Seal	1	
-90	MS29513-125	. RING, Seal	1	
-91	02-13405	. GEAR, Booster drive	1	
-92	02-13406	. GEAR, Booster driven	1	
-93	99-5008	. PIN, Thrust washer	1	
-94	02-13412	. WASHER, Gear end thrust	1	
	102-836	. RETAINER AND BODY ASSY	1	
	102-832	. . RETAINER ASSY	1	
		(ATTACHING PARTS)		
-95	99-2506-10-4	. . SCREW	4	
-96	AN960C10L	. . WASHER	4	
-97	302-15	. . PIN	2	
		---*---		
-98	02-13413	. . . BEARING, Booster drive gear	1	
-99	02-13416	. . . BEARING, Booster driven gear	1	
-100	99-2350	. . . PIN	2	
-101	02-13397	. . . RETAINER	1	
	102-830	. . BODY ASSY	1	
-102	02-13413	. . . BEARING, Booster drive gear	1	
-103	02-13414	. . . BEARING, Booster driven gear	1	

Fig. & Index No.	Part No.	Description 1 2 3 4 5 6 7	Units Per Assy	Usable On Code
1-104	99-2350	. . . PIN	2	
-105	99-908	. . . PIN	1	A
-106	PS112-21-0	. . . STUD	7	
	PS112-21-3	. . . STUD (0.003 inch oversize)	AR	
	PS112-21-6	. . . STUD (0.006 inch oversize)	AR	
-107	99-4011-7	. . . RING, Key	8	
-108	933B4SE0562	. . . INSERT (01556) (99-3676; 99167)	8	
-109	02-13404	. . . BODY	1	
-110	AN814-5DL	. PLUG	1	
-111	MS29512-05	. GASKET	1	
	99-3293	. PLATE, Name	1	
		(ATTACHING PARTS)		
	AN500A6-3	. SCREW	2	
		---*---		
	02-14124	. PLATE, Shipping	2	
	99-3991	. GASKET	2	
	MS35304-6	. SCREW	6	
	AN960-416L	. WASHER	3	
	02-14122	. PLATE, Shipping	1	
	AN7[illegible]-21	. GASKET	1	
	AN4047-1	. GASKET	1	
	98-312-516-32	. SCREW	2	
	99-4385	. BLOCK	1	
	99-1987	. NUT	2	
	99-204-08	. WASHER	4	
	MS35304-5	. SCREW	4	
	99-4104-4	. PLUG, Shipping	3	
	99-4104-5	. PLUG, Shipping	1	

Fig. & Index No.	Part No.	Description 1 2 3 4 5 6 7	Units Per Assy	Usable On Code
2-1	024090-014-F1	JIG, Bearing seal pin drill	1	
-2	SF-024090-019-F1	FIXTURE, Pressure test	1	
-3	SF-024090-010-T1	WRENCH, Impeller	1	
-4	T-1144-E	PLUG, Relief valve	1	
-5	97-129-01	FIXTURE, Dowelling	1	
-6	97-129-03	FIXTURE, Dowelling	1	
-7	102-542-ST1	TOOL, Piston restraining	1	
-8	SF-024090-021-F11	TOOL, Impeller housing removal	1	
-9	SF-024090-021-M10	TOOL, Impeller housing removal	1	
	1C2813	TEST STAND, Main fuel pump	1	
-10	SF-102-1428-G1	GAGE, Bore measuring	1	

DISASSEMBLY/ASSEMBLY PROFILE

NAME P HUNT ALC OC DATE 060589 RCC MATPCB SHEET ___ OF ___

(INDENTURED)

TOP ASSEMBLY ITEM NUMBER	TOP ASSEMBLY WCD	TOP ASSEMBLY WCD DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY ITEM NUMBER	SUBASSEMBLY CHILD WCD	SUBASSEMBLY CHILD WCD DATE	SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
PCN NSN P/N 38690A	CBEM07	88236	20	100	PCN NSN P/N 02-13407	CBEM0751		
PCN NSN P/N					PCN NSN P/N 02-13390	CBEM075		
PCN NSN P/N					PCN NSN P/N 02-13389	CBEM075		
PCN NSN P/N					PCN NSN P/N 02-12012	CBEM075		
PCN NSN P/N					PCN NSN P/N 02-13652	CBEM075		
PCN NSN P/N					PCN NSN P/N 02-13619	CBEM075		
PCN NSN P/N					PCN NSN P/N 02-13650	CBEM075		
PCN NSN P/N					PCN NSN P/N 02-13404	CBEM075		
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-2(XF)5A

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 3/MAY89 RCC MTPCB SHEET 1 OF 1

PCN / NSN / PIN 38690A PARENT WCD _____ PARENT WCD DATE MTPCB

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~ HRS
1	8277	8212	21
2	8225	8180	21
3	8334	8305	24
4	9020	9002	72
5	9100	9004	96
6	9052	9057	24
			441

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

LSC-20107A

"OUT" DATES PRO[illegible]LE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPCB SHEET 1 OF 1

PCII/ISII/PII 38690A PARENT WCD _____ PARENT WCD DATE 90TFCB

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (HRS)
1	8281	8[illegible]21	0
2	8[illegible]23	8[illegible]23	0
3	8[illegible]41	8[illegible]41	0
4	9027	9027	0
5	1030	1030	0
6	9065	9065	24
			(4)

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

LSC-20103A

OPERATION PROFILE

NAME P Hunt ALC OC DATE 6-05-89 RCC MATPCB SHEET 1 OF 3

PCN
NSN
P/N 38690A WCD CBEM08 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
000	MATP CB	IN DATA	1.0	TRANSIT											
				SETUP											
				PROCESS		44									
010	MATP CB	TEST	1.0	~~TRANSIT~~											INST. PUMP ON STAND + RUN TWO TESTS.
				~~SETUP~~											
				PROCESS			DP09	1	100	.25	OCOTTA	1	100	.25	OCOTTA ALT
020	MATP CB	TEST	1.0	~~TRANSIT~~											OCOTTA ALT ENDURANCE RUN
				SETUP			DP09	1	100	.08	OCOTTA	1	100	1.0	
				PROCESS			DP09	1	100	2.00	OCOTTA	1	100	2.08	MAXIMUM THEORETICALLY POSSIBLE, AT 1.0 HRS.
030	MATP CB	TEST	1.0	~~TRANSIT~~											RAPID SPEED RUN
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	OCOTTA	1	100	.08	OCOTTA ALT
040	MATP. CB	SET	1.0	~~TRANSIT~~											CALIBRATION RUN
				~~SETUP~~											
				PROCESS			DP09	1	100	.12	OCOTTA	1	100	.12	OCOTTA ALT

LSC 2000126

OPERATION PROFILE

NAME P HUNT ALC OC DATE 6-05-89 RCC MATPCB SHEET 2 OF 3

PCN/MSN/PIN 38690A WCD CBEM08 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MATP CB	ADJ.	1.0	~~TRANSIT~~											RELIEF VALVE ADJ.
				~~SETUP~~											
				PROCESS			DP09	1	100	.50	XXX72	1	100	.50	OCCRRC ACT
060	MATP CB	SET	1.0	~~TRANSIT~~											RELIEF VALVE CALIB.
				~~SETUP~~											
				PROCESS			DP09	1	100	.25	OCO912	1	100	.25	OCORRC ACT
070	MATP CB	TEST	1.0	~~TRANSIT~~											FLOW & TORQUE TESTS.
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	OCO912	1	100	.33	OCCRRC ACT
080	MATP CB	TEST	1.0	~~TRANSIT~~											LEAK TESTS
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	OCO912	1	100	.17	OCCRRC ACT
090	MATP. CB	TEST	1.0	~~TRANSIT~~											BREAK-AWAY TORQUE TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	OCO912	1	100	.08	OCCRRC ACT

OPERATIO ROFILE

NAME P HUNT ALC OC DATE 6-05-89 RCC MATPCB SHEET 3 OF 3

PCN/NSN/PIN 38690A WCD CBEM08 ✓ WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MATP CB	OIL	1.0	~~TRANSIT~~											OIL, + FLUSH.
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	00972	1	100	.17	[illegible] ACT
110	MATP CB	P/W	1.0	~~TRANSIT~~											TEST OPS COMPL, PW COMPL.
				~~SETUP~~											
				PROCESS			DP09	1	10	.17	00972	1	100	.17	[illegible] ACT
120	MATP CB	PW	1.0	~~TRANSIT~~											[illegible] ACT COMPLY WITH MAOI 66-36 PA-2.13
				~~SETUP~~											
				PROCESS			DP09	1	10	.08	00972	1	100	.08	
130	MATP CB	MOVE	1.0	TRANSIT				1	10	.08					MOVE TO FINAL ASSY AREA
				~~SETUP~~											
				~~PROCESS~~			DP09								
9999	MATP. CB	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									

FLOW PROCESS CHART

SUBJECT 38690 A MAIN FUEL PUMP DATE 6-05-24

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

WCD CBEMC2 WCD DATE 22236

TEST

CHART BEGINS 010 INSTALL PUMP ONTO TEST STAND

CHART ENDS 130 REMOVE PUMP TO FINAL ASSY PREPARED BY PHM

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	INSTALL PUMP			○◇D□▽	
20	20	○◇D■▽	ENGINEER RUN			○◇D□▽	
30	30	○◇D■▽	RATED SPEED RUN			○◇D□▽	
40	40	●◇D□▽	CALIBRATION RUN.			○◇D□▽	
50	50	●◇D□▽	RELIEF VALVE ADJ.			○◇D□▽	
60	60	●◇D□▽	RELIEF VALVE CALIB.			○◇D□▽	
70	70	○◇D■▽	FLOW + TORQUE TESTS			○◇D□▽	
80	80	○◇D■▽	LEAK TESTS			○◇D□▽	
90	90	●◇D□▽	BREAK-AWAY TORQUE TEST			○◇D□▽	
100	100	●◇D□▽	OIL + FLUSH			○◇D□▽	
110	110	●◇D□▽	TEST OPS COMPLETE			○◇D□▽	
120	120	●◇D□▽	PW, C/W			○◇D□▽	
130	130	○●D□▽	MOVE TO FINAL ASSY			○◇D□▽	
9999	9999	○◇D□▽	END.			○◇D□▽	
		○◇D□▽ ○◇D□▽				○◇D□▽ ○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

OPERATION PRC _E

NAME E. Toffen ALC OC DATE 5/11/89 RCC MATPCB SHEET 1 OF 8

PCN
NSN
PN 3869/A WCD CBEM10 ✓ WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	28.0									
001		REC	0.9	[redacted]											
				[redacted]											
				PROCESS	—	—	BP05	1	1.0	2.7	BEN12	1	1.0	2.7	
005		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	BP05	1	1.0	.20	BEN12	1	1.0	.20	
010		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	.20	BEN12	1	1.0	.20	
012		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	.20	BEN12	1	1.0	.20	

OPERATION PRC _E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 8

PCN
HSN
PN _____ WCD CBEM10 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
015	MAT PCB	CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	APOG	1	1.0	.05	OC 1178	1	1.0	.05	
020		DIS	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.60	BEN12	1	1.0	.60	
021		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	BEN12	1	1.0	.10	
030		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.30	OC 4547	1	1.0	.30	
031		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	BEN12	1	1.0	.05	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 8

ITEM CODE PCN NSN P/N _____ WCD CBEM10 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
032	MAT PCB	PROC	1.0	[illegible]										
				SETUP										
				PROCESS	—	APO9	1	1.0	.20	Ben 12	1	1.0	.20	
033		PROC	1.0	[illegible]										
				SETUP										
				PROCESS	—		1	1.0	.10	BEN 12	1	1.0	.10	
035		PW	1.0	[illegible]										
				SETUP										
				PROCESS	—		1	1.0	.05	BEN 12	1	1.0	.05	
036		CLN	1.0	[illegible]										
				SETUP										
				PROCESS	—		1	1.0	.20	BEN 12	1	1.0	.20	
				TRANSIT										
				SETUP										
				PROCESS										

OPERATION PRO..LE

NAME _____ ALC _____ DATE _____ NCC _____ SHEET 4 OF 8

PCN
NSN
PIN _____ WCD CBEM10 ✓ WCD DATE _____

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
037	MAT ACM	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	+	.1	APO9	1	1.0	.10	BEN12	1	1.0	.10	
038		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	1.5		1	1.0	.05	BEN12	1	1.0	.05	
045		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	-.1		1	1.0	.05	BEN12	1	1.0	.05	
050		INSP	1.0	[redacted]											NDE
				[redacted]											
				PROCESS	—	-.1		1	1.0	.08	QC 6025	1	1.0	.08	
060		INSP	1.0	[redacted]											NDE
				[redacted]											
				PROCESS	—	-.1		1	1.0	.08	QC 6025	1	1.0	.08	

24.

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 5 OF 8

ITEM CODE PCN NSN P/N _____ WCD CBEM10 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
061	MAT AB	REP	1.0	~~TRANSIT~~										
				~~SETUP~~										
				PROCESS	—	APO9	1	1.0	.20	BEN12	1	1.0	.20	
062		PROC	1.0	~~TRANSIT~~										Backshop test facility MAINCOM (-1111)
				~~SETUP~~										
				PROCESS	1.0 16.0									
063		ASSY	1.0	~~TRANSIT~~										
				~~SETUP~~										
				PROCESS	—	APO9	1	1.0	.20	BEN12	1	1.0	.20	
064		ASSY	1.0	~~TRANSIT~~										
				~~SETUP~~										
				PROCESS	—		1	1.0	.10	BEN12	1	1.0	.10	
065		ASSY	1.0	~~TRANSIT~~										
				~~SETUP~~										
				PROCESS	—		1	1.0	.40	BEN12	1	1.0	4.0	

OPERATION PRO. .LE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 6 OF 8

PCII
NSII
P/II _____ WCD CREM10 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
070	MAT PCB	PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	APO9	1	1.0	.17	BEN12	1	1.0	.17	
075		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.05	BEN12	1	1.0	.05	
080		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.25	BEN12	1	1.0	.25	
085		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.25	BEN12	1	1.0	.25	
090		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.05	BEN12	1	1.0	.05	

OPERATION PRO. _E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 7 OF 8

PCN
NSN
PN _____ WCD CBEM10 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	APO9	1	1.0	.42	BEN12	1	1.0	.42	
110		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.25	BEN12	1	1.0	.25	
120		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.50	BEN12	1	1.0	.50	
130		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.25	BEN12	1	1.0	.25	
140		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.50	BEN12	1	1.0	.50	

OPERATION PRO. .E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 8 OF 8

PCN
NSN
PN _____ WCD CBEM10 ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT ACB	TEST	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	APO9	1	1.0	.25	Ben12	1	1.0	.25	
170		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	Ben12	1	1.0	.05	
185		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.16	Ben12	1	1.0	.16	
9999		OUT	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	32.0									
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT 38691A DATE 6-17-89

ITEM CODE PCH [X] M&K. [ ] P/N [ ]

WCD CBEM10 WCD DATE 88236

CHART BEGINS 01 REC'

CHART ENDS 200 SCRL IT PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
01	—	●▷D□▽	REC - MSTR			○▷D□▽	
05	—	●▷D□▽	UNLOAD			○▷D□▽	
010	010	●▷D□▽	REC & DO PW			○▷D□▽	
012	—	●▷D□▽	PUMP TO W. IN BLANK			○▷D□▽	
015	—	●▷D□▽	CLEAN - PD680			○▷D□▽	
020	DIS	●▷D□▽	TOTALLY DIS. PUMP.			○▷D□▽	
021	—	○▷D■▽	VISUAL INSP PUMP			○▷D□▽	
030	30	●▷D□▽	CLEAN DIS. PUMP.			○▷D□▽	
040	40	○▷D■▽	INSP., REJ. PARTS			○▷D□▽	
050	50	○▷D■▽	NDI - GEARS/SHAFTS			○▷D□▽	
060	60	○▷D■▽	NDI - IMPELLER			○▷D□▽	
061	—	●▷D□▽	REPAIR GEARS			○▷D□▽	
062	—	●▷D□▽	MACHINE IMPELLER			○▷D□▽	
063	—	●▷D□▽	ASSY RELIEF VALVE			○▷D□▽	
064	—	●▷D□▽	ASSY BEARINGS			○▷D□▽	
065	—	●▷D□▽	ASSY COVER ELEMENT			○▷D□▽	
070	70	●▷D□▽	LUBE ALL PARTS			○▷D□▽	
075	75	●▷D□▽	REAM TAPER PIN HOLES			○▷D□▽	
080	80	●▷D□▽	ASSY GEAR ELEMENT			○▷D□▽	
085	85	●▷D□▽	ASSY PUMP ELEMENT			○▷D□▽	
090	90	●▷D□▽	INSTALL TAPER PINS.			○▷D□▽	
100	100	●▷D□▽	ASSY IMPELLER HSNG			○▷D□▽	
110	110	●▷D□▽	ASSY BOOSTER ELEM.			○▷D□▽	
120	120	●▷D□▽	ASSY RELIEF VALVE			○▷D□▽	
130	130	●▷D□▽	ASSY FILTER			○▷D□▽	
140	140	●▷D□▽	ASSY SEAL PLATE			○▷D□▽	
150	150	○▷D■▽	ROTATIONAL CHECK			○▷D□▽	
160	160	○●D□▽	MOVE TO 3108			○▷D□▽	
170	170	●▷D□▽	SAFETY WIRE			○▷D□▽	
180	180	●▷D□▽	DO PACKING			○▷D□▽	
190	190	●▷D□▽	COMPLETE TO			○▷D□▽	
200	200	○●D□▽	MOVE TO SCRL IT			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME PHUNT ALC OC DATE 061589 RCC OC SHEET 1 OF 3

PCN NSN PIN 38691A WCD CREM11 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		28									
10	MATP CB	PROC	1.0	~~TRANSIT~~											INSTALL PUMP ONTO
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	0C0972	1	100	.33	TEST STAND
20	MATP CB	TEST	1.02	~~TRANSIT~~											RUN-IN
				~~SETUP~~											
				PROCESS			DP09	1	100	1.0	0C0972	1	100	1.0	
21	MATP CB	TEST	.98	~~TRANSIT~~											RUN-IN
				~~SETUP~~											
				PROCESS			DP09	1	100	2.0	0C0972	1	100	2.0	
30	MATP. CB	TEST	1.0	~~TRANSIT~~											RAPID SPOOL RUN
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0972	1	100	.08	

OPERATION PROFILE

NAME PHWT ALC OC DATE 061589 RCC OC SHEET 2 OF 3

PCN
NSN 38691A
P/N

WCD CBEM11 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
40	MATP CB	TEST	1.0	TRANSIT											CALIBRATION
				SETUP											
				PROCESS			DP09	1	100	.12	OC0972	1	100	.12	
50	MATP CB	TEST	1.0	TRANSIT											RELIEF VALVE ADJUSTMENT
				SETUP											
				PROCESS			DP09	1	100	.08	OC0972	1	100	.08	
60	MATP CB	TEST	1.0	TRANSIT											SET/TEST RELIEF VALVE
				SETUP											
				PROCESS			DP09	1	100	.17	OC0972	1	100	.17	
70	MATP CB	TEST	1.0	TRANSIT											FLOW + TORQUE TESTS.
				SETUP											
				PROCESS			DP09	1	100	.7	OC0972	1	100	.7	
80	MATP CB	TEST	1.0	TRANSIT											LEAK TESTS
				SETUP											
				PROCESS			DP09	1	100	.13	OC0972	1	100		

OPERATION PROFILE

NAME Pilunt ALC OC DATE 061589 RCC OC SHEET 3 OF 3

PCN
NSN 38691A
P/N

WCD CBEM11 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
90	MATP CB	TEST	1.0	~~TRANSIT~~											BREAK-AWAY TORQUE TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0972	1	100	.08	
100	MATP CB	PROC.	1.0	~~TRANSIT~~											OIL FLUSH
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0972	1	100	.08	
110	MATP CB	PW	1.0	~~TRANSIT~~											PW CONTROL
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	0C0972	1	100	.05	
120	MATP CB	PW	1.0	TRANSIT											PW/CW
				SETUP											
				PROCESS			DP09	1	100	.05	—	—	—	—	
9999	MATP CB	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		0									

LSC-200120

FLOW PROCESS CHART

SUBJECT 38691A DATE 61589

WCD CBEM11 WCD DATE 88236

ITEM CODE
PCH [X]
NSN. [ ]
P/N [ ]

CHART BEGINS 10

CHART ENDS 120 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	INSTALL PUMP ON STAND			○◇D□▽	
20	20	○◇D■▽	RUN IN			○◇D□▽	
21	21	○◇D■▽	RUN IN			○◇D□▽	
30	30	○◇D■▽	RATED SPEED RUN			○◇D□▽	
40	40	○◇D■▽	CALIBRATION			○◇D□▽	
50	50	●◇D□▽	RELIEF VALVE ADJ.			○◇D□▽	
60	60	●◇D□▽	SET RELIEF VALVE			○◇D□▽	
70	70	○◇D■▽	FLOW + TORQUE TESTS			○◇D□▽	
80	80	○◇D■▽	LEAK TESTS			○◇D□▽	
90	90	○◇D■▽	BREAK AWAY TORQUE			○◇D□▽	
100	100	●◇D□▽	OIL FLUSH			○◇D□▽	
110	110	●◇D□▽	PW COMPL.			○◇D□▽	
120	120	●◇D□▽	PW / CW			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽ ○◇D□▽				○◇D□▽ ○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME PITUNT ALC OC DATE 61589 RCC CBEM12 SHEET 1 OF 2

PCN/NSN/P/N 38691A WCD CBEM12 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
10	MATP CB	PROC	1.0	~~TRANSIT~~											PREPARE IMPELLER HOUSING & CHECK VALVE
				SETUP			AP09	1	100	.05	OC0972	1	100	.05	
				~~PROCESS~~											
20	MATP CB	MOV	1.0	TRANSIT			AA09	1	100	.05	—				ROUTE TO MTPCT/3108
				~~SETUP~~											
				~~PROCESS~~											
25	MATP CB	REC	1.0	~~TRANSIT~~											RECEIVE
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	OC0972	1	100	.08	
26	MATP CB	PROC	1.0	~~TRANSIT~~											ATTACH CLAMP, DISCARD
				SETUP			DP09	1	100	.12	OC0972	1	100	.12	
				~~PROCESS~~											

OPERATION PROFILE

NAME PHUNT ALC OC DATE 61589 RCC CBEM12 SHEET 2 OF 2

PCN
NSN 38691A
P/N

WCD CBEM12 ✓ WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
30	MATP CB	TEST	1.0	~~TRANSIT~~											PERFORM LEAK TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.42	0C0972	1	100	.42	
35	MATP CB	PROC	.3	~~TRANSIT~~											TEARDOWN, MINOR
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0972	1	100	.08	
40	MATP CB	PW	1.0	~~TRANSIT~~											C/W IAW TO T=TO
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0972	1	100	.08	
50	MATP CB	PW	1.0	~~TRANSIT~~											C/W MAOI 66-36 PAR 13
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	—				
9999	↓	DUT	1.0	TRANSIT											
				SETUP											
				PROCESS		0									

FLOW PROCESS CHART

SUBJECT 38691A DATE 61589

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

WCD CBEM12 WCD DATE 88236

CHART BEGINS 10 — CHK IMPELLER

CHART ENDS 50 PARKING PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	CHK IMPELLER			○◇D□▽	
20	20	○◇D□▽	ROUTE TO MTR 8/3108			○◇D□▽	
25	25	●◇D□▽	RECEIVE			○◇D□▽	
26	26	●◇D□▽	ATTACH CLAMP			○◇D□▽	
30	30	○◇D■▽	PUMP IN LEAK TEST			○◇D□▽	
35	35	●◇D□▽	MINOR TEAR DOWN			○◇D□▽	
40	40	●◇D□▽	C/W TO TCTO			○◇D□▽	
50	50	●◇D□▽	PW			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽ ○◇D□▽				○◇D□▽ ○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 2[illegible]12

PARENT WCD _____

PARENT WCD DATE [illegible]

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	8[illegible]20	8[illegible]21	24
2	8[illegible]14	[illegible]14	24
3	8[illegible]17	8[illegible]15	.418
4	[illegible]	[illegible]	24
5	[illegible]	[illegible]	24
6	[illegible]	[illegible]	24
			28

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

LSC-20107A

"OUT" DATES PR. ILE

NAME _____ ALC OC-ALC DATE 31MAY89 MCC MTPCB SHEET 1 OF 1

PCN
NSN
PN 3[illegible]117 PARENT WCD _____ PARENT WCD DATE [illegible]

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
1	8[illegible]27	2[illegible]27	0
2	8300	2300	0
3	2[illegible]01	8[illegible]01	0
4	8 - 5	[illegible]3	0
5	8[illegible]	2[illegible]	0
6	[illegible]	[illegible]	0
			0

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

LSC-20108A

DISASSEMBLY/ASSEMBL PROFILE

NAME E TATTEN ALC OC DATE 5/1/89 NCC MATRCS SHEET 1 OF 1

TOP ASSEMBLY ITEM NUMBER	TOP ASSEMBLY WCD	TOP ASSEMBLY WCD DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY (2) ITEM NUMBER	SUBASSEMBLY CHILD WCD	SUBASSEMBLY CHILD WCD DATE	SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
49802A	CBE401	89088	080	310	PCN NSN P/N 50135A	CBE402	89019	N (1)
49806A					PCN NSN P/N 50138A	CBE402	89019	N (1)
49808A					PCN NSN P/N 50136A	CBE403	88174	N (1)
49810A					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			

NOTE: (1) NOZZLES REMOVED ARE NOT MATCHED SETS AND ARE NOT REQUIRED TO BE REINSTALLED IN SAME MANIFOLD FROM WHICH REMOVED.
(2) NOZZLES ARE INTERCHANGEABLE IN ALL 4 MANIFOLD POSITIONS

LSC-2(XM)5A

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 49802A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS) HRS
1	8277	[redacted] 8278	24
2	8293	8295	48
3	8314	8314	0
4	8333	8335	48
5	8342	8343	24
6	8362	8362	0
7	9005 [redacted]	9009	96
8	9023	9023	0
9	9031	9034	72
10	9046	9048	48
			36

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE

LSC-20107A

"OUT" DATES PRC. .LE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPCB SHEET 1 OF 1

PCII
IISH
PII 49802A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS A TIME (RANK)
1	8295	8298	72
2	8309	8309	0
3	8336	8337	24
4	8354	8357	72
5	8358	8358	0
6	9017	9018	24
7	9030	9030	0
8	9034	9037	72
9	9052	9052	0
10	9067	9069	48
			32

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

LSC-20108A

OPERATION PROFILE

NAME E. TOTEN ALC OC DATE 5/9/87 RCC MATPCB SHEET 1 OF 4

PCN
NSN
PN 498024 WCD CBEATIA ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
010		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.10	BEN	1	1.0	.10	
020		PROC	.33	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.40	OC 1132	1	1.0	.40	
030		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	OC 1132	1	1.0	.10	
040		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	BEN	1	1.0	.10	

LSC-20092C

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 4

PCH

HSH 4980RA PN _____ WCD CBEAT 1A ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	[illegible]											
				SETUP											
				PROCESS	—	—	OP09	1	1.0	.20	OC 1132	1	1.0	.20	
060		PROC	1.0	[illegible]											
				SETUP											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
070		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
080		TEST	1.0	[illegible]											
				SETUP											
				PROCESS	—	—		1	1.0	.12	OC 1132	1	1.0	.12	
090		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 4

PCN
NSN 45802A
PIN

WCD CBEAT 1 A ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.02	OC 1132	1	1.0	.02	
110		PROC	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	4.0	OC 1132	1	1.0	4.0	
120		REP	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	OC 1132	1	1.0	.05	
130		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.80	OC 1132	1	1.0	.80	
140		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.01	OC 1132	1	1.0	.01	

OPERATION PROFILE

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

PCN/ISN/PIN 45802A WCD CBEAT 1A ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.01	BEN	1	1.0	.05	
160		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	BEN	1	1.0	.05	
170		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.20	BEN	1	1.0	.20	
9999		OUT	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	32.0									
				TRANSIT											
				SETUP											
				PROCESS											

LSC-20092C

5678B

FLOW PROCESS CHART

SUBJECT JSV MANIFOLD DATE 5/3/89

ITEM CODE
PCN ☒
NSN ☐
P/N ☐

WCD CBE4T1 WCD DATE 88174

49802A, ~~49806A, 49808A, 49810A~~

CHART BEGINS SAMPLE - ORIGINAL ISSUE

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○▶D□▽	RECEIVE, MOVE MANIFOLD TO TEST			○▷D□▽	
020		○▷▶□▽	SETUP TEST STAND			○▷D□▽	
030	010	●▷D□▽	MOUNT MANIFOLD ON TEST STAND			○▷D□▽	
040		○▷▶□▽	CHANGE NOZZLE CLAMP TIPS			○▷D□▽	
050		●▷D□▽	REMOVE ANS			○▷D□▽	
060		●▷D□▽	INSTALL CLAMPS			○▷D□▽	
070	040/050	●▷D□▽	PERFORM SPRAY TEST			○▷D□▽	
080	060	●▷D□▽	PERFORM INTERNAL LEAK TEST			○▷D□▽	
090	030	●▷D□▽	PERFORM EXTERNAL LEAK TEST			○▷D□▽	
100		●▷D□▽	REMOVE NOZZLE CLAMPS			○▷D□▽	
110		●▷D□▽	BARE FACE NOZZLE SEATS			○▷D□▽	
120		●▷D□▽	REPLACE NOZZLE AND SEAL			○▷D□▽	
130	070	●▷D□▽	OIL FLUSH MANIFOLD			○▷D□▽	
140		●▷D□▽	INSTALL NEW GASKET			○▷D□▽	
150		●▷D□▽	REMOVE MANIFOLD FROM TEST STAND			○▷D□▽	
160	080, 085	●▷D□▽	COMPLETE PAPERWORK			○▷D□▽	
170		○▶D□▽	MOVE MANIFOLD TO PICK UP AREA			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME E. Tohen ALC OC DATE 04/20/89 RCC MATPCB SHEET 1 OF 5

PCN
NSN 49806A
P/N

WCD CBE401B WCD DATE 89088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[illegible]											
				[illegible]											
				PROCESS	1.0	36.0									
020		REC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	BP09	1	1.0	4.5	BEN40	1	1.0	4.5	
075		DIS	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.45	BEN40	1	1.0	.45	
115		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
135		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.12	BEN40	1	1.0	.12	

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 5

PCN
NSN
P/N _____ WCD CBE401B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	CLN	1.0	[redacted] Process	-	-	BP09	1	1.0	.10	OC 3338	1	1.0	1.0	total of of 3.0 hrs cln.
				[redacted] Proces	-	-		1	1.0	.10	OC 3349	1	1.0	1.0	
				PROCESS	-	-		1	1.0	.10	OC 4132	1	1.0	1.0	
160		PROC	1.0	[redacted]											ory
				SETUP											
				PROCESS	1.0	8.0		1	1.0	.07	BEN40	1	1.0	.07	
180	MAT CM	MACH	1.0	[redacted]											
				SETUP											
				PROCESS	1.0	72.0									
190	MAT PCB	INSP	1.0	[redacted]											
				SETUP											
				PROCESS	-	-	BP09	1	1.0	.03	BEN40	1	1.0	.03	
200		REP	1.0	[redacted]											
				[redacted]											
				PROCESS	-	-		1	1.0	.08	BEN40	1	1.0	.08	

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

PCN
NSN
P/N _____ WCD CBE401B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
215	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	.02	BEN40	1	1.0	.02	
235		PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.12	BEN40	1	1.0	.12	
250		REP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
265	MAT PCM	MACH	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	24.0									
280	MAT PCB	PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	2.5	BEN40	1	1.0	2.5	

OPERATI . . PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 5

PCN
NSN
P/N _____ WCD CBE 401B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
290	MAT ACB	CLN	1.0	~~[illegible]~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	.10	OC 1178	1	1.0	.10	
300		INSP	1.0	~~TRANSIT~~											
				~~SCRAP~~											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
310		ASSY	1.0	~~TRANSIT~~											
				~~SCRAP~~											
				PROCESS	—	—		1	1.0	.70	BEN40	1	1.0	.70	
335		PROC	1.0	~~TRANSIT~~											
				~~SCRAP~~											
				PROCESS	—	—		1	1.0	.15	BEN40	1	1.0	.15	
360		DIS	1.0	~~TRANSIT~~											
				~~SCRAP~~											
				PROCESS	—	—		1	1.0	.05	BEN40	1	1.0	.05	

OPERATIC . PROFILE

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

PCN
NSN
P/N _____ WCD CBE401B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
370	MAT PCB	INSP	1.0	TRANSIT											NDT
				SETUP											
				PROCESS	—	—	BP09	1	1.0	.02	OC 0229	1	1.0	.02	
390		INSP	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.01	BEN 40	1	1.0	.01	
415		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.15	BEN 40	1	1.0	.15	
444		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	--		1	1.0	.26	BEN 40	1	1.0	.26	
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	32.0									

LSC-2000C

(5, 6, 7, 8A)

FLOW PROCESS CHART

SUBJECT J57 MANIFOLDS DATE 4/21/89

ITEM CODE PCN ☒ NSN ☐ P/N ☐ WCD CBE401 WCD DATE 89088

4[redacted]A, 4980GA, 4[redacted]8A, 4[redacted]0A MAT PCB

CHART BEGINS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	RECEIVE MANIFOLDS IN BLDG 3123		340	● ▷ D □ ▽	CAP NOZZLES AND INLET FLANGE
011		● ▷ D □ ▽	UNCRATE MANIFOLDS (SHOP PERSONNEL)		350	○ ▶ D □ ▽	MOVE TO TEST IN BLDG 3108
012		○ ▶ D □ ▽	MOVE MANIFOLDS TO BLDG 3001 O/H SHOP		350	○ ▷ ■ □ ▽	DELAY FOR TESTING IAW CBT401
013		● ▷ D □ ▼	UNLOAD; STORE ON SHOP FLOOR		350	○ ▶ D □ ▽	RETURN FROM TEST TO BLDG 3001 O/H
014		● ▷ D □ ▽	REMOVE MANIFOLD FROM SHIPPING BOARDS			● ▷ D □ ▽	DEMOUNT MANIFOLD FROM METAL SHIP FIXT.
015		● ▷ D □ ▽	REMOVE NOZZLE DUST CAPS; OIL NOZZLES		360	○ ▷ D ■ ▽	DISTORTION / WARP CHECK INSPECT FLANGE, ETC.
016		○ ▷ ▶ □ ▽	WAIT 1-1/2 HRS FOR OIL TO LOOSEN NOZZLES		360	● ▷ D □ ▽	COLD BEND MANIFOLD IF WARPED
020	020	● ▷ D □ ▽	REMOVE NOZZLES (24) FM MANIFOLD & CLOSE.		365	○ ▷ D ■ ▽	VISUALLY INSPECT HEAT SHIELDS & WELDS FOR CRACKS
021		● ▷ D □ ▽	REMOVE TABLOCKS AND SEALS FROM NOZZLES		368	● ▶ D □ ▽	SEND TO WELDING FOR CRACK REPAIR IF REQ B/S
022		● ▷ D □ ▽	SEPARATE NOZZLES; PLACE IN SHIPG TRAYS			○ ▷ D □ ▽	— TABLOCKS
030		○ ▷ D ■ ▽	VISUALLY INSPECT MANIFOLD & IDENTIFY		370	● ▷ D □ ▽	CAP PORTS, SECURE BOLTS TO FLANGE ETC.
050	050	● ▷ D □ ▽	MEASURE INLET FLANGE THICKNESS DIMENSION			● ▷ D □ ▽	MOUNT MANIFOLD IN WOOD SHIPPING BOARD
065	065	● ▷ D □ ▽	DRILL 4 Ø.55 HOLES IN CLUSTER DUMMY TUBES		380	● ▷ D □ ▽	COMPLETE PROCESS PAPERWORK ATP 249
070		● ▷ D □ ▽	INSTALL RESTRICTORS IN HEAD; NOZZLE PORTS		390	● ▷ D □ ▽	TAG MANIFOLD STRAIN PAPERWORK
080		● ▷ D □ ▽	CLEAN MANIFOLD IAW T.O.		400	● ▷ D □ ▽	SUPPLY QA MOD 66-26 & 13 CELL
090		● ▷ D □ ▽	REMOVE RESTRICTORS FM NOZZLES/HARDWARE; THRUK			○ ▷ D □ ▽	
100		○ ▷ ▶ □ ▽	HANG IN RACK TO DRY- MIN 8 HRS			○ ▷ D □ ▽	
150 B/S		● ▶ D □ ▽	TRANSFER TO/FROM MACHINE SHOP			○ ▷ D □ ▽	
220	220	○ ▷ D ■ ▽	PERFORM MANIFOLD DISTORTION/WARP CHECK			○ ▷ D □ ▽	
221	220	● ▷ D □ ▽	COLD BEND MANIFOLD IF WARPED			○ ▷ D □ ▽	
222		○ ▷ D ■ ▽	INSPECT HEAT SHIELDS & WELDS FOR CRACKS			○ ▷ D □ ▽	
	221	○ ▷ D ■ ▽	INSPECT FOR NOZZLE CLUSTER DISTORTION			○ ▷ D □ ▽	
		● ▷ D □ ▽	ALIGN MANIFOLD METRAS			○ ▷ D □ ▽	
	223	● ▷ D □ ▽	IF FLEX MOUNT MAN: STD TORQUE BOLTS; LOCKWIR			○ ▷ D □ ▽	
	223	● ▷ D □ ▽	REPLACE LOOSE/DAMAGED COMBUSTION CHAMBER H			○ ▷ D □ ▽	
B/S 250		● ▷ D □ ▽	REMOUNT MANIFOLD ON METAL SHIP FIXT; INSTA			○ ▷ D □ ▽	
B/S 260		● ▷ D □ ▽	BACKSHOP; MACHINE AND WELDING SHOPS			○ ▷ D □ ▽	
290	290	● ▷ D □ ▽	INSPECT NOZZLE BOSS SEATS, THREADS; LAP S			○ ▷ D □ ▽	
300	300	● ▷ D □ ▽	FLUSH MANIFOLD W/ PD-680			○ ▷ D □ ▽	
	290	○ ▷ D ■ ▽	MEASURE NOZZLE SEAT DEPTH DIMENSION			○ ▷ D □ ▽	
	310*	● ▷ D □ ▽	SELECT & INSTALL CORRECT NOZZLES; SERIAL; TABLOCKS			○ ▷ D □ ▽	
	330	○ ▷ D ■ ▽	IDENTIFY & DOCUMENT P/N S/N OF MANIFOLD			○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

* INCLUDES WCO OPERATION 320

NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE INCLUDED IN OPERATIONS

DISASSEMBLY/ASSEMBLY ROUTE

NAME E. TOTTEN ALC OC DATE 5/1/89 RCC MAT-PCB SHEET 1 OF 1

TOP ASSEMBLY ITEM NUMBER	TOP ASSEMBLY WCO	TOP ASSEMBLY WCO DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY (2) ITEM NUMBER	SUBASSEMBLY CHILD WCO	SUBASSEMBLY CHILD WCO DATE	SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
49802A	CBE401	89088	080	310	PCN/NSN/P/N 50135A	CBE402	89019	N (1)
49806A					PCN/NSN/P/N 50138A	CBE402	89019	N (1)
49808A					PCN/NSN/P/N 50136A	CBE403	88174	N (1)
49810A					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			

NOTE: (1) NOZZLES REMOVED ARE NOT MATCHED SETS AND ARE NOT REQUIRED TO BE REINSTALLED IN SAME MANIFOLD FROM WHICH REMOVED.
(2) NOZZLES ARE INTERCHANGEABLE IN ALL 4 MANIFOLD SECTIONS

LSC-2(XH)5A

OPERATION PROFILE

NAME E. TOTEN ALC OC DATE 5/9/87 NCC MATPCB SHEET 1 OF 4

PCN
NSN
P/N 49806A WCD CBATT1B WCD DATE 88174

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
010		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.10	BEN	1	1.0	.10	
020		PROC	.33	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.40	OC 1132	1	1.0	.40	
030		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	OC 1132	1	1.0	.10	
040		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	BEN	1	1.0	.10	

OPERATION PR ILE

NAME _____ ALC _____ DATE _____ NCC _____ SHEET 2 OF 4

PCH

NSN 4980BA WCD CBEAT 1B WCD DATE 88174

PN _____

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	OP 09	1	1.0	.20	OC 1132	1	1.0	.20	
060		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
070		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
080		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.12	OC 1132	1	1.0	.12	
090		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 4

PCN
NSN 49806A
PIN _____ WCD CBE4T1B ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.02	OC 1132	1	1.0	.02	
110		PROC	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	4.0	OC 1132	1	1.0	4.0	
120		REP	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	OC 1132	1	1.0	.05	
130		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.80	OC 1132	1	1.0	.80	
140		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.01	OC 1132	1	1.0	.01	

OPERATION PROFILE

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

PCN
NSN 49806A
PN _____ WCD CBE4T 1B ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MAT			[redacted]											
150	PCB	PROC	1.0	[redacted]											
				PROCESS	—	—	DP09	1	1.0	.01	BEN	1	1.0	.05	
160		PW	1.0	[redacted]											
				PROCESS	—	—		1	1.0	.05	BEN	1	1.0	.05	
170		PW	1.0	[redacted]											
				PROCESS	—	—		1	1.0	.20	BEN	1	1.0	.20	
9999		OUT	1.0	[redacted]											
				PROCESS	1.0	32.0									
				TRANSIT											
				SETUP											
				PROCESS											

5,678

FLOW PROCESS CHART

SUBJECT J57 MAN. FOLD DATE 5/7/89

ITEM CODE
PCN [X]
NSN [ ]
P/N [ ]

WCD CBEAT1 WCD DATE 88174

~~44[illegible]~~, 49806A, ~~49[illegible]~~, ~~49[illegible]~~A

CHART BEGINS _____ SOURCE: MELVIN LOVINGS

CHART ENDS _____ PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○▶D□▽	RECEIVE & MOVE MANIFOLD TO TEST			○▷D□▽	
020		○▷●□▽	SETUP TEST STAND			○▷D□▽	
030	010	●▷D□▽	MOUNT MANIFOLD ON TEST STAND			○▷D□▽	
040		○▷●□▽	CHANGE NOZZLE CLAMP TIPS			○▷D□▽	
050		●▷D□▽	REMOVE CAPS			○▷D□▽	
060		●▷D□▽	INSTALL CLAMPS			○▷D□▽	
070	040/050	●▷D□▽	PERFORM SPRAY TEST			○▷D□▽	
080	020	●▷D□▽	PERFORM INTERNAL LEAK TEST			○▷D□▽	
090	030	●▷D□▽	PERFORM EXTERNAL LEAK TEST			○▷D□▽	
100		●▷D□▽	REMOVE NOZZLE CLAMPS			○▷D□▽	
110		●▷D□▽	BACKFACE NOZZLE SEATS			○▷D□▽	
120		●▷D□▽	REPLACE NOZZLE AND SEAL			○▷D□▽	
130	090	●▷D□▽	OIL FLUSH MANIFOLD			○▷D□▽	
140		●▷D□▽	INSTALL MAIN GASKET			○▷D□▽	
150		●▷D□▽	REMOVE MANIFOLD FROM TEST STAND			○▷D□▽	
160	020, 025	●▷D□▽	COMPLETE HARDWARE			○▷D□▽	
170		○▶D□▽	MOVE MANIFOLD TO PICK UP AREA			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC 20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 NCC MTPCB SHEET 1 OF 1

PCN
NSN
PIN [redacted] 498061A

PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)
1	8264	8264	0
2	8293	8295	48
3	8298	8299	24
4	8306	8306	0
5	8306	8307	24
6	8323	8323	0
7	9017	9018	24
8	9017	9018	24
9	9030	9032	48
10	9041 [redacted]	9044	72
			27

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

LSC-20107A

"OUT" DATES PRC. .LE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 49806A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
1	8281	8281	0
2	8213	8214	24
3	8319	8319	0
4	8323	8326	72
5	8326	8326	0
6	8347	8348	24
7	9037	9037	0
8	9037	9038	24
9	9047	9048	24
10	9060	9061	24
			(10)

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

LSC-20108A

OPERATIC.. PROFILE

NAME E. Tothen ALC OC DATE 04/20/89 RCC MATPCB SHEET 1 OF 5

PCN NSN 49808A P/N WCD CBE401C V/CD DATE 89088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[illegible]											
				[illegible]											
				PROCESS	1.0	36.0									
020		REC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	BP09	1	1.0	4.5	BEN40	1	1.0	4.5	
075		OIS	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.45	BEN40	1	1.0	.45	
115		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
135		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.12	BEN40	1	1.0	.12	

OPERATIC...PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 5

PCN
NSN
P/N _____ WCD CBE401C WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	CLN	1.0	[illegible] Process	-	-	BP09	1	1.0	.10	OC 3338	1	1.0	1.0	total of of 3.0 hrs cln.
				[illegible] Proces	-	-		1	1.0	.10	OC 3349	1	1.0	1.0	
				PROCESS	-	-		1	1.0	.10	OC 4132	1	1.0	1.0	
160		PROC	1.0	~~TRANSIT~~											ory
				~~SETUP~~											
				PROCESS	1.0	8.0		1	1.0	.07	BEN40	1	1.0	.07	
180	MAT CM	MACH	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	72.0									
190	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	-	-	BP09	1	1.0	.03	BEN40	1	1.0	.03	
200		REP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	-	-		1	1.0	.08	BEN40	1	1.0	.08	

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

PCN
NSN
P/N _____ WCD CBE401C WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
215	MAT PCB	INSP	1,0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	.02	BEN40	1	1.0	.02	
235		PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.12	BEN40	1	1.0	.12	
250		REP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
265	MAT PCM	MACH	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	24.0									
260	MAT PCB	PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	2.5	BEN40	1	1.0	2.5	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 5

PCN
NSN
P/N _____ WCD CBE 401C WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
290	MAT ACB	CLN	1.0	~~LABOR~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	.10	OC 1178	1	1.0	.10	
300		INSP	1.0	~~TRANSOFF~~											
				~~SCRUB~~											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
310		ASSY	1.0	~~TRANSOFF~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.70	BEN40	1	1.0	.70	
335		PROC	1.0	~~TRANSOFF~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.15	BEN40	1	1.0	.15	
360		DIS	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.05	BEN40	1	1.0	.05	

OPERATIC . .PROFILE

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

PCN
NSN
P/N _____ WCD CBE401C WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
370	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											NDE
				PROCESS	—	—	BP09	1	1.0	.02	OC 0229	1	1.0	.02	
390		INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.01	BEN 40	1	1.0	.01	
415		PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.15	BEN 40	1	1.0	.15	
444		PW	1.0	~~TRANSIT~~											
				SETUP											
				PROCESS	—	—		1	1.0	.26	BEN 40	1	1.0	.26	
9999		OUT	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	32.0									

(5, 6, 7, 8A)

J57 MANIFOLDS FLOW PROCESS CHART

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

WCD CBE401 WCD DATE 89088

ITEM CODE
PCN ☒
NSN ☐
P/N ☐

~~4988A~~, ~~4988A~~, 4980BA, ~~4988AA~~ MAT PCB

CHART BEGINS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	RECEIVE MANIFOLDS IN BLDG 3123		340	● ▷ D □ ▽	CAP NOZZLES AND INLET FLANGE
011		● ▷ D □ ▽	UNCRATE MANIFOLDS (SHOP PERSONNEL)		350	○ ▶ D □ ▽	MOVE TO TEST IN BLDG 3108
012		○ ▶ D □ ▽	MOVE MANIFOLDS TO BLDG 3001 O/H SHOP		350	○ ▷ ▶ □ ▽	DELAY FOR TESTING IAW CBT401
013		● ▷ D □ ▼	UNLOAD; STORE ON SHOP FLOOR		350	○ ▶ D □ ▽	RETURN FROM TEST TO BLDG 3001 O/H
014		● ▷ D □ ▽	REMOVE MANIFOLD FROM SHIPPING BOARDS			● ▷ D □ ▽	DEMOUNT MANIFOLD FROM METAL SHIP FXTR
015		● ▷ D □ ▽	REMOVE NOZZLE DUST CAPS; OIL NOZZLES		360	○ ▷ D ■ ▽	DISTORTION/WARP CHECK INSPECT FLANGE, ETC.
016		○ ▷ ▶ □ ▽	WAIT 1-1½ HRS FOR OIL TO LOOSEN NOZZLES		360	● ▷ D □ ▽	COLD BEND MANIFOLD IF WARPED
020	020	● ▷ D □ ▽	REMOVE NOZZLES (24) FM MANIFOLD & CLOSE.		365	○ ▷ D ■ ▽	VISUALLY INSPECT HEAT SHIELDS & WELDS FOR CRACKS
021		● ▷ D □ ▽	REMOVE TABLOCKS AND SEALS FROM NOZZLES		368	● ▶ D □ ▽	SEND TO WELDING FOR CRACK REPAIR IF REQ B/S — TABLOCKS
022		● ▷ D □ ▽	SEPARATE NOZZLES; PLACE IN SHOP TRAYS			○ ▷ D □ ▽	
030		○ ▷ D ■ ▽	VISUALLY INSPECT MANIFOLD & IDENTIFY		370	● ▷ D □ ▽	CAM PORTS; SECURE BOLTS TO FRAME ETC.
050	050	● ▷ D □ ▽	MEASURE INLET FLANGE THICKNESS DIMENSION			● ▷ D □ ▽	MOUNT MANIFOLD ON WOOD SHIPPING BOARD
065	065	● ▷ D □ ▽	DRILL & REAM 55 HOLES IN CLUSTER DUMMY TUBES		380	● ▷ D □ ▽	COMPLETE PROCESS PAPERWORK/ ATP 244
070		● ▷ D □ ▽	INSTALL RESTRICTORS IN HEAD & NOZZLE PORTS		390	● ▷ D □ ▽	TAG MANIFOLD ATTACH PAPERWORK
080		● ▷ D □ ▽	CLEAN MANIFOLD IAW T.O.		400	● ▷ D □ ▽	COMPLY W/ MADI 66-26 & 13 CELL
090		● ▷ D □ ▽	REMOVE PROTECTIVE FM NOZZLES/INSPECT/TAG			○ ▷ D □ ▽	
100		○ ▷ ▶ □ ▽	HANG IN RACK TO DRY - MIN 8 HRS			○ ▷ D □ ▽	
B/S 150		● ▶ D □ ▽	TRANSFER TO/FROM MACHINE SHOP			○ ▷ D □ ▽	
220	220	○ ▷ D ■ ▽	PERFORM MANIFOLD DISTORTION/WARP CHECK			○ ▷ D □ ▽	
221	220	● ▷ D □ ▽	COLD BEND MANIFOLD IF WARPED			○ ▷ D □ ▽	
222		○ ▷ D ■ ▽	INSPECT HEATSHIELDS & WELDS FOR CRACKS			○ ▷ D □ ▽	
	221	○ ▷ D ■ ▽	INSPECT FOR NOZZLE CLUSTER DISTORTION			○ ▷ D □ ▽	
		● ▷ D □ ▽	ALIGN MANIFOLD METALS			○ ▷ D □ ▽	
	223	● ▷ D □ ▽	IF FLEX MOUNT MAN: STD TORQUE BOLTS; LOCKWIRE			○ ▷ D □ ▽	
	223	● ▷ D □ ▽	REPLACE LOOSE/DAMAGED COMBUSTION CHAMBER HW			○ ▷ D □ ▽	
B/S 250		● ▷ D □ ▽	REMOUNT MANIFOLD ON METAL SHIP FXTR; INSTR			○ ▷ D □ ▽	
B/S 260		● ▷ D □ ▽	BACKSHOP: MACHINE AND WELDING SHOPS			○ ▷ D □ ▽	
290	290	● ▷ D □ ▽	INSPECT NOZZLE BOSS, SEATS, THREADS; LAP SE			○ ▷ D □ ▽	
300	300	● ▷ D □ ▽	FLUSH MANIFOLD W/ PD-680			○ ▷ D □ ▽	
	290	○ ▷ D ■ ▽	MEASURE NOZZLE SEAT DEPTH DIMENSION			○ ▷ D □ ▽	
	310*	● ▷ D □ ▽	SELECT & INSTALL LOCAL NOZZLES; SEAL; TABLOCK			○ ▷ D □ ▽	
	330	○ ▷ D ■ ▽	IDENTIFY & DOCUMENT P/N S/N OF MANIFOLD			○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

* INCLUDES CWCO OPERATION 320

NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE INCLUDED IN OPERATIONS

DISASSEMBLY/ASSEMBLY PROFILE

NAME E. TOTTEN ALC OC DATE 5/1/89 RCC MAT PCB SHEET 1 OF 1

TOP ASSEMBLY ITEM NUMBER	WCO	WCO DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY ITEM NUMBER	CHILD WCO	CHILD WCO DATE	SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
49802A	CBE401	89088	080	310	PCN/NSN/P/N 50135A	CBE402	89019	N (1)
49806A	↓	↓	↓	↓	PCN/NSN/P/N 50138A	CBE402	89019	N (1)
49808A	↓	↓	↓	↓	PCN/NSN/P/N 50136A	CBE403	88174	N (1)
49810A	↓	↓	↓	↓	PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			
					PCN/NSN/P/N			

NOTE: (1) NOZZLES REMOVED ARE NOT MATCHED SETS AND ARE NOT REQUIRED TO BE REINSTALLED IN SAME MANIFOLD FROM WHICH REMOVED.

(2) NOZZLES ARE INTERCHANGEABLE IN ALL 4 MANIFOLD SECTIONS

LSC-2(XH)5A

OPERATION PROFILE

NAME E. TOTEN ALC OC DATE 5/9/87 RCC MATPCB SHEET 1 OF 4

PCN
NSN
P/N 49808A WCD CBEATIC WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
010		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.10	BEN	1	1.0	.10	
020		PROC	.33	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.40	OC 1132	1	1.0	.40	
030		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	OC 1132	1	1.0	.10	
040		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	BEN	1	1.0	.10	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 4

PCN
NSN
P/N 49808A WCD CBEAT 1C WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	OP 09	1	1.0	.20	OC 1132	1	1.0	.20	
060		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
070		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
080		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.12	OC 1132	1	1.0	.12	
090		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	

OPERATION PRO LE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 4

PCN
NSN
PIN 49808A WCD CBE4T1C ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.02	OC 1132	1	1.0	.02	
110		PROC	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	4.0	OC 1132	1	1.0	4.0	
120		REP	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	OC 1132	1	1.0	.05	
130		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.80	OC 1132	1	1.0	.80	
140		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.01	OC 1132	1	1.0	.01	

OPERATION PRO[illegible]LE

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

PCN
NSN
PN 49808C

WCD CBEXT 1C ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	PROC	1.0	[illegible]											
				SETUP											
				PROCESS	—	—	DP09	1	1.0	.01	BEN	1	1.0	.05	
160		PW	1.0	[illegible]											
				SETUP											
				PROCESS	—	—		1	1.0	.05	BEN	1	1.0	.05	
170		PW	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	BEN	1	1.0	.20	
9999		OUT	1.0	[illegible]											
				SETUP											
				PROCESS	1.0	32.0									
				TRANSIT											
				SETUP											
				PROCESS											

5,6,7,8 B

FLOW PROCESS CHART

SUBJECT JSJ MANIFOLD DATE 5/9/89

ITEM CODE PCN [X] NSN [ ] P/N [ ] WCD CBE4T1 WCD DATE 88174

[redacted], [redacted], 49808A, [redacted]

CHART BEGINS SOURCE: MELVIN LOUNGS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○ ▷ D □ ▽	ASSEMBLY MOVE MANIFOLD TO TEST			○ D □ ▽	
020		○ ▷ D □ ▽	SETUP TEST STAND			○ D □ ▽	
030	010	○ ▷ D □ ▽	MOUNT MANIFOLD ON TEST STAND			○ D □ ▽	
040		○ ▷ D □ ▽	CHANGE NOZZLE CLAMP TIPS			○ D □ ▽	
050		○ ▷ D □ ▽	REMOVE CAPS			○ D □ ▽	
060		○ ▷ D □ ▽	INSTALL CLAMPS			○ D □ ▽	
070	040/050	○ ▷ D □ ▽	PERFORM SPRAY TEST			○ D □ ▽	
080	020	○ ▷ D □ ▽	PERFORM INTERNAL LEAK TEST			○ D □ ▽	
090	030	○ ▷ D □ ▽	PERFORM EXTERNAL LEAK TEST			○ D □ ▽	
100		○ ▷ D □ ▽	REMOVE NOZZLE CLAMPS			○ D □ ▽	
110		○ ▷ D □ ▽	BACKFACE NOZZLE SEATS			○ D □ ▽	
120		○ ▷ D □ ▽	REPLACE NOZZLE AND SEAL			○ D □ ▽	
130	090	○ ▷ D □ ▽	OIL FLUSH MANIFOLD			○ D □ ▽	
140		○ ▷ D □ ▽	INSTALL NEW GASKET			○ D □ ▽	
150		○ ▷ D □ ▽	REMOVE MANIFOLD FROM TEST STAND			○ D □ ▽	
160	060, 065	○ ▷ D □ ▽	COMPLETE PAPERWORK			○ D □ ▽	
170		○ ▷ D □ ▽	MOVE MANIFOLD TO PICK UP AREA			○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	
		○ ▷ D □ ▽				○ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPC B SHEET 1 OF 1

PCN
NSN
PN 49808A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (~~DAYS~~ HRS)
1	8264	8265	24
2	8278	8279	24
3	8294	8298	96
4	8298	8299	24
5	[redacted]9005	9005	0
6	9018	9019	24
7	9031	9031	0
8	9031	9031	0
9	9038	9040	48
10	9038	9039	24
			27

* "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD OR DATE

LSC-20107A

"OUT" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPCB SHEET 1 OF 1

PCII NSN P/N 49808A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS ~~DAYS~~ A TIME
1	8281	8281	0
2	8293	8295	48**
3	8309	8309	0
4	8312	8314	48
5	9025	9026	24
6	9038	9038	0
7	9047	9048	24
8	9048	9048	0
9	9060	9061	24
10	9060	9060	0.
			(17)

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

LSC-20108A

OPERATIC.. PROFILE

NAME E. Tolhen ALC OC DATE 04/20/89 RCC MATPCB SHEET 1 OF 5

PCN NSN 498104 P/N WCD CBE401D WCD DATE 89088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[illegible]											
				[illegible]											
				PROCESS	1.0	36.0									
020		REC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	BP09	1	1.0	4.5	BEN40	1	1.0	4.5	
075		DIS	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.45	BEN40	1	1.0	.45	
115		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
135		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.12	BEN40	1	1.0	.12	

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 5

PCN
NSN
P/N _____ WCD CBE4010 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	CLN	1.0	[illegible] Process	-	-	BP09	1	1.0	.10	OC 3338	1	1.0	1.0	total of of 3.0 hrs cln.
				[illegible] Proces	-	-		1	1.0	.10	OC 3349	1	1.0	1.0	
				PROCESS	-	-		1	1.0	.10	OC 4132	1	1.0	1.0	
160		PROC	1.0	~~TRANSIT~~											ory
				~~SETUP~~											
				PROCESS	1.0	8.0		1	1.0	.07	BEN40	1	1.0	.07	
180	MAT CM	MACH	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	72.0									
190	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	-	-	BP09	1	1.0	.03	BEN40	1	1.0	.03	
200		REP	1.0	TRANSIT											
				~~SETUP~~											
				PROCESS	-	-		1	1.0	.08	BEN40	1	1.0	.08	

LSC-2000 (C

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

PCN
NSN
P/N _____ WCD CBE4010 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
215	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	.02	BEN40	1	1.0	.02	
235		PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.12	BEN40	1	1.0	.12	
250		REP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
265	MAT PCM	MACH	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	24.0									
280	MAT PCB	PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	2.5	BEN40	1	1.0	2.5	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 5

PCN
NSN
P/N _____ WCD CBE 401P WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
290	MAT RCB	CLN	1.0	~~[illegible]~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	.10	OC 1178	1	1.0	.10	
300		INSP	1.0	~~TRANSOFF~~											
				~~SCRAP~~											
				PROCESS	—	—		1	1.0	.10	BEN40	1	1.0	.10	
310		ASSY	1.0	~~TRANSF~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.70	BEN40	1	1.0	.70	
335		PROC	1.0	~~TRANSOFF~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.15	BEN40	1	1.0	.15	
360		DIS	1.0	~~TRANSF~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.05	BEN40	1	1.0	.05	

OPERATIC . . PROFILE

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

PCN
NSN
P/N _____ WCD CBE4010 W/CD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
370	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											NDE
				PROCESS	—	—	BP09	1	1.0	.02	OC 0229	1	1.0	.02	
390		INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.01	BEN 40	1	1.0	.01	
415		PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.15	BEN 40	1	1.0	.15	
444		PW	1.0	~~TRANSIT~~											
				SETUP											
				PROCESS	—	—		1	1.0	.26	BEN 40	1	1.0	.26	
9999		OUT	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	32.0									

(5, 6, 7, 8A)

J57 MANIFOLDS FLOW PROCESS CHART

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

ITEM CODE
PCN [X]
NSN [ ]
P/N [ ]

WCD CBE401 WCD DATE 89088

~~4956~~A, ~~4986~~A, ~~4~~A, 4981OA MAT PCB

CHART BEGINS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	RECEIVE MANIFOLDS IN BLDG 3123		340	●▷D□▽	CAP NOZZLES AND INLET FLANGE
011		●▷D□▽	UNCRATE MANIFOLDS (SHOP PERSONNEL)		350	○▶D□▽	MOVE TO TEST IN BLDG 3108
012		○▶D□▽	MOVE MANIFOLDS TO BLDG 3081 O/H SHOP		350	○▷▶□▽	DELAY FOR TESTING IAW CBT401
013		●▷D□▼	UNLOAD; STORE ON SHOP FLOOR		350	○▶D□▽	RETURN FROM TEST TO BLDG 3081 O/H
014		◐▷D□▽	REMOVE MANIFOLD FROM SHIPPING BOARDS			◐▷D□▽	DEMOUNT MANIFOLD FROM METAL SHIP FIXT
015		●▷D□▽	REMOVE NOZZLE DUST CAPS; OIL NOZZLES		360	○▷D■▽	DISTORTION/WARP CHECK INSPECT FLANGE, ETC.
016		○▷▶□▽	WAIT 1-1½ HRS FOR OIL TO LOOSEN NOZZLES		360	●▷D□▽	COLD BEND MANIFOLD IF WARPED
020	020	●▷D□▽	REMOVE NOZZLES (24) FM MANIFOLD & CLOSE.		365	○▷D■▽	VISUALLY INSPECT HEAT SHIELDS & WELDS FOR CRACKS
021		●▷D□▽	REMOVE TABLOCKS AND SEALS FROM NOZZLES		368	●▶D□▽	SEND TO WELDING FOR CRACK REPAIR IF REQ
022		◐▷D□▽	SEPARATE NOZZLES; PLACE IN SHOP TRAYS			○▷D□▽	
030		○▷D■▽	VISUALLY INSPECT MANIFOLD & IDENTIFY		370	●▷D□▽	CAN PORTS, SECURE BOLTS TO FLANGE, ETC.
050	050	●▷D□▽	MEASURE INLET FLANGE THICKNESS DIMENSION			●▷D□▽	MOUNT MANIFOLD ON WOOD SHIPPING BOARD
065	065	●▷D□▽	DRILL 4 #55 HOLES IN CLUSTER DUMMY TUBES		380	◐▷D□▽	COMPLETE PROCESS PAPERWORK AFTER 240
070		●▷D□▽	INSTALL RESTRICTORS IN HEAD; NOZZLE PORTS		390	◐▷D□▽	TAG MANIFOLD STATE PAPERWORK
080		●▷D□▽	CLEAN MANIFOLD IAW T.O.		400	◐▷D□▽	ASSEMBLY W/ MAOI 66-62 @ 13 CELL
090		●▷D□▽	REMOVE RESTRICTORS FM NOZZLES/HEADS; ATTACK			○▷D□▽	
100		○▷▶□▽	HANG IN RACK TO DRY - MIN 8 HRS			○▷D□▽	
B/S 150		●▶D□▽	TRANSFER TO/FROM MACHINE SHOP			○▷D□▽	
220	220	○▷D■▽	PERFORM MANIFOLD DISTORTION/WARP CHECK			○▷D□▽	
221	220	●▷D□▽	COLD BEND MANIFOLD IF WARPED			○▷D□▽	
222		○▷D■▽	INSPECT HEATSHIELDS & WELDS FOR CRACKS			○▷D□▽	
	221	○▷D■▽	INSPECT FOR NOZZLE CLUSTER DISTORTION			○▷D□▽	
		●▷D□▽	ALIGN MANIFOLD HEADS			○▷D□▽	
	223	●▷D□▽	IF FLEX MOUNT MAN: STD TORQUE BOLTS; LOCKWIRE			○▷D□▽	
	223	●▷D□▽	INSPECT LOOSE/DAMAGED COMBUSTION CHAMBER #'S			○▷D□▽	
B/S 250		●▷D□▽	REMOUNT MANIFOLD ON METAL SHIP FIXT; INSTR			○▷D□▽	
B/S 260		●▷D□▽	BACKSHOP; MACHINE AND WELDING SHOPS			○▷D□▽	
290	290	●▷D□▽	INSPECT NOZZLE BODY, SEATS, THREADS; LAP SEATS			○▷D□▽	
310	300	●▷D□▽	FLUSH MANIFOLD W/ PD-680			○▷D□▽	
	290	○▷D■▽	MEASURE NOZZLE SEAT DEPTH DIMENSION			○▷D□▽	
	310*	●▷D□▽	SELECT & INSTALL CORRECT NOZZLES; WEAR; TABS IN			○▷D□▽	
	330	○▷D■▽	IDENTIFY & DOCUMENT P/N S/N OF MANIFOLD			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

* INCLUDES CWCO OPERATION 320

NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE INCLUDED IN OPERATIONS

DISASSEMBLY/ASSEMBLY TOOLE

NAME E. TOTTEN ALC OC DATE 5/1/89 RCC MAT PCB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY (2)			SAME REMOVED ITEM INSTALLED INTO ASST. Y/N
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
PCN 1	49802A	CBE401	8988	080	310	PCN NSN P/N 50135A	CBE402	89019	N (1)
PCN 1	49806A	↓	↓	↓	↓	PCN NSN P/N 50138A	CBE402	89019	N (1)
PCN 1	49808A					PCN NSN P/N 50136A	CBE403	88174	N (1)
PCN 1	49810A					PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			
PCN						PCN NSN P/N			

LSC-2(XH)5A

NOTE: (1) NOZZLES REMOVED ARE NOT MATCHED SETS AND ARE NOT REQUIRED TO BE REINSTALLED IN SAME MANIFOLD FROM WHICH REMOVED.
(2) NOZZLES ARE INTERCHANGEABLE IN ALL 4 MANIFOLD SECTIONS

OPERATION PROFILE

NAME E. TOTEN ALC OC DATE 5/9/87 RCC MATPCB SHEET 1 OF 4

PCN
NSN
P/N 49810A WCD CBA4TID WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
010		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.10	BEN	1	1.0	.10	
020		PROC	.33	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.40	OC 1132	1	1.0	.40	
030		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	OC 1132	1	1.0	.10	
040		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.10	BEN	1	1.0	.10	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 4

PCN
NSN
P/N 49810 A

WCD CBEAT 10 ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	OP09	1	1.0	.20	OC 1132	1	1.0	.20	
060		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
070		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	
080		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.12	OC 1132	1	1.0	.12	
090		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	OC 1132	1	1.0	.20	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 4

PCN / ASH / PIN 49810A WCD CBEATID ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	DP09	1	1.0	.02	OC 1132	1	1.0	.02	
110		PROC	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	4.0	OC 1132	1	1.0	4.0	
120		REP	.80	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.05	OC 1132	1	1.0	.05	
130		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.80	OC 1132	1	1.0	.80	
140		PROC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.01	OC 1132	1	1.0	.01	

OPERATION PR. ILE

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

PCN
NSN
PIN 49810A

WCD CBEAT 1 D ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	DP09	1	1.0	.01	BEN	1	1.0	.05	
160		PW	1.0	TRANSIT											
				[illegible]											
				PROCESS	—	—		1	1.0	.05	BEN	1	1.0	.05	
170		PW	1.0	TRANSIT											
				[illegible]											
				PROCESS	—	—		1	1.0	.20	BEN	1	1.0	.20	
9999		OUT	1.0	TRANSIT											
				[illegible]											
				PROCESS	1.0	32.0									
				TRANSIT											
				SETUP											
				PROCESS											

5,6,7,8 B

FLOW PROCESS CHART

SUBJECT J57 MANIFOLD DATE 5/9/89

ITEM CODE
PCN ☒
NSN ☐
P/N ☐

WCD CBEAT1 WCD DATE 88174

49~~80~~A, 49~~80~~A, 49~~80~~A, 49810A

CHART BEGINS SOURCE: MELVIN LOVINGS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○●D□▽	RECEIVING MOVE MANIFOLD TO TEST			○▷D□▽	
020		○▷●□▽	SETUP TEST STAND			○▷D□▽	
030	010	●▷D□▽	MOUNT MANIFOLD ON TEST STAND			○▷D□▽	
040		○▷●□▽	CHANGE NOZZLE CLAMP TIPS			○▷D□▽	
050		●▷D□▽	REMOVE CAPS			○▷D□▽	
060		●▷D□▽	INSTALL CLAMPS			○▷D□▽	
070	040/050	●▷D□▽	PERFORM SPRAY TEST			○▷D□▽	
080	020	●▷D□▽	PERFORM INTERNAL LEAK TEST			○▷D□▽	
090	030	●▷D□▽	PERFORM EXTERNAL LEAK TEST			○▷D□▽	
100		●▷D□▽	REMOVE NOZZLE CLAMPS			○▷D□▽	
110		●▷D□▽	BACKFACE NOZZLE SEATS			○▷D□▽	
120		●▷D□▽	REPLACE NOZZLE AND SEAL			○▷D□▽	
130	090	●▷D□▽	OIL FLUSH MANIFOLD			○▷D□▽	
140		●▷D□▽	INSTALL HORN GASKET			○▷D□▽	
150		●▷D□▽	REMOVE MANIFOLD FROM TEST STAND			○▷D□▽	
160	060, 065	●▷D□▽	COMPLETE PAPERWORK			○▷D□▽	
170		○●D□▽	MOVE MANIFOLD TO PICK UP AREA			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MMPCB SHEET 1 OF 1

PCN
NSN
PN 49810A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~ HRS
1	8280	8281	24
2	8294	8294	0
3	8298	8299	24
4	8298	8299	24
5	8312	8312	0
6	9023	9024	24
7	9023	9025	48
8	9034	9034	0
9	9037 [redacted]	9038	24
10	9038	9040	48
			22

* "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD OR DATE

LSC-20107A

"OUT" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN/NSN/PN 49810A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
1	8298	8298	0
2	8314	8315	24
3	8320	8320	0
4	8319	8321	48
5	8333	8333	0
6	9044	9045	24
7	9045	9045	0
8	9055	9058	72
9	9058	9058	0
10	9060	9061	24
			(20)

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

LSC-20108A

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MATPCB SHEET 1 OF 4

ITEM CODE (PCN) H8N 50067A P/N WCD CBEM29 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN, DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	20									
010	MAT PCB	REC	1.0	TRANSIT	100 0.05	BP09	001	100	0.05	OC4968	001	100	0.05	IF HAVE FAC VALVE ASSEMBLY STILL DISASSEMBLE TO RECOVER SOME PARTS. SAME ON REJECT BATCH IS 20
				SETUP										
				PROCESS										
020		DIS	1.0	TRANSIT	100 0.2			100	0.2	BEN44	001	100	0.2	DISASSEMBLE VALVE ASSY W/ SPECIAL WRENCH. 6/11 11106-1-20
				SETUP						BEN44	001	100	0.2	
				PROCESS										
030		CLN	1.0	TRANSIT	100 0.15		1	100	0.05	OC2848	001	100	0.15	CLEAN PARTS IN DEGREASER BATH
				SETUP										
				PROCESS										
031		CLN	1.0	TRANSIT	100 0.55			100	0.05	OC4137	001	100	0.5	CLEAN PARTS FREON (SONIC) TANK
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC QC DATE 5/16/87 RCC MATPCB SHEET 2 OF 4

ITEM CODE (PCN) NSN 50067A P/N WCD CBEM29 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW % / HOURS / HRS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT GRP	INSP	1.0	TRANSIT	100 0.2	AP07	001	100	0.2	BEN44	001	100	0.2	BATCH 20
				SETUP										
				PROCESS										
050		TEST	1.0	TRANSIT	100 0.2			100	0.2	BEN44	001	100	0.2	BATCH 20 EMPLOY 1 OF 15X MICROSCOPE
				SETUP										
				PROCESS										
060		NDI	0.8	TRANSIT	100 0.2	AP07	001	100	0.2	OC0229	001	100	0.2	BATCH 20 ONE IN QC LOW STOP. ARES PROBES DONE FOR INSPECTION FPI LINE.
				SETUP										
				PROCESS										
070		TEST	1.0	TRANSIT	100 0.2	BP07	001	100	0.2	BEN40	001	100	0.2	BATCH 20 NO 1% SIZE MINIMUM TO CAL. OC1602
				SETUP										
				PROCESS										
080		INSP	1.0	TRANSIT	100 0.2			100	0.2	BEN40	001	100	0.2	BATCH 20 TEST 7 PIECES EACH. NOTE 1 WIRE MEASUREMENTS
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MATPCB SHEET 3 OF 4

ITEM CODE (PCN) H8N 50067A WCD CBEM29 WCD DATE 88180

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
081	MAT PCN	DEL	1.0	TRANSIT	10	0.05		001	0	0					HOW BAGGED BOTTLE CAPS AND WANDS TILL COMPARING TO GO TO TEST
				SETUP	50	48			0	0					
				PROCESS	40	112			0	0					VACUUM - DRYING AND CLEANING TEST
082		MOVE	1.0	TRANSIT	100	0.1	BP09		100	0.1					MOVE PARTS TO TEST OR BIAS
				SETUP											
				PROCESS											
085	MAT PCN (TEST)	ASSY	1.0	TRANSIT	100	0.1	BP09	001	100	0.1	BCN43	001	100	0.1	ASSEMBLE FLOC DISPENSE PARTS @ TEST STAND OR BIAS AFTER FLOW TEST (DONE INDIVIDUALLY)
				SETUP											
				PROCESS											
090		TEST	0.05	TRANSIT	100	1.2			100	0.8	OC1777	001	100	1.2	BATCH 20 TEST OF VALVE (ASSEMBLED ABOVE IS WET, A TOOLING CHANGE ALLOWS TESTING OF ASSEMBLY INSTALLED IN NOZZLE FROM CBEM 29. (SINCE TRANSIT)
				SETUP											
				PROCESS											
100		PW	0.05	TRANSIT	100	0.1			100	0.1	BCN43	1		.1	PRESSURE TEST VALVE ASSEMBLIES ALONE, ASSEMBLY, PRESSURE CYCLE ASSEMBLY TO CONNECTED TO NOZZLES.
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MATPCB SHEET 4 OF 4

ITEM CODE (PCN) NSN 50067A WCD CBEM29 WCD DATE 88180

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
							SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
110	MAT DCB (c/m)	PW	1.0	TRANSIT	100	0.05	BP19	001	100	0.05	BGN43	001	100	0.05	VALVE ASSEMBLIES INSTALLED AND NOT INSTALLED WHILE DC MOVED TO ANOTHER PROC. PNEUMATIC
				SETUP											
				PROCESS											
120	↓	PW	1.0	TRANSIT	100	0.05			100	0.05	BGN43	001	100	0.05	PNEUMATIC
				SETUP											
				PROCESS											
130	↓	PW	1.0	TRANSIT	100	0.05			100	0.05	BGN43	150	100	0.05	SEAL
				SETUP											
				PROCESS			↓	↓							
9999	↓	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		44									
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT J74-15/17 LOW SMOKE NOZZLE O/H DATE 5/16/88

ITEM CODE
PCN [X]
NSN [ ]
P/N [ ]

WCD CBEM29 WCD DATE 88180

50067A

CHART BEGINS 010

CHART ENDS 130 PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	RECEIVE			○▷D□▽	
020	020	●▷D□▽	DISASSEMBLE			○▷D□▽	
030	030	●▷D□▽	CLEAN PL SEG			○▷D□▽	
031		●▷D□▽	CLEAN [illegible]			○▷D□▽	
040	040	○▷D■▽	INSPECT			○▷D□▽	
050	050	○▷D■▽	INSPECT			○▷D□▽	
060	060	○▷D■▽	FPI			○▷D□▽	
070	070	○▷D■▽	TURN SEAL			○▷D□▽	
080	080	○▷D■▽	FLOW CHECK W/A TEMPLATE			○▷D□▽	
081		○▷●□▽	REMOVE AND REMAKE SEAL			○▷D□▽	
082		○▷●□▽	MOVE TO BIKE UNIT			○▷D□▽	
085	085	●▷D□▽	ASSEMBLE FIXTURE			○▷D□▽	
090	090	●▷D□▽	LEAK TEST FLOW DIVIDER			○▷D□▽	
100	100	●▷D□▽	PAPERWORK			○▷D□▽	
110	110	●▷D□▽	PAPERWORK			○▷D□▽	
120	120	●▷D□▽	PAPERWORK			○▷D□▽	
130	130	●▷D□▽	SELL			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

STQ 30, 31, 29

J'17 - 15/17 LOAD SMOKE NOZZLES OVERHAUL

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MAT PCB SHEET 1 OF 7

ITEM CODE NSN (PCN) 50067A WCD CBEM30 WCD DATE 88180

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
IN	MATP CB	IN DATE	1.0	TRANSIT										DATE MARICK
				SETUP										
				PROCESS	20									
005	MAT PCB	REC	.7	TRANSIT	2.0	BP09	001	25	2.0	BEN45	1	25	2.0	NOZZLES FROM SUPPLY ARRIVING IN BLDG 3123. DOES NOT INCLUDE THOSE FROM ENGINE LINE. UNCHAT, LOAD AT INSPART
				SETUP	1.0	↓	↓	75	1.0			75	1.0	
				PROCESS										
008		INSP UC	.7	TRANSIT	0.1	BP07	001	100	0.1		~~001~~	~~100~~	~~0.1~~	MOVE NOZZLES TO SHOP IN BLDG 3031
				SETUP										
				PROCESS										
010		REC	1.0	TRANSIT	0.2	BP07	001	100	0.2	OC4968	C01	100	0.2	NOZZLES FM ENGINE LINE ("FAT CAT") ARRIVE AT SHOP. ONES FM SUPPLY ENTER FM BLDG 3123 BY CART. SEPARATE OUT CERT. STEST. AND OVERHAUL
				SETUP										
				PROCESS										
015		OIS	1.0	TRANSIT	0.02	BP09	001	100	0.02	BEN45	001	100	0.02	DISASSEMBLE VALVE ENDS. REMOVE VALVE ASSEMBLY. REINSTALL CAP. (PER INDIVIDUAL NOZZLE)
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MATPCB SHEET 2 OF 7

ITEM CODE (PCN) NSN PIN 50067A WCD CBEM30 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
020	MAT PCB	CLN	1.0	TRANSIT	0.3	BP09	001	100	0.1	OC 4947	001	100	0.25	DEGREASER TO REMOVE FUEL EXTERNAL CLEAN. (CLEANED IN FACES OF 20)
				SETUP										
				PROCESS										
021		PROC		TRANSIT	0.02	BP09	001	100	0.02	BENCH	001	100	0.02	IF ANY SHOP MODIFICATION, ETCH NEW NUMBERS OR MARKS (PER NOZZLE)
				SETUP										
				PROCESS										
022		PW	1.0	TRANSIT	0.2	BP09	001	100	0.2	BENCH	001	100	0.2	COMPLETE PENETRANT REPORT ROUTE TO MACHINE SHOP (OVERHAUL, TEST, MACHINE SHOP WORK) (FOR 20 NOZZLES)
				SETUP										
				PROCESS						?				
B/S 040	MAT PCM	PROC	1.0	TRANSIT	4.0			20						ROUTE TO MACHINE SHOP FOR TA REMOVAL/REPAIR. PER CBEM27 BACKSHOP
				SETUP	6.0			80						
				PROCESS										
050	MAT PCB	CLN	1.0	TRANSIT	1.1	BP09	001	100	0.1	OC 3024	001	100	1.0	CLEAN NOZZLE IN AFTER MACHINE SHOP INTERNAL & BASKETS OF 10, TOTAL 20 NOZ.
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MATPCB SHEET 3 OF 7

ITEM CODE (PCN) NSN P/N 50067A WCD CBEM30 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
051	MAT PCB	CLN	1.0	TRANSIT	0.25	9	001	100	0.05	OC 4133	001	100	0.25	COLD WATER RINSE
				SETUP										
				PROCESS										
052			1.0	TRANSIT	1.0			100	0.05	OC 4137	001	100	1.0	ACKALI
				SETUP										
				PROCESS										
053			1.0	TRANSIT	0.25			100	0.05	OC 4134	001	100	0.25	COLD H2O RINSE
				SETUP										
				PROCESS										
054			1.0	TRANSIT	0.5			100	0.05	OC 4140	001	100	0.5	Soak Clean Both
				SETUP										
				PROCESS										
055			1.0	TRANSIT	0.25			100	0.1	OC 4132	001	100	0.25	H2O COLD RINSE
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MATPCB SHEET 4 OF 7

ITEM CODE (PCN) NSN P/N 50067A WCD CBEM30 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
056	MAT PCB	CLN	1.0	TRANSIT	2.0	BP07	001	100	0.1	OC4136	001	100	20	FROM AIR DRY.
				SETUP										
				PROCESS										
B/S 057	MAT PCB	NDI	1.0	TRANSIT		BP09	1		1.0	OC0229	1	100	1.0	ROUTE TO SHOP FOR NDI. FLUOR. PENETRANT. (LOTS OF 20) CMEMO2 WCD
				SETUP										
				PROCESS										
058	|	PROC	1.0	TRANSIT	0.1	BB09	001	100	0.1	BEN45	001	100	0.1	INSTALL COVER GASKET
				SETUP										
				PROCESS										DONE IN LOTS OF 20 — TOTAL TIME SAME
B/S 059	|	TEST	1.0	TRANSIT	17									ROUTE TO BLDG 3108 FOR FLOW TEST (HOUSING PRESSURE TEST) LOT OF 20)
				SETUP	41									
				PROCESS	65									
060	↓	PROC	1.0	TRANSIT						BEN45	001	100		LAP & MEASURE SHOULDER.
				SETUP										
				PROCESS		↓	↓							LOT OF 20

Unit Setup Man = Machine

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MAT PCB SHEET 5 OF 7

ITEM CODE (PCN) NSN P/N 50067A WCD CBEM30 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
080	MAT PCB	ASSY	1.0	TRANSIT	1.0	BP09	001	100	1.0	BEN45	1	100	1	BATCHED IN TO QUANTITY OF 20.
				SETUP										
				PROCESS										
090		INSP	1.0	TRANSIT	0.1			100	0.1	6963659	001	100	0.1	BATCHED INTO QUANTITY OF 20
				SETUP										ALIGNMENT FIXTURE
				PROCESS										
100		MOVE	1.0	TRANSIT	0.05			100	0.05					ROUTE TO WELDING TO WELD TIP
				SETUP										
				PROCESS										
B/S 110	MAT PIN	PROC	1.0	TRANSIT	5.0									WELD TIP TO HOUSING
				SETUP										
				PROCESS										
120	MAT PCB	INSP	1.0	TRANSIT	0.2	BP09	001	100	0.2	6963659	001	100	0.1	BATCHED BY 20 ALIGNMENT FIXTURE
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MAT PCB SHEET 6 OF 7

ITEM CODE (PCN) NSN PIN 50067A WCD CBEM30 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
130	MAT PCB	MOVE	1.0	TRANSIT	0.1	BP07	001	100	0.1					ROUTE TO BIAS FOR TEST
				SETUP										
				PROCESS										
140	MAT PCB (TEST)	ASSY	1.0	TRANSIT		BP09	001	100	1	BEN45	1	100	1	ASSEMBLE UNIT ASSEMBLY IAW CBEM29
				SETUP										
				PROCESS										
150	↓	ASSY	1.0	TRANSIT		BP09	001	100	1	BEN45	1	100	1	FINAL ASSEMBLY
				SETUP										
				PROCESS										
160	↓	PKG	1.0	TRANSIT		BP09	001	100	1	BEN45	1	100	1	ATTACH PAPERWORK
				SETUP										
				PROCESS										
175	MAT PCB 10/H	PROC	0.6	TRANSIT	0.25	BP09	001	100	0.25	BEN45	001	100	0.25	INSTALL RIVET (P/N) IN L/S MOD NOZZLES.
				SETUP										
				PROCESS										

B/S TEST

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/15/89 RCC MATPCB SHEET 7 OF 7

ITEM CODE NSN PCN P/N 50067A WCD CBEM30 WCD DATE 88180

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
180	MAT PCB	INSP	1.0	TRANSIT	0.6	B07	001	100	0.6	1276359	001	100	0.6	BATCH SIZE 20
				SETUP										ALIGNMENT FIXT.
				PROCESS										
190		PW	1.0	TRANSIT	0.1			100	0.1	BEN45	001	100	0.1	COMPLETE AFO 340's & OPTICAL ALIGNMENT
				SETUP										
				PROCESS										
200		PW	1.0	TRANSIT	0.1			100	0.1	BEN45	001	100	0.1	
				SETUP										
				PROCESS										
210		PW	1.0	TRANSIT	0.05			100	0.05	BEN45	001	100	0.05	SETL
				SETUP										
				PROCESS										
9999		OUT DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	44									

FLOW PROCESS CHART

SUBJECT _____ DATE 5/19/89

ITEM CODE
PCN [X]
KSN [ ]
P/N [ ]

WCD CBEM30 WCD DATE 88180

50067A

CHART BEGINS 005 VALVE ASSEMBLY

CHART ENDS 510 PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005		●▷D□▽	REC [illegible]	215	215	●▷D□▽	SEAL
007		○●D□▽	MOVE [illegible] TO [illegible]			○▷D□▽	
010	010	●▷D□▽	[illegible] STEM			○▷D□▽	
015		●▷D□▽	[illegible]			○▷D□▽	
020		●▷D□▽	[illegible]			○▷D□▽	
021		●▷D□▽	ETCH [illegible]			○▷D□▽	
022		●▷D□▽	[illegible]			○▷D□▽	
040		●▷D□▽	MACHINE [illegible]			○▷D□▽	
050		●▷D□▽	CLEAN INTERNAL [illegible]			○▷D□▽	
051		●▷D□▽	COLD H2O RINSE			○▷D□▽	
052		●▷D□▽	NaOH WASH			○▷D□▽	
053		●▷D□▽	COLD H2O RINSE			○▷D□▽	
054		●▷D□▽	HOT [illegible] H2O			○▷D□▽	
055		●▷D□▽	COLD H2O RINSE			○▷D□▽	
056		●▷D□▽	HOT AIR DRY			○▷D□▽	
057		○▷D■▽	FPI TEST			○▷D□▽	
058		●▷D□▽	INSTALL [illegible] GASKET			○▷D□▽	
059		●▷D□▽	HOLDING [illegible] (FLOW) TEST			○▷D□▽	
060	060	●▷D□▽	LEAK MEASURE SHOULDER			○▷D□▽	
080	080	●▷D□▽	ASSEMBLY			○▷D□▽	
090	090	○▷D■▽	ALIGNMENT CHECK			○▷D□▽	
100	100	○●D□▽	MOVE TO WELDING			○▷D□▽	
110	110	●▷D□▽	WELD TIP TO HOUSING			○▷D□▽	
120	120	○▷D■▽	POST WELD ALIGN. CHECK			○▷D□▽	
130	130	○▷D■▽	ROUTE TO [illegible] FOR TEST			○▷D□▽	
140	140	●▷D□▽	ASSEMBLE VALVE ASY			○▷D□▽	
150	150	●▷D□▽	FINAL ASY.			○▷D□▽	
160	160	●▷D□▽	HARDWARE			○▷D□▽	
175		●▷D□▽	INSTALL [illegible]			○▷D□▽	
180	180	○▷D■▽	INSERT [illegible]			○▷D□▽	
190	190	●▷D□▽	PACKAGE			○▷D□▽	
200	200	●▷D□▽	WAREHOUSE			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATI...PROFILE

NAME PHUNT ALC OC DATE 061589 RCC MAIPCB SHEET 1 OF 6

PCN
NSN 50067A WCD CBEM31 WCD DATE 89094
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAIP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		20									
10	MAIP CB	REC.	1.0	~~TRANSIT~~											REC., ID, PW
				~~SETUP~~											
				PROCESS			DP04	1	100	.16	0C4278	1	100	.16	
15	MAIP CB	PROC	1.0	~~TRANSIT~~											SET-UP, TIGHTEN CAPS, PUT IN PLUG, ETC.
				SETUP											
				~~PROCESS~~			DP04	1	100	.25	0C4278	1	100	.25	
20	MAIP CB	TEST	1.0	~~TRANSIT~~											PRESSURE TEST SUBASSY.
				~~SETUP~~											
				PROCESS			DP04	1	100	.05	0C4278	1	100	.05	
21	MAIP CB	PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP04	1	100	.10	0C4278	1	100	.05	

OPERATI . .PROFILE

NAME PHUNT ALC OC DATE 061589 RCC MATPCB SHEET 2 OF 6

PCN
NSN
P/N 50067A WCD CBEM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
22	MATP CB	TEST	1.0	~~TRANSIT~~											CLEAN, TEST
				~~SETUP~~											
				PROCESS		.17	DP09	1	100	.17	0C4278	1	100	.25	
30	MATP CB	TEST	1.0	~~TRANSIT~~											LEAK TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.25	0C0952	1	100	.25	
40	MATP CB	TEST	1.0	~~TRANSIT~~											PRESSURE TEST HOUSING
				~~SETUP~~											
				PROCESS			DP09	1	100	.10	0C4278	1	100	.10	
55	MATP CB	PROC	1.0	~~TRANSIT~~											BUILD VALVE ASSY
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	0C4278	1	100	.17	
60	MATP CB	PROC.	1.0	TRANSIT											REMOVE O-RING
				SETUP											
				PROCESS			DP09	1	100	.17	0C4278	1	100	.17	

LSC-2000-C

OPERATION PROFILE

NAME P HUNT ALC 0C DATE 061589 RCC MATPCB SHEET 3 OF 6

PCN NSN P/N 50067A WCD CBEM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
70	MATP CB	TORQ	1.0	~~TRANSIT~~											SEE OP. 55
				~~SETUP~~											
				PROCESS			DP09	1	100	0	0C4278	1	100	0	
80	MATP CB	TEST	1.0	~~TRANSIT~~											RECHECK PINTLE NUT
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	0C4278	1	100	.05	
90	MATP CB	TORQ	1.0	~~TRANSIT~~											TORQUE LINER
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	0C4278	1	100	.05	
100	MATP CB	INSP.	1.0	~~TRANSIT~~											INSPECT CAVITY
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	0C4278	1	100	.05	
110	MATP CB	PROC	1.0	~~TRANSIT~~											INSTALL NEW CARTRIDGE
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	0C4278	1	100	.05	

LSC 2000/C

OPERATI . .PROFILE

NAME P HUNT ALC OC DATE 061589 RCC MATPCB SHEET 4 OF 6

PCN
NSN
P/N 50067A WCD CBEM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
120	MATP CB	TEST	1.0	~~TRANSIT~~											FLOW TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	OC4278	1	100	.33	
130	MATP CB	Info.	1.0	~~TRANSIT~~											INFO ONLY
				~~SETUP~~											
				PROCESS			DP09	1	100	NA	NA	NA	NA	NA	
140	MATP CB	TEST	1.0	~~TRANSIT~~											SPRAY ANGLE TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.03	OC4278	1	100	.03	
150	MATP CB	TEST	1.0	~~TRANSIT~~											SECONDARY FLOW PATTERN TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.10	OC952	1	100	.10	
160	MATP CB	TEST	1.0	~~TRANSIT~~											STATIC PRESSURE TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.12	OC4278	1	100	.12	

OPERATI . .PROFILE

NAME PHUNT ALC OC DATE 061589 RCC MATPCB SHEET 5 OF 6

PCN / NSN / P/N 50067A WCD CBCM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
170	MATP CB	TEST	1.0	~~TRANSIT~~											VALVE LEAK TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	OC4743	1	100	.05	
180	MATP CB	TEST	1.0	~~TRANSIT~~											ALL TEST OPS COMPL.
				~~SETUP~~											
				PROCESS			DP09	1	100	.07	OC4743	1	100	.07	
190	MATP CB	WRK	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP09	1	100	.03	OC4318	1	100	.11	
200	MATP CB	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP09	1	100	.03	OC4318	1	100	.17	
210	MATP CB	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP09	1	100	.03	OC4318	1	100	.17	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 061589 RCC MAIPCB SHEET 6 OF 6

PCN
NSN
P/N 50067A WCD CBEM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
9994	MAIP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		44									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

LSC-20000C

FLOW PROCESS CHART

SUBJECT 50067A DATE 061589

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

WCD CBEM31 WCD DATE 84094

CHART BEGINS 10 REC

CHART ENDS 210 PW PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	REC			○◇D□▽	
15	15	●◇D□▽	SET-UP			○◇D□▽	
20	20	○◇D■▽	PRESS TEST			○◇D□▽	
21	21	●◇D□▽	PROC			○◇D□▽	
22	22	○◇D■▽	CLEAN, TEST			○◇D□▽	
30	30	○◇D■▽	LEAK TEST			○◇D□▽	
40	40	○◇D■▽	PRESSURE TEST			○◇D□▽	
55	55	●◇D□▽	BUILD VALVE ASSY			○◇D□▽	
60	60	●◇D□▽	PROC.			○◇D□▽	
70	70	●◇D□▽	TORQ.			○◇D□▽	
80	80	○◇D■▽	TEST			○◇D□▽	
90	90	●◇D□▽	TORQUE			○◇D□▽	
100	100	○◇D■▽	INSPECT CAVITY			○◇D□▽	
110	110	●◇D□▽	INSTALL NEW GASKET.			○◇D□▽	
120	120	○◇D■▽	FLOW TEST			○◇D□▽	
130	130	●◇D□▽	INFO.			○◇D□▽	
140	140	○◇D■▽	SPRAY ANGLE TEST			○◇D□▽	
150	150	○◇D■▽	SECONDARY SPRAY PATTERN			○◇D□▽	
160	160	○◇D■▽	STATIC PRESS. TEST			○◇D□▽	
170	170	○◇D■▽	VALVE LEAK TEST			○◇D□▽	
180	180	●◇D□▽	ALL TEST OPS COMPL			○◇D□▽	
190	190	●◇D□▽	SAFETY WIRE			○◇D□▽	
200	200	●◇D□▽	PW COMPL.			○◇D□▽	
210	210	●◇D□▽	PW			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPC B SHEET 1 OF 1

PCN
NSN
PIN 50067A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~ HRS
1	8298	8298	0
2	8298	8299	24
3	8305	8306	24
4	8305	8307	48
5	8319	8319	0
6	8319	8319	0
7	8333	8334	24
8	8333	8334	24
9	8333	8335	48
10	9010	9010	0
			20

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE

LSC-20107A

"OUT" DATES PROFILE

NAME _____ ALC OC-ALC DATE 3/MAY/89 RCC MTFCB SHEET 1 OF 1

PCII/ISH/PII 50067A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME ~~(DAYS)~~ HRS
1	8300	8300	0
2	8307	8307	0 "
3	8309	8312	" 72
4	8309	8319	240
5	8322	8323	24
6	8321	8321	0
7	8336	8337	24
8	8342	8342	0
9	8337	8340	72
10	9012	9012	0
			44

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

LSC-20108A

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 RCC MTPCT SHEET 1 OF 4

PCN
NSN 50134A
P/N
WCD CBEY10 ✓ WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MTP CT	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
10	MTP CT	TEST	1.0	~~TRANSIT~~											BREAK-IN RUN, ON HYDRAULIC TEST STAND
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	0C948	1	100	.33	
20	MTP CT	TEST	1.0	~~TRANSIT~~											T.O. CALLS FOR 3 MIN, DOWN FROM 63 MIN.
				~~SETUP~~											
				PROCESS			DP09	1	100	.75	0C948	1	100	.75	
030	MTP	TEST	1.0	~~TRANSIT~~											PART OF OP. 020
				~~SETUP~~									1		
				PROCESS			DP09	1	100	0	0C948	1	100	0	
040	MTP	TEST	1.0	~~TRANSIT~~											25% FAIL RATE
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	0C948	1	100	.17	

LSC-200926

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 RCC MTPCT SHEET 2 OF 4

PCN
NSN
PIN 50134A WCD CBEY10 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
045	MTP CT	REP.	.25	~~TRANSIT~~											TEST STAND OPERATOR CALLS MECHANIC TO REPAIR UNIT ON STAND. SLAFT SEAL
				~~SETUP~~											
				PROCESS			DP09	1	25	.25	0C948	1	100	.33	
050	MTP CT	TEST	1.0	~~TRANSIT~~											SET FULL FLOW
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	0C948	1	100	.17	
055	MTP CT	TEST	1.0	~~TRANSIT~~											INTERNAL LEAK CHECKS
				~~SETUP~~											
				PROCESS			DP09	1	100	.25	0C948	1	100	.25	
060	MTP CT	TEST	1.0	~~TRANSIT~~											PERF. CALIB. TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	0C948	1	100	.33	
075	MTP CT	TEST	1.0	TRANSIT											HYSTERESIS LIMITS TESTS
				SETUP											
				PROCESS			DP09	1	100	.17	0C948	1	100	.17	

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 RCC MTPCT SHEET 3 OF 4

PCN
NSN
PN 50134A WCD CBEY10 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
080	MTP CT	TEST	0	~~TRANSIT~~											IS PART SET ON TEST STAND
				~~SETUP~~											
				PROCESS			DP09	1	0	0	0c948	1	100	0	
090	MTP CT	TEST	1.0	~~TRANSIT~~											CYCLE TEST
				~~SETUP~~											
				PROCESS			DP09	1	100	.42	0c948	1	100	.42	
110	MTP CT	TEST	1.0	~~TRANSIT~~											50% REJECT AT THIS POINT. CONTACT BENCH MECHANIC.
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	0c948	1	100	.33	
115	MTP CT	REP	.5	~~TRANSIT~~											REPAIR PROBLEMS WITH UNIT WHILE ON TEST STAND
				~~SETUP~~											
				PROCESS			DP09	1	100	.50	0c948	1	100	.50	
120	MTP CT	TEST	1.0	~~TRANSIT~~											OIL FLUSH
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	0c948	1	100	.17	

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 NCC MTPCT SHEET 4 OF 4

PCN
NSN
PIN 50134A WCD CBEY10 WCD DATE 89094

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
125	MTP CT	WRE	1.0	~~TRANSIT~~											LOCKWIRE
				~~SETUP~~											
				PROCESS			DP09	1	100	.15	0C948	1	100	.15	
130	MTP CT	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	0C948	1	100	.17	
140	MTP CT	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP09	1	100	0	0C948			0	
150	MTP CT	MOV	1.0	~~TRANSIT~~											RET. TO ASSY MECHANIC
				~~SETUP~~											
				PROCESS			DP09	1	100	.17					
9909	MTP CT	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		34									

FLOW PROCESS CHART

SUBJECT PUMP, HYD. FUEL DATE 5-30-89

ITEM CODE PCN [X] 50139A NOM. [ ] P/N [ ]

WCD CBE410 WCD DATE 88188

CHART BEGINS 010 BREAK IN PROG

CHART ENDS 150 MOVE TO FINAL ASSY PREPARED BY P. HUNT

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	SET R... IN			○▷D□▽	
020	020	●▷D□▽	RUN BRK IN			○▷D□▽	
030	030	●▷D□▽	BREAK-IN			○▷D□▽	
040	040	○▷D■▽	TEST PUMP FLOW			○▷D□▽	
045	—	●▷D□▽	50% REPAIRED			○▷D□▽	
050	050	○▷D■▽	FULL FLOW TEST			○▷D□▽	
055	—	○▷D■▽	INTERNAL LEAK CHECK			○▷D□▽	
060	060	○▷D■▽	PERFORMANCE CALIBRATION			○▷D□▽	
075	075	○▷D■▽	HYSTERESIS CHECK			○▷D□▽	
080	080	●▷D□▽	PRESET TEST STAND			○▷D□▽	
090	090	○▷D■▽	TEST CYCLE TEST			○▷D□▽	
110	110	○▷D■▽	EXTERNAL LEAK CHK			○▷D□▽	
115	—	●▷D□▽	REPAIR 50%			○▷D□▽	
120	120	●▷D□▽	FLUSH PUMP			○▷D□▽	
125	125	○▷D□▽ ●▷D□▽	LOCKWIRE			○▷D□▽ ○▷D□▽	
130	130	●▷D□▽	P/W, CERTIFICATION			○▷D□▽	
140	140	●▷D□▽	TYPE WORK PERF			○▷D□▽	
150	150	○▶D□▽	TO FINAL ASST.			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME P.HUNT ALC OC DATE 5-30-89 RCC MATPCB SHEET 1 OF 6

PCN
NSN
PIN 50134A WCD CBC711 WCD DATE 88269

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		32									
10	MATP CB	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											PROCESS PAPERWORK
				PROCESS			BP09	1	100	.11	BEN433	1	100	.11	
11	MATP CB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											VISUAL INSPECT HOUSING
				PROCESS			BP09	1	100	.03	BEN433	1	100	.03	
12	MATP CB	REFL	.07	~~TRANSIT~~											
				~~SETUP~~											7% NEED HOUSINGS REFL, SEND TO MACHINE SHOP.
				PROCESS	100	24	BP09	1	100	.11	BEN433	1	100	.12	
15	MATP CB	CLN	1.00	~~TRANSIT~~											
				~~SETUP~~											CLEAN EXTERIOR.
				PROCESS			BP09	1	100	.17	OC1178	1	100	.17	

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 RCC MATPCB MTPCB SHEET 2 OF 6

PCN RSN PIN 50134A WCD CBET 11 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
20	MATP CB	DIS	1.0	~~TRANSIT~~											DISCARD O RINGS, SPRINGS, PISTONS + DO VISUAL INSPCT.
				~~SETUP~~											
				PROCESS			BP09	1	100	1.0	BEN433	1	100	1.0	
030	MATP CB	CLN	1.0	~~TRANSIT~~											DECREASE
				~~SETUP~~											
				PROCESS			BP09	1	100	.75	OC 1947	1	100	.75	
040	MATP CB	INSP.	1.0	~~TRANSIT~~											VISUAL INSP. / TEST
				~~SETUP~~											
				PROCESS			BP09	1	100	3.0	BEN433	1	100	3.0	
050	MATP CB	NDI	1.0	~~TRANSIT~~											FLUOR. PEN. INSP.
				~~SETUP~~											
				PROCESS	100	—	BP09	1	100	.11	OC 1947	1	100	.11	
060	MATP CB.	NDI	1.0	~~TRANSIT~~											MAG PARTICLE INSP.
				~~SETUP~~											
				PROCESS	100	24	BP09	1	100	.11	OC 1947	1	100	.11	

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 NCC MATPCB MTPCB SHEET 3 OF 6

PCN/NSN/PIN 50134A WCD CBET 11 WCD DATE 88267

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
070	MATP CB	REP	1.0	~~TRANSIT~~											BEARING MARKINGS ARE TOO SMALL TO READ.
				~~SETUP~~											
				PROCESS			BP09	1	100	.5	BEN433	1	100	.5	
075	MATP CB	REP	1.0	~~TRANSIT~~											IMPELLER MOD,
				~~SETUP~~											
				PROCESS			BP09	1	100	.25	BEN433	1	100	.25	
080	MATP CB	REPL.	1.0	~~TRANSIT~~											IT HAS NEW SPRINGS SO ALL SPRINGS REPLACED BECAUSE OF MAT.
				~~SETUP~~											
				PROCESS			BP09	1	100	.08	BEN433	1	100	.08	
090	MATP CB	ASSY	1.0	~~TRANSIT~~											SELECT FIT BEARING INTO PUMP HOUSING
				~~SETUP~~											
				PROCESS			BP09	1	100	.25	BEN433	1	100	.25	
100	MATP CB.	ASSY	1.0	~~TRANSIT~~											ASSY INSTRS
				~~SETUP~~											
				PROCESS			BP09	1	100	.33	BEN433	1	100	.33	

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OPERATION PROFILE

NAME P. Hunt ALC OC DATE 5-30-89 RCC MATPCB MTPCB SHEET 4 OF 6

PCN/NSN P/N 50134A WCD CBET II WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MATP CB	ASSY	100	~~TRANSIT~~											INSTALL ALL NEW SPRINGS.
				~~SETUP~~											
				PROCESS			BP09	1	100	.08	BEN433	1	100	.08	
120	MATP CB	ASSY	100	~~TRANSIT~~											ASSY REAR COVER ASSEMBLY.
				~~SETUP~~											
				PROCESS			BP09	1	100	.50	BEN433	1	100	.50	
130	MATP CB	ASSY	100	~~TRANSIT~~											ASSY SPOOL & SLEEVE ASSEMBLY.
				~~SETUP~~											
				PROCESS			BP09	1	100	.17	BEN433	1	100	.17	
140	MATP CB	ASSY	100	~~TRANSIT~~											ASSY IMPELLER & THRUST COVER TO HOUSING.
				~~SETUP~~											
				PROCESS			BP09	1	100	.17	BEN...	1	100	.17	
150	MATP CB.	PW	100	TRANSIT											C/O TO DRILL C'M 3.
				~~SETUP~~											
				PROCESS			BP09	1	100	.17	BEN...	1	100	.17	

OPERATION PROFILE

NAME P. HUNT ALC 0C DATE 5-30-89 NCC MATPCB MTPCB SHEET 5 OF 6

PCN/NSN/PIN 50134A WCD CBET II WCD DATE 88267

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
160	MATP CB	PW	1.0	~~TRANSIT~~											C/W OH TO
				~~SETUP~~											
				PROCESS			BP09	1	100	.17	BEN433	1	100	.17	
170	MATP CB	PW	1.0	~~TRANSIT~~											DATA PLATE MADE CORRECT
				~~SETUP~~											
				PROCESS			BP09	1	100	.17	BEN4[illegible]	1	100	.17	
180	MATP CB	TEST	1.0	~~TRANSIT~~											MOVE TO BLDG. 3108 TEST.
				~~SETUP~~											
				PROCESS	100	24	BP09	1	100	.17	NA	NA	NA	NA	
190	MATP CB	WRE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP09	1	100	.25	BEN[illegible]	1	100	.25	
200	MATP CB	PW		~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP09	1	100	.08	BEN4[illegible]	1	100	.08	

OPERATION PROFILE

NAME P. Hunt ALC OC DATE 5-30-89 RCC MATPCB MTPCB SHEET 6 OF 6

PCN/HSN/PIN 50134A WCD CB67 11 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
210	MATP CB	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP09	1	100	.08	BCN43	1	100	.08	
9999	MATP CB	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

DISASSEMBLY/ASSEMBLY PROFILE

NAME P. HUNT ALC OC DATE 053089 RCC MPCB SHEET 1 OF 2

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
PCN NSN P/N 50134A	CBE711	89094	020	140	PCN NSN P/N 02-14151	CBE711 S1		Y
PCN NSN P/N					PCN NSN P/N 102-1046	S2		Y
PCN NSN P/N					PCN NSN P/N 02-14563-02	S3		Y
PCN NSN P/N					PCN NSN P/N 02-14581-02	S4		Y
PCN NSN P/N					PCN NSN P/N 102-1160-12	S5		Y
PCN NSN P/N					PCN NSN P/N 02-14561-02	S6		Y
PCN NSN P/N					PCN NSN P/N 02-14543-16	S7		Y
PCN NSN P/N					PCN NSN P/N 02-14567-04	S8		Y
PCN NSN P/N					PCN NSN P/N 02-14694-02	S9		Y
PCN NSN P/N					PCN NSN P/N 02-14565-01	S10		Y
PCN NSN P/N					PCN NSN P/N 102-1554	S11		Y
PCN NSN P/N					PCN NSN P/N 02-14385	S12		Y

LSC-2(XX)5A

DISASSEMBLY/ASSEMBLY PROFILE

NAME P. HUNT ALC OC DATE 053089 RCC MTPCB SHEET 2 OF 2

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN NSN P/N 50134A	CBC711	89044	020	140	PCN NSN P/N 02-14690-02	CBC711 S13		Y
PCN NSN P/N					PCN NSN P/N 02-14554-06	S14		Y
PCN NSN P/N					PCN NSN P/N 02-15713	S15		Y
PCN NSN P/N					PCN NSN P/N 02-14556-04	S16		Y
PCN NSN P/N					PCN NSN P/N 02-14540-03	S17		Y
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-2(XX)5A

FLOW PROCESS CHART

SUBJECT PUMP - H1 FUEL DATE 5 30 89

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

WCD CBE711 WCD DATE 88267

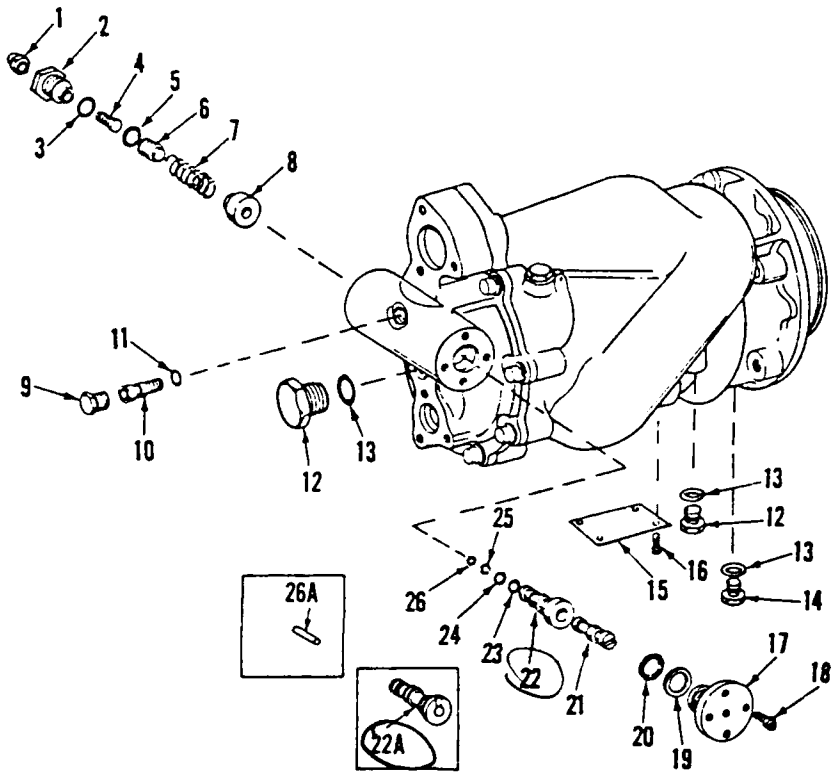
CHART BEGINS 010 - RECEIVE

CHART ENDS 210 - PW C/W TO. PREPARED BY P. HUST

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	RECEIVE			○◇D□▽	
15	—	●◇D□▽	CLN. PD680			○◇D□▽	
20	20	●◇D□▽	DISASSY			○◇D□▽	
30	30	●◇D□▽	CLN			○◇D□▽	
40	40	○◇D■▽	VISUAL INSP.			○◇D□▽	
50	50	○◇D■▽	NDI, FLOW PIN INSP.			○◇D□▽	
60	60	○◇D■▽	NDI, MAG PARTICLE INSP.			○◇D□▽	
70	70	●◇D□▽	REPAIR + REPL			○◇D□▽	
75	75	●◇D□▽	IMPELLER MOD			○◇D□▽	
80	80	○◇D■▽	CHK SPRNG.			○◇D□▽	
90	90	●◇D□▽	ASSY BRNG.			○◇D□▽	
100	100	●◇D□▽	ASSY PISTONS			○◇D□▽	
110	110	●◇D□▽	ASSY RET. SPRINGS			○◇D□▽	
120	120	●◇D□▽	ASSY RETR COVER			○◇D□▽	
130	130	○◇D□▽ ●◇D□▽	ASSY SPOOL + SLEEVE			○◇D□▽ ○◇D□▽	
140	140	●◇D□▽	ASSY IMPELLER			○◇D□▽	
150	150	●◇D□▽	PW - C/W TORQ. LIM.			○◇D□▽	
155	155	●◇D□▽	RETORQUE			○◇D□▽	
160	160	●◇D□▽	PW			○◇D□▽	
170	170	●◇D□▽	CORRECT DATA PLATE			○◇D□▽	
180	180	○◆D□▽	MOVE TO BLDG 3108 TEST			○◇D□▽	
190	190	●◇D□▽	WIRE - SAFETY			○◇D□▽	
200	200	○◇D■▽	INSP. + PW			○◇D□▽	
210	210	●◇D□▽	PW - C/W MAGI 66-3			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

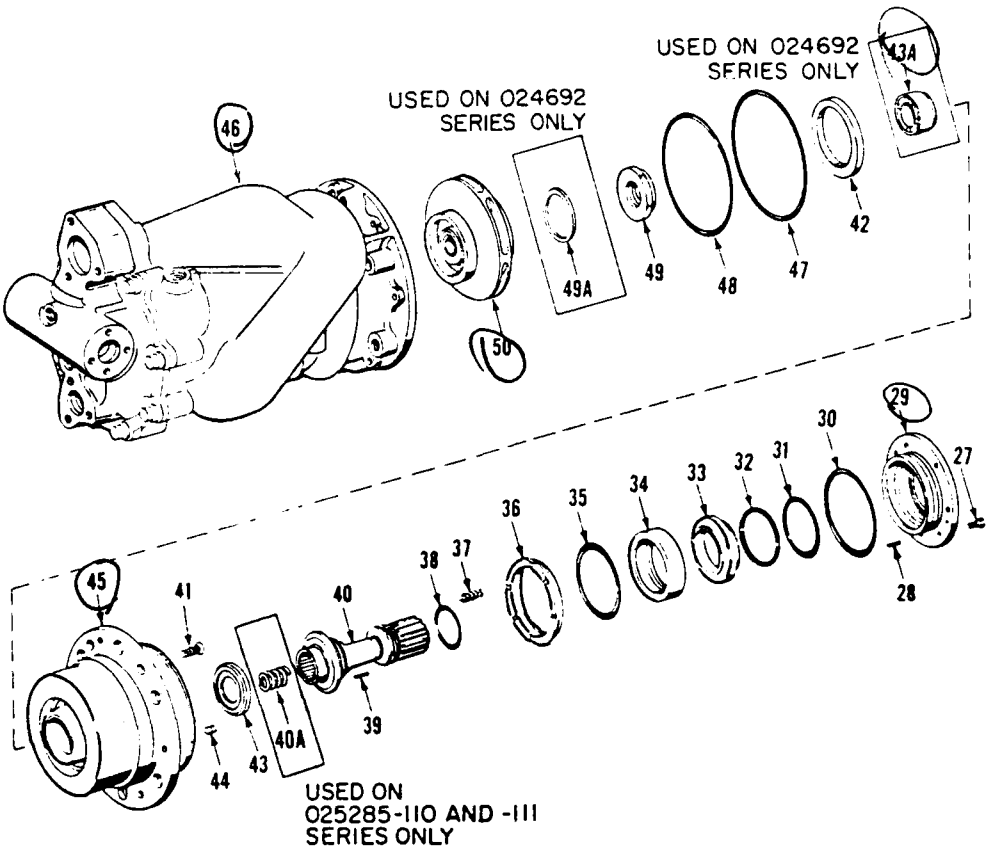
○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147



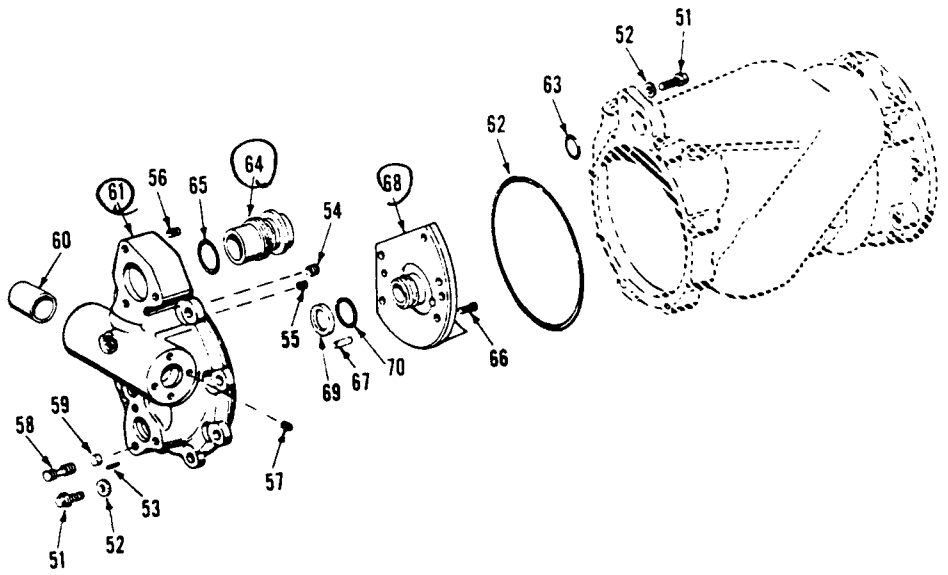
A-43421-1

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 1)



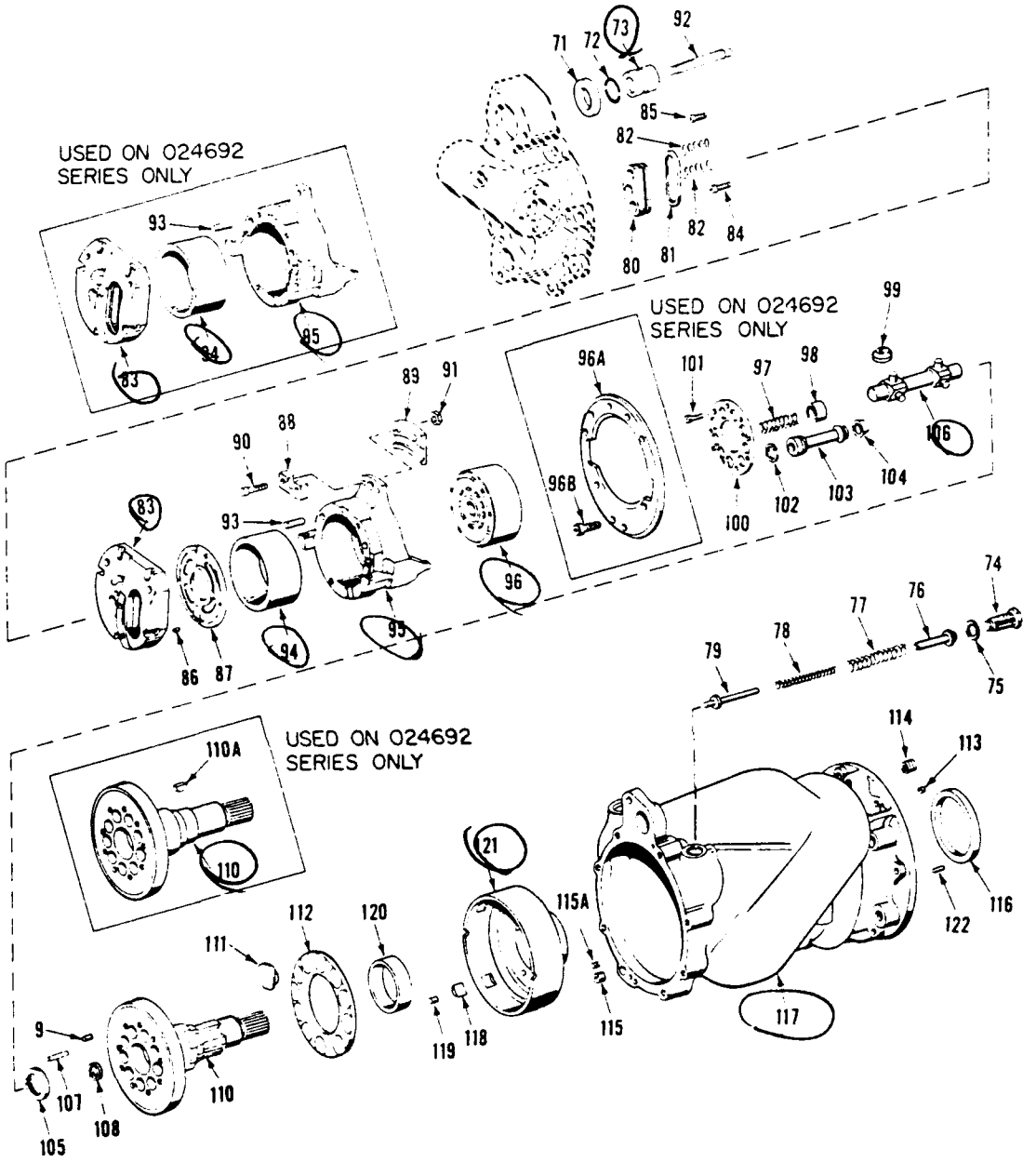
A-19700-1

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 2)



A-19701-1

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 3)



A-19702

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 4)

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/1	025285-107-01	PUMP ASSEMBLY, Axial Piston	1	A
	025285-110-01	PUMP ASSEMBLY, Axial Piston	1	B
	025285-111-01	PUMP ASSEMBLY, Axial Piston	1	C
	024692-114-18	PUMP ASSEMBLY, Axial Piston	1	D
	024692-112-18	PUMP ASSEMBLY, Axial Piston	1	E
	024692-113-18	PUMP ASSEMBLY, Axial Piston	1	F
-1	99-4209	. NUT, Cap plain	1	
-2	02-14569	. PLUG	1	
-3	99-4602-10	. GASKET	1	
-4	02-14575	. SCREW, Adjusting	1	
-5	99-4601-014	. PACKING, Preformed	1	
-6	02-14574	. SEAT, Compensator valve	1	
-7	99-4017-01	. SPRING, Compensator valve	1	
-8	02-15817	. RETAINER, Spring	1	ABCDF
	02-14573-02	. RETAINER, Spring	1	E
-9	02-14590	. PLUG, Adjusting screw	1	
-10	02-14571	. SCREW, Adjusting	1	
-11	99-4601-006	. PACKING, Preformed	1	
-12	AN814-4DL	. PLUG	2	
-13	99-4602-04	. PACKING, Preformed	3	
-14	99-4378	. PLUG, Shipping	1	
-15	99-5000-18	. PLATE, Identification	1	
-16	99-4213-01	. SCREW, Cap, socket head (AP)	4	
-17	02-14570-03	. PLUG, Compensator valve	1	
-18	99-4365-08	. SCREW, Cap, socket head	4	
-19	99-4362	. RETAINER, Packing backup	1	
-20	99-4601-113	. PACKING, Preformed	1	
-21	02-15818	. SPOOL	1	ABCDF
-22	02-14151	. SLEEVE	1	ABCDF
-22A	102-1046	. SPOOL AND SLEEVE ASSEMBLY	1	E
	02-14152	. . SPOOL	1	E
	02-14151	. . SLEEVE	1	E
-23	99-3518-12	. RING, Seal	1	
-24	MS28774-12	. RETAINER	1	
-25	99-2973-11	. RING, Seal	1	
-26	99-2973-10	. RING, Seal	1	
-26A	02-14576-01	. PIN, Straight headless	1	E

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/2	102-1193	. COVER SUBASSEMBLY, Seal	1	
-27	99-4295-03	. SCREW, Cap, socket head (AP)	6	
-28	99-4207-02	. . PIN, Straight headless	1	
-29	02-14572-02	. . COVER, Seal	1	
-30	99-4601-038	. PACKING, Preformed	1	
-31	99-4991	. RETAINER, Packing, backup	1	
-32	99-4601-223	. PACKING, Preformed	1	
-33	02-14149-02	. RING, Seal	1	
-34	02-14568-03	. RING, Seal rotating	1	
-35	99-3518-228	. RING, Seal	1	
	M83248/2-228	. RING, Seal	1	
	NAS1594-228	. RING, Seal	1	
-36	02-14577-03	. WASHER, Thrust	1	
-37	99-4262	. SPRING, Shaft seal	8	
-38	99-4601-126	. PACKING, Preformed	1	ADEF
	5902378	. PACKING, Preformed	1	BC
	102-1157-02	. COUPLING, Subassembly	1	
-39	99-4420-04	. . PIN, Straight headless	2	
-40	02-14563-02	. . COUPLING, Shaft, rigid drive	1	
	No Number	. HOUSING AND FRONT COVER SUB-ASSEMBLY (Unmatched)	1	ABC
	102-1161-06	. HOUSING AND FRONT COVER SUB-ASSEMBLY (Matched Set)	1	DEF
	102-1159-03	. . COVER SUBASSEMBLY, Front	1	ABC
	102-1159-01	. . COVER SUBASSEMBLY, Front	1	DEF
-40A	5005226	. SPRING, Helical compression	1	BC
-41	99-4211-01	. . SCREW, Machine, flat head (AP)	2	
-42	02-15452	. . . SLEEVE, Labrynth	1	ABC
	02-14720	. . . SLEEVE, Labrynth	1	DEF
-43	02-14580-03	. . . BUSHING, Sleeve, front cover	1	ABC
	02-14580-02	. . . BUSHING, Sleeve, front cover	1	DEF
-43A	02-14581-02	. . . BEARING, Sleeve	1	DEF
-44	MS21209C0815	. . . INSERT, Screw, locking	6	
-45	02-14550-03	. . . COVER, Front	1	ABC
	02-14550-01	. . . COVER, Front	1	DEF
-46	102-1160-12	. . HOUSING SUBASSEMBLY (see sheet 4 for details)	1	ABC
	102-1160-06	. . HOUSING SUBASSEMBLY (see sheet 4 for details)	1	DEF
-47	99-4601-155	. PACKING, Preformed	1	
-48	99-4601-154	. PACKING, Preformed	1	
-49	99-4912	. NUT, Thin, self-locking	1	ABC
-49A	02-14719	. WASHER, Thrust, impeller	1	DEF
-50	02-14561-02	. IMPELLER, Pump	1	ABC
	02-14561-01	. IMPELLER, Pump	1	EF
	5000614	. IMPELLER, Pump	1	D
	102-1162-16	. COVER SUBASSEMBLY, Rear	1	

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/3-51	99-4214-08	. BOLT, 12-Point head (AP)	9	
-52	AN960-516	. WASHER (AP)	9	
-53	AN385AH3P10	. PIN, Taper (KD)	1	
-54	MS21209F4-15	. . INSERT, Screw locking, helical coil	1	
-55	MS21209F4-20	. . INSERT, Screw locking, helical coil	5	
-56	MS21209F5-15	. . INSERT, Screw locking, helical coil	1	
-57	MS124753	. . INSERT, Screw locking, helical coil (MS21208F1-20)	4	
-58	99-4205	. . STUD	6	
-59	99-4000-5	. . KEY RING, Key locked	6	
-60	02-14620	. . SLEEVE	1	
-61	02-14543-16	. . COVER, Rear	1	
-62	99-4601-247	. PACKING, Preformed	1	
-63	99-4601-026	. PACKING, Preformed	1	
-64	02-14567-04	. BUSHING, Actuator piston	1	
	02-14567-03	. BUSHING, Actuator piston	1	DEF
-65	99-2973-21	. RING, Seal	1	
	102-1192-02	. GUIDE SUBASSEMBLY, Retainer port slipper	1	
-66	99-4320-03	. SCREW, Cap, socket head (AP)	5	
-67	99-3985-08	. . PIN, Straight headless	1	
-68	02-14694-02	. . GUIDE, Retainer, port slipper	1	
-69	MS28774-18	. RETAINER, Packing backup	1	
-70	99-3518-18	. RING, Seal	1	

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/4-71	99-4149-04	. SEAL, OD Channel	1	
-72	99-2973-113	. RING, Seal	1	
-73	02-14565-01	. PISTON, Actuator	1	
-74	02-14587-03	. SEAT, Ball socket	2	
-75	99-4602-06	. PACKING, Preformed	2	
-76	02-14585-03	. RETAINER, Spring return	2	
-77	99-4018-01	. SPRING, Return	1	
-78	99-4020-01	. SPRING, Return	2	
-79	02-14584-04	. GUIDE, Spring return	2	
-80	02-14699-04	. PORT SLIPPER, Discharge	1	
	02-14699-01	. PORT SLIPPER, Discharge	1	DEF
-81	02-14986	. SEAL, Slipper discharge	1	
-82	99-4903	. SPRING, Port slipper	2	
	99-4260	. SPRING, Port slipper	2	DEF
-83	102-1554	. RETAINER SUBASSEMBLY, Port slipper	1	
	102-1196-07	. RETAINER SUBASSEMBLY, Port slipper	1	DEF
-84	99-4324-07	. SCREW, Cap, socket head (AP)	1	
-85	99-4324-04	. SCREW, Cap, socket head (AP)	4	
-86	99-4399	. . PIN, Shouldered	1	
-87	02-14824-02	. INSERT, Slipper retainer	1	
-88	02-15538-01	. RETAINER, Actuator rod	1	ABCDF
-89	5000610	. PLATE, Retaining	1	AC
-90	NAS1351C06-16	. SCREW, Cap, socket head, self-locking (AP)	2	ABC
-91	5900338	. NUT, Hex, miniature (AP)	2	AC
-92	02-14140	. ROD, Actuator	1	
	5000611	. PIVOT SUBASSEMBLY, Cylinder barrel		
	102-1154-02	. PIVOT SUBASSEMBLY, Cylinder barrel	1	DEF
-93	99-3988-07	. . PIN, Dowel	2	
-94	02-14385	. . BEARING, Pivot	1	
-95	5000611-1	. . PIVOT, Cylinder barrel	1	
	02-14689	. . PIVOT, Cylinder barrel	1	DEF
-96	02-14690-02	. CYLINDER BARREL	1	
-96A	02-14707-02	. STOP, Shaft	1	DEF
-96B	99-4307-03	. SCREW, Cap, socket head (AP)	2	DEF
-97	99-4258	. SPRING, Pivot	1	
-98	02-14586	. SEAT, Ball socket	1	
-99	02-14378-13	. ROLLER, Universal	6	
-100	02-14603-01	. PLATE, Piston return	1	
-101	99-4208-08	. SCREW, Cap, socket head (AP)	7	
	102-1156-05	. PISTON AND RING SUBASSEMBLY	9	
	102-1156-04	. PISTON AND RING SUBASSEMBLY	9	DEF
-102	02-14166-03	. . RING, Piston	1	
	02-14166-02	. . RING, Piston	1	DEF
-103	02-14600-05	. . PISTON, Pump	1	
-104	02-14606-02	. BALL END, Piston	9	

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/4-105	02-15012	. RING, Retaining	1	
-106	02-14554-06	. COUPLING, Shaft, rigid universal	1	
	02-14554-01	. COUPLING, Shaft, rigid universal	1	DEF
-107	02-14987	. INSERT, Wear, drive shaft	3	
-108	02-14578	. SEAT, Ball socket, pivot	1	
	102-1190-06	. SHAFT SUBASSEMBLY, Shouldered	1	ABC
	5000615	. SHAFT SUBASSEMBLY, Shouldered	1	D
	102-1190-07	. SHAFT SUBASSEMBLY, Shouldered	1	EF
-109	02-14683	. . PIN, Shouldered	2	
-110	02-15713	. . SHAFT, Shouldered	1	BC
	102-1194-05	. . SHAFT SUBASSEMBLY, Shouldered	1	DEF
-110A	02-14755-01	. KEY, Woodruff	AR	DEF
	102-1163	. SEAT SUBASSEMBLY, Multiple ball socket	1	
-111	02-14536	. . BEARING, Thrust	12	
-112	02-14552	. . SEAT, Ball socket, multiple	1	
	No Number	. HOUSING AND FRONT COVER SUB-ASSEMBLY (Unmatched)	REF	ABC
	102-1161-06	. HOUSING AND FRONT COVER SUB-ASSEMBLY (Matched set)	REF	DEF
	102-1160-12	. . HOUSING SUBASSEMBLY (See 1-40)	REF	ABC
	102-1160-06	. . HOUSING SUBASSEMBLY (See 1-40)	REF	DEF
-113	02-14579	. . . SEAT, Puller screw	4	
-114	MS21209F6-20	. . . INSERT, Screw locking helical coil	6	
-115	MS21209F5-15	. . . INSERT, Screw locking helical coil	8	
-115A	MS21209F1-20	. . . INSERT, Screw locking helical coil	2	DEF
-116	02-15451	. . . SLEEVE, Labrynth	1	ABC
	02-14721	. . . SLEEVE, Labrynth	1	DEF
-117	02-14556-04	. . . HOUSING, Pump	1	ABC
	02-14556-01	. . . HOUSING, Pump	1	DEF
	102-1151-04	. . . RETAINER SUBASSEMBLY, Bearings and pin	1	
-118	02-14535-03	. . . . BEARING, Radial	7	
-119	99-3985-12	. . . . PIN, Straight headless	1	
-120	02-14551	. . . . BEARING, Sleeve	1	
-121	02-14540-03	. . . . RETAINER, Radial and sleeve bearing	1	
-122	99-3985-08	. . PIN, Straight headless	2	
	99-1973	. BLOCK, Shipping	1	
	99-1972	. GASKET	1	
	99-4217	. BLOCK, Shipping	1	
	99-4218	. GASKET	1	
	32-0454	PARTS KIT, Pump, Field (Leakproof)	1	
	99-204-07	. WASHER	6	
	99-112-01	. NUT, Hex	6	
	99-4215	. BLOCK, Shipping	1	
	AN4047-1	. GASKET	1	
	98-312-416-32	. SCREW, Slotted round head	2	

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 NCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 50134A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (~~DAYS~~) HRS
1	8291	8292	24
2	8295	8298	72
3	8307	8307	0
4	8321	8323	48
5	8344	8344	0
6	9009	9011	48
			32

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE

LSC-20107A

"OUT" DATES PROFILE

NAME _____ ALC QC-ACC DATE 31MAY89 NCC MTPCB SHEET 1 OF 1

PCN/NSN/PN 50134A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS ~~DAYS~~ TIME
1	8295	8295	0
2	8300	8302	48
3	8312	8312	0
4	8326	8326	0
5	8347	8348	24
6	9013	9013	0
			12

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

LSC-20108A

OPERATION PROFILE

NAME L. Tolen ALC OC DATE 5/5/89 RCC MATPCB SHEET 1 OF 5

PCN
NSN
PN 50135A WCD CBE402A ✓ WCD DATE 89019

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	30.0									
1		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP 09	1	1.0	4.5	BEN 48	1	1.0	4.5	
20		DIS	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	8.0	BEN 48	1	1.0	8.0	
30		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.50	OC 3020	1	1.0	.50	
31		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.30	OC 4132	1	1.0	.30	

OPERATION PRO[illegible]LE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 5

PCN/ NSN/ PIN 50135A WCD CBE402A ✓ WCD DATE 88019

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
34	MAT PCB	PROC	1.0	[illegible]											Dry and cool
				[illegible]											
				PROCESS	1.0	2.0	BP09	1	1.0	.20	OC4947	1	1.0	.20	
60		Insp	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	6.5	BEN48	1	1.0	6.5	
73		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	2.3	BEN48	1	1.0	2.3	
83		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	4.3	BEN48	1	1.0	4.3	
100		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.90	OC 3391	1	1.0	.90	

LSC-2000-2C

OPERATION PRC .E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

PCN
NSN
PN 50135A WCD CBE402A ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MAT ACB	CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	BP09	1	1.0	.20	OC 1178	1	1.0	.20	
111		PROC	1.0	[redacted]											Oty, include cooling
				[redacted]											
				PROCESS	1	1.0		1	1.0	.20	OC 4947	1	1.0	.20	
120		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	1.6	BEN 48	1	1.0	1.6	
125		DIS	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	14.0	BEN48	1	1.0	14.0	
133		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	2.4	Ben 48	1	1.0	2.4	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 5

PCN
NSN
PN 50135A WCD CBE402A ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
140	MAT PCB	ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP09	1	1.0	16.0	BEN48	1	1.0	16.0	
150		TEST	1.0	~~TRANSIT~~											CB backshop
				~~SETUP~~											
				PROCESS	1.0	48.0									
151		CLN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	2.25	OC 3020	1	1.0	2.25	
152		CLN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.20	OC 4132	1	1.0	.20	
154		CLN	1.0	~~TRANSIT~~											Dry & cool
				~~SETUP~~											
				PROCESS	1.0	2.0		1	1.0	.2	OC 4140	1	1.0	.2	

OPERATION PROFILE

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

PCN
NSN
P/N 50135A

WCD CBE402A WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
157	MAT ACB	CLN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	AP07	1	1.0	1.4	OC 1174	1	1.0	1.4	
158		INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	AP07	1	1.0	4.0	BEN48	1	1.0	.40	
160		ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	12.0	Ben 48	1	1.0	12.0	
170		INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	1.2	BEN 48	1	1.0	1.2	
180		PWJ	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.50	Ben 48	1	1.0	.50	
9999		OUT	1.0	Process	1.0	24.0									

LSC-200020

DISASSEMBLY/ASSEMBLY PROFILE

NAME TOTTEN ALC OC DATE 5/1/89 RCC MATRB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
(PCN) 50135A/ NSN P/N 50138A	CBE402	89019	040	210	(PCN) 50135A/51 NSN P/N 50138A/51	SUB 1	89019	N
(PCN) 49302A, 49306A, NSN 49308A, 49810A P/N	CBE401	89088	080	310	(PCN) 50135A, NSN P/N 50138A	CBE402	89019	N
N N N					PCN NSN P/N			
N N N					PCN NSN P/N			
N N N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			
CN SN /N					PCN NSN P/N			

LSC-2000-5A

FLOW PROCESS CHART

SUBJECT J-57, TF33 FUEL MANIFOLD ASSY INSTALL DATE 5/1/69

ITEM CODE
PCN ☒
NSN ☐
P/N ☐ 5013SA 5013-1

WCD CRE 402 WCD DATE 7907

5013A = EARLIER MODEL
5013-1 = NEW MODEL

CHART BEGINS 1

CHART ENDS 180 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
1		●▷D□▽				●▷D□▽	
5		○●D□▽				●▷D□▽	
8		○▷D□▼		155		●▷D□▽	
10	10	●▷D□▽		160		○▷D■▽	
20	20	●▷D□▽				○▷D□▼	
25		○▷D■▽		165	165	●▷D□▽	
30	30	●▷D□▽	CLEAN	170	170	○▷D■▽	
31	30	●▷D□▽		175	170	●▷D□▽	
35	35	●▷D□▽				○▷D□▽	
37	37	●▷D□▽	WATER RINSE			○▷D□▽	
38	38	●▷D□▽				○▷D□▽	
39	39	●▷D□▽	AIR PURGE			○▷D□▽	
60	160	○▷D■▽				○▷D□▽	
70	70	○▷D■▽				○▷D□▽	
75	75	○▷D■▽				○▷D□▽	
80	80	●▷D□▽				○▷D□▽	
~~85~~		●▷D□▽	~~ASSY TO TEST STAND~~			○▷D□▽	
100	100	●▷D□▽	INSTALL LAP NOZZLES			○▷D□▽	
105		●▷D□▽				○▷D□▽	
110	110	●▷D□▽				○▷D□▽	
111		●▷D□▽				○▷D□▽	
112		●▷D□▽	AIR PURGE			○▷D□▽	
120		○▷D■▽				○▷D□▽	
~~125~~		●▷D□▽	~~DISASSY 5013A ONLY~~			○▷D□▽	
~~130~~	~~130~~	●▷D□▽				○▷D□▽	
~~135~~	~~135~~	●▷D□▽	~~ASSY 5013A~~			○▷D□▽	
140	140	●▷D□▽				○▷D□▽	
150	150	●▷D□▽				○▷D□▽	
155		●▷D□▽	CLEAN NOZZ - ACID			○▷D□▽	
156		●▷D□▽				○▷D□▽	
157		●▷D□▽				○▷D□▽	
164		●▷D□▽				○▷D□▽	

5013A N/A

5013A N/A

R/S

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROF[illegible]

NAME E. Totten ALC OC DATE 5/5/89 RCC MATPCB SHEET 1 OF 2

PCN
NSN 50135A WCD CBELT2 A WCD DATE 8/8/74
PN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[illegible]											
				[illegible]											
				PROCESS	1.0	24.0									
5		REC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	DP09	1	1.0	.10	OC 0702	1	1.0	.10	
8		PROC	.40	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.50	OC 0702	1	1.0	.50	
10		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.50	OC 0702	1	1.0	.50	
20		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	3.5	OC 0702	1	1.0	3.5	

OPERATION PROFII

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

WCD 501354 WCD CBEMT2A WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
51	MAT PCB	DIS	.75	TRANSIT											
				SETUP											
				PROCESS	—	—	DP07	1	1.0	.45	OC 0702	1	1.0	.45	
52		REP	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	1.0	OC 0702	1	1.0	1.0	
53		ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	1.0	OC 0702	1	1.0	1.0	
54		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.48	OC 0702	1	1.0	.48	
60		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.14	OC 0702	1	1.0	.14	
9999		OUT	1.0	Process	1.0	30.0									

LSC-20092C

FLOW PROCESS CHART

SUBJECT J57 P9/EXCELLO JET ENGINE NOZZLE DATE 5/5/89

ITEM CODE PCN ☒ NSN ☐ P/N ☐ WCD CBE4T2 WCD DATE 88174

50135A, 5[redacted]A

CHART BEGINS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○◆D□▽	MTRON NOZZLES AT UNIT, MOVE TO STATION			○▷D□▽	
020		○▷◆□▽	SET UP TEST STAND (ONCE / SHIFT)			○▷D□▽	
030	010	◆▷D□▽	LOAD NOZZLE INTO TEST CHAMBER			○▷D□▽	
040	(1)	◆▷D□▽	PERFORM NOZZLE TESTS			○▷D□▽	
050	(2)	◆▷D□▽	REMOVE NOZZLE AND DISASSEMBLE IF TEST FAIL			○▷D□▽	
060		◆▷D□▽	FILE AND/OR REPLACE PARTS			○▷D□▽	
070		◆▷D□▽	ASSEMBLE NOZZLE			○▷D□▽	
080		◆▷D□▽	REMOVE NOZZLE & REBOX IF TEST PASS			○▷D□▽	
090	(3)	◆▷D□▽	COMPLETE PAPER WORK			○▷D□▽	
100	080	○◆D□▽	RETURN NOZZLES TO FINAL ASSEMBLY			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN / NSN / P/N 50135A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (~~DAYS~~ HRS)
1	8321	8323	48
2	8328	8330	48
3	8341	8341	0
4	8362 [redacted]	8364	48
			OC

LSC-20107A

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

"OUT" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 MCC MIPCB SHEET 1 OF 1

PCII
NSN
PII 5,0135A

PARENT
WCD _____

PARENT
WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS ~~DAYS~~ TIME
1	8323	8323	0
2	8334	8336	48
3	8343	8344	24
4	8365	8365	0

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

LSC-20108A

ONE ~~BEN~~ WCO (24 NOZZLES

OPERATION PROFILE ORIGINAL

SOURCE: SHIRLEY SMITH

NAME E. TOTTEN ALC OC DATE 5/3/89 RCC MATPCB SHEET 1 OF 8

ITEM CODE (PCN) NSN PIN 50136A WCD CBE403 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00 ~~TRN~~	MAT PCB	IN DATE	+1.0 .25	TRANSIT										"OLD" DECAVAN NOZZLES
				SETUP										
				PROCESS	36									
010		REC	* +.0 .25	~~TRANSIT~~		BP09	02	50	8			50	8.0	~25% OF NOZZLES COMING IN ARE FROM SUPPLY - THESE GO TO 3C0C 3123 FOR UNPACKING
				~~SETUP~~				15	16		1	15	16.0	
				PROCESS				35	8	BEN 49	1	35	8.0	UNPACK NOZZLES. FLOW TIME IS BASED ON ~~1000~~ QTY. SOME BEN TYPE
020		MOVE	1.0	TRANSIT	0.1	BP05	001	100	0.1		1	100	0.1	MOVE NOZZLES ON TRAILER FROM DEPT 3123 TO SHOP IN 3001.
				SETUP							1	100	0.1	
				~~PROCESS~~										
030		UNLO	1.0	TRANSIT	0.2	BP09	001	~~50~~ 100	0.1					UNLOAD TRAILER. MOVE NOZZLES TO MANIFOLD DISASSEMBLY AREA AND STACK.
				SETUP				50	0.2					
		IN	.75	~~PROCESS~~										
040		REC	1.0	~~TRANSIT~~	0.1	BP09	001	100	0.1	BEN 49	1	100	0.1	INCLUDE NOZZLES FROM BOTH SUPPLY AND MANIFOLD DISASSY. FLOW TIME INCLUDES MOVING TRAY OF NOZZLES FROM MANIFOLD DISASSY AREA TO NOZZLE SHOP. TIME IS
				SETUP										
				PROCESS										

(FROM MANIFOLD)

OPERATION PROFILE ORIGINAL

NAME Totten ALC _____ DATE _____ RCC _____ SHEET 2 OF 8

ITEM CODE (PCN) NSN _____ PIN 50136A WCD CBE403 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	015	1.0	TRANSIT	< 0.1	BP09	001	100	< 0.1	BEN49	5	100	< 0.1	DISASSEMBLE ENTIRE NOZZLE, SORT OUT BY PARTS. PLACE IN BARCLY NOZZLE MAY BE CONDEMNED BECAUSE DISASSY IN 3 MIN/NOZZLE
				SETUP							1	100	< 0.1	
				PROCESS							1	100	< 0.1	
060		CLN	1.0	TRANSIT	0.6	BP09	001	100	0.1	BEN50	1	20	0.5	SOAK IN K_2MnO_3 ACID. 20 - 60 MIN. BASED ON 1 TRAY
				SETUP	0.75	BP09				BUN51	1	75	0.75	
				PROCESS	1.1	BP09				BUN51	1	5	1.0	
070		CLN	1.0	TRANSIT	0.2	BP09	001	100	0.2	OC3023	1	100	0.2	RINSE WITH HOT WATER 10 - 15 MIN.
				SETUP										
				PROCESS										
080		CLN	1.0	TRANSIT		BP09	001	100	01	OC3020	1	50	0.3	DIPPING NOZZLES IN NaOH ALKALI 20-30 MIN.
				SETUP		BP09	001	100	0.1	OC3020	1	50	0.5	
				PROCESS										MAY USE 2 VATS IF QUANTITY REQUIRES. VATS ARE SHARED.
090		CLN	1.0	TRANSIT	0.2	BP09	001	100	0.2	OC3023	1	100	0.2	RINSE IN HOT H_2O 10-15 MIN.
				SETUP										
				PROCESS										

CAN BE DONE BY ONE PERSON TOO IS MUCH FAST

TANKS W/ PROPERTIES REQ. SEE OFFICE N

OPERATION PROFILE ORIGINAL

NAME E. TOTTEN ALC _____ DATE _____ RCC _____ SHEET 3 OF 8

ITEM CODE (PCN) NSN P/N 50136A WCD CRE-103 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	CLN	1.0	TRANSIT	.75	BP09	001	100	0.1					AIR DRY WITH HOT AIR DRYER TANK.
				SETUP										
				PROCESS										
110		DEL	1.0	TRANSIT	1.0			100	1.0					ALLOW HOT NOZZLES TO AIR COOL FOR 1 HR.
				SETUP										
				PROCESS										
120		PROC	1.0	TRANSIT	0.3	BP09	001	100	0.1	BLH46	1	50	0.1	SAND BLAST NOZZLES AFTER CLEANING AND DRYING.
				SETUP		BP07	001	100	0.3	BLH46	1	100	0.3	
				PROCESS										
130		INSP	1.0	TRANSIT	0.1	BP09	001	100	0.1	MIC	1	100	0.1	MICROMETER & INSPECTION IN 1 MIN./NOZZLE. (AUT: METHANE, CHECK, THREAD FILE IN 5 MIN/NOZZLE)
				SETUP										
				PROCESS										
140		PROC	1.0	TRANSIT	<0.1	BP09	001	100	0.1	BLH46	1	100	0.1	~ 2 MIN TO REMOVE OLD DEFLECTOR, INSTALL NEW ONE.
				SETUP						BLH46	1	100	0.1	
				PROCESS										

TIME CONSUMED TO PREPARE FOR INSPN

OPERATION PROFILE

ORIGINAL

NAME E. TOTTEN ALC _____ DATE _____ RCC _____ SHEET 4 OF 8

ITEM CODE (ECN) A.BN P/N 5013GA WCD CBE403 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	PROC.	1.0	TRANSIT	<0.1	BP09	1	100	<0.1	BEH46	1	100	0.1	INSPECT SECONDARY ORIFICE, AIRAY FOR PENETRATION OF H10 OIL. TOAK TIME N 3 MIN.
				SETUP										
				PROCESS										
160		PROC	1.0	TRANSIT	<0.1	BP09	1	100	<0.1	BEH46	1	100	0.1	PLACE NOZZLE NUTS IN "EGG CRATON" BOX FOR LAPPING. MACHINE LAP. OUTER NUT SURFACE. ATTACH PAPERWORK TIME PER NUT TO BE 3-4 MIN
				SETUP										
				PROCESS										
170		CLN	1.0	TRANSIT	0.3	BP09	1	100	0.3	OC1178	1	100	0.2	CLEAN LAPPED NUTS IN PD680, THEN DEGREASER SOLUTION. BOX NUTS AFTER DEGREASING.
				SETUP						OC4947	1		.1	
				PROCESS										
180		PROC	1.0	TRANSIT	0.2	BP09	1	100	0.2	BEH46	1	100	0.2	LAPPING OF BUSHINGS 10-15 MIN BUSHINGS ARE LAPPED IN BOX QUANTITIES OF MORE. QUANTITY MAY REQ 2 LAPPERS (15% OF TIME)
				SETUP										
				PROCESS										
190		CLN	1.0	TRANSIT	0.3	BP09	1	100	0.3	OC1178	1	100	0.2	CLEAN BUSHINGS IN PD680 TANK. THEN DEGREASER N 5 MIN. THEN PLACE IN TANK.
				SETUP						OC4947	1	100	0.1	
				PROCESS										

INSPECT BUSHING I/ MICR ARRANGE SIMILAR BEFORE

OPERATION PROFILE

ORIGINAL

NAME E. TOTTEN ALC OC DATE 5/3/89 RCC MAT PCB SHEET 5 OF 8

ITEM CODE (PCN) NSN P/N 50136 A WCD CBE403 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
200	MAT PCB	INSP	1.0	TRANSIT		BP09	1	100	0.1	BEN 49	1	100	0.1	INSERT BUSHING AND MEASURE W/ MICROMETER AFTER LAPPING. ~1 MIN PER NOZZLE AVG.
				SETUP										
				PROCESS										
210		INSP	1.0	TRANSIT		BP09	1	100	0.1	BEN 49	1	100	0.1	INSERT FUEL METERING SETS ~1 MIN. PER UNIT
				SETUP										
				PROCESS										
220		INSP	1.0	TRANSIT		BP09	1	100	0.1	N/A	1	100	0.1	INSERT BUSHING TIGHTEN AFTER LAPPING [redacted] <1 MIN PER UNIT (VISUAL INSPECTION)
				SETUP										
				PROCESS										
230		INSP	1.0	TRANSIT		BP09	1	100	0.1	BEN 49	1	100	0.1	
				SETUP										
				PROCESS										
240		ASSY	1.0	TRANSIT		BP09	1	100	0.1					~2-3 MIN PER UNIT. DO 48 BEFORE TORQUE STEP USUALLY. ~1.5 - 1.8 HR TOTAL BEFORE TORQUE (USE TOOTHPICK TO INSTALL SEAL)
				SETUP										
				PROCESS										

OPERATION PROFILE

ORIGINAL

NAME E. TOTTEN ALC OC DATE 5/3/89 RCC MAT PCB SHEET 6 OF 8

ITEM CODE (PCN) HSN PIN 50136A WCD ~~88174~~ CBE403 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
250	MAT PCB	PROC	1.0	TRANSIT		BP09	1	100	0.1	BEN 49	1	100	0.1	TORQUE NUT TO BUSHING TO 300 IN/LBS. W/ MAN POR NOZZLE
				SETUP										
				PROCESS										
260		PROC	1.0	TRANSIT		BP09	1	100	0.1	BEN 49	1	100	0.1	TORQUE PRIMARY STRAINER BODY 50-80 in/lb. ITEM REMAINS IN FIXTURE AFTER LAST STEP W/ 30 SEC PORTION
				SETUP										
				PROCESS										
270		~~PROC~~ PW	1.0	TRANSIT	SET 1PH	BP09	1	100	0.1					COMPLETE ONE SET INSPECTION FOR EA. 24 NOZZLES. PLACE IN PLASTIC BAG
				SETUP										
				PROCESS										
280		MOVE	1.0	TRANSIT		BP09	1	100	0.2					MOVE TO TEST - "HAND CARRY" FROM 3001 TO 3005.
				SETUP										
				PROCESS										
290		TEST	1.0	TRANSIT	?	—								BACKSTOP TEST OPERATION IN BLOG 3105
				SETUP										
				PROCESS										

B/S

TIME RANGE, DEPENDING ON TEST FAILURES

OPERATION PROFILE

ORIGINAL

NAME E. TOTTEN ALC OC DATE _____ RCC _____ SHEET 7 OF 8

ITEM CODE PCN/NSN SEE 50136A WCD C3E403 WCD DATE 88174

P/N _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
300	MAF AB	MOVE	1.0	TRANSIT		BP09	1	100	0.2					SOME STOCK MAY BE PLACED ON CONVEYOR AT END OF SHIFT. TIME IS TAKEN .8 HR.
				SETUP										
				PROCESS										
310		TEST	1.0	TRANSIT		BP09	1	100	0.1	OC 0952	1	100	0.1	PERFORM LEAK TEST W/ N2
				SETUP										1 MIN AIR NOZZLE PLUS LOAD, UNLOAD N2. MIN/NOZZLE
				PROCESS										
320		ASSY	1.0	TRANSIT		BP09	1	100	0.2	BEN49	1	100	0.2	APPROX 2-2.5 MIN. PER NOZZLE, 1 BOX OF 48 DONE IN 1-1.5 HR.
				SETUP										
				PROCESS										
330		INSP	1.0	TRANSIT		BP09	1	100	0.1					VISUALLY INSPECT. NOTE: WCD CALLS FOR FINAL PC SEALING. THIS IS NOT DONE. NOZZLES ARE PLACED IN BOXES FOR MOVEMENT TO MANIFOLD ASSY.
				SETUP										
				PROCESS										
340		PW		TRANSIT		BP09	1	100	0.1					COMPLY W/ MAOI CC-26 FIG B. IF NOZZLES GO TO SUPPLY MORE PAPERWORK IS REQUIRED
				SETUP										
				PROCESS										

OPERATION PROFILE

ORIGINAL

NAME E. TOTTEN ALC OC DATE 5/2/88 RCC MAT PCB SHEET 8 OF 8

ITEM CODE (PCN) NSN 50136A WCD CBE403 WCD DATE 88174

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
350	MAT PCB	PW	1.0	TRANSIT	0.1	8P09	1	100	0.1					SIGNATURE
				SETUP										
				PROCESS										
360	↓	PW	1.0	TRANSIT	0.1	8P09	1	100	0.1					AFTO 349
				SETUP										
				PROCESS										READY FOR CERL
9999		OUT DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	24									
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

FLOW PROCESS CHART

SUBJECT 50136A DATE 6-13-84

ITEM CODE
PCH ☒
NSN. ☐
P/N ☐ 50136A

WCD CB8403 WCD DATE 88174

CHART BEGINS 10

CHART ENDS 360 PREPARED BY PHunt

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	REC	320	320	●◇D□▽	CLEAN
20	20	○◆D□▽	MOVE	330	330	○◇D■▽	INSP.
30	30	●◇D□▽	UNLOAD	340	340	●◇D□▽	C/W IMPACT
40	40	●◇D□▽	RECEIVE	350	350	●◇D□▽	PCW
50	50	●◇D□▽	DIS	360	360	●◇D□▽	C/W AFT.
60	60	●◇D□▽	CLEAN			○◇D□▽	
70	70	●◇D□▽	CLEAN			○◇D□▽	
80	80	●◇D□▽	CLEAN			○◇D□▽	
90	90	●◇D□▽	CLEAN			○◇D□▽	
100	100	●◇D□▽	CLEAN			○◇D□▽	
110	110	●◇D□▽	DEL			○◇D□▽	
120	120	●◇D□▽	SANDBLAS-			○◇D□▽	
130	130	○◇D■▽	INSP. MICR			○◇D□▽	
140	140	●◇D□▽	PROC.			○◇D□▽	
150	150	○◇D□▽ ●◇D□▽	INSTALL ORI			○◇D□▽ ○◇D□▽	
160	160	●◇D□▽	LAP NOZZL			○◇D□▽	
170	170	●◇D□▽	CLEAN			○◇D□▽	
180	180	●◇D□▽	LAP			○◇D□▽	
190	190	●◇D□▽	CLEAN			○◇D□▽	
200	200	○◇D■▽	MICROMETER			○◇D□▽	
210	210	○◇D■▽	VISUAL INSP.			○◇D□▽	
220	220	○◇D■▽	VISUAL INSP.			○◇D□▽	
230	230	○◇D■▽	INSP.			○◇D□▽	
240	240	●◇D□▽	ASSY, TORQUE			○◇D□▽	
250	250	●◇D□▽	TORQUE			○◇D□▽	
260	260	●◇D□▽	TORQUE			○◇D□▽	
270	270	●◇D□▽	PAPERWORK			○◇D□▽	
280	280	○◆D□▽	CARRY TO TEST			○◇D□▽	
290	290	○◇D■▽	TEST IN BIOB			○◇D□▽	
300	300	○◆D□▽	ONTO CONTROL			○◇D□▽	
310	310	○◇D■▽	LEAK TEST			○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

SECTION VII

ILLUSTRATED PARTS BREAKDOWN

7-1. GENERAL. This section lists and describes the parts for the fuel nozzle (Figure 7-1) installed on J57 Engines manufactured by United Technologies Corporation, Pratt & Whitney Aircraft Group, Government Products Division, P.O. Box 2691, West Palm Beach, Florida 33402, U.S.A.

7-2. MAINTENANCE PARTS LIST. The Maintenance Parts List consists of the complete fuel nozzle, as shown in figure 7-1. The assembly listed has its component parts indented thereunder, to show their relationship to the assembly. Interchangeable and substitute assemblies and parts, subsequently authorized by the Government, are not listed in this manual; such items are identified by information available through the Interchangeable and Substitute (I&S) Data Systems, refer to T.O. 00-25-184.

7-3. UNITS PER ASSEMBLY. The quantities listed in the Units per Assy. column of the Maintenance Parts List are, in the case of assemblies, the total quantity used per fuel nozzle at the location indicated, while the component parts indented under the assemblies are the quantity used per assembly. The quantities specified, therefore, are not necessarily the total used per fuel nozzle.

7-4. PART NUMBERS. Part numbers are used exclusively to identify parts.

7-5. INDEX NUMBERS. The index numbers appearing on the illustration are numerically arranged by figure numbers in the Maintenance Parts List and are used mainly to assist in locating a part in the Maintenance Parts List after it has been found on an illustration. The illustration in this section is intended primarily to facilitate the identification of parts. This section is intended as a supplement to, not a substitute for, the associated maintenance and overhaul sections which shall be considered the final authority on assembly procedures.

7-6. SUPERSEDES. Supersedes indicates that the old and new parts are interchangeable. The disposition of parts subject to the term Supersedes as identified in this section shall further be governed by any applicable specific instructions, such as Time Compliance Technical Orders.

7-7. DIMENSIONS. All dimensions shown herein are nominal. They are inserted to facilitate identification for ordering, and are not to be construed as restrictive in inspection.

7-8. SOURCE, MAINTENANCE, AND RECOVERABILITY (SMR) CODES. Definitions of applicable source, maintenance, and recoverability (SMR) codes are set forth in T.O. 00-25-195.

7-9. ABBREVIATIONS. The abbreviations used throughout this section are as follows:

Abbreviation	Full Name
ASSY	Assembly
DIA	Diameter
C/O	Consists of
ID	Inside Diameter
IN	Inch(es)
MTR	Metering
NO.	Number(s)
NOZ	Nozzle
OD	Outside Diameter
OPTL	Optional
OVHL	Overhaul
PRCMT	Procurement
PRI	Primary
RTNG	Retaining
SEC	Secondary
SPR	Spring
THK	Thick

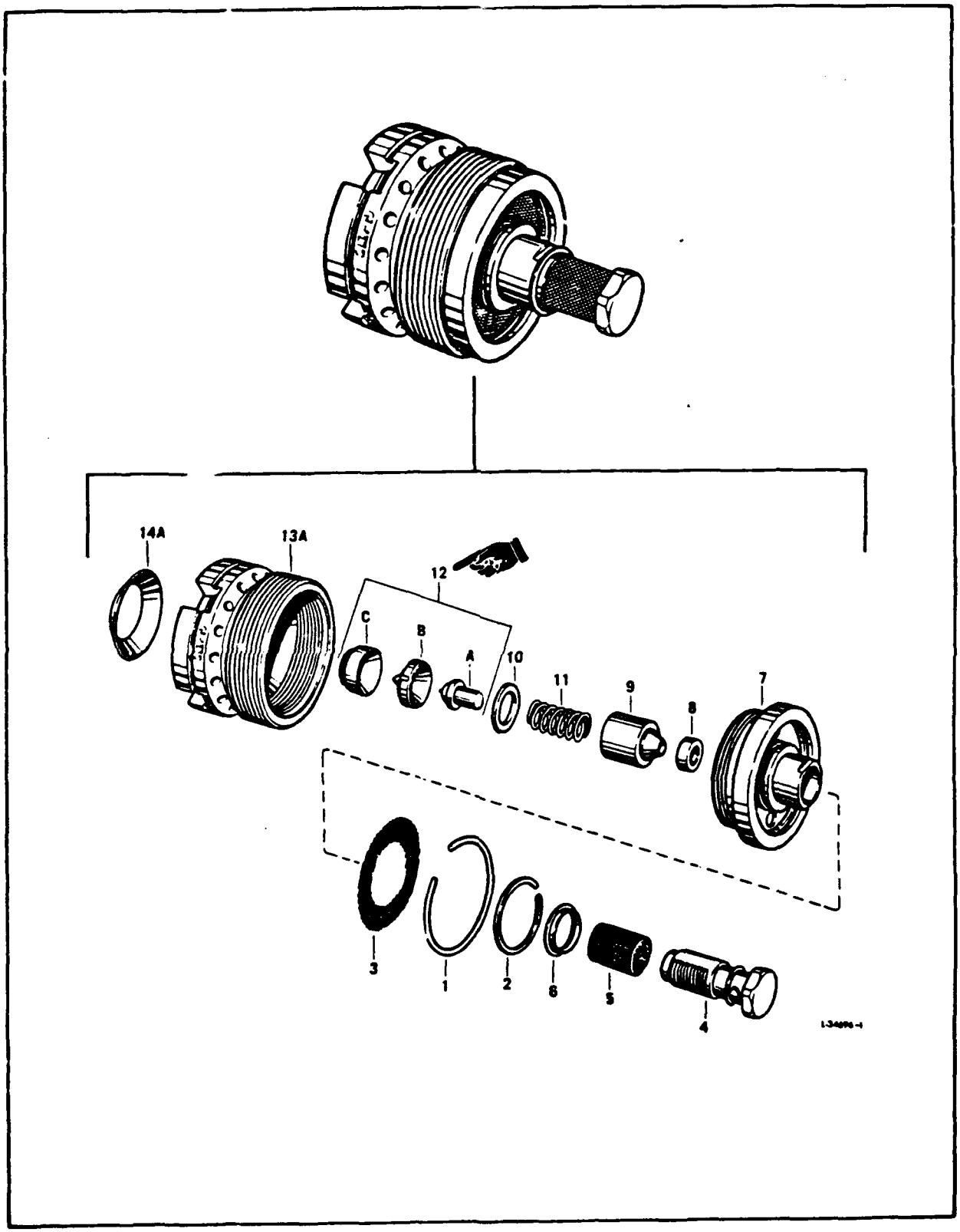


Figure 7-1. Fuel Nozzle

FIGURE & INDEX NUMBER	PART NUMBER	1234567 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
		FUEL NOZZLE			
7-1	3 18466	NOZZLE ASSEMBLY-FUEL, 492 102 repair kit AVAILABLE	24		
-1	267286	.RING-Rtng-0.8 10 OD x 0.035 in. thk	1		PADZZ
-2	267285	.RING-Rtng-0.404 ID x 0.035 in. thk	1		PADZZ
-3	267440	.STRAINER OPTION-Fuel noz sec prcmt no. c/o	1		PADZZ
	267443	STRAINER-optl to 267444			P 1
	267444	STRAINER-optl to 267443			P 1
-4	26728 1	.HOUSING-Fuel noz pri strainer	1		PADZZ
-5	267439	.STRAINER OPTION-Fuel noz pri prcmt no. c/o	1		PADZZ
	26744 1	STRAINER-optl to 267442			P 1
	267442	STRAINER-optl to 26744 1			P 1
-6	267283	.FLANGE-Fuel noz strainer	1		PADZZ
-7	267277	.BUSHING-Fuel noz	1		
-8	267287	.SEAL-Fuel noz spr seat	1		PADZZ
-9	267282	.SEAT-Fuel noz spr	1		PADZZ
-10	267288	.GASKET-0.2255 ID x 0.3 105 OD x 0.03 1 in. thk, fuel noz spr	1		PADZZ
-11	267284	.SPRING-0. 190 OD x 0.029 in. dia wire, fuel noz	1		PADZZ
-12	267279	.NOZZLE-Fuel mtr set	1		
-13	DELETED				
-13A	3 18467	.NUT-Fuel noz rtng	1		
-14	DELETED				
-14A	3 18468	.DEFLECTOR-Fuel noz air	1		PADZZ
	492 102	KIT-Repair, for repair of 3 18466 noz assy	1		D

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985 M-659-002 (2438

DISASSEMBLY/ASSEMBLY PROFILE

NAME E TOTTEN ALC OC DATE 5/3/89 RCC MATRCB SHEET 1 OF 1

TOP ASSEMBLY ITEM NUMBER	TOP ASSEMBLY WCD	TOP ASSEMBLY WCD DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY ITEM NUMBER	SUBASSEMBLY CHILD WCD	SUBASSEMBLY CHILD WCD DATE	SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N	
49802A	CBE401	89088	080	310	PCN NSN P/N 50136A	CBE403	88114	N (1)	NOZZLES
49806A					PCN NSN P/N				
49808A					PCN NSN P/N				
49810A					PCN NSN P/N				
50136A	CBE403	88114	050	130	PCN NSN P/N 50136A/51	SUB 1	88114	N	NOTE: NOT NECESSARILY NOT MATCHED SETS
					PCN NSN P/N				
					PCN NSN P/N				
					PCN NSN P/N				
					PCN NSN P/N				
					PCN NSN P/N				
					PCN NSN P/N				
					PCN NSN P/N				

(1) OLD DELAVAN NOZZLES ARE REMOVED FROM MANIFOLD AND REPLACED BY NEW/OH MARKED DELAVAN NOZZLES. SOME OLD NOZZLES ARE OVERHAULED AND SENT TO STOCK. OTHERS ARE SENT TO SHOP DIRECTLY W/O OVERHAUL (GREEN TAG). (UNSERVICEABLE/REPAIRABLE)

LSC-2(XX)5A

OPERATION PROFILE

NAME P HUNT ALC OC DATE 10-13-89 RCC MATPCB SHEET 1 OF 3

(PCN) NSN 50136A 36-24 WCD CB54T3 WCD DATE

PIN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		36									
05	MATP CB	MOVE	1.0	TRANSIT			DP09	1	100	.17					48 PER BATCH. TIMES SHOWN ARE PER EACH
				SETUP											
				PROCESS											
10	MATP CB	TEST	1.0	TRANSIT											OC702, OC703, OC705 ARE ALTERNATES.
				SETUP											
				PROCESS			DP09	1	100	.25	OC701	1	100	.25	
15	MATP CB	TEST	1.0	TRANSIT											REMOVE MASTER NOZZLE
				SETUP											
				PROCESS			DP09	1	100	.01	OC701	1	100	.06	
20	MATP CB	TEST	.85	TRANSIT											85% ARE GOOD AND REQUIRE ONLY S.U.
				SETUP											
				PROCESS			DP09	1	100	.08	OC701	1	100	.08	

LSC-2000-C

OPERAT[illegible] PROFILE

NAME P HUNT ALC OC DATE 6-13-89 RCC MATPCB SHEET 2 OF 3

PCN/NSN 50136A WCD CB54T3 WCD DATE

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
25	MATP CB	TEST	.15	TRANSIT											15% ARE BAD, AND REQUIRE REWORK
				SETUP											
				PROCESS			DP09	1	100	.25	0C701	1	100	.25	
30	MATP CB	TEST	1.0	TRANSIT											HOURS INCLUDED IN # 20, THIS IS INFO. ONLY CALIBRATION.
				SETUP											
				PROCESS			DP09	1	100	-	0C701	1	100	-	
40	MATP CB	TEST	1.0	TRANSIT											SPRAY CONE ANGLE. HOURS INCLUDED IN # 20 ABOVE.
				SETUP											
				PROCESS			DP09	1	100	-	0C701	1	100	-	
50	MATP CB	PW	1.0	TRANSIT											PW, 6 MIN FOR ALL 48 IN BATCH.
				SETUP											
				PROCESS			DP09	1	100	.01	0C701	1	100	.01	
60	MATP CB	PW	1.0	TRANSIT											CW MADE 6-6-89 PAR. 13
				SETUP											
				PROCESS			DP09	1	100	—	0C701	1	100	—	

OPERAT ... PROFILE

NAME P HUNT ALC OC DATE 6-13-89 RCC MATPCB SHEET 3 OF 3

PCN/ISN 50136A P/N WCD CB54T3 WCD DATE

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
70.	MATP CB	MOVE	1.0	TRANSIT											RET TO FINAL ASY.
				SETUP											
				PROCESS			DP09	1	100	.08	0C701	1	100	.08	
9994	MATP CB	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											
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				PROCESS											
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				SETUP											
				PROCESS											

LSC-200920

FLOW PROCESS CHART

SUBJECT _____ DATE _____

ITEM CODE
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NSN ☐
P/N ☐

WCD CBE4T3 WCD DATE 88174

50136A

CHART BEGINS _____

CHART ENDS _____ PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○●D□▽	SET UP NOZZLES AT 9 ABOVE TO TEST STATION			○◇D□▽	
020		○◇●□▽	SET UP TEST STATION (ONCE/SHIFT)			○◇D□▽	
030		●◇D□▽	LOAD NOZZLE INTO TEST CHAMBER			○◇D□▽	
040		●◇D□▽	PERFORM NOZZLE TEST			○◇D□▽	
050		●◇D□▽	REMOVE NOZZLE AND DISASSEMBLE IF TEST FAIL			○◇D□▽	
060		●◇D□▽	FILE AND/OR POLISH PARTS			○◇D□▽	
070		●◇D□▽	ASSEMBLE NOZZLE			○◇D□▽	
080		●◇D□▽	REMOVE NOZZLE & REBOX IF TEST PASS			○◇D□▽	
090		●◇D□▽	COMPLETE PAPERWORK			○◇D□▽	
100		○●D□▽	RETURN NOZZLE TO FINAL ASSEMBLY			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31 MAY 99 RCC MTPCB SHEET 1 OF 1

PCN
NSN
PIN 50136A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (~~DAYS~~ HRS)
1	8312	8315	72
2	8327	8327	0
3	8348	8349	24
4	8356	8358	48
			36

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

LSC-20107A

"OUT" DATES PRC. .LE

NAME _____ ALC OC-ALC DATE 31 MAY 89 NCC MIPCB SHEET 1 OF 1

PCH
NSN
P/N 50136A

PARENT
WCD _____

PARENT
WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	+/- S A TIME (~~DATE~~)
1	8320	8320	0
2	8330	8333	72"
3	8351	8351	" 0
4	8363	8364	24
			(24)

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

LSC-20108A

OPERATION PRO .E

NAME E. Toten ALC OC DATE 5/5/89 RCC MATPCB SHEET 1 OF 5

PCN
NSN
PN 50138A WCD CBE402B ✓ WCD DATE 89019

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	30.0									
1		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	4.5	BEN4F	1	1.0	4.5	
20		DIS	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	8.0	BEN48	1	1.0	8.0	
30		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.50	OC 3020	1	1.0	.50	
31		CLN	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.30	OC 4132	1	1.0	.30	

OPERATION PRO .E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 5

PCN
NSN 50138A
PIN

WCD CBE402B ✓ WCD DATE 89019

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
34	MAT PCB	PROC	1.0	PROCESS	1.0	2.0	BP09	1	1.0	.20	OC4947	1	1.0	.20	Dry and cool
60		Insp	1.0	PROCESS	—	—		1	1.0	6.5	BEN48	1	1.0	6.5	
73		INSP	1.0	PROCESS	—	—		1	1.0	2.3	BEN48	1	1.0	2.3	
83		ASSY	1.0	PROCESS	—	—		1	1.0	4.3	BEN48	1	1.0	4.3	
100		PROC	1.0	PROCESS	—	—		1	1.0	.90	OC 3391	1	1.0	.90	

OPERATION PRC. .E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

PCN
IISN 50138A
PIN

WCD CBE402B ✓ WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MAT PCB	CLN	1.0	[illegible]											
				SETUP											
				PROCESS	—	—	BP09	1	1.0	.20	OC 1178	1	1.0	.20	
111		PROC	1.0	[illegible]											OC, include cooling
				[illegible]											
				PROCESS	1	1.0		1	1.0	.20	OC 4947	1	1.0	.20	
120		INSP	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	1.6	BEN 48	1	1.0	1.6	
125		DIS	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	14.0	BEN48	1	1.0	14.0	
133		ASSY	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	2.4	Ben 48	1	1.0	2.4	

OPERATION PRC _E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 5

PCN
NSN
PN 50138A WCD CBE402 B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
140	MAT PCB	ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP09	1	1.0	16.0	BEN 48	1	1.0	16.0	
150		TEST	1.0	~~TRANSIT~~											CB backshop
				~~SETUP~~											
				PROCESS	1.0	48.0									
151		CLN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	2.25	OC 3020	1	1.0	2.25	
152		CLN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.20	OC 4132	1	1.0	.20	
154		CLN	1.0	~~TRANSIT~~											Dry & cool
				~~SETUP~~											
				PROCESS	1.0	2.0		1	1.0	.2	OC 4140	1	1.0	.2	

OPERATION PROFILE

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

PCN
NSN
P/N 50138A

WCD CBE402B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
157	MAT ACB	CLN	1.0	~~TRANSH~~											
				~~SETUP~~											
				PROCESS	—	—	AP07	1	1.0	1.4	OC 1174	1	1.0	1.4	
158		INSP	1.0	~~TRANSH~~											
				~~SETUP~~											
				PROCESS	—	—	AP07	1	1.0	4.0	BEN48	1	1.0	.40	
160		ASSY	1.0	~~TRANSH~~											
				~~SETUP~~											
				PROCESS	—	—	BP09	1	1.0	12.0	Ben 48	1	1.0	12.0	
170		INSP	1.0	~~TRANSH~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	1.2	BEN48	1	1.0	1.2	
180		PW	1.0	~~TRANSH~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.50	Ben 48	1	1.0	.50	
9999		OUT	1.0	Process	1.0	24.0									

LSC-2000[illegible]

FLOW PROCESS CHART

SUBJECT J-57, TF33 FUEL NOZZLE ASSY OVERHAUL DATE 5/5/89

ITEM CODE
PCN ☒
NSN ☐
P/N ☐ 5013SA, 5013SA

WCD CLE402 WCD DATE 89019

5013SA = EXCELLO NOZZLE
5013SA = P&W NOZZLE

CHART BEGINS 1

CHART ENDS 180 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
1		◔ ▷ D □ ▽	SEPT IN SOLID TANK NOZZLES/NUTS	151		● ▷ D □ ▽	HOT AIR WAY NUTS
5		○ ◔ D □ ▽	MOVE NOZZLES TO [illegible]	152		● ▷ D □ ▽	AIR COOL NUTS
8		○ ▷ D □ ▼	MATERIAL SEPARATION [illegible]	154	152	◔ ▷ D □ ▽	SAND BLAST NUTS
10	10	● ▷ D □ ▽	MOVE NOZZLES TO WORK STATION (45 TRAY) ELEC	157	155	○ ▷ D ■ ▽	VISUALLY INSPECT NUTS THREADS
20	20	● ▷ D □ ▽	DISASSEMBLE	159		○ ▷ D □ ▼	SHIFT FROM STORAGE - NUTS
25		○ ▷ D ■ ▽	IN PROCESS INSPECTION	160	160	● ▷ D □ ▽	FINAL ASSEMBLE NOZZLES NUTS
30	30	● ▷ D □ ▽	CLEAN BY ULTRASONIC [illegible]	170	170	○ ▷ D ■ ▽	INSPECT NOZZLES - GAUGES
31	30	● ▷ D □ ▽	SOAK IN WAX	180	180 190	● ▷ D □ ▽	FINAL PAPERWORK
32	30	● ▷ D □ ▽	CLEAN WITH DETERGENT			○ ▷ D □ ▽	
33	30	● ▷ D □ ▽	WATER RINSE			○ ▷ D □ ▽	
34	30	● ▷ D □ ▽	CLEAN - ULTRASONIC			○ ▷ D □ ▽	
35	30	● ▷ D □ ▽	AIR COOL			○ ▷ D □ ▽	
60	60	○ ▷ D ■ ▽	INSPECT, POLISH			○ ▷ D □ ▽	
70	70	○ ▷ D ■ ▽	INSPECT SECONDARY WELDING JOINT			○ ▷ D □ ▽	
75	75	○ ▷ D ■ ▽	INSPECT NOZZLE TO FLANGE			○ ▷ D □ ▽	
80	80	● ▷ D □ ▽	ASSY INSTALL METERING TAB ETC.			○ ▷ D □ ▽	
85		● ▷ D □ ▽	ASSY SOLDER SAW NUT & NUT RING			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	INSTALL LAW NOZZLES			○ ▷ D □ ▽	
105		● ▷ D □ ▽	REMOVE NOZZLES FOR LATER TRAY NOZZLES			○ ▷ D □ ▽	
110	110	● ▷ D □ ▽	CLEAN NOZZLES IN [illegible]			○ ▷ D □ ▽	
111		● ▷ D □ ▽	WET - VAPOR DEGREASER			○ ▷ D □ ▽	
112		● ▷ D □ ▽	AIR COOL			○ ▷ D □ ▽	
120		○ ▷ D ■ ▽	INCREASE HOUSING ASSY NO INSPECT			○ ▷ D □ ▽	
125		● ▷ D □ ▽	DISASSY 5013A ONLY - REMOVE OIL METERING			○ ▷ D □ ▽	
130	130	● ▷ D □ ▽	INSERT MAN METERING RING (5013A ONLY)			○ ▷ D □ ▽	
135	135	● ▷ D □ ▽	ASSY: 5013A INSERT [illegible]			○ ▷ D □ ▽	
140	140	● ▷ D □ ▽	ASSY: METERING PLUG SPRING [illegible]			○ ▷ D □ ▽	
150	150	● ▷ D □ ▽	MOVE TO FINAL TEST [illegible] BACK-UP			○ ▷ D □ ▽	
151		● ▷ D □ ▽	CLEAN NUTS - AGAIN			○ ▷ D □ ▽	
152		● ▷ D □ ▽	WATER RINSE NUTS			○ ▷ D □ ▽	
153		● ▷ D □ ▽	CLEAN NUTS - AGAIN			○ ▷ D □ ▽	
154		● ▷ D □ ▽	WATER RINSE NUTS			○ ▷ D □ ▽	

NUT ASSEMBLY/ALLEN WRENCH

Q/S

NUT ASSEMBLY/ALLEN WRENCH

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

VAPOR DEGREASER - PERCHLOROETHYLENE

OPERATION PROCESS

NAME E. Totten ALC OC DATE 5/5/89 RCC MATPCB SHEET 1 OF 2

PCN
NSN
PN 50138A WCD CBERT2B WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	[illegible]											
				[illegible]											
				PROCESS	1.0	24.0									
5		REC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—	OP 09	1	1.0	.10	OC 0702	1	1.0	.10	
8		PROC	.40	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.50	OC 0702	1	1.0	.50	
10		PROC	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	.50	OC 0702	1	1.0	.50	
20		TEST	1.0	[illegible]											
				[illegible]											
				PROCESS	—	—		1	1.0	3.5	OC 0702	1	1.0	3.5	

OPERATION PROFIL

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 3

DIVISION 40135A WCD CBE4T2B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
51	MAT PCB	DIS	.75	TRANSIT											
				SETUP											
				PROCESS	—	—	DP07	1	1.0	.45	OC 0702	1	1.0	.45	
52		REP	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	1.0	OC 0702	1	1.0	1.0	
53		ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	1.0	OC 0702	1	1.0	1.0	
54		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.48	OC 0702	1	1.0	.48	
60		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.14	OC 0702	1	1.0	.14	
1999		OUT	1.0	Process	1.0	300									

LSC-20092C

J57 P9/EXCELLO JET

FLOW PROCESS CHART

SUBJECT ENGINE NOZZLE DATE 5/5/89

ITEM CODE
PCN
NSN
P/N

WCD CBE4T2 WCD DATE 88174

5R4135A, 50138A

CHART BEGINS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○▶D□▽	MICRO NOZZLES AT ENTRY; MOVE TO STATION			○▷D□▽	
020		○▷●□▽	SET UP TEST STAND (ONCE/SHIFT)			○▷D□▽	
030	010	●▷D□▽	LOAD NOZZLE INTO TEST CHAMBER			○▷D□▽	
040	(1)	●▷D□▽	PERFORM NOZZLE TESTS.			○▷D□▽	
050	(2)	●▷D□▽	REMOVE NOZZLE AND DISASSEMBLE IF TEST FAIL			○▷D□▽	
060		●▷D□▽	FILE AND/OR REPLACE PARTS			○▷D□▽	
070		●▷D□▽	ASSEMBLE NOZZLE.			○▷D□▽	
080		●▷D□▽	REMOVE NOZZLE & REBOX IF TEST PASS			○▷D□▽	
090	(3)	●▷D□▽	COMPLETE PAPERWORK			○▷D□▽	
100	080	○▶D□▽	RETURN NOZZLES TO FINAL ASSEMBLY			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 50138A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS) HRS
1	8295	8298	72
2	8307	8307	0
3	8319	8321	48
4	8342	8342	0
			30

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

LSC-20107A

"OUT" DATES PR. ILE

NAME _____ ALC O-ALC DATE 3/MAY 89 RCC 11TPC13 SHEET 1 OF 1

PCII/ISII/PII 50130A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	LRS A TIME (DAYS)
1	8300	8300	0
2	8308	8309	24 "
3	8326	8326	" 0
4	8344	8347	12
			24

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

LSC-2010RA

OPERATION PROFILE

NAME PHUNT ALC OC DATE 53089 RCC MTPCB SHEET 1 OF 3

PCN/NSN/PIN 96515A WCD CBE706 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
10	MATP CB	REC	1.0	~~TRANSIT~~											NO MAT ROC
				~~SETUP~~											
				PROCESS			BP09	1	100	.42	BEN436	1	100	.42	
15	MATP CB	CLN	1.0	~~TRANSIT~~											PD660 AIR DRY OC1773 ALT
				~~SETUP~~											
				PROCESS			BP09	1	100	.17	OC4447	1 1	100 100	.08 .08	
20	MATP CB	DIS	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP09	1	100	1.0	BEN436	1	100	1.0	
30	MATP CB	CLN	1.0	TRANSIT											WIPE PARTS CLEAN AS REQ'D.
				~~SETUP~~											
				PROCESS			BP09	1	100	.10	BEN436	1	100	.10	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 53089 RCC MTPCB SHEET 2 OF 3

PCN / NSN / PIN 96515 A WCD C6E Y06 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
40	MATP CB	INSP.	1.0	~~TRANSIT~~											INSP.
				~~SETUP~~											
				PROCESS			AP 09	1	100	1.5	BEN436	1	100	1.5	
50	MATP CB	NDI	1.0	~~TRANSIT~~											MAG, PT.
				~~SETUP~~											
				PROCESS	100	24	AP09	1	100	.08	OC6025	1	100	.08	
100	MATP CB	ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			AP 09	1	100	1.0	BEN436	1	100	1.0	
110	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			AP 09	1	100	.33	BEN436	1	100	.33	
140	MATP CB	ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			AP 09	1	100	1.0	BEN436	1	100	1.0	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 53089 RCC MTPCB SHEET 3 OF 3

PCN / NSN / PIN 96515 A WCD ~~CBE~~ Y06 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MATP CB	ASSY	1.0	~~TRANSIT~~											INST. SHAFT ASSY
				~~SETUP~~											
				PROCESS			BP 09	1	100	.08	BEN436	1	100	.08	
160	MATP CB	ASSY	1.0	~~TRANSIT~~											INST IMPELLER + INDUCER
				~~SETUP~~											
				PROCESS			BP09	1	100	.33	BEN436	1	100	.33	
9994	MATP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24	BP 09								
				~~TRANSIT~~											
				~~SETUP~~											
				PROCESS											
				~~TRANSIT~~											
				~~SETUP~~											
				PROCESS											

FLOW PROCESS CHART

SUBJECT CENTRIFUGAL PUMP ASSY DATE 53089

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

WCD CBE706 WCD DATE 88267

CHART BEGINS 010 RECEIVE, IDENTIFY & ATTACH PW

CHART ENDS 250 COMPL AFTO 349 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	REC, PW			○◇D□▽	
15	15	●◇D□▽	CLN PD680			○◇D□▽	
20	20	●◇D□▽	DISASSY UNIT			○◇D□▽	
30	30	●◇D□▽	CLN-WIPE			○◇D□▽	
40	40	○◇D■▽	INSP.			○◇D□▽	
50	50	○◇D■▽	NDI INSP.			○◇D□▽	
100	100	●◇D□▽	ASSY			○◇D□▽	
110	110	○◇D■▽	TEST			○◇D□▽	
140	140	●◇D□▽	ASSY			○◇D□▽	
150	150	●◇D□▽	ASSY			○◇D□▽	
160	160	●◇D□▽	ASSY			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽ ○◇D□▽				○◇D□▽ ○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

DISASSEMBLY/ASSEMBLY PROFILE

NAME P HUNT ALC OC DATE 53089 RCC MTPCB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
PCN NSN P/N 96515A	CBE706	88267	20	200	PCN NSN P/N 02-14731	CBE7065 1		N
PCN NSN P/N					PCN NSN P/N 102-1231-01	CBE7065 2		N
PCN NSN P/N					PCN NSN P/N 102-1235-02	CBE7065 3		N
PCN NSN P/N					PCN NSN P/N 02-14868-2	CBE7065 4		
PCN NSN P/N					PCN NSN P/N 102-1302-02	CBE7065 5		
PCN NSN P/N					PCN NSN P/N 102-1347-04	CBE7065 6		
PCN NSN P/N					PCN NSN P/N 102-1142	CBE7065 7		
PCN NSN P/N					PCN NSN P/N 02-14518	CBE7065 8		
PCN NSN P/N					PCN NSN P/N 102-1274-02	CBE7065 9		
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-20XXJ5A

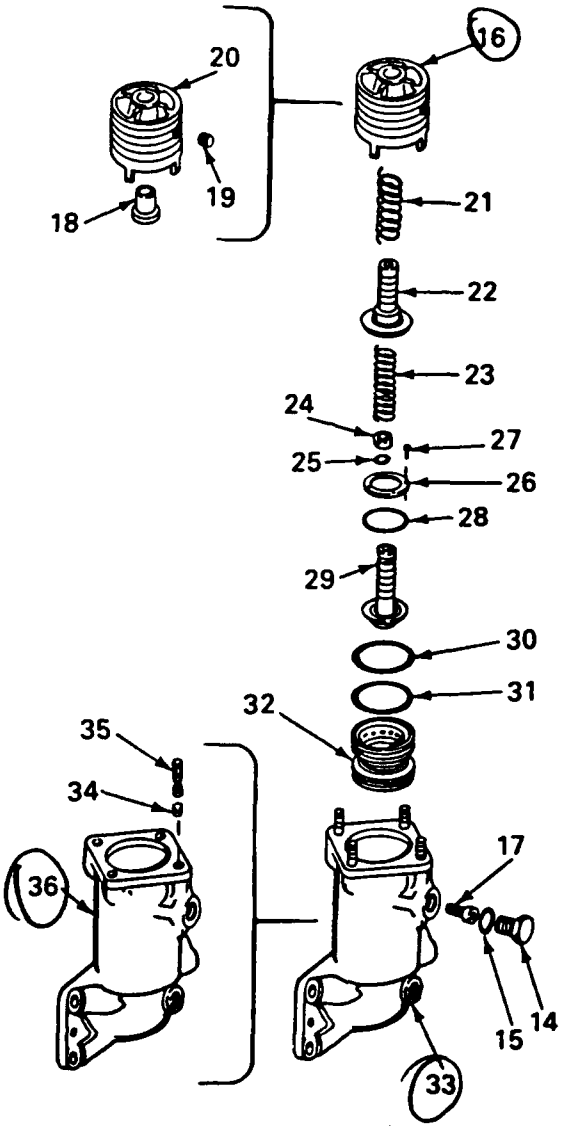
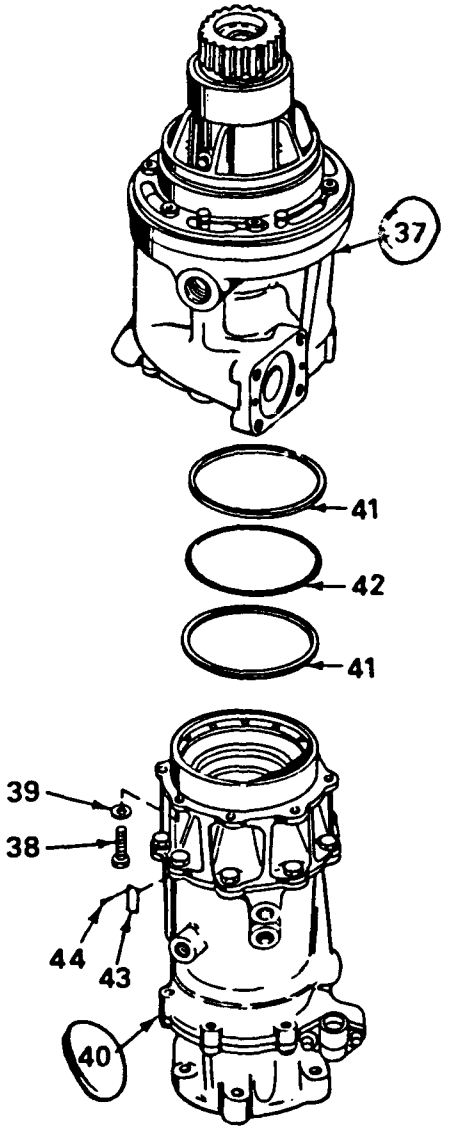


Figure 1. Centrifugal Pump Assembly (Sheet 2 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMk
1/1-						
	024536-209-09	99167	PUMP ASSEMBLY, Centrifugal . (Repair Kit Available)	REF	A	PAOLD
	025264-200-02	99167	PUMP ASSEMBLY, Centrifugal .	REF	B	PAOLD
	024536-213-09	99167	PUMP ASSEMBLY, Centrifugal .	REF	C	PAOLD
	024536-214-10	99167	PUMP ASSEMBLY, Centrifugal .	REF	D	PAOLD
-1	02-14887	99167	. FILTER, Oil	1		PAOZZ
-2	99-2975-8	99167	. PACKING, Preformed	1		PAOZZ
-3	102-1381	99167	. VALVE ASSEMBLY, Poppet . . (see figure 2)	1	A	PAOZZ
	102-1381-01	99167	. VALVE ASSEMBLY, Poppet . . (see figure 2)	1	BCD	PAOZZ
-4	99-2975-5	99167	. PACKING, Preformed	1	A	PADZZ
	99-4602-05	99167	. PACKING, Preformed	1	BCD	PADZZ
-5	102-1478	99167	. FILTER ASSEMBLY (see . . . figure 3)	1	B	PADZZ
-6	99-4602-05	99167	. PACKING, Preformed	1	B	PAOZZ
-7	02-14731	99167	. TUBE, Turbine inlet	1		PADZZ
-8	99-4346-112	99167	. PACKING, Preformed	2	A	PADZZ
	99-4601-112	99167	. PACKING, Preformed	2	BCD	PADZZ
-9	99-4498	99167	. RETAINER	2		PADZZ
-10	99-4195-06	99167	. SCREW, Cap (AP)	4		PADZZ
-11	99-4344	99167	. WASHER (AP)	4		PADZZ
-12	99-4346-221	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-221	99167	. PACKING, Preformed	1	BCD	PADZZ
-13	99-4345	99167	. CAP SEAL	1		PADZZ



A-52651

Figure 1. Centrifugal Pump Assembly (Sheet 3 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/2-						
-14	AN814-4L	88044	. PLUG	1		PADZZ
-15	99-2975-4	99167	. PACKING, Preformed	1	A	PAOZZ
	99-4602-04	99167	. PACKING, Preformed	1	BCD	PAOZZ
-16	102-1231-01	99167	. GUIDE SUBASSEMBLY, Flow . .	1		PADZZ
-17	99-4196-02	99167	. SCREW, Socket head (AP) . .	1		PADZZ
-18	02-14781	99167	. . GUIDE, Valve	1		PADZZ
-19	MS21209F4-15	96906	. . INSERT	1		PADZZ
-20	02-14801-01	99167	. . GUIDE, Flow	1		PADZZ
-21	99-4303	99167	. SPRING, High pressure check valve	1		PADZZ
-22	02-14875-02	99167	. VALVE, High pressure check	1		PADZZ
-23	99-4304	99167	. SPRING, Low pressure check valve	1		PADZZ
-24	99-4302	99167	. RING, Glyd	1		PADZZ
-25	99-2973-6	99167	. PACKING, Preformed	1		PADZZ
-26	02-15301	99167	. RETAINER, Packing	1	ACD	PADZZ
	02-15301-01	99167	. RETAINER, Packing	1	B	PADZZ
-27	99-4581	99167	. SCREW, Flat head (AP) . . .	6		PADZZ
-28	99-4580	99167	. PACKING, Preformed	1		PADZZ
-29	02-15302	99167	. VALVE, Low pressure check .	1		PADZZ
-30	99-2973-127	99167	. PACKING, Preformed	1		PADZZ
-31	99-2973-127	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-127	99167	. PACKING, Preformed	1	BCD	PADZZ
-32	02-15397	99167	. SEAT, Check valve	1		PADZZ
-33	102-1235-02	99167	. VALVE HOUSING SUBASSEMBLY, Check	1		PADZZ
-34	KR5A-15	99057	. . RING, Key	4		PADZZ
-35	99-4186	99167	. . STUD	4		PADZZ
-36	02-14808-02	99167	. . HOUSING, Valve	1		PADLD

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/3-						
-37	No Number	99167	. PUMP UNIT ASSEMBLY . . .	1		PADBZ
-38	99-4190	99167	. BOLT (AP)	8		PADZZ
-39	AN960-516L	88044	. WASHER (AP)	8		PADZZ
-40	102-1302-02	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	A	PADZZ
	102-1561-03	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	B	PADZZ
	102-1302-05	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	C	PADZZ
	102-1302-06	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	D	PADZZ
-41	99-4496	99167	. RETAINER, Packing	2		PADZZ
-42	99-4346-241	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-241	99167	. PACKING, Preformed	1	BCD	PADZZ
-43	99-5000-03	99167	. PLATE, Identification . . .	1		PADZZ
-44	AN535-00-2	88044	. SCREW (AP)	4		PADZZ

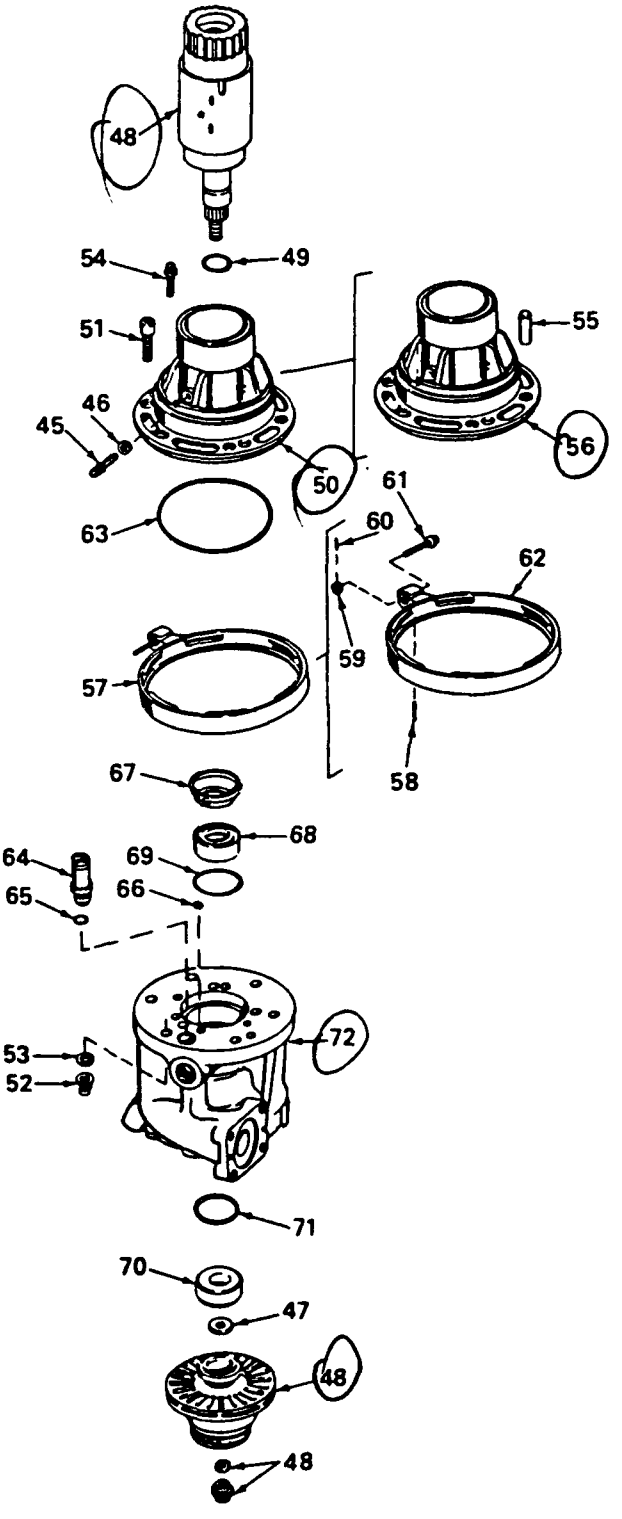
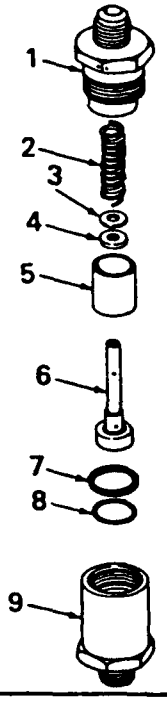


Figure 1. Centrifugal Pump Assembly (Sheet 4 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/4-						
-45	99-4188	99167	. BOLT	3		PADZZ
-46	MS20002C4	96906	. WASHER	1		PADZZ
-47	02-12869-07	99167	. SHIM (0.001 inch thick)	AR	ACD	PADZZ
	02-12869-06	99167	. SHIM (0.016 inch thick)	AR	ACD	PADZZ
	02-12869-05	99167	. SHIM (0.014 inch thick)	AR	ACD	PADZZ
	02-12869-04	99167	. SHIM (0.012 inch thick)	AR	ACD	PADZZ
	02-12869-03	99167	. SHIM (0.010 inch thick)	AR	ACD	PADZZ
	02-12869-02	99167	. SHIM (0.005 inch thick)	AR	ACD	PADZZ
	02-12869-01	99167	. SHIM (0.003 inch thick)	AR	ACD	PADZZ
	02-15827-01	99167	. SHIM (0.001 inch thick)	AR	B	PADZZ
	02-15827-02	99167	. SHIM (0.003 inch thick)	AR	B	PADZZ
	02-15827-03	99167	. SHIM (0.005 inch thick)	AR	B	PADZZ
	02-15827-04	99167	. SHIM (0.010 inch thick)	AR	B	PADZZ
	02-15827-05	99167	. SHIM (0.012 inch thick)	AR	B	PADZZ
	02-15827-06	99167	. SHIM (0.014 inch thick)	AR	B	PADZZ
	02-15827-07	99167	. SHIM (0.016 inch thick)	AR	B	PADZZ
-48	102-1347-04	99167	. SHAFT ASSEMBLY, Balancing (see figure 5)	1	ACD	PADZZ
	102-1522-01	99167	. SHAFT ASSEMBLY, Balancing (see figure 5)	1	B	PADZZ
-49	99-2973-19	99167	. RING, Seal	1		PADZZ
-50	102-1142	99167	. HOUSING SUBASSEMBLY, Bearing	1		PAFDD
-51	99-4368	99167	. SCREW (AP)	6		PADZZ
-52	LH3830-064	72962	. NUT (99-4198) (AP)	6		PADZZ
-53	AN960-616L	88044	. WASHER (AP)	6		PADZZ
-54	99-4194-10	99167	. BOLT (AP)	3		PADZZ
-55	99-4247	99167	. . PIN, Dowel	1		PADZZ
-56	02-14518	99167	. . HOUSING, Bearing	1		PADBZ
-57	504245	77445	. NUT, Gearbox, quick disconnect	1	A	PADZZ
	02-16113	77445	. NUT, Gearbox, quick disconnect (702805)	1	BCD	PADZZ
-58	AN150237	88044	. . PIN	2		PAFZZ
-59	504243	77445	. . COLLAR	1		PAFZZ
-60	AN150212	88044	. . PIN	1		PAFZZ
-61	702086	77445	. . BOLT	1		PAFZZ
-62	No Number	77445	. . NUT, Gearbox quick disconnect	1		XA
-63	99-2973-241	99167	. RING, Seal	1		PADZZ
-64	02-14533	99167	. SLEEVE, Oil lube	1		PADZZ
-65	99-2973-13	99167	. RING, Seal	1		PADZZ
-66	99-2973-10	99167	. RING, Seal	1		PADZZ
-67	02-14859	99167	. RETAINER	1		PADZZ
-68	02-14696	99167	. SEAL, Shaft, oil	1		PADZZ
-69	99-2973-130	99167	. RING, Seal	1		PADZZ
-70	02-14892-01	99167	. SEAL, Shaft, fuel	1		PADZZ
-71	99-4448	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-501	99167	. PACKING, Preformed	1	BCD	PADZZ
-72	102-1274-02	99167	. HOUSING SUBASSEMBLY, Pump (see figure 6)	1		PADBZ



A-51567

Figure 2. Poppet Valve Assembly

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
2-						
	102-1381	99167	VALVE ASSEMBLY, Poppet (see index 3, figure 1)	REF	A	PAOZZ
	102-1381-01	99167	VALVE ASSEMBLY, Poppet (see index 3, figure 1)	REF	BCD	PAOZZ
-1	02-15245	99167	. CAP, Valve	1		PAOZZ
-2	99-4531	99167	. SPRING	1		PAOZZ
-3	02-15246-04	99167	. SPACER (0.005 in. thick) .	AR		PAOZZ
	02-15246-03	99167	. SPACER (0.010 in. thick) .	AR		PAOZZ
	02-15246-02	99167	. SPACER (0.015 in. thick) .	AR		PAOZZ
-4	02-15246-01	99167	. SPACER (0.050 in. thick) .	1		PAOZZ
-5	102-1380	99167	. POPPET ASSEMBLY	1		PAOZZ
-6	02-15243	99167	. SEAT, Valve	1		PAOZZ
-7	99-4533	99167	. RETAINER	1		PAOZZ
-8	99-4346-16	99167	. PACKING, Preformed	1	A	PAOZZ
	99-4601-016	99167	. PACKING, Preformed	1	BCD	PAOZZ
-9	02-15242	99167	. HOUSING, Valve	1		PAOZZ

Usable on Code

A	024536-209-09
B	025264-200-02
C	024536-213-09
D	024536-214-10

OPERATION PROFILE

NAME PHUNT ALC OC DATE 53089 RCC MTPCB SHEET 1 OF 4

PCN/RSN 96515A WCD CBE701 ✓ WCD DATE 88267

PIN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
05	MATP CB	MOV	1.0	~~TRANSIT~~											RETRIEVE PUMP FROM CONVEYOR LINE - INCOMING
				~~SETUP~~											
				PROCESS			DP 09	1	100	.17	—				
10	MATP CB	TEST	1.0	~~TRANSIT~~											PREPARE PUMP MOUNT (MNT) IT INTO TEST STAND CC0145 ACT
				SETUP			DP 09	1	100	.17	CC5139	1	100	.17	
				~~PROCESS~~											
15	MATP CB	TEST	1.0	~~TRANSIT~~											PUMP, BEARING LUBE CC0145 ACT
				~~SETUP~~											
				PROCESS			DP 09	1	100	.02	CC5139	1	100	.02	
20	MATP CB	TEST	1.0	~~TRANSIT~~											PREPARE TO PUMP CC0145 ACT
				~~SETUP~~											
				PROCESS			DP 09	1	100	.17	CC5139	1	100	.17	

OPERATION PROFILE

NAME P HUNT ALC 0C DATE 5 30 89 RCC M7PC13 SHEET 2 OF 4

PCN
NSN
P/N 96515A-- WCD CBE707 WCD DATE 8823-7

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
30	MATP CK	TEST	1.0	~~TRANSIT~~											CYCLING TEST —
				~~SETUP~~											
				PROCESS			DP09	1	100	.6	OC5137	1	100	.6	OC0945 ALT
40	MATP	TEST	1.0	~~TRANSIT~~											MIN FLOW CALIB
				~~SETUP~~											
				PROCESS			DP09	1	100	.6	OC5137	1	100	.6	OC0945 ALT
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME PHUNT ALC OC DATE 53089 RCC MTPCB SHEET 3 OF 4

PCN / RSN 96515A PIR WCD CBE 10.7 ✓ WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
50	MATP CB	TEST	1.0	~~TRANSIT~~											SCROLL DRAIN VALVE OPERATION
				~~SETUP~~											
				PROCESS			DP 09	1	100	.08	OC 5139	1	100	.08	OR OC 0445
60	MATP CB	TEST	1.0	~~TRANSIT~~											PUPPET SEAL
				~~SETUP~~											
				PROCESS			DP09	1	100	.42	OC 5139	1	100	.42	OR OC0445
70	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											OR OC0445
				PROCESS			DP 09	1	100	.17	OC 5139	1	100	.17	
130	MATP CB	TEST	1.0 1.5	~~TRANSIT~~											REMOVE PUMP FROM TEST STAND. OR OC0445
				~~SETUP~~			DP 09	1	100	.33	OC 5139	1	100	.33	
				~~PROCESS~~											
140	MATP CB	PLS	1.0	~~TRANSIT~~											OR OC 0445
				~~SETUP~~											
				PROCESS			DP 09	1	100	.08	OC 5139	1	100	.08	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 53089 NCC MTPCB SHEET 4 OF 4

PCN
NSN 9651SA
PIN

WCD CBE Y0.7 ✓ WCD DATE 88239

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
180	MATP CB	MOV	1.0	~~TRANSIT~~											MOVE TO FINAL ASSY
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	—				
190	MATP CB	PW	1.0	~~TRANSIT~~											C/W MOD 66-36 PWB
				~~SETUP~~											
				PROCESS			DP09	1	100	.05	—	—	—	—	
9999	MATP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24	DP09								
				~~TRANSIT~~											
				~~SETUP~~											
				PROCESS											
				~~TRANSIT~~											
				~~SETUP~~											
				PROCESS											

LSC-200926

FLOW PROCESS CHART

SUBJECT CENTRIFUGAL PUMP ASSY DATE 53089

ITEM CODE PCN ☒ MSK. ☐ P/N ☐

WCD CBE707 WCD DATE 88239

CHART BEGINS 005 GET PUMP

CHART ENDS 190 C/W MAOI 66-36 PREPARED BY PAT F

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
05	—	○●D□▽	GET PUMP			○◇D□▽	
10	10	◐◇D□▽	SET-UP			○◇D□▽	
15	15	●◇D□▽	PUMP LOD.			○◇D□▽	
20	20	○◇D■▽	BREAK IN - LIC TEST			○◇D□▽	
30	30	○◇D▨▽	CYCLE TEST			○◇D□▽	
40	40	○◇D▨▽	HOT TEST			○◇D□▽	
50	50	○◇D■▽	SCRUB DRAIN VALVE			○◇D□▽	
60	60	○◇D■▽	DRAIN + LEAK TO CLEAR TEST			○◇D□▽	
70	70	●◇D□▽	MAX FLOW CTRL.			○◇D□▽	
—	80	○◇D□▽	|			○◇D□▽	
—	100	○◇D□▽	| OMITTED BY			○◇D□▽	
—	110	○◇D□▽	| OPERATOR			○◇D□▽	
—	120	○◇D□▽	|			○◇D□▽	
130	130	●◇D□▽	FLUSH PUMP			○◇D□▽	
140	140	○◇D□▽ ●◇D□▽	PW			○◇D□▽ ○◇D□▽	
180	180	●◇D□▽	PW			○◇D□▽	
190	190	●◇D□▽	C/W TO			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PRO"LE

NAME _____ ALC OC ALC DATE 31MAY89 NCC MTPCB SHEET 1 OF ___

PCN / NSN / PN 96515A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~ HRS
1	8272	8273	24
2	8272	8274	48
3	8288	8288	0
4	8335	8336	24
5	8363	8363	0
6	9004	9006	48
			(24)

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

LSC-20107A

"OUT" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC N-PCB SHEET 1 OF 1

PCH NSN P/N 96515A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	~~A TIME (DAYS)~~
1	8280	8280	0
2	8280	8280	0
3	8298	8299	24
4	8342	8342	0
5	9005	9005	0
6	9006	9009	72
			(16)

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

LSC-20108A

OPERATION PROFILE

NAME Packer ALC OC DATE 5/30 RCC MATRCB SHEET 1 OF 6

PCN / NSN / PIN 96523A WCD CAEY08 WCD DATE 88235

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
005	MAT RCB	INDUCT	1.0	[redacted]		24									
010		REC	1.0	[redacted]											
				PROCESS			AP09	1	1.0	.17	BEN419	1	1.0	.17	
015		INSP	1.0	[redacted]											
				PROCESS	—	—		1	1.0	2.5	BEN419	1	1.0	2.5	
020		DIS	1.0	[redacted]											
				PROCESS	—	—		1	1.0	1.0	BEN419	1	1.0	1.0	
030		CLN	1.0	[redacted]											
				PROCESS	—	—			1.0	.33	OC 4947	1	1.0	.33	
040		INSP	1.0	[redacted]											
				PROCESS	—	—		1	1.0	.33	BEN419	1	1.0	.33	

LSC-20092C

OPERATIC PROFILE

NAME Packer ALC OC DATE 5/30 [illegible] RCC MATP B SHEET 2 OF 6

PCN
NSN
PIN 96523A WCD CAEY08 WCD DATE C8239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
045	MAT RCB	INSP	1.0	[redacted]											Flouresan penetrant
				[redacted]											
				PROCESS	—	—	BI 09	1	1.0	2.0	OC 0229	1	1.0	2.0	
047		INSP	1.0	[redacted]											Magnetic particle insp.
				[redacted]											
				PROCESS	—	—		1	1.0	.20	OC 0625	1	1.0	.20	included with above flow hours.
050		INSP	1.0	[redacted]											micrometers, feeler gauges, spring load checker, etc
				[redacted]											
				PROCESS	—	—	AP 04	1	1.0	.50	[illegible]419	1	1.0	.50	
060		INSP	1.0	[redacted]											[illegible] bore
				[redacted]											
				PROCESS	—	—		1	1.0	.08	[illegible]419	1	1.0	.08	
070		INSP	1.0	[redacted]											[illegible] spirit re[illegible] value
				[redacted]											
				PROCESS				1	1.0	.12	[illegible]419	1	1.0	.12	

OPERATIC PROFILE

NAME Parker ALC OC DATE 5/30/89 NCC MATPCB SHEET 3 OF 6

PCII
NSN
PIN 96523A WCD CAEY08 WCD DATE 8823 9

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
073	MAT PCB	REP	.25	TRANSIT											(Quantities of 5 -) 25% of filters are separated from ... repair. Dry ...
				SETUP											
				PROCESS	1	12.0	AP09	1	1.0	4.0	5121	1	1.0	1.0	
075	MAT PCD	CLN	.25	[redacted]											Clean ... Quantities of 10 - 20
				[redacted]											
				PROCESS	1.0	40.0	—	—	—	—	—	—	—	—	
090	MAT PCB	TEST	.25	[redacted]											Filters are done in Quant. of 10 - 20. Time of return will ...
				[redacted]											
				PROCESS	1.0	120.0	—	—	—	—	—	—	—	—	Did not pick ...
100		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	AP09	1	1.0	.25	BEN419	1	1.0	.25	
120		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.25	BEN419	1	1.0	.25	

OPERATIC PROFILE

NAME Parker ALC OC DATE 5/30/89 NCC MATPCB SHEET 4 OF 6

PCN
NSN
PIN 96523A WCD CAEY08 WCD DATE 88239

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
125	MAT PCB	REP	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	APO9	1	1.0	1.50	BEN419	1	1.0	1.5	
140		INSP	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.25	BEN419	1	1.0	.25	
150		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	BEN419	1	1.0	.08	
160		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	BEN419	1	1.0	.08	
170		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	BEN419	1	1.0	.08	

LSC-200926

OPERATIC PROFILE

NAME Parker ALC OC DATE 5/30/89 RCC MAT PCB SHEET 5 OF 6

PCN
HSH
PIN 36523A WCD CAEY08 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
180	MAT PCB	ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	APO9	1	1.0	.08	[redacted]	1	1.0	.08	
190		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.08	[redacted]	1	1.0	.08	
210		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.08	[redacted]	1	1.0	.08	
220		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.08	[redacted]	1	1.0	.08	
250	MAT PCB	TEST	1.0	[redacted]											Functional test of pump in bld. 3108. Performed by the personnel etc.). (see Opn Profile of RCN 96523)
				[redacted]											
				PROCESS	1.0	16.0	—	—	—	—	—				

OPERATIC PROFILE

NAME Parker ALC OC DATE 5/30/89 RCC MAT PCB SHEET 6 OF 6

PCN
RSH
PIN 96523A WCD CAEY08 ✓ WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
265	MAT PCB	ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS			APO1	1	1.0	.17	[redacted]	1	1.0	.17	
280		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS				1	1.0	.50	[redacted]	1	1.0	.50	
299		PW	1.0	[redacted]NT											
				[redacted]											
				PROCESS				1	1.0	.25	[redacted]	1	1.0	.25	
9999		OUT PART	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											

126

FLOW PROCESS CHART

SUBJECT MAIN FUEL PUMP DATE 5/30/89

ITEM CODE
PCN ☒
NSN ☐
P/N ☐

WCD CBEY09 WCD DATE 88239

965234

CHART BEGINS 010

CHART ENDS 299 PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC			○▷D□▽	
015	—	○▷D□▽	INSP			○▷D□▽	
020	020	○▷D□▽	DIS.			○▷D□▽	
030	030	○▷D□▽	CLN.			○▷D□▽	
040	040	○▷D□▽	INSP			○▷D□▽	
045	—	○▷D□▽	INSP			○▷D□▽	
047	—	○▷D□▽	INSP			○▷D□▽	
050	050	○▷D□▽	INSP			○▷D□▽	
060	060	○▷D□▽	INSP			○▷D□▽	
070	070	○▷D□▽	INSP			○▷D□▽	
073	—	○▷D□▽	REPAIR			○▷D□▽	
075	—	○▷D□▽	CLN			○▷D□▽	
090	090	○▷D□▽	TEST			○▷D□▽	
100	100	○▷D□▽	INSP			○▷D□▽	
120	120	○▷D□▽	INSP			○▷D□▽	
125	—	○▷D□▽	REPAIR			○▷D□▽	
140	140	○▷D□▽	INSP			○▷D□▽	
150	150	○▷D□▽	ASSY.			○▷D□▽	
160	160	○▷D□▽	ASSY			○▷D□▽	
170	170	○▷D□▽	ASSY			○▷D□▽	
180	180	○▷D□▽	ASSY			○▷D□▽	
190	190	○▷D□▽	ASSY			○▷D□▽	
210	210	○▷D□▽	ASSY			○▷D□▽	
220	220	○▷D□▽	ASSY			○▷D□▽	
250	250	○▷D□▽	TEST			○▷D□▽	
265	—	○▷D□▽	ASSY			○▷D□▽	
280	280	○▷D□▽	ASSY			○▷D□▽	
299	—	○▷D□▽	PW			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/30/89 NCC MAT PCB SHEET 1 OF 3

PCN
NSN
PIN 96523 WCD CBEY09 WCD DATE 88239

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
000		IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
010	MAT PCB	TEST	1.0	TRANSIT											
				SETUP	—	—	CP09	1	1.0	.25					
				PROCESS	—	—		1	1.0	.50	OC 0973	1	1.0	.25	
035		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	1.5	OC 0973	1	1.0	1.5	
050		DIS	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.25	OC 0973	1	1.0	.25	Filter changes, etc.
060		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	1.5	OC 0973	1	1.0	1.5	Time Dependent on problems requiring relief valve adjustments.

OPERATION PROFILE

NAME Parker ALC OC DATE 5/30/89 NCC MATPCB SHEET 2 OF 3

PCN / NSN / PN 96523 WCD CBEY09 WCD DATE 88239

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
089	MAT PCB	PROC	1.0	TRANSP											adjustments required multi-step
				SETUP											
				PROCESS	—	—	CP09	1	1.0	1.0	OC 0973	1	1.0	1.0	
110		TEST	1.0	TRANSP											
				SETUP											
				PROCESS	—	—		1	1.0	1.0	OC 0973	1	1.0	1.0	
120		INSP	1.0	TRANSP											
				SETUP											
				PROCESS	—	—		1	1.0	.17	OC 0973	1	1.0	.17	
130		ASSY	1.0	TRANSP											safety wire, plugs installed
				SETUP											
				PROCESS				1	1.0	.50	OC 0973	1	1.0	.50	
150		PROC	1.0	TRANSP											
				SETUP											
				PROCESS	—	—		1	1.0	.50	OC 0973	1	1.0	.50	

OPERATION PROFILE

NAME Parker ALC OC DATE 5/30/89 NCC MATPCB SHEET 3 OF 3

(CH) NSN PN 96523 WCD CREY09 WCD DATE 88239

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
165	MAT PCB	PW	1.0	[illegible]											includes tracking, rejection notation etc.
				SETUP											
				PROCESS	-	-	CP09	1	1.0	1.0	OC 0973	1	1.0	1.0	
9999		OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT MAIN FUEL PUMP DATE 5/30/89

ITEM CODE PCH [X] NSN. [ ] P/N [ ] WCD CBEV09 WCD DATE 88239

965-23

CHART BEGINS 010

CHART ENDS 165 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○⇨D□▽	TEST			○⇨D□▽	
035	—	○⇨D□▽	TEST			○⇨D□▽	
050	050	○⇨D□▽	DIS.			○⇨D□▽	
060	060	○⇨D□▽	TEST			○⇨D□▽	
089	—	○⇨D□▽	PROC			○⇨D□▽	
110	110	○⇨D□▽	TEST			○⇨D□▽	
120	120	○⇨D□▽	INSP			○⇨D□▽	
130	130	○⇨D□▽	ASSY			○⇨D□▽	
150	150	○⇨D□▽	PROC			○⇨D□▽	
165	—	○⇨D□▽	PW			○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	
		○⇨D□▽				○⇨D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

⇨ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PRC 'LE

NAME _____ ALC OC-ALC DATE 3/11/97 RCC MTPC B SHEET 1 OF 1

PCII/ISII/PII 965[redacted]23A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (~~DAYS~~ HRS)
1	8295	8298	72
2	8348	8348	0
3	8348 [redacted]	8349	24
4	9004 [redacted]	9004	0
5	9059	9060	24
6	9096	9097	24
			24

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

LSC-20107A

"OUT" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 96523A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS) HRS
1	8302	8302	0
2	8355	8356	24
3	[redacted] 8357	[redacted] 8357	0
4	9009	9009	0
5	9062	9065	72
6	9103	9103	0
			16

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

LSC-20108A

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31MAY89 RCC MATPCB SHEET 1 OF 7

ITEM CODE (PCN / NON) P/N 96555A WCD CBEY16 WCD DATE 98267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
000		IN	1.0	TRANSIT										
				SETUP										
				PROCESS	0									
010	MAT PCB	REC	1.0	~~TRANSIT~~										RECEIVE PART IDENTIFY AND ATTACH PAPERWORK
				~~SETUP~~										MOSTLY PUMPS ARE WORKED ON IMMEDIATELY BUT SOME O-TIMES MAY BE 36 HOURS
				PROCESS		AP09	1	100	.25	B0436	1	100	.25	WCD 010
015	CB	CLN	1.0	~~TRANSIT~~										WASH OUTSIDE OF PUMP, BLOW OUTSIDE WITH AIR
				~~SETUP~~										
				PROCESS		AP09	1	100	.25	0C1178	1	100	.25	
020	CB	DIS	1.0	~~TRANSIT~~										DISASSEMBLE PUMP, DEWIRE + BREAKDOWN, SAME PARTS GO BACK INTO SAME PUMP
				~~SETUP~~										
				PROCESS	1	AP09	1		1.0	B0436	1	100	1.0	WCD 020
030	CB	CLN	1.0	~~TRANSIT~~										DEGREASER
				~~SETUP~~										
				PROCESS		AP09	1	100	.25	0C4947	1			WCD 030

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31MAY89 RCC MATPCB SHEET 2 OF 7

ITEM CODE PCN / NSN / P/N 96555A WCD CBEY16 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER: SKILL CODE/ LEVEL	MANPOWER: QTY.	MANPOWER: TIME REQUIRED %	MANPOWER: TIME REQUIRED HRS.	EQUIPMENT: EQUIPMENT CODE	EQUIPMENT: QTY.	EQUIPMENT: TIME REQUIRED %	EQUIPMENT: TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	CB	INSP	1.0	~~TRANSIT~~						OC0229	1		2.0	NDI FLUORESCENT PENETRANT INSPECTION
				~~SETUP~~						OC6025	1		.2	
				PROCESS	20	BI09								WCD 050 + 060
052	CB	INSP	1.0	~~TRANSIT~~										VISUAL INSPECTION OF PART
				~~SETUP~~										
				PROCESS		AP09	1	100	1.5	B0436	1	100	.2	040
054	CB	INSP	1.0	~~TRANSIT~~										INSPECT DRIVE JOURNALS AND IMPELLER END (A)
				~~SETUP~~										
				PROCESS		AP09	1	100	.4	B0436	1	100	.2	040
058	CB	INSP	1.0	~~TRANSIT~~										INSPECT SEALING SURFACES (B)
				~~SETUP~~										
				PROCESS	1	AP09	1	100	.3	B0436	1	100	.3	040
062	CB	INSP	1.0	~~TRANSIT~~										INSPECT LOCK NUT AND IMPELLER LAP. (C)
				~~SETUP~~										
				PROCESS		AP09	1	100	.5	B0436	1	100	.3	040

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31 MAY 89 RCC MAT PCB SHEET 3 OF 7

ITEM CODE PCN / NSN / P/N 96555A WCD CBE116 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
064	CB	INSP	1.0	TRANSIT										INSPECT HOUSING I.D. (D)
				~~SETUP~~										
				PROCESS		AP09	1	100	.5	B04[illegible]	1	100	.5	040
066	CB	INSP	1.0	~~TRANSIT~~										INSPECT VALVE BODY I.D. (E)
				~~SETUP~~										
				PROCESS		AP09	1	100	.2	B04,6	1	100	.2	040
068	CB	INSP	1.0	~~TRANSIT~~										F, G, J BEARING INSPECTIONS
				~~SETUP~~										
				PROCESS		AP09	1	100	1.0	B04,6	1	100	1.0	040
070	CB	PROC	.9	TRANSIT		A1 09	1	100	.2	B04,6	1	100	.2	MACHINE SHOP PLATING IF NEEDED, MOVE TO FROM ONE FOR ONE STATATIME IMPELLERS + HOUSING ONLY * WORK ORDERS & TOOLS
				~~SETUP~~										
				PROCESS	32.100									WCD 070
080	CB	REP	1.0	~~TRANSIT~~										REPAIR & REPLACE PARTS AS REQUIRED
				~~SETUP~~										
				PROCESS		AP 09	1	100	.75	B04,6	1	100	.75	WCD 080

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31 MAY 89 RCC MAT PCB SHEET 4 OF 7

ITEM CODE (PCN) NSN P/N 96555A WCD CBEY116 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
090	CB	ASSY	1.0	~~TRANSIT~~										PARTIAL ASSEMBLY
				~~SETUP~~										
				PROCESS		AP09	1		1.25	B0436	1	100	1.25	WCD 090
095	CB	ASSY	1.0	~~TRANSIT~~										CHECK LINERS BEFORE INSTALLING
				~~SETUP~~										
				PROCESS		AP09	1	100	.75	B0436	1	100	.75	WCD 090
120	CB	TEST	1.0	~~TRANSIT~~										TEST FOR LEAKAGE
				SETUP		AP09	1	100	.1	B0436	1	100	.1	
				PROCESS		AP09	1	100	.2	B0436	1	100	.2	WCD 120 AND 130
140	CB	ASSY	1.0	~~TRANSIT~~										ASSEMBLE ELBOW & TORQUE BOLTS
				~~SETUP~~										
				PROCESS		AP09	1	100	.2	B0436	1	100	.2	WCD 140
150	CB	ASSY	1.0	~~TRANSIT~~										ASSEMBLE PUMP IN STAGES
				~~SETUP~~										
				PROCESS		AP09	1	100	1.75	B0436	1	100	1.75	WCD 150

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31 MAY 89 RCC MATPCB SHEET 5 OF 7

ITEM CODE PCN NSN P/N 96555A WCD CBEY16 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
155	CB	PROC	1.0	~~TRANSIT~~										BUILD BELLEVILLE SPRINGS
				~~SETUP~~										
				PROCESS		AP09	1	100	.3	B0436	1	100	.3	
160	CB	PROC	1.0	~~TRANSIT~~										ASSEMBLE BEARINGS AND ALIGN
				~~SETUP~~										
				PROCESS		AP09	1	100	.75	B0436	1	100	.5	WCD 160
165	CB	PROC	1.0	~~TRANSIT~~										MIC CLEARANCES BEARING SPACER + OUTER SLEEVE
				~~SETUP~~										
				PROCESS		AP09	1	100	.2	B0436	1	100	.2	
170	CB	PROC	1.0	~~TRANSIT~~										ASSEMBLE AND MEASURE CLEARANCES OF DRIVE SHAFT
				~~SETUP~~										
				PROCESS	1	AP09	1	100	1.0	B0436	1	100	1.0	WCD 170
174	CB	TEST	1.0	~~TRANSIT~~										DO IMPELLER RUNOUT TEST
				~~SETUP~~										
				PROCESS		AP09	1	100	1.0	B0436	1	100	1.0	

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31 MAY 89 RCC MATPCB SHEET 6 OF 7

ITEM CODE PCN NBN P/N 96555A WCD CBEY16 WCD DATE 89267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
176	CB	PROC	1.0	~~TRANSIT~~										BALANCE DRIVESHAFT
				~~SETUP~~										
				PROCESS		AP09	1	100	.4	OC 5035	1	100	.4	WCD 170
180	CB	PROC	1.0	TRANSIT										CHECK BODY BOLT
				SETUP										
				PROCESS		AP09	1	100	.4	BEN136	1	100	.4	WCD 180
190	CB	PROC	1.0	~~TRANSIT~~										CHECK [illegible] CLEARANCE
				~~SETUP~~										
				PROCESS		AP09	1	100	.4	BEN136	1	100	.4	WCD 190
200	CB	PROC	1.0	TRANSIT										TORQUE & VACUUM CHECK
				SETUP										
				PROCESS	1	AP09	1	100	1.3	BEN136	1	100	1.3	WCD 200
210	MAT PCB	TEST	1.0	TRANSIT										TEST BUILDING 3108 CBEY17
				SETUP										
				PROCESS	24									WCD 210

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 31 MAY 89 RCC MAT PCB SHEET 7 OF 7

ITEM CODE PCN NSN P/N 96555A WCD CBEY16 WCD DATE 89267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
215	MAT PCB	PROC	1.0	~~TRANSIT~~										CHECK POPPET VALVE TORQUE, RETORQUE AND LOCKWIRE
				~~SETUP~~										
				PROCESS		AP09	1	100	.2	BEN456	1	100	.2	WCD 215
220	CB	PAPERWORK	1.0	~~TRANSIT~~										COMPLETE PAPERWORK
				~~SETUP~~										
				PROCESS		AP09	1	100	.3	BEN436	1	100	.3	WCD 220+230
9999		OUT	1.0	TRANSIT										
				SETUP										
				PROCESS	0									
				TRANSIT										
				SETUP										
				PROCESS	1									
				TRANSIT										
				SETUP										
				PROCESS										

FLOW PROCESS CHART

SUBJECT A/B FUEL PUMP DATE 31MAY89

ITEM CODE
PCN ☒
NSN ☐
P/N ☐

WCD CBGY16 WCD DATE 88267

965554

CHART BEGINS 0000 (IN)

CHART ENDS 9999 (OUT) PREPARED BY KOB/LK

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
0000	—	○◆D□▽	IN	220	220	●◇D□▽	PAINT MARK
010	010	●◇D□▽	RETRIEVE IDENTIFY PUMP	—	230	●◇D□▽	PAINT MARK
015	—	●◇D□▽	CLEAN OUTSIDE OF PUMP	9999	OUT	○◆D□▽	
020	020	●◇D□▽	DISASSEMBLE			○◇D□▽	
030	030	●◇D□▽	DEGREASE PUMP			○◇D□▽	
050	050	○◇D■▽	FLUORESCENT PENETRANT			○◇D□▽	
—	060	○◇D■▽	MAGNETIC			○◇D□▽	
052	040	○◇D■▽	VISUAL INSP			○◇D□▽	
054	040	○◇D■▽	INSPECT DRIVE JOURNALS			○◇D□▽	
058	040	○◇D■▽	SEALING SURFACE			○◇D□▽	
062	040	○◇D■▽	LOCKNUT & IMPELLER			○◇D□▽	
064	040	○◇D■▽	HOUSING I.D.			○◇D□▽	
066	040	○◇D■▽	VALVE BODY I.D.			○◇D□▽	
068	040	○◇D■▽	BEARINGS			○◇D□▽	
070	070	●◇D□▽	MACHINE SHOP & PLATING			○◇D□▽	
080	080	●◇D□▽	REPAIR			○◇D□▽	
090	090	●◇D□▽	ASSEMBLY			○◇D□▽	
095	090	●◇D□▽	INSPECT INSTALL LINING			○◇D□▽	
120	120	●◇D□▽	TEST SETUP			○◇D□▽	
—	130	●◇D□▽	TEST			○◇D□▽	
140	140	●◇D□▽	ASSEMBLY ELBOW			○◇D□▽	
150	150	●◇D□▽	ASSEMBLY			○◇D□▽	
155	—	●◇D□▽	BUILD SPRINGS			○◇D□▽	
160	160	●◇D□▽	ASSEMBLY BEARINGS			○◇D□▽	
170	170	●◇D□▽	ASSEMBLY DRIVESHAFT			○◇D□▽	
174	—	●◇D□▽	IMPELLER RUNOUT TEST			○◇D□▽	
176	170	●◇D□▽	DRIVESHAFT RUNOUT			○◇D□▽	
180	180	●◇D□▽	CHECK BODY BORE			○◇D□▽	
190	190	●◇D□▽	IMPELLER CLEARANCE			○◇D□▽	
200	200	●◇D□▽	TORQUE VACUUM CHECK			○◇D□▽	
210	210	●◇D□▽	GO TO TEST CELL 17			○◇D□▽	
215	215	●◇D□▽	POPPET VALVE			○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

DISASSEMBLY/ASSEMBLY PROFILE

NAME KOBYLK ALC OC-ALC DATE 31MAY89 RCC MATCB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
024536-214-10	CBEY16	88267	020	150	PCN (1) NSN 02-14999-01 P/N			N
					PCN NSN 02-1258-01 P/N			N
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			
					PCN NSN P/N			

LSC-2000SA

SECTION II

GROUP ASSEMBLY PARTS LIST

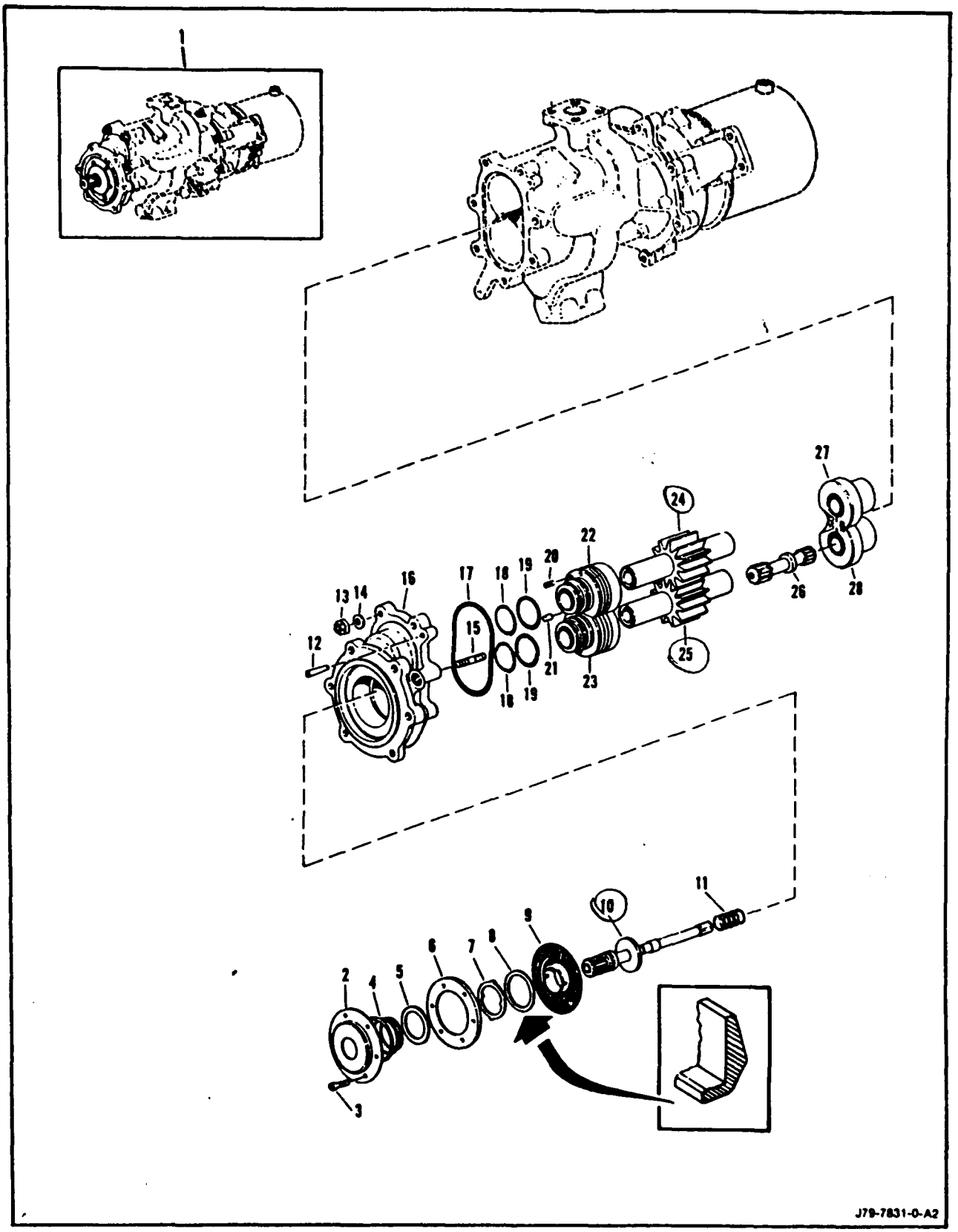


Figure 1. Exploded View of Fuel Pump Assembly (Sheet 1 of 3)

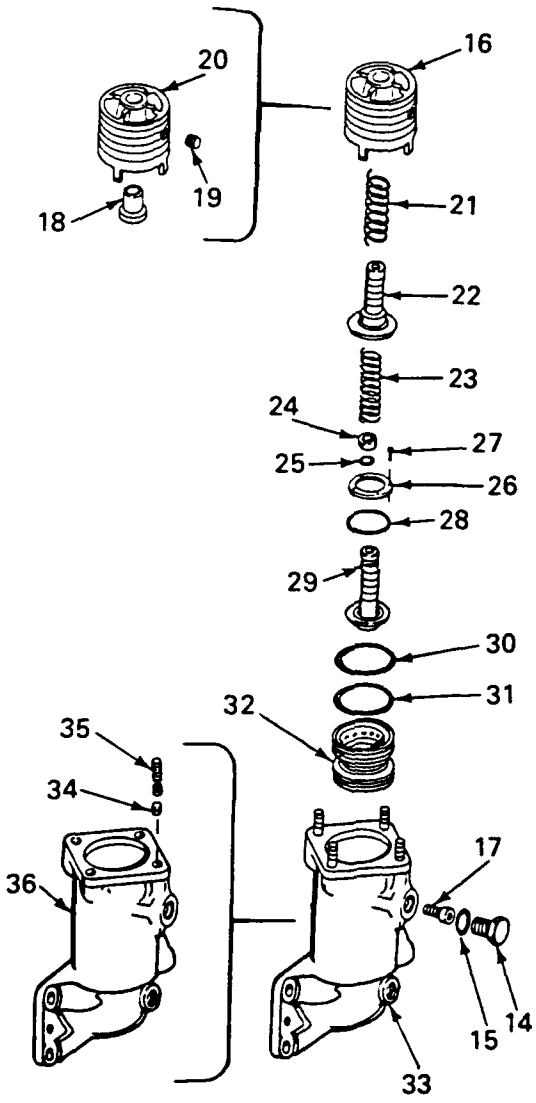


Figure 1. Centrifugal Pump Assembly (Sheet 2 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/1-						
	024536-209-09	99167	PUMP ASSEMBLY, Centrifugal . (Repair Kit Available)	REF	A	PAOLD
	025264-200-02	99167	PUMP ASSEMBLY, Centrifugal .	REF	B	PAOLD
	024536-213-09	99167	PUMP ASSEMBLY, Centrifugal .	REF	C	PAOLD
	024536-214-10	99167	PUMP ASSEMBLY, Centrifugal .	REF	D	PAOLD
-1	02-14887	99167	. FILTER, Oil	1		PAOZZ
-2	99-2975-8	99167	. PACKING, Preformed	1		PAOZZ
-3	102-1381	99167	. VALVE ASSEMBLY, Poppet . . (see figure 2)	1	A	PAOZZ
	102-1381-01	99167	. VALVE ASSEMBLY, Poppet . . (see figure 2)	1	BCD	PAOZZ
-4	99-2975-5	99167	. PACKING, Preformed	1	A	PADZZ
	99-4602-05	99167	. PACKING, Preformed	1	BCD	PADZZ
-5	102-1478	99167	. FILTER ASSEMBLY (see . . . figure 3)	1	B	PADZZ
-6	99-4602-05	99167	. PACKING, Preformed	1	B	PAOZZ
-7	02-14731	99167	. TUBE, Turbine inlet	1		PADZZ
-8	99-4346-112	99167	. PACKING, Preformed	2	A	PADZZ
	99-4601-112	99167	. PACKING, Preformed	2	BCD	PADZZ
-9	99-4498	99167	. RETAINER	2		PADZZ
-10	99-4195-06	99167	. SCREW, Cap (AP)	4		PADZZ
-11	99-4344	99167	. WASHER (AP)	4		PADZZ
-12	99-4346-221	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-221	99167	. PACKING, Preformed	1	BCD	PADZZ
-13	99-4345	99167	. CAP SEAL	1		PADZZ

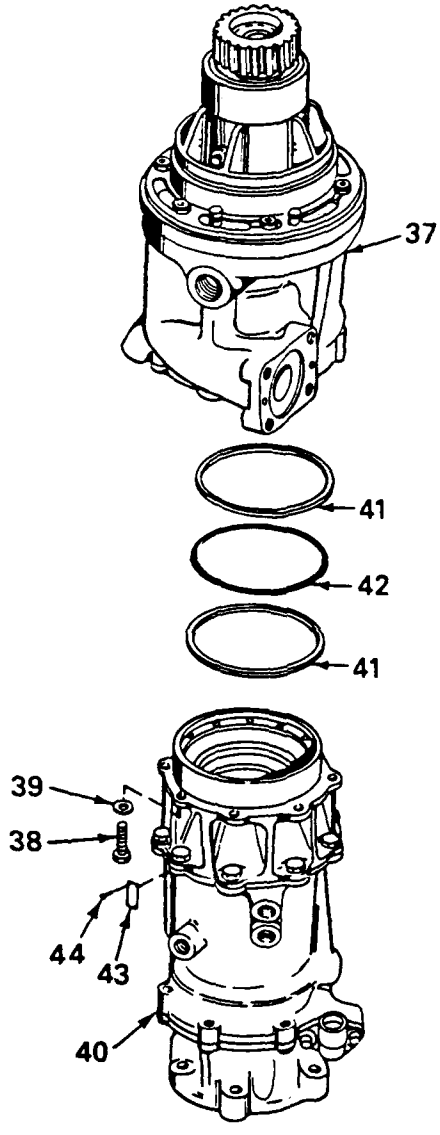


Figure 1. Centrifugal Pump Assembly (Sheet 3 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/2-						
-14	AN814-4L	88044	. PLUG	1		PADZZ
-15	99-2975-4	99167	. PACKING, Preformed	1	A	PAOZZ
	99-4602-04	99167	. PACKING, Preformed	1	BCD	PAOZZ
-16	102-1231-01	99167	. GUIDE SUBASSEMBLY, Flow . .	1		PADZZ
-17	99-4196-02	99167	. SCREW, Socket head (AP) . .	1		PADZZ
-18	02-14781	99167	. . GUIDE, Valve	1		PADZZ
-19	MS21209F4-15	96906	. . INSERT	1		PADZZ
-20	02-14801-01	99167	. . GUIDE, Flow	1		PADZZ
-21	99-4303	99167	. SPRING, High pressure check valve	1		PADZZ
-22	02-14875-02	99167	. VALVE, High pressure check	1		PADZZ
-23	99-4304	99167	. SPRING, Low pressure check valve	1		PADZZ
-24	99-4302	99167	. RING, Glyd	1		PADZZ
-25	99-2973-6	99167	. PACKING, Preformed	1		PADZZ
-26	02-15301	99167	. RETAINER, Packing	1	ACD	PADZZ
	02-15301-01	99167	. RETAINER, Packing	1	B	PADZZ
-27	99-4581	99167	. SCREW, Flat head (AP) . . .	6		PADZZ
-28	99-4580	99167	. PACKING, Preformed	1		PADZZ
-29	02-15302	99167	. VALVE, Low pressure check .	1		PADZZ
-30	99-2973-127	99167	. PACKING, Preformed	1		PADZZ
-31	99-2973-127	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-127	99167	. PACKING, Preformed	1	BCD	PADZZ
-32	02-15397	99167	. SEAT, Check valve	1		PADZZ
-33	102-1235-02	99167	. VALVE HOUSING SUBASSEMBLY, Check	1		PADZZ
-34	KR5A-15	99057	. . RING, Key	4		PADZZ
-35	99-4186	99167	. . STUD	4		PADZZ
-36	02-14808-02	99167	. . HOUSING, Valve	1		PADLD

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/3-						
-37	No Number	99167	. PUMP UNIT ASSEMBLY . . .	1		PADBZ
-38	99-4190	99167	. BOLT (AP)	8		PADZZ
-39	AN960-516L	88044	. WASHER (AP)	8		PADZZ
-40	102-1302-02	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	A	PADZZ
	102-1561-03	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	B	PADZZ
	102-1302-05	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	C	PADZZ
	102-1302-06	99167	. INLET VALVE & INDUCER . . . SUBASSEMBLY (see figure 4)	1	D	PADZZ
-41	99-4496	99167	. RETAINER, Packing	2		PADZZ
-42	99-4346-241	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-241	99167	. PACKING, Preformed	1	BCD	PADZZ
-43	99-5000-03	99167	. PLATE, Identification . . .	1		PADZZ
-44	AN535-00-2	88044	. SCREW (AP)	4		PADZZ

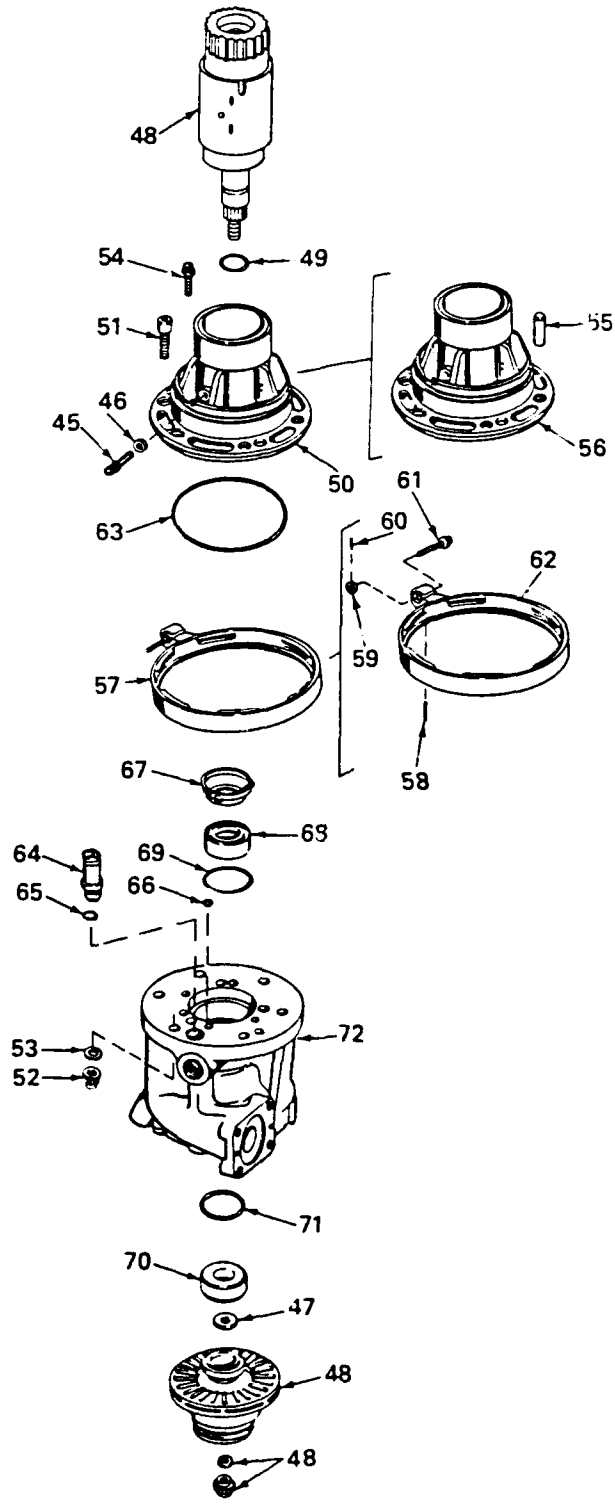


Figure 1. Centrifugal Pump Assembly (Sheet 4 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
1/4-						
-45	99-4188	99167	. BOLT	3		PADZZ
-46	MS20002C4	96906	. WASHER	1		PADZZ
-47	02-12869-07	99167	. SHIM (0.001 inch thick) . .	AR	ACD	PADZZ
	02-12869-06	99167	. SHIM (0.016 inch thick) . .	AR	ACD	PADZZ
	02-12869-05	99167	. SHIM (0.014 inch thick) . .	AR	ACD	PADZZ
	02-12869-04	99167	. SHIM (0.012 inch thick) . .	AR	ACD	PADZZ
	02-12869-03	99167	. SHIM (0.010 inch thick) . .	AR	ACD	PADZZ
	02-12869-02	99167	. SHIM (0.005 inch thick) . .	AR	ACD	PADZZ
	02-12869-01	99167	. SHIM (0.003 inch thick) . .	AR	ACD	PADZZ
	02-15827-01	99167	. SHIM (0.001 inch thick) . .	AR	B	PADZZ
	02-15827-02	99167	. SHIM (0.003 inch thick) . .	AR	B	PADZZ
	02-15827-03	99167	. SHIM (0.005 inch thick) . .	AR	B	PADZZ
	02-15827-04	99167	. SHIM (0.010 inch thick) . .	AR	B	PADZZ
	02-15827-05	99167	. SHIM (0.012 inch thick) . .	AR	B	PADZZ
	02-15827-06	99167	. SHIM (0.014 inch thick) . .	AR	B	PADZZ
	02-15827-07	99167	. SHIM (0.016 inch thick) . .	AR	B	PADZZ
-48	102-1347-04	99167	. SHAFT ASSEMBLY, Balancing . (see figure 5)	1	ACD	PADZZ
	102-1522-01	99167	. SHAFT ASSEMBLY, Balancing . (see figure 5)	1	B	PADZZ
-49	99-2973-19	99167	. RING, Seal	1		PADZZ
-50	102-1142	99167	. HOUSING SUBASSEMBLY, . . . Bearing	1		PAFDD
-51	99-4368	99167	. SCREW (AP)	6		PADZZ
-52	LH3830-064	72962	. NUT (99-4198) (AP)	6		PADZZ
-53	AN960-616L	88044	. WASHER (AP)	6		PADZZ
-54	99-4194-10	99167	. BOLT (AP)	3		PADZZ
-55	99-4247	99167	. . PIN, Dowel	1		PADZZ
-56	02-14518	99167	. . HOUSING, Bearing	1		PADBZ
-57	504245	77445	. NUT, Gearbox, quick . . . . disconnect	1	A	PADZZ
	02-16113	77445	. NUT, Gearbox, quick . . . . disconnect (702805)	1	BCD	PADZZ
-58	AN150237	88044	. . PIN	2		PAFZZ
-59	504243	77445	. . COLLAR	1		PAFZZ
-60	AN150212	88044	. . PIN	1		PAFZZ
-61	702086	77445	. . BOLT	1		PAFZZ
-62	No Number	77445	. . NUT, Gearbox quick . . . disconnect	1		XA
-63	99-2973-241	99167	. RING, Seal	1		PADZZ
-64	02-14533	99167	. SLEEVE, Oil lube	1		PADZZ
-65	99-2973-13	99167	. RING, Seal	1		PADZZ
-66	99-2973-10	99167	. RING, Seal	1		PADZZ
-67	02-14859	99167	. RETAINER	1		PADZZ
-68	02-14696	99167	. SEAL, Shaft, oil	1		PADZZ
-69	99-2973-130	99167	. RING, Seal	1		PADZZ
-70	02-14892-01	99167	. SEAL, Shaft, fuel	1		PADZZ
-71	99-4448	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-501	99167	. PACKING, Preformed	1	BCD	PADZZ
-72	102-1274-02	99167	. HOUSING SUBASSEMBLY, Pump . (see figure 6)	1		PADBZ

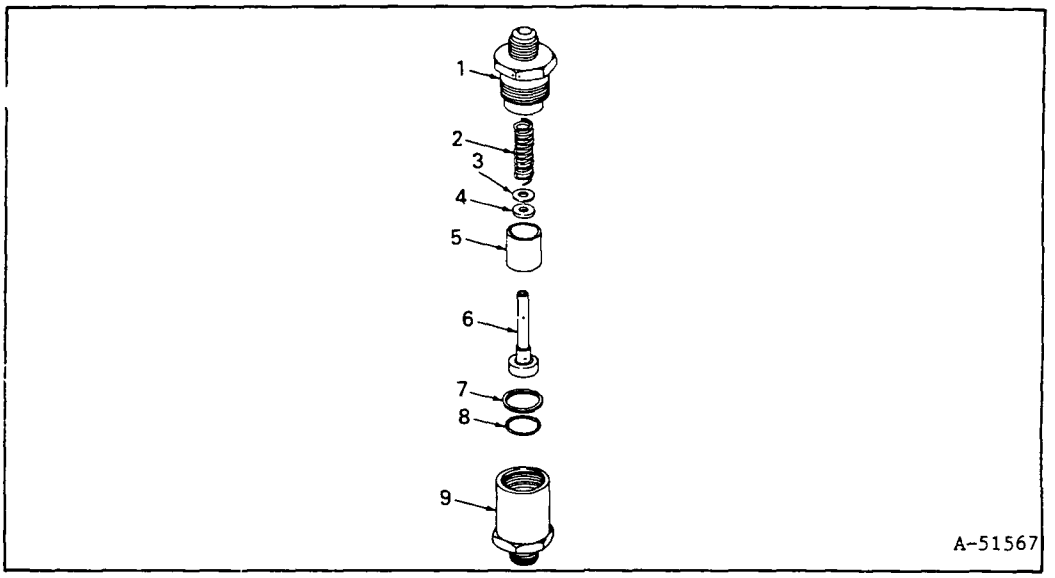


Figure 2. Poppet Valve Assembly

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
-						
	102-1381	99167	VALVE ASSEMBLY, Poppet (see index 3, figure 1)	REF	A	PAOZZ
	102-1381-01	99167	VALVE ASSEMBLY, Poppet (see index 3, figure 1)	REF	BCD	PAOZZ
-1	02-15245	99167	. CAP, Valve	1		PAOZZ
-2	99-4531	99167	. SPRING	1		PAOZZ
-3	02-15246-04	99167	. SPACER (0.005 in. thick) .	AR		PAOZZ
	02-15246-03	99167	. SPACER (0.010 in. thick) .	AR		PAOZZ
	02-15246-02	99167	. SPACER (0.015 in. thick) .	AR		PAOZZ
-4	02-15246-01	99167	. SPACER (0.050 in. thick) .	1		PAOZZ
-5	102-1380	99167	. POPPET ASSEMBLY	1		PAOZZ
-6	02-15243	99167	. SEAT, Valve	1		PAOZZ
-7	99-4533	99167	. RETAINER	1		PAOZZ
-8	99-4346-16	99167	. PACKING, Preformed	1	A	PAOZZ
	99-4601-016	99167	. PACKING, Preformed	1	BCD	PAOZZ
-9	02-15242	99167	. HOUSING, Valve	1		PAOZZ

Usable on Code

A	024536-209-09
B	025264-200-02
C	024536-213-09
D	024536-214-10

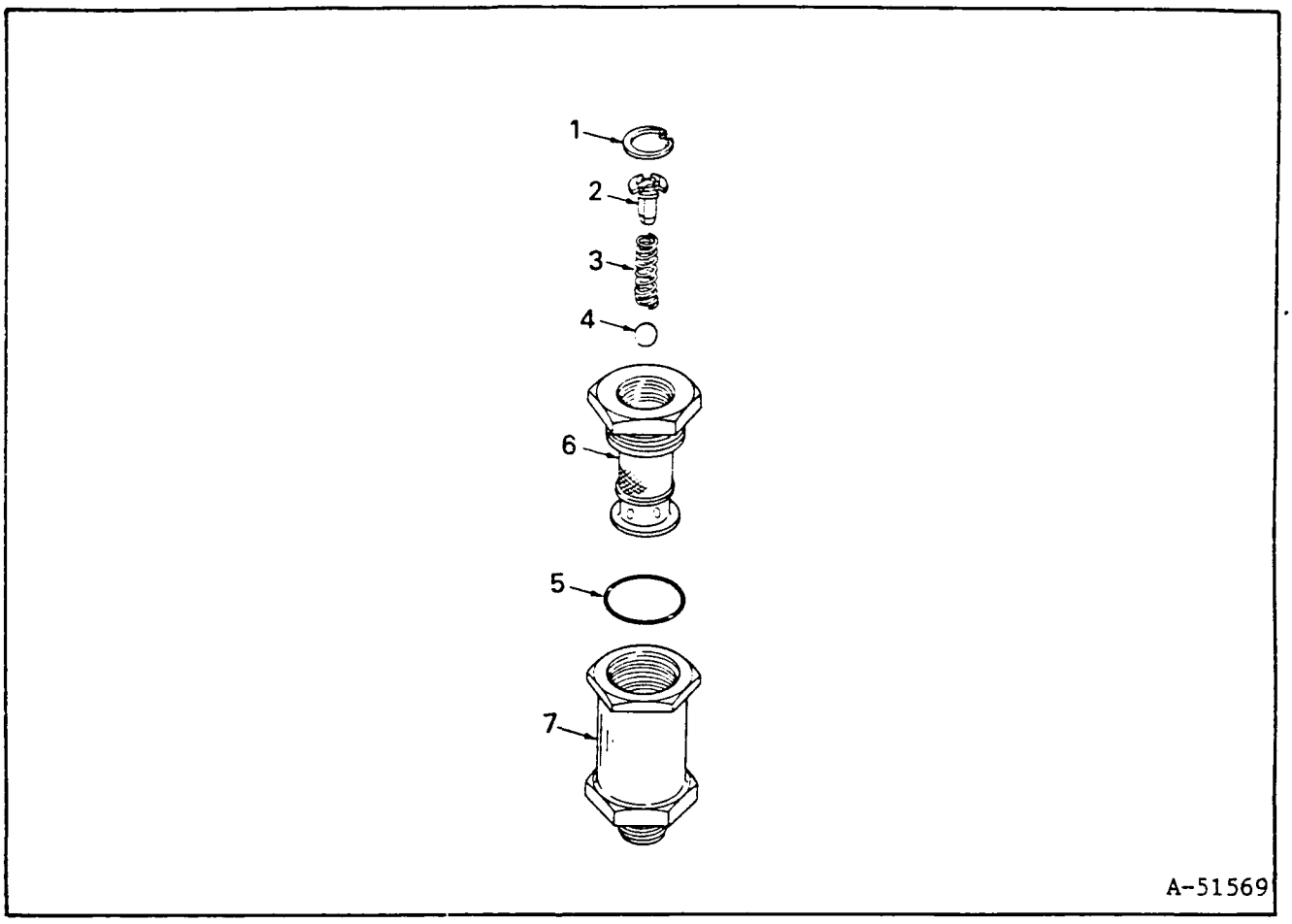


Figure 3. Filter Assembly

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
3-						
	102-1478	99167	FILTER ASSEMBLY (see index 5, figure 1)	REF	B	PAOZZ
-1	102-1482	99167	. FILTER	1	B	PAOZZ
-2	99-4601-017	99167	. PACKING, Preformed	1	B	PAOZZ
-3	MS16625-4045	96906	. RING, Retaining	1	B	PAOZZ
-4	02-15584	99167	. RETAINER, Spring	1	B	PAOZZ
-5	99-4777	99167	. SPRING, Filter bypass . . .	1	B	PAOZZ
-6	MS134356	96906	. BALL	1	B	PAOZZ
-7	02-15582	99167	. HOUSING, Filter	1	B	PAOZZ
			Usable On Code A 024536-209-09 B 025264-200-02 C 024536-213-09 D 024536-214-10			

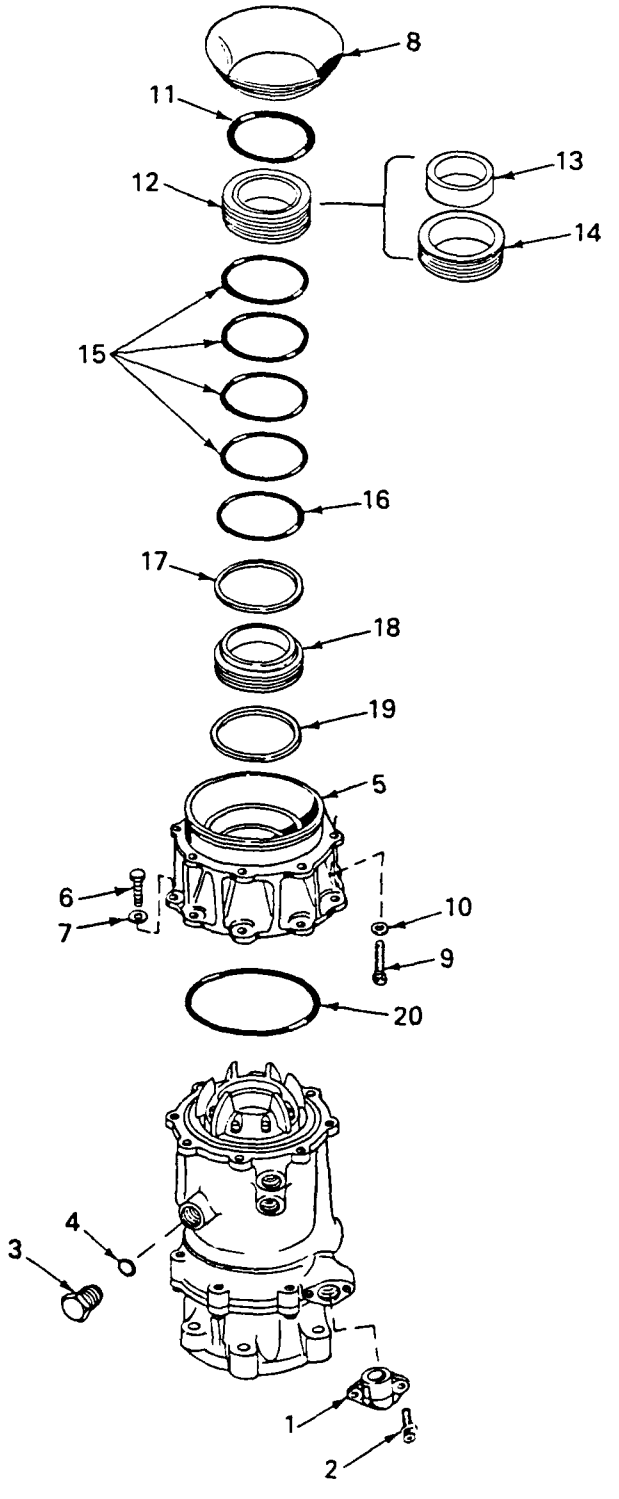


Figure 4. Inlet Valve and Inducer Subassembly (Sheet 1 of 3)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
4/1-						
	102-1302-02	99167	INLET VALVE & INDUCER . . . . SUBASSEMBLY (see index 40, figure 1)	REF	A	PADLD
	102-1561-03	99167	INLET VALVE & INDUCER . . . . SUBASSEMBLY (see index 40, figure 1)	REF	B	PADLD
	102-1302-05	99167	INLET VALVE & INDUCER . . . . SUBASSEMBLY (see index 40, figure 1)	REF	C	PADLD
	102-1302-06	99167	INLET VALVE & INDUCER . . . . SUBASSEMBLY (see index 40, figure 1)	REF	D	PADLD
-1	02-14723-02	99167	. ELBOW, Turbine inlet . . .	1		PADZZ
-2	99-4203-06	99167	. BOLT, Twelve point . . . . head (AP)	2		PADZZ
-3	AN814-4L	88044	. PLUG	1		PADZZ
-4	99-2975-4	99167	. RING, Seal	1	A	PADZZ
	99-4602-04	99167	. PACKING, Preformed	1	BCD	PADZZ
-5	02-14999	99167	. COVER, Impeller	1	AC	PADLD
	02-14999-01	99167	. COVER, Impeller	1	BD	PADLD
-6	99-4191	99167	. BOLT (AP)	8		PADZZ
-7	AN960-416	88044	. WASHER (AP)	8		PADZZ
-8	02-15000-01	99167	. LINER, Impeller cover . . .	1		PADZZ
-9	99-4394-07	99167	. SCREW (AP)	8		PADZZ
-10	NAS620-8	80205	. WASHER (AP)	8		PADZZ
-11	99-4346-234	99167	. PACKING, Preformed		A	PADZZ
	99-4601-234	99167	. PACKING, Preformed		BCD	PADZZ
-12	102-1288-01	99167	. RING SUBASSEMBLY, Wear . .	1		PADZZ
-13	02-14852	99167	. . RING, Wear	1		PADZZ
-14	02-14964	99167	. . RETAINER, Wear ring . . .	1		PADZZ
-15	99-2973-38	99167	. RING, Seal	4		PADZZ
-16	99-2973-142	99167	. RING, Seal	1	A	PADZZ
	99-4601-142	99167	. PACKING, Preformed	1	BCD	PADZZ
-17	99-4630	99167	. RETAINER, Packing backup .	1	BD	PADZZ
-18	02-14855	99167	. SEAT, Valve inlet	1	AC	PADZZ
	02-15825	99167	. SEAT, Valve inlet	1	B	PADZZ
	02-15383	99167	. SEAT, Valve inlet	1	D	PADZZ
-19	02-15001-01	99167	. SHIM (0.002 inch thick) . .	AR		PADZZ
	02-15001-02	99167	. SHIM (0.005 inch thick) . .	AR		PADZZ
	02-15001-03	99167	. SHIM (0.010 inch thick) . .	AR		PADZZ
-20	99-4346-240	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-240	99167	. PACKING, Preformed	1	BCD	PADZZ

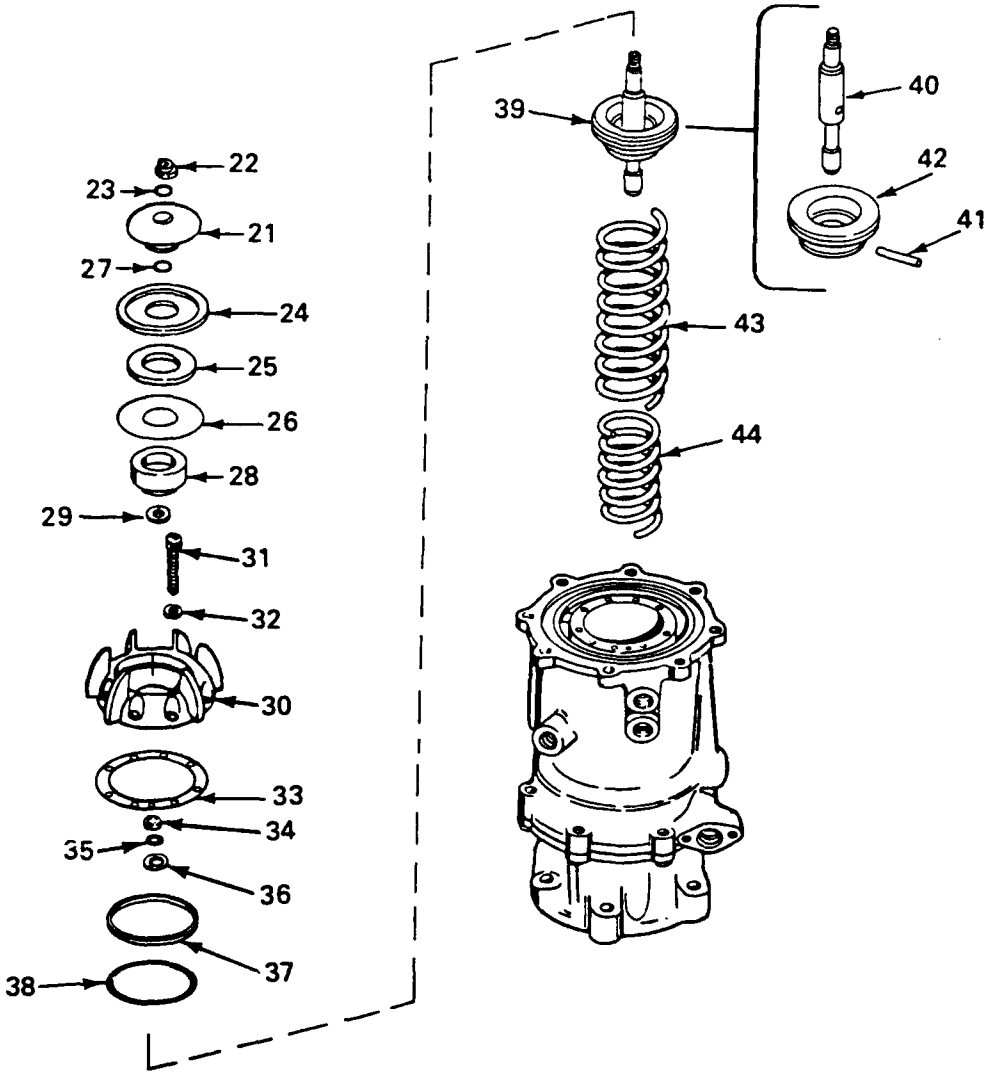


Figure 4. Inlet Valve and Inducer Subassembly (Sheet 2 of 3)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
4/2-						
-21	02-14182-01	99167	. RETAINER, Seal	1		PADZZ
-22	MS20365 -1032C	96906	. NUT (AP)	1		PADZZ
-23	AN960C10	88044	. WASHER (AP)	1		PADZZ
-24	02-14183	99167	. DIAPHRAGM	1		PADZZ
-25	02-14184	99167	. WASHER	1		PADZZ
-26	02-14914	99167	. SPRING, Diaphragm	1		PADZZ
-27	99-2973-9	99167	. RING, Seal	1	A	PADZZ
	99-4601-009	99167	. PACKING, Preformed	1	BCD	PADZZ
-28	02-13704	99167	. RETAINER	1		PADZZ
-29	02-12793-01	99167	. SPACER (0.024 to 0.025 inch thick) . .	AR		PADZZ
	02-12793-02	99167	. SPACER (0.029 to 0.030 inch thick) . .	AR		PADZZ
	02-12793-03	99167	. SPACER (0.034 to 0.035 inch thick) . .	AR		PADZZ
	02-12793-04	99167	. SPACER (0.039 to 0.040 inch thick) . .	AR		PADZZ
	02-12793-05	99167	. SPACER (0.044 to 0.045 inch thick) . .	AR		PADZZ
-30	02-14745-01	99167	. HEAD, Piston	1		PADZZ
-31	99-4193-04	99167	. SCREW, Socket Head (AP) . .	9		PADZZ
-32	NAS620-8	80205	. WASHER (AP)	9		PADZZ
-33	02-12826	99167	. GASKET, Piston head	1		PADZZ
-34	99-4352	99167	. SEAL, Channel	1		PADZZ
-35	99-4351	99167	. RING, Seal	1	A	PADZZ
	99-4601-110	99167	. PACKING, Preformed	1	BCD	PADZZ
-36	02-13070	99167	. PLUG	1		PADZZ
-37	99-4288	99167	. RING, Glyd	1		PADZZ
-38	99-4287	99167	. RING, Seal	1	A	PADZZ
	99-4601-500	99167	. PACKING, Preformed	1	BCD	PADZZ
-39	102-1213	99167	. ROD SUBASSEMBLY, Piston . .	1		PADZZ
-40	02-14762	99167	. . PISTON, Inlet valve . . .	1		PADZZ
-41	MS16555-631	96906	. . PIN	1		PADZZ
-42	02-14761	99167	. . ROD, Piston	1		PADZZ
-43	99-4319	99167	. SPRING, Inlet valve	1		PADZZ
-44	99-4318	99167	. SPRING, Inlet valve	1		PADZZ

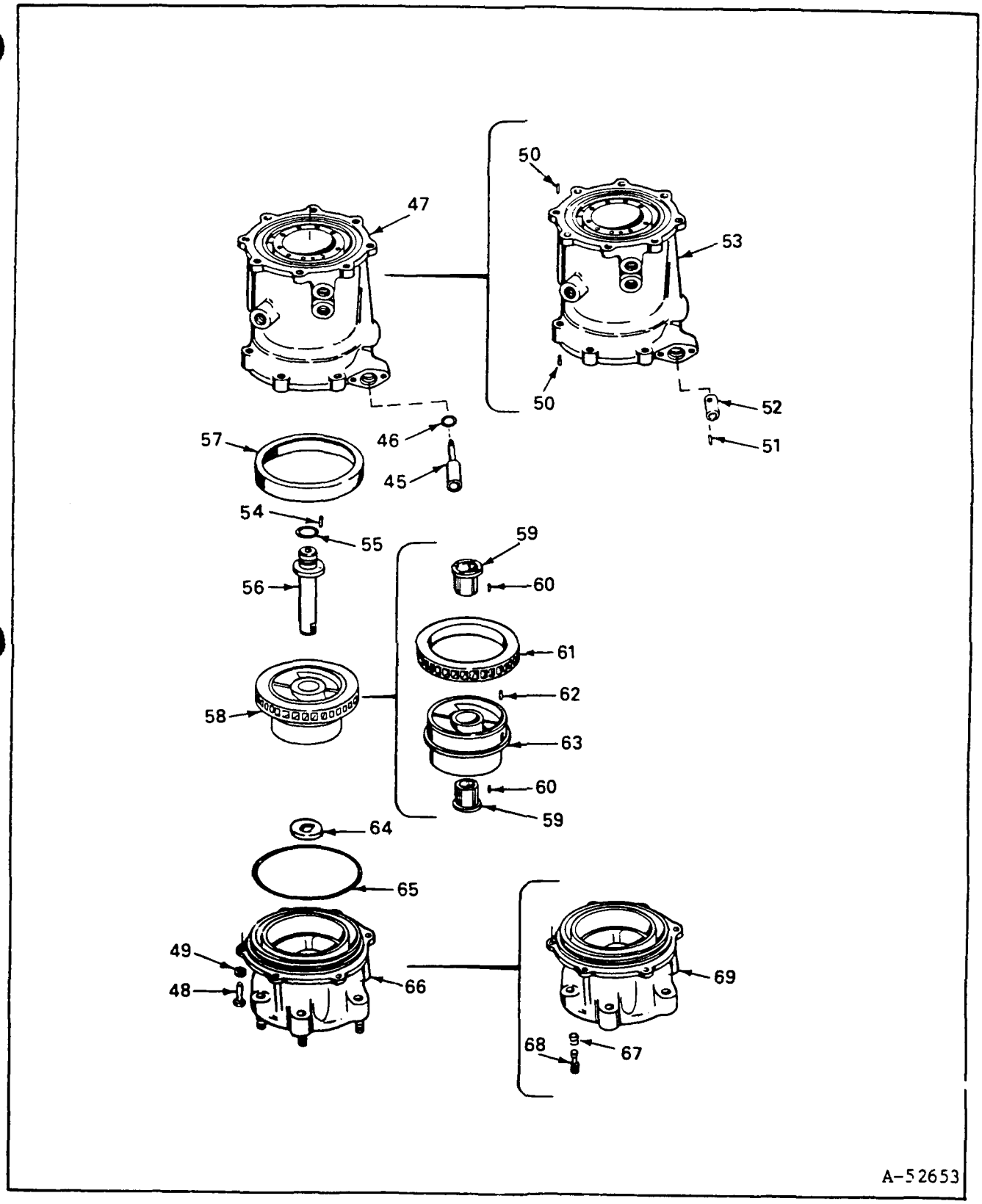


Figure 4. Inlet Valve and Inducer Subassembly (Sheet 3 of 3)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
4/3-						
-45	02-14794-01	99167	. NOZZLE, Turbine inlet . . .	1	ACD	PADZZ
	02-15824	99167	. NOZZLE, Turbine inlet . . .	1	B	PADZZ
-46	99-4346-16	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-016	99167	. PACKING, Preformed	1	BCD	PADZZ
-47	102-1352	99167	. HOUSING SUBASSEMBLY, . . . Inlet valve	1		PADBZ
-48	99-4191	99167	. BOLT (AP)	6		PADZZ
-49	AN960-416	88044	. WASHER (AP)	6		PADZZ
-50	MS16556-825	96906	. . PIN	2		PADZZ
-51	MS171432	96906	. . PIN, Spring	1		PADZZ
-52	02-15010-01	99167	. . INSERT	1		PADZZ
-53	02-14795-02	99167	. . HOUSING	1		PADBZ
-54	MS9105-30	96906	. PIN	1		PADZZ
-55	99-2973-12	99167	. RING, Seal	1	A	PADZZ
	99-4601-012	99167	. PACKING, Preformed	1	BCD	PADZZ
-56	02-14912	99167	. SHAFT, Inducer	1	ACD	PADZZ
	02-15826-01	99167	. SHAFT, Inducer	1	B	PADZZ
-57	02-14881	99167	. LINER, Inlet valve . . . . housing	1		PADZZ
-58	102-1224	99167	. INDUCER SUBASSEMBLY, . . . Turbine	1	ACD	PADZZ
	102-1562-02	99167	. INDUCER SUBASSEMBLY, . . . Turbine	1	B	PADZZ
-59	02-14566	99167	. . BEARING, Inducer	2		PADZZ
-60	99-2350	99167	. . PIN	2		PADZZ
-61	02-14850	99167	. . WHEEL, Turbine	1		PADZZ
-62	MS9105-27	96906	. . PIN	1		PADZZ
-63	02-14785	99167	. . INDUCER, Shrouded	1	ACD	PADZZ
	02-15830-01	99167	. . INDUCER, Shrouded	1	B	PADZZ
-64	02-14211	99167	. WASHER, Thrust	1		PADZZ
-65	99-4346-240	99167	. PACKING, Preformed	1	A	PADZZ
	99-4601-240	99167	. PACKING, Preformed	1	BCD	PADZZ
-66	102-1207-01	99167	. HOUSING SUBASSEMBLY, . . . Inducer	1	ACD	PADBZ
	102-1559-02	99167	. HOUSING SUBASSEMBLY, . . . Inducer	1	B	PADBZ
-67	KR6A-15	99057	. . RING, Key (99-4000-6) . .	6		PADZZ
-68	99-3371	99167	. . STUD	6		PADZZ
-69	02-14534-02	99167	. . HOUSING, Inducer	1	ACD	PADBZ
	02-15823-02	99167	. . HOUSING, Inducer	1	B	PADBZ

Usable On Code

A	024536-209-09
B	025264-200-02
C	024536-213-09
D	024536-214-10

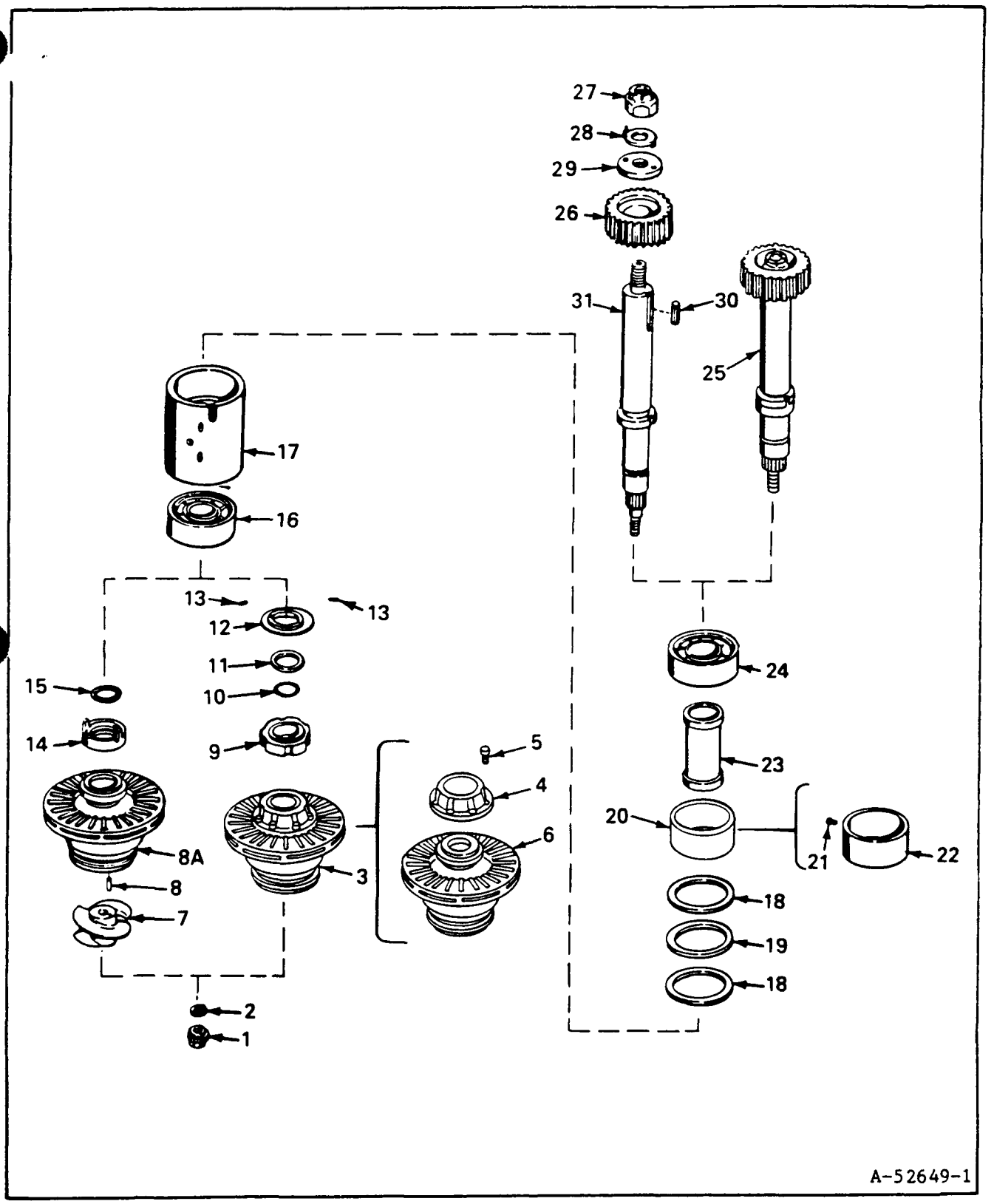


Figure 5. Balancing Shaft Assembly

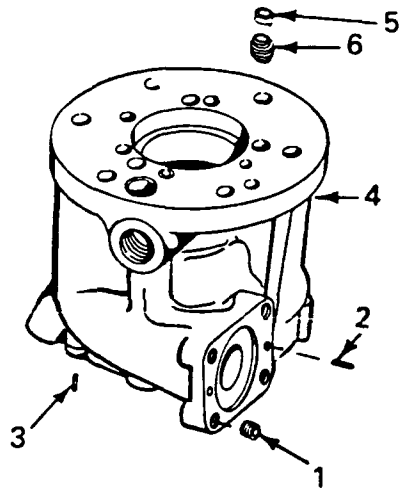
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
5-						
	102-1347-04	99167	SHAFT ASSEMBLY, Balancing . . (see index 48, figure 1)	REF	ACD	PADZZ
	102-1522-01	99167	SHAFT ASSEMBLY, Balancing . .	REF	B	PADZZ
-1	119FW428	56878	. LOCKNUT (99-4197-02) . . .	1		PADZZ
-2	NAS620-416L	80205	. WASHER	1	ACD	PADZZ
	NAS620-416	80205	. WASHER	1	B	PADZZ
-3	102-1258-01	99167	. IMPELLER ASSEMBLY . . . . . (Note 1)	1	ACD	PADDD
-4	02-15279	99167	. . SHROUD (Note 1)	NP	ACD	
-5	99-4567-04	99167	. . SCREW (Note 1)	NP	ACD	
-6	02-15280	99167	. . IMPELLER SUBASSEMBLY . . (Note 1)	NP	ACD	
-7	02-15828	99167	. INDUCER	1	B	PADZZ
	102-1560	99167	. IMPELLER ASSEMBLY	1	B	PADDD
-8	MS16555-602	96906	. . PIN, STRAIGHT, HEADLESS .	1	B	PADZZ
-8A	02-15829	99167	. . IMPELLER	1	B	PADZZ
-9	02-14711-01	99167	. LOCKNUT	1	ACD	PADZZ
-10	99-2973-20	99167	. RING, Seal	1	ACD	PADZZ
-11	MS28774-020	96906	. RETAINER, Backup	1	ACD	PADZZ
-12	02-14712-01	99167	. LOCKWASHER	1	ACD	PADZZ
-13	MS16555-602	96906	. PIN, Straight, headless . .	2	ACD	PADZZ
-14	02-15289-01	99167	. RING, Rotating seal	1	B	PADZZ
-15	99-2973-21	99167	. RING, Seal	1	B	PADZZ
-16	VJ305AS7DA	43334	. BEARING, Ball (99-4019) . .	1		PADZZ
	M305JX2014	70854	. BEARING, Ball (99-4019) . .	1		PADZZ
-17	02-14530-01	99167	. SLEEVE, Outer	1		PADZZ
-18	99-3999	99167	. SPRING, Belleville	2		PADZZ
-19	02-14125	99167	. RING	1		PADZZ
-20	102-1149	99167	. SPACER SUBASSEMBLY	1		
-21	99-3987	99167	. . PIN	1		PADZZ
-22	02-14528	99167	. . SPACER	1		PADZZ
-23	02-14724-01	99167	. SPACER, Bearing	1		PADZZ
-24	VJ305AS7DA	43334	. BEARING, Ball (99-4019) . .	1		PADZZ
	M305JX2014	70854	. BEARING, Ball (99-4019) . .	1		PADZZ
-25	02-14709-03	99167	. SHAFT, Drive	1	ACD	PADZZ
-26	02-15293	99167	. GEAR, Spur	1	B	PADZZ
-27	MS21046C8	96906	. NUT, Self-locking (AP) . .	1	B	PADZZ
-28	MS9276-14	96906	. WASHER, Key (AP)	1	B	PADZZ
-29	02-15292-01	99167	. WASHER (AP)	1	B	PADZZ
-30	02-15294	99167	. KEY, Machine	1	B	PADZZ
-31	02-15288-01	99167	. SHAFT, Shouldered	1	B	PADZZ

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR

Note 1: Two configurations of the impeller exist under the same part number 102-1258-01. The original configuration consists of impeller subassembly 02-15280, shroud 02-15279, and six screws 99-4567-04. The second configuration is a one-piece casting deleting all of the piece parts. Both configurations are usable and interchangeable, but the original configuration is no longer procurable.

Usable On Code

A	024536-209-09
B	025264-200-02
C	024536-213-09
D	024536-214-10



A-52632

Figure 6. Pump Housing Subassembly

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7 Description	Units Per Assy.	Usable on Code	SMR
6-						
	102-1274-02	99167	HOUSING SUBASSEMBLY, Pump . . (see index 72, figure 1)	REF		PADBZ
-1	MS21208C5-15	96906	. INSERT	4		PADZZ
-2	MS16566-825	96906	. PIN	1		PADZZ
-3	MS16556-840	96906	. PIN	2		PADZZ
-4	02-14882-02	99167	. HOUSING, Pump	1		PADBZ
-5	KR6-15	99057	. . RING, Key (99-4011-7) . .	3		PADZZ
-6	L246-7-6S-PF	99057	. . INSERT (99-4187)	3		PADZZ
	32-0455	99167	PARTS KIT, PUMP, FIELD . . . (Leakproof)	1		
	99-2975-6	99167	. PACKING, Preformed (KF) . .	1		
	99-5000-23	99167	. TAG, Warning (KF)	2		
	99-4381	99167	. PLUG, Shipping (KF)	1		
	99-4221	99167	. CAP, Shipping (KF)	1		
	99-4058	99167	. BLOCK, Shipping, ... Outlet (KF)	1		
	AF325-4		. NUT (KF) (AP)	2		
	AN960-416		. WASHER (KF) (AP)	2		
	99-4059	99167	. GASKET, Shipping, Outlet . (KF)	1		
	99-2198	99167	. PLUG, Shipping (KF)	2		
	99-4200	99167	. PLUG, Shipping (KF)	1		
	99-4380	99167	. CAP, Shipping (KF)	1		
	02-15234	99167	. BLOCK, Shipping, ... Inlet (KF)	1		
	AF325-5		. NUT (KF) (AP)	3		
	AN960-516		. WASHER (KF) (AP)	3		
	99-4061	99167	. GASKET, Shipping, ... Inlet (KF)	1		
	102-1153	99167	. COVER ASSEMBLY, Shipping . (KF)	1		

Usable On Code

A	024536-209-09
B	025264-200-02
C	024536-213-09
D	024536-214-10

SECTION III

NUMERICAL INDEX

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MS16556-825	4-50	02-14533	1-64	02-15280	5-6
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MS16566-825	6-2	02-14566	4-59	02-15289-01	5-14
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MS20365-1032C	4-22	02-14712-01	5-12	02-15301	1-26
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99-4186	1-35
99-4188	1-45
99-4190	1-38
99-4191	4-48
	4-6
99-4193-04	4-31
99-4194-10	1-54
99-4195-06	1-10
99-4196-02	1-17
99-4200	F 6-6
99-4203-06	4-2
99-4221	F 6-6
99-4247	1-55
99-4287	4-38
99-4288	4-37
99-4302	1-24
99-4303	1-21
99-4304	1-23
99-4318	4-44
99-4319	4-43
99-4344	1-11
99-4345	1-13
99-4346-112	1-8
99-4346-16	2-8
	4-46
99-4346-221	1-12
99-4346-234	4-11
99-4346-240	4-20
	4-65
99-4346-241	1-42
99-4351	4-35
99-4352	4-34
99-4368	1-51
99-4380	F 6-6
99-4381	F 6-6
99-4394-07	4-9
99-4448	1-71
99-4496	1-41
99-4498	1-9
99-4531	2-2
99-4533	2-7
99-4567-04	5-5
99-4580	1-28
99-4581	1-27
99-4601-009	F 4-27
99-4601-012	F 4-55
99-4601-016	F 2-8
	F 4-46
99-4601-017	3-2
99-4601-110	F 4-35
99-4601-112	F 1-8
99-4601-127	F 1-31
99-4601-142	F 4-16
99-4601-221	F 1-12
99-4601-234	F 4-11
99-4601-240	F 4-20
	F 4-65
99-4601-241	F 1-42
99-4601-500	F 4-38
99-4601-501	1-71
99-4602-04	F 1-15
	F 4-4
99-4602-05	1-6
	F 1-4
99-4630	4-17

Part ber	Figure and Index	Part Number	Figure and Index	Part Number	Figure and Index
99-4777	3-5				
99-5000-03	1-43				
99-5000-23	F 6-6				

☆U.S. GOVERNMENT PRINTING OFFICE: 1989 - 668-000

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 1 OF 4

PCN

NSN 96555 A WCD CREW 17 WCD DATE 88 239

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		32									
05	MAT PCB	REC	1.0	TRANSIT			BI NA 09	1		.14					
				~~SETUP~~											
				PROCESS			BI NA 09	1		.03					
10	MAT PCB	ASSY	1.0	~~TRANSIT~~											INSTALL ON FLOW STAND
				~~SETUP~~											
				PROCESS			BI NA 09	1		0.5	OC 0945			0.5	EQUIP ALT = OC # 5139
15	MAT PCB	ASSY	.60	~~TRANSIT~~											~60% OF PUMPS REQUIRE REWORK WHILE ON FLOW STAND; REWORK TAKES BETWEEN 1 AND 2 HOURS. ALT. EQUIP = OC 5139
				~~SETUP~~											
				PROCESS			BI NA 09	1		1.5	OC 0945			1.5	
18	MAT PCB	INSP	1.0	~~TRANSIT~~											OLD OP 080; INSP OIL FILTER
				~~SETUP~~											
				PROCESS			BI NA 09	1		.08	OC 0945			.08	ALT. EQUIP = OC 5139

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MAT PCB SHEET 2 OF 4

PCN NSN 96555 A P/N WCD CREW 17 WCD DATE 88 239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
19	MAT PCB	TEST	1.0	~~TRANSIT~~											OLD OP # 090
				SETUP											CHECK LUBE FLOW
				PROCESS			BT NA 09	1		.08	OC 0945	1		.08	ALT EQUIP = OC 5139
20	MAT PCB	TEST	1.0	~~TRANSIT~~											INCLUDES OLD OPS # 20, 30, 40, 50, 60, & 70
				SETUP			BT NA 09	1		.4	OC 0945	1		.4	
				PROCESS			BT NA 09	1		1.4	OC 0945	1		1.4	ALT. EQUIP = OC 5139
100	MAT PCB	INSP	1.0	TRANSIT											NOT USUALLY DONE — ANY CONDITIONS DISCOVERED BY THIS PROCEDURE WILL HAVE CAUSED PUMP TO FAIL TEST REFORE THIS POINT
				SETUP				N/A							
				PROCESS											
110	MAT PCB	TEST	1.0	TRANSIT											ANY INTERNAL LEAKAGE WILL BE EVIDENT IN OP # 020
				SETUP				N/A							
				PROCESS											
120	MAT PCB	ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BT NA 09	1		0.25					

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 3 OF 4

PCN NSN 96055 A P/N WCD CREW 17 WCD DATE 88 239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
130	MAT PCB	ASSY	1.0	TRANSIT											TIME INCLUDED IN PREVIOUS OPS.
				SETUP				N/A							
				PROCESS											
140	MAT PCB	P.W.	1.0	~~TRANSIT~~											CERTIFICATION
				~~SETUP~~											
				PROCESS			BI NA 09	1		.08					
150	MAT PCB	PROC	1.0	~~TRANSIT~~											OIL FLUSH — NO OIL FLUSH STAND AVAILABLE SO PUMP ~ ± PT. OF OIL INTO PUMP AND SPIN IMPELLER
				~~SETUP~~											
				PROCESS			BI NA 09	1		.08					
160	MAT PCB	MOVE	1.0	TRANSIT			~~NA 01~~	±		.75					← ON MONOGRAM
				~~SETUP~~											
				PROCESS			BI NA 09	1		.17					
170	MAT PCB	P.W.	1.0	TRANSIT											
				SETUP											
				PROCESS			BI NA 09	1		.08					

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MAT PCB SHEET 4 OF 4

PCN RSN 96555 A WCD CREW 17 WCD DATE 88231

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
9999	MAT PCB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP		½									
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

LSC-2XXX2C

FLOW PROCESS CHART

SUBJECT FUEL PUMP TEST DATE 1 JUN 89

ITEM CODE PCN ☒ NSN ☐ P/N ☐ 965555A WCD CREY 17 WCD DATE 88239

CHART BEGINS 00 IN

CHART ENDS 9999 SELL OUT PREPARED BY R S. OLDS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
00	—	○◆D□▽	IN			○◇D□▽	
05	—	○◆D□▽	RECEIVE			○◇D□▽	
10	10	●◇D□▽	INSTALL ON STAND			○◇D□▽	
15	—	●◇D□▽	REMOVE ON STAND			○◇D□▽	
18	80	○◇D■▽	INSP. OIL FILTER			○◇D□▽	
19	90	○◇D■▽	CHECK LUBE FLOW			○◇D□▽	
20	20, 30, 40, 50, 60, 70	●◇D□▽	TEST SERVICES			○◇D□▽	
100	100	○◇D■▽	TEAR DOWN / INSP			○◇D□▽	
110	110	○◇D■▽	INTERNAL LEAKAGE			○◇D□▽	
120	120	●◇D□▽	ASSY & EXT. LEAK. CK.			○◇D□▽	
130	130	●◇D□▽	ADJ. SEALS			○◇D□▽	
140	140	●◇D□▽	CLOSE.			○◇D□▽	
150	150	●◇D□▽	OIL FLUSH			○◇D□▽	
160	160	○◆D□▽	MOVE			○◇D□▽	
170	170	●◇D□▽	SIGN OFF			○◇D□▽	
9999	—	○◆D□▽	SELL			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PRO[illegible]LE

NAME _____ ALC OC-ALC DATE 21MAY89 RCC MTPCB SHEET 1 OF 1

PCII IISN PII 96555A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~
1	8286	8289	72
2	8300	8300	0
3	8347	8348	24
4	9005	9006	24
5	9034	9037	72
6	9045	9045	0
			32

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

LSC-20107A

"OUT" DATES PRO[illegible]LE

NAME _____ ALC OC-ALC DATE 31MAY89 NCC [illegible] SHEET ___ OF 1

PCII / NSN / P/N 96555A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (~~DAYS~~)
1	8295	8295 ~~8275~~	0
2	8305	8306	[illegible]
3	8355	8355	0
4	9012	9017	[illegible]
5	9041	9041	0
6	9048	9048	0
~~7~~			24

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

LSC-2010BA

OPERATION PROFILE

NAME P. Hunt ALC OC DATE 6 03 89 RCC OC SHEET 1 OF 4

PCII/ISH/PII 97150-A WCD CBE404 ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24									
10	MATP CB	REC	1.0	~~TRANSIT~~											REC, SCRUB, ATTACH PW
				~~SETUP~~											
				PROCESS			AP04	1	100	1.0	BEN41L	1	100	1.0	
20	MATP CB	DIS	1.0	~~TRANSIT~~											DIS. PUMP, DYE MARK ENDS OF GEAR TEETH.
				~~SETUP~~											
				PROCESS			AP04	1	100	.33	0C6025	1	100	.33	
30	MATP CB	CLN		~~TRANSIT~~											CLN IN PD680- USE WIRE BASKET
				~~SETUP~~											
				PROCESS			AP04	1	100	.33	0C1178	1	100	.33	
40	MATP CB.	PW		~~TRANSIT~~											ASSURE S/N + PW IS CORRECT
				~~SETUP~~											
				PROCESS			AP04	1	100	.08	BEN41L	1	100	.08	

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 6-03-89 RCC OC SHEET 2 OF 4

PCII/ISH/PII 97150 WCD CBE404 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
50	MATP CB	INSP.	1.0	~~TRANSIT~~											INSPECT, SOME MICROMETER WORK.
				~~SETUP~~											
				PROCESS			AP09	1	100	1.0	BEN412	1	100	1.0	
90	MATP CB	NDI	.01	~~TRANSIT~~											1% OF HOUSINGS & COVERS GO THROUGH FLUOR. PEN
				~~SETUP~~											
				PROCESS			AP09	1	100	.11	CB[illegible]	1	100	.11	
100	MATP CB	NDI	.01	~~TRANSIT~~											1% OF COVERS, HOUSINGS GO THROUGH MAG PART. INSP.
				~~SETUP~~											
				PROCESS		3.0	AP09	1	100	.11	CB[illegible]	1	100	.11	
110	MATP CB	INSP	1.0	~~TRANSIT~~											REMOVE + INSTALL IS REQ'D.
				~~SETUP~~											
				PROCESS			AP09	1	100	3.25	BEN412	1	100	3.25	
120	MAIP. CB	ASSY	1.0	~~TRANSIT~~											INTERNAL PARTS INSPECTION FACILITIES REQUIRED
				~~SETUP~~											
				PROCESS			AP09	1	100	.25	B[illegible]	1	100	.25	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 6-03-89 RCC OC SHEET 3 OF 4

PCH
NSN PN 97150 WCD CBE404 ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
130	MATP CB	CHK	1.0	~~TRANSIT~~											CHK DATA PLATE, MAKE CORRECT
				~~SETUP~~											
				PROCESS			AP09	1	100	.5	BCN412	1	100	.5	
131	MATP	MOV	.15	TRANSIT		3.0	AP09								MOV MOD UNITS INTO MACH SHOP
				~~SETUP~~											
				~~PROCESS~~											
140	MATP CB	MOV	1.0	TRANSIT											FLOW TIME FROM 3001 BLDG TO 3108 BLDG.
				~~SETUP~~											
				PROCESS		24.0	AP09	1	100	.50					
150	MATP CB	WRE	1.0	~~TRANSIT~~											SAFETY WIRE, PW, CERT.
				~~SETUP~~											
				PROCESS			AP09	1	100	1.0	BCN412	1	100	1.0	
160	MATP. CB	MOV	1.0	TRANSIT			AP09	1	100	.17	—	—	—	—	
				~~SETUP~~											
				~~PROCESS~~											

OPERATION PROFILE

NAME P HUNT ALC OC DATE 6-03-89 RCC OC SHEET 4 OF 4

PCN / NSN 97150 WCD CBE404 ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
170	MATP CB	CW	1.0	~~TRANSIT~~											C/W MAOI 66-36 PAR. 13
				SETUP											
				PROCESS			AP09	1	100	.17	BEN412	1	100	.17	
9999	MATP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT Dual fuel Pump DATE 6-03-89

WCD CBE404 WCD DATE 88174

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

CHART BEGINS 010 Rec, Screen & Attach PW

CHART ENDS 170 c/w MAOI 66-36 PREPARED BY PHANT

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●▷D□▽	Rec, Attach PW			○▷D□▽	
15	75	●▷D□▽	Clean Ext. PW & FO			○▷D□▽	
20	20	●▷D□▽	Dis Pump			○▷D□▽	
30	30	●▷D□▽	Cln Parts			○▷D□▽	
40	40	●▷D□▽	PW + S/N Correct			○▷D□▽	
50	50	○▷D■▽	Insp, Some Miss.			○▷D□▽	
90	90	○▷D■▽	Housings (2) NDI			○▷D□▽	
100	100	○▷D■▽	Gears, Cover, Mag Plate			○▷D□▽	
110	110	○▷D■▽	Final Insp.			○▷D□▽	
120	120	●▷D□▽	Assy, Dec.			○▷D□▽	
130	130	●▷D□▽	Make Data Plate (Complete)			○▷D□▽	
131	131	●▷D□▽	Mach Shop. Mod Items			○▷D□▽	
140	140	○●D□▽	Move to 3108 Blo-Test			○▷D□▽	
150	150	●▷D□▽	Safety Wire Pump.			○▷D□▽	
160	160	○▷D□▽ ○●D□▽	Move to Pick up Station			○▷D□▽ ○▷D□▽	
170	170	●▷D□▽	c/w MAOI 66-36 P.13			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

DISASSEMBLY/ASSEMBLY PROFILE

NAME PHUNT ALC OC DATE 6-05-89 RCC MAINPCB SHEET 1 OF 2

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
PCN NSN P/N 97150A	CBE404	88174	20	120	PCN NSN P/N C251	CBE40451		
PCN NSN P/N					PCN NSN P/N C283			
PCN NSN P/N					PCN NSN P/N 102-230			
PCN NSN P/N					PCN NSN P/N 02-15767			
PCN NSN P/N					PCN NSN P/N 02-12707			
PCN NSN P/N					PCN NSN P/N 02-15790			
PCN NSN P/N					PCN NSN P/N 02-12272			
PCN NSN P/N					PCN NSN P/N 02-15763			
PCN NSN P/N					PCN NSN P/N 02-15164			
PCN NSN P/N					PCN NSN P/N 02-12705			
PCN NSN P/N					PCN NSN P/N 02-12704			
PCN NSN P/N					PCN NSN P/N 02-11925			

LSC-2(XX)5A

DISASSEMBLY/ASSEMBLY PROFILE

NAME PHUNT ALC OC DATE 06-05-89 RCC MAY PCB SHEET 2 OF 2

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN NSN P/N 97150A	CBE404	88174	20	120	PCN NSN P/N 02-13098			
PCN NSN P/N					PCN NSN P/N 02-13077			
PCN NSN P/N					PCN NSN P/N 02-12774			
PCN NSN P/N					PCN NSN P/N 02-13926			
PCN NSN P/N					PCN NSN P/N 02-13096			
PCN NSN P/N					PCN NSN P/N 02 13095			
PCN NSN P/N					PCN NSN P/N 02-1[illegible]3			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-20095A

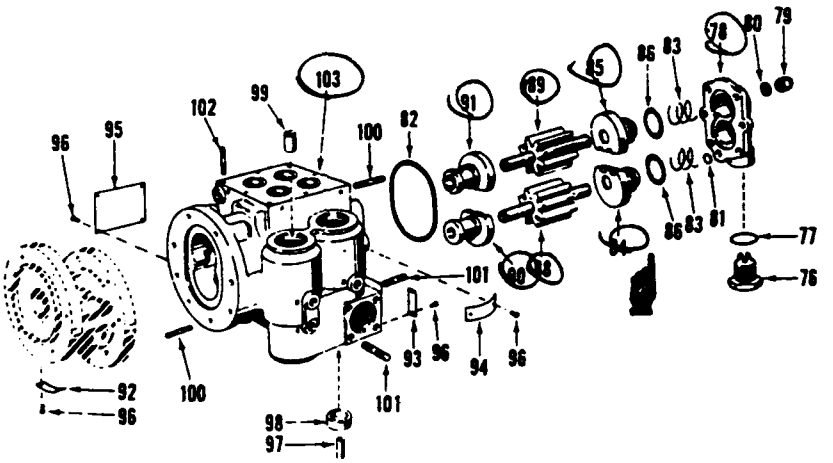
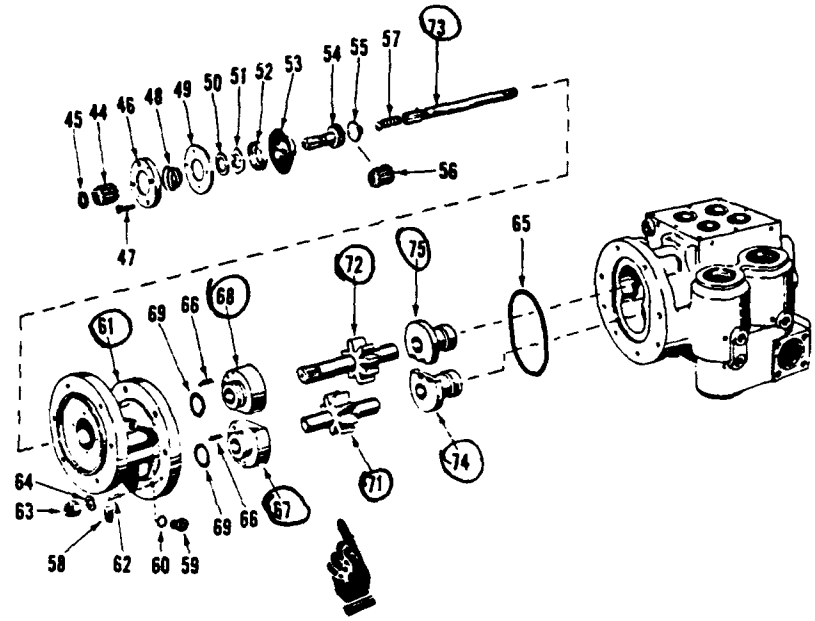


Figure 2. Part Number 022994 Series Dual Fuel Pump Assembly Exploded View (Sheet 3 of 3)

FIG & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNIT PER ASSY	USABLE ON CODE
2-				
-76	AN814-12DL	. PLUG (KC)	1	
-77	MS29512-12	. GASKET	1	
-78	02-11925	. COVER, Rear	1	
		(ATTACHING PARTS)		
-79	AN310-6	. NUT (KC)	6	
-80	AN960-616	. WASHER (KC)	6	
		------*------		
-81	MS29513-112	. PACKING, Preformed	1	
-82	MS29513-235	. PACKING, Preformed	1	
-83	02-650	. SPRING, Bearing (KD)	2	
-84	02-13098	. BEARING, Rear Cover Driven Gear	1	ADEFGH LJK
	02-12282	. BEARING, Rear Cover Driven Gear	1	BC
-85	02-13097	. BEARING, Rear Cover Drive Gear	1	ADEFGH LJK
	02-12281	. BEARING, Rear Cover Drive Gear	1	BC
-86	MS29513-126	. PACKING, Preformed	2	
-87	902-031	. GEARS (Matched set)	1	ALJK
-88	02-12274	. . GEAR, Driven	1	
-89	02-13926	. . GEAR, Drive	1	ALJK
	02-12273	. . GEAR, Drive	1	BCDEFGH
	902-029	. BEARINGS, Body (Matched set)	1	ALJK
-90	02-13096	. . BEARING, Body Driven Gear	1	ADEFGHI JK
	02-12280	. . BEARING, Body Driven Gear	1	BC
-91	02-13095	. . BEARING, Body Drive Gear	1	ADEFGHI JK
	02-12279	. . BEARING, Body Drive Gear	1	BC
-92	99-520	. PLATE, Rotation Name	1	
-93	316-13	. PLATE, Inlet Name	1	
-94	172-32BN	. PLATE, Name	1	
-95	02-580	. PLATE, Pressure Port Identification	1	
		(ATTACHING PARTS FOR PLATES)		
-96	AN535-00-2	. SCREW (KD)	10	
		------*------		
	102-515	. BODY ASSY	1	
-97	02-563	. . GUIDE, Valve	1	
-98	99-1137	. . SEAT, Valve (KD)	1	
-99	02-1209	. . GUIDE, Valve	1	
-100	99-378	. . STUD	14	
	99-1698-01	. . STUD (0.003 inch oversize) (replacement for 99-378)	AR	
	99-1698-02	. . STUD (0.006 inch oversize) (replacement for 99-378)	AR	
-101	99-1136	. . STUD	8	
	99-1606-01	. . STUD (0.003 inch oversize) (replacement for 99-1136)	AR	
	99-1601-02	. . STUD (0.006 inch oversize) (replacement for 99-1136)	AR	
-102	99-2553	. . STUD	8	
	99-2553-01	. . STUD (0.003 inch oversize) (replacement for 99-2553)	AR	
	99-2553-02	. . STUD (0.006 inch oversize) (replacement for 99-2553)	AR	
-103	02-10993	. . BODY	1	
	102-516	. KIT, Front Cover Shipping Block (KD, KF)	1	
	102-176	. KIT, Inlet Port Shipping Block (KD)	1	
	102-177	. KIT, Fuel Bypass Return Port Shipping Block (KD)	1	
	102-178	. KIT, Discharge Port Shipping Block (KD)	1	
	32-0534	PARTS KIT, Pump, Overhaul (D)	1	AHLJK
	32-0026	PARTS KIT, Pump, Overhaul	1	B
	32-0025	PARTS KIT, Pump Cure Date	1	B
	32-0373	PARTS KIT, Pump, Field (F)	1	J
	32-0377	PARTS KIT, Pump, Overhaul (D)	1	J

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
2-70				
	902-151	. GEARS (Matched set)	1	A
	902-032	. GEARS (Matched set)	1	LJK
71	02-12272	. . GEAR, Driven	1	
72	02-15763	. . GEAR, Drive	1	A
	02-12283	. . GEAR, Drive	1	BCDEFGH
	02-13924	. . GEAR, Drive	1	LJK
73	02-15764	. SHAFT, Drive	1	A
	02-10969	. SHAFT, Drive	1	BCDEFGH
	02-13925	. SHAFT, Drive	1	LJK
	902-030	. BEARINGS, Body (Matched set)	1	ALJK
74	02-12705	. . BEARING, Body Driven Gear	1	ACDEFGH LJK
	02-12278	. . BEARING, Body Driven Gear	1	B
75	02-12704	. . BEARING, Body Drive Gear	1	ACDEFGH LJK
	02-12277	. . BEARING, Body Drive Gear	1	B

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
2-				
-44	02-561	. ADAPTER	1	BCDE
	02-13738	. ADAPTER	1	FGHLJK
		(ATTACHING PARTS)		
-45	MS901321	. RING (KD)	1	BCEDFG HLJK
		------*------		
-46	02-13460	. PLATE, Thrust	1	A
	02-81	. PLATE, Thrust (KC)	1	BC
	02-12361	. PLATE, Thrust (KC)	1	DEFGHI JK
		(ATTACHING PARTS)		
-47	782-22	. SCREW, Use 4 units with usable on codes D, E, F, G, H, I, J, K (KC)	6	A
	AN505-10-10	. SCREW (KC)	4	BC
		------*------		
-48	99-1924	. SPRING	1	A
	99-227	. SPRING, Seal	1	BCDEFG HLJK
-49	02-14016	. STOP, Seal	1	A
	02-1206	. STOP, Seal	1	BC
	02-12360	. STOP, Seal	1	DEFGHI JK
-50	99-1925	. WASHER, Spring	1	A
	99-276	. WASHER, Spring (KD)	1	BCDEFG HLJK
-51	02-14015	. WASHER Wobble	1	A
	02-1207	. WASHER, Tab	1	BCDEFG HLJK
-52	02-11027	. GUIDE, Diaphragm	1	A
	739-53	. GUIDE, Diaphragm	1	BCDEFG HLJK
-53	102-974	. SEAL ASSY, Diaphragm	1	A
	102-388	. SEAL ASSY, Diaphragm (KC)	1	BCD
	102-728	. SEAL ASSY, Diaphragm	1	E
	102-417	. SEAL ASSY, Diaphragm (KC)	1	FGHLJK
-54	02-15765	. COUPLING	1	A
	02-12148	. COUPLING	1	BCD
	02-12703	. COUPLING	1	EFG
	02-13740	. COUPLING	1	HLJK
-55	02-13731	. SPACER, Coupling	AR	JK
	02-14041	. SPACER, Coupling	AR	JK
-56	02-15766	. ADAPTER	1	A
-57	99-3781	. SPRING	1	A
	99-1919	. SPRING (KD)	1	BCDEFG HLJK
-58	AN913-1S	. PLUG (KD)	1	BCDEFG HLJK
-59	AN814-4L	. PLUG (KC)	2	
-60	MS29512-4	. GASKET	2	
-61	02-15767	. COVER, Front	1	A
	02-10907	. COVER, Front	1	BCDEFG HLJ
	02-14365	. COVER, Front	1	K
		(ATTACHING PARTS)		
-62	99-1230	. PIN, Taper (KC)	2	
-63	AN310-6	. NUT (KC)	8	
-64	AN960-616	. WASHER (KC)	8	
		------*------		
-65	MS29513-241	. PACKING, Preformed	1	
-66	764-6C	. SPRING, Bearing (KD)	14	
-67	02-12707	. BEARING, Front Cover Driven Gear	1	ACDEFG HLJK
	02-11787	. BEARING, Front Cover Driven Gear	1	B
-68	02-15790	. BEARING, Front Cover Drive Gear	1	A
	02-11786			B
	02-12706	. BEARING, Front Cover Drive Gear	1	CDEFGH
	02-15790	. BEARING, Front Cover Drive Gear	1	IJK
-69	MS29513-131	. PACKING, Preformed	2	



A-20526

Figure 2. Part Number 022994 Series Dual Fuel Pump Assembly Exploded View (Sheet 2 of 3)

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
2-	022994-024-08	PUMP ASSY, Dual Gear-Type Fuel	1	A
	022994-020-01	PUMP ASSY, Dual Gear-Type Fuel	1	B
	022994-020-02	PUMP ASSY, Dual Gear-Type Fuel	1	C
	022994-020-3B	PUMP ASSY, Dual Gear-Type Fuel	1	D
	022994-020-04	PUMP ASSY, Dual Gear-Type Fuel	1	E
	022994-021-04	PUMP ASSY, Dual Gear-Type Fuel	1	F
	022994-021-05	PUMP ASSY, Dual Gear-Type Fuel	1	G
	022994-022-05	PUMP ASSY, Dual Gear-Type Fuel	1	H
	022994-022-06	PUMP ASSY, Dual Gear-Type Fuel	1	I
	022994-022-07	PUMP ASSY, Dual Gear-Type Fuel	1	J
	022994-024-07	PUMP ASSY, Dual Gear-Type Fuel	1	K
-1	C103-03	VALVE ASSY, Pressure Relief (MFD by 98939) (02-13670)	1	AGHLJK
	C103-01	VALVE ASSY, Pressure Relief (MFD by 98939) (02-11021)	1	BC
	C103-02	VALVE ASSY, Pressure Relief (MFD by 98939) (02-12889)	1	DEF
-2	A21117	. . NUT, Lock (98939)	1	
-3	C252	. . SCREW, Adjusting (98939)	1	
-4	MS29513-112	. . PACKING, Preformed (98939)	1	
-5	A331R007	. . SPRING (98939) (KD)	1	
-6	C282	. . END, Spring (98939)	1	
-7	A21137	. . BALL (98939) (KD)	1	
-8	C251	. . HOUSING (98939)	1	
-9	C255	. . SPRING, Valve (98939) (KD)	1	
-10	A211R020	. . SCREW, Lock (98939)	1	AGHLJK
	C134	. . SCREW, Lock (98939)	1	BC
	A211R007	. . SCREW, Lock (98939)	1	DEF
-11	A2073	. . SCREEN SUB-ASSEMBLY Filter (98939) (KD)	1	ADEFGH LJK
-12	A441R0147	. . SEAT (98939) (KD)	1	ADEFGH LJK
	C154	. . SEAT (98939) (KD)	1	BC
-13	C151	. . GASKET (98939) (KD)	1	
-14	MS29513-114	. . PACKING, Preformed (98939)	1	
-15	A2047	. . RING, Retaining (98939) (KD)	1	
-16	A2044	. . SCREEN, Back-up (98939) (KD)	1	
-17	A2045	. . SCREEN, Filter (98939) (KD)	1	
-18	C283	. . PISTON AND SLEEVE ASSY (98939)	1	
	*C281	. . . RIVET (98939)	1	
	*C254	. . . PISTON (98939)	1	
	*C253	. . . SLEEVE (98939)	1	
-19	MS29513-116	. PACKING, Preformed	1	
-20	MS29512-16	. GASKET	1	
	102-225	. PLUG ASSY, Filter	2	BC
-21	02-1214	. . SHAFT, Filter	1	BC
-22	02-10942	. . PIN	1	BC
-23	02-10935	. . PLUG, Filter	1	
-24	MS29512-28	. GASKET	2	
-25	99-1135	. SPRING, Filter (KD)	2	BC
-26	102-230	. FILTER ASSEMBLY	2	BC
-27	02-1215	. PLUG, Inlet Check Valve (KD)	1	
-28	MS29512-10	. GASKET	1	
-29	02-1213	. RETAINER, Spring (KD) (ATTACHING PARTS)	1	
-30	99-1451	. PIN (KD) ------*------	1	
-31	99-1184	. SPRING, Inlet Check Valve (KD)	1	
-32	02-1212	. VALVE, Inlet Check	1	
-33	02-10375	. RETAINER, Pressure Regulating Valve	1	
-34	MS29512-16	. GASKET Retainer	1	
-35	02-10374	. STOP, Valve	1	
-36	99-1666	. SPRING, Valve (KD)	1	
-37	02-564	. VALVE, Secondary Pressure Regulating	1	
-38	02-11020	. PLUG	1	
-39	MS29512-16	. GASKET	1	
-40	AN814-10L	. PLUG (KC)	2	
-41	MS29512-10	. GASKET	2	
-42	AN814-4L	. PLUG, Use 5 units with usable on code K	6	
-43	MS29512-4	. GASKET	6	

*Not procurable as a separate part

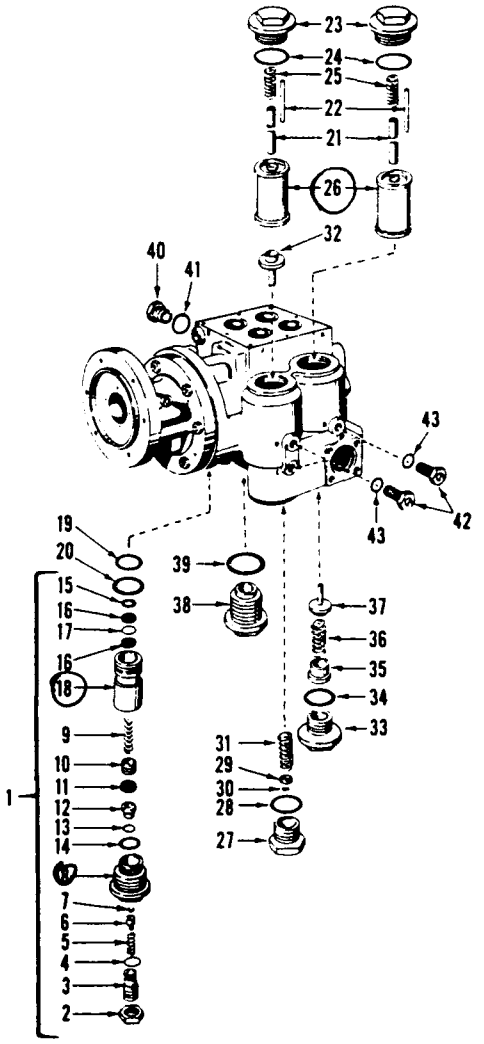


Figure 2. Part Number 022994 Series Dual Fuel Pump Assembly Exploded View (Sheet 1 of 3)

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060389 RCC MATPCB SHEET 1 OF 3

PCN/NSN/PIN 97150 A WCD CBE 4T4 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24									
010	MATP CB	TEST	1.0	~~TRANSIT~~											INST. PUMP ONTO FLOW BENCH.
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	OC0975	1	100	.33	
020	MATP CB	TEST	1.0	~~TRANSIT~~											CALIBRATION RUN.
				~~SETUP~~											
				PROCESS			DP09	1	100	—	OC0975	1	100	—	
030	MATP CB	TEST	1.0	~~TRANSIT~~											ENDURANCE RUN
				~~SETUP~~											
				PROCESS			DP09	1	100	2.0	OC0975	1	100	2.0	
031	MATP. CB	TEST	.1	~~TRANSIT~~											10% OF ITEMS ARE MATPOC'D.
				~~SETUP~~											
				PROCESS			DP09	1	100	1.0	OC0975	1	100	1.0	

LSC-200920

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060389 RCC MATP CB SHEET 2 OF 3

PCN NSN 97150 PIN WCD CBE4T4 ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											SURGE TEST
				PROCESS			DP09	1	100	.17	OC 0975	1	100	.17	OR 0C0884
050	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											SURGE TEST- HIGH PRESSURE
				PROCESS			DP09	1	100	.05	OC 0975	1	100	.05	OR [illegible]
060	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											MISC. FLOW RATES
				PROCESS			DP09	1	100	.12	OC 0975	1	100	.12	[illegible]
070	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											INSTALL DUMMY RELIEF
				PROCESS			DP09	1	100	.25	OC 0975	1	100	.25	VALVE [illegible]
110	MATP CB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											PUMP CALIB. FLOW
				PROCESS			DP09	1	100	.13	OC 0975	1	100	.13	OR 0C0889

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060389 RCC MATPCB SHEET 3 OF 3

PCII NSN 97150 PIN

WCD CBE474 ✓ WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
120	MATP CB	TEST	1.0	~~TRANSIT~~											LEAK TEST, STATIC INLET PRESSURE ONLY.
				~~SETUP~~											
				PROCESS			DP09	1	100	.15	OC 0975	1	100	.15	DR OC 0881
130	MATP CB	PW	1.0	~~TRANSIT~~											PW IAW TO, TCTO
				~~SETUP~~											
				PROCESS			DP09	1	100	.12	OC 0975	1	100	.12	
140	MATP CB	INST	1.0	~~TRANSIT~~											REMOVE FROM TEST STAND, LUBRICATE,
				~~SETUP~~											
				PROCESS			DP09	1	100	.33	OC 0975	1	100	.33	CR IAW CB4
150	MATP CB	MOV	1.0	~~TRANSIT~~											MOVE TO FINAL ASSY
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	—	1	100	.17	
9999	MATP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			0								

FLOW PROCESS CHART

SUBJECT DUAL FUEL PUMP DATE 6-03-89

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

WCD CBE414 WCD DATE 88174

CHART BEGINS 010 INSTALL PUMP ON FLOW BENCH

CHART ENDS 140 INST. SHIPPING BLOCKS + BLKS PREPARED BY P HUNT

OP. PROFILE OP. NO.	WCO OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCO OP. NO.	SYMBOLS	DESCRIPTION
10	10	○▷D■▽	INST PUMP ON TEST STAND			○▷D□▽	
20	20	●▷D□▽	PW - INTO OVEN			○▷D□▽	
30	30	○▷D■▽	PUMP TEST - RUN IN			○▷D□▽	
31	—	○▷D■▽	MATRIC RUN IN			○▷D□▽	
40	40	○▷D■▽	SURGE DISCH. PRESSURE			○▷D□▽	
50	50	○▷D■▽	SURGE TEST			○▷D□▽	
60	60	○▷D■▽	RATE RUN - CHK HOT SPOTS			○▷D□▽	
70	70	○▷D■▽	ADJ. RELIEF VALVE			○▷D□▽	
110	110	○▷D■▽	PUMP CALIB RUN.			○▷D□▽	
120	120	○▷D■▽	LEAK TEST			○▷D□▽	
130	130	●▷D□▽	PW, C/W TO			○▷D□▽	
140	140	●▷D□▽	INST SHIPPING BLKS.			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽ ○▷D□▽				○▷D□▽ ○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN/ESN/P/N 97150F PARENT WCD _____ PARENT WCD DATE 71 R

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)
1	8278	8:77	24
2	8324	8335	24
3	9010	9011	24
4	1013	9054	24
5	9080	1021	24
6	9074	9115	24
7	9103	9113	24
8	9193	9185	24
9	1184	1230	24
10	1137	1138	24
			(24)

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

LSC-20107A

"OUT" DATES PRO. .LE

NAME _____ ALC OC-ALC DATE 31MAY89 NCC MTPCB SHEET 1 OF 1

PCN
NSN
PN 97150A

PARENT WCD _____

PARENT WCD DATE 70[illegible]

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (~~DAYS~~ HRS)
1	8[illegible]8	[illegible]	0
2	[illegible]	[illegible]	0
3	[illegible]	[illegible]	0
4	9062	9062	0
5	9090	[illegible]90	0
6	9102	[illegible]	0
7	9110	9110	0
8	9122	[illegible]	0
9	9132	9132	0
10	[illegible]6	[illegible]	0
			0

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

LSC-20109A

OPERATION PROFILE

NAME R. HARRIS / R.S. OLDS ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 1 OF 5

PCN
RSN 97178 A WCD CBE 405 WCD DATE 88174
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS		0									
5	MAT PCB	REC	1.0	TRANSIT											RECEIVE PUMP FROM ENGINE LINE AND STOCK IN BIN
				SETUP											
				PROCESS			BP 09	1		.03					
10	MAT PCB	REC	1.0	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.03	02 ~~B0410~~	1		.03	
15	MAT PCB	CLN	.05	TRANSIT											5% OF ALL PUMPS ARE MATROC.; ARE CLEANED AND SENT TO TEST (CBE 475)
				SETUP											
				PROCESS			BP 09	1		1.0					
20	MAT PCB	DIS	.95	TRANSIT											
				SETUP							ok				
				PROCESS			BP 09	1		1.5	B0410	1		1.5	

OPERATION PROFILE

NAME R. HARRIS / R.S. OLDS ALC OC DATE 30 MAY 89 RCC MATPCB SHEET 2 OF 5

PCN NSN 97178 A P/N WCD CRE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
30	MAT PCB	CLN	.95	TRANSIT											3 PD-680 MACHINES ALL ID # OC 1178 (2 AGITATED TANKS + 1 SPRAY BOOTH)
				SETUP											
				PROCESS		1.2	BP 09	1			OC 1178 OC 4947	1 1		0.03 0.17	
40	MAT PCB	INSP	.95	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.25	B0410	1		.25	
45	MAT PCB	MACH	.02	TRANSIT											
				SETUP											
				PROCESS		24									
50	MAT PCB	INSP	.95	TRANSIT											TIME INCLUDED IN OP 40
				SETUP			N/A								
				PROCESS											
60	MAT PIN	PROC.	.10	TRANSIT											WELDING/ SOLDERING OF VALVE "B" PART
				SETUP											
				PROCESS		24									

OPERATIC PROFILE

NAME R. HARRIS / R.S. OLDS ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 3 OF 5

(PCD) NSN 97178A P/N WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
70	MAT PCB			TRANSIT				N/A							MECHANIC INDICATED HE DOES NOT NEED TO CALL FOR FLUORESCENT PENETRANT INSPECTION
				SETUP											
				PROCESS											
80	MAT PCB	REPL	.98	TRANSIT											OLD 80(A) MECHANIC IDENTIFIES PARTS TO BE SCRAPPED
				SETUP							OK				
				PROCESS			BP 09	1		.17	B0410	1		.17	
82	MAT PCB	P.W.	.98	TRANSIT											OLD 80(B)
				SETUP							OK				
				PROCESS			BP 09	1		.25	B0410	1		.25	
84	MAT PCB	PROC	.75	TRANSIT											OLD 80(C) HAND LAP SHAFT AS NECESSARY
				SETUP							OK				
				PROCESS			BP09	1		.04	B0410	1		.04	
90	MAT PCB	ASSY	.98	TRANSIT											REASSEMBLY OF PUMP — INCLUDES 1 HR HAND WIRE BRUSH CLEANING
				SETUP							OK				
				PROCESS			BP 09	1		4.5	B0410	1		4.5	

OPERATION PROFILE

NAME R. HARRIS / R.S. OLDS ALC OC. DATE 30 MAY 89 RCC MAT PCB SHEET 4 OF 5

PCN
NSN
P/N 97178 A WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
95	MAT PCB	ASSY	.98	TRANSIT											OLD OP 105
				SETUP											
				PROCESS			BP 09	1		.17	B0410	1		.17	
100	MAT PCB	ASSY	.98	TRANSIT											
				SETUP											
				PROCESS			BP 07	1		.25	B0410	1		.25	
110	MAT PCB	P.W.	.98	TRANSIT											INCLUDES OP 120
				SETUP											
				PROCESS			BP 09	1		.03	B0410	1		.03	
130	MAT PCB	TEST	.98	~~TRANSIT~~											OPS ON WCD CBE #TS ARE DONE HERE
				~~SETUP~~	20	48									
				PROCESS	80	24									
140	MAT PCB	PW	.98	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.03	B0410	1		.03	

OPERATION PROFILE

NAME R. HARRIS / R. S. OLDS ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 5 OF 5

PCN NSN 97178A P/N

WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	ASY	.98	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.75	B0410	1		.75	
160	MAT PCB	~~ASSY~~ MOVE	.98	TRANSIT											MOVE PUMP TO SELL OUT (INCL. OLD OP 170)
				SETUP											
				PROCESS			BP 09	1		.03					
9999	MAT PCB	OUT		TRANSIT											SELL DATE
				SETUP											
				PROCESS		32									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

LSC-2(XX)2C

FLOW PROCESS CHART

SUBJECT _____ DATE 5/3/89

ITEM CODE
PCH X 97178A
NSN. ☐
P/N ☐

WCD CBE415 WCD DATE 88174

CHART BEGINS 005

CHART ENDS 160

PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	—	●◇D□▽	REC PUMP AND SHAFT			○◇D□▽	
010	010	●◇D□▽	REC PARTS FROM BIN			○◇D□▽	
015	015	●◇D□▽	CLN MATROC PART			○◇D□▽	
020	080	●◇D□▽	DISASSEMBLE PUMP			○◇D□▽	
030	030	●◇D□▽	CLN PUMP PARTS			○◇D□▽	
040	040	○◇D■▽	INSP PARTS			○◇D□▽	
045	—	○◆◗□▽	MOVE PARTS TO MATCH			○◇D□▽	
050	050	○◇D□▽	N/A			○◇D□▽	
060	060	○◆◗□▽	MOVE TO MAIN			○◇D□▽	
070	070	○◇D□▽	N/A			○◇D□▽	
080	080(A)	●◇D□▽	TAG CONDEMNED PARTS			○◇D□▽	
082	080(B)	●◇D□▽	P.U. ON PARTS			○◇D□▽	
084	080(C)	●◇D□▽	HAND UP SHAFT			○◇D□▽	
090	090	●◇D□▽	RE-ASSY PUMP			○◇D□▽	
095	105	●◇D□▽	ASSY SHAFT			○◇D□▽	
100	100	●◇D□▽	ASSY PUMP			○◇D□▽	
110	110,120	●◇D□▽	PW			○◇D□▽	
130	130	○◆◗■▽	MOVE TO BLDG 3108			○◇D□▽	
140	140	●◇D□▽	PW			○◇D□▽	
150	150	●◇D□▽	FINAL ASSY ON PUMP			○◇D□▽	
160	160,130	○◆D□▽	MOVE TO SELL-OUT			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

DISASSEMBLY/ASSEMBLY PROFILE

NAME R.S. OLDS ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 97178A NSN P/N	CBE 405	88174	45	90	PCN 81603 NSN [redacted] P/N	CM1 CBE 405M	89180	NO
PCN 97178A NSN P/N	CBE 405	88174	60	90	PCN NSN 76875 P/N	IW1 CBE 405W	89180	NO
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-2(XX)5A

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 30 MAY 89 RCC MATPCB SHEET 1 OF 3

PCN NSN 97178 A P/N WCD CBE 475 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS		0									
5	MAT PCB	~~MATE~~ ~~TEST~~ REC	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		0.5	~~BOARD BENCH~~	1		0.5	
10	MAT PCB	ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		0.5	OC 0889	1		0.5	
20	MAT PCB	TEST	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		1.0	OC 0889	1		1.0	5-10% NEED TROUBLESHOOTING ON FLOW BENCH (15-30 min.) MAT/OC = 5% OF TOTAL
30	MAT PCB	TEST	1.0	TRANSIT											0530 - 50 INCLUDED IN TIME FOR OP 20
				SETUP											
				PROCESS											

LSC-2(XX)2C

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 30 MAY 89 RCC MATPCB SHEET 2 OF 3

PCN NSN 97178A P/N WCD CBE 4TS WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
60	MAT PCB	INSP	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		.08		1		.08	
70	MAT PCB	TEST	1.0	TRANSIT											INCLUDES OP 70 THRU OP 120
				SETUP											
				PROCESS			BI 09	1		.25	OC 0889	1		.25	
130	MAT PCB	P.W.	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		.17					
140	MAT PCB	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		0.5	~~OC 0889~~ OP 400	1		0.5	
145	MAT PCB	P.W.	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 09	1		0.05					

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 30 MAY 89 RCC MATPCB SHEET 3 OF 3

PCN
NSN
P/N

WCD

WCD DATE

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	ASSY	1.0	TRANSIT											TIME INCL. IN OP 140
				SETUP				N/A							
				PROCESS											
170	MAT PCB	MOVE	1.0	TRANSIT											
				SETUP											
				PROCESS			BI 04	1		.08					
9999	11	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS		32									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT _____ DATE 5/3/89

ITEM CODE
PCN ☐
N&N. ☐
P/N ☐

WCD CBE4T5 WCD DATE 88174

CHART BEGINS 005

CHART ENDS _____ PREPARED BY R HARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
005	—	●◇D□▽	REC MAT'L FROM [illegible]			○◇D□▽	
010	010	●◇D□▽	INSP & MARK [illegible]			○◇D□▽	
020	020	●◇D□▽	BREAK-IN TEST RUN			○◇D□▽	
030	030, 040 050	●◇L□▽	TEST PART ON COND.			○◇D□▽	
060	060	○◇D■▽	INSP PART FOR CHIPS			○◇D□▽	
070	070 - 120	●◇D□▽	COMPLETE FINAL TEST			○◇D□▽	
130	130	●◇D□▽	PW			○◇D□▽	
140	140	●◇D□▽	DIE PUNCH PRESS			○◇D□▽	
145	145	●◇D□▽	PW			○◇D□▽	
150	150	●◇D□▽	ASSY CAPS AND WIRES			○◇D□▽	
170	170	○◆D□▽	MOVE TO FINAL ASSY			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

LSC-20147

SECTION II

GROUP ASSEMBLY PARTS LIST

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS		
2-1-	9450-A14	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	A
2-1-	9450-A15	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	B
2-1-	9450-A16	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	C
2-1-	9450-A17	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	D
2-1-	9450-A18	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	E
2-1-	9450-A19	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	F
2-1-	9450-A20	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	G
2-1-	9450-A21	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	H
2-1-	9450-A22	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	I
2-1-	9450-A23	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	J
2-1-	9450-A24	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	K
2-1-	9450-A25	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	L
2-1-	9484-A19	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	M
2-1-	9484-A20	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	N
2-1-	9484-A21	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	O
2-1-	9484-A22	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	P
2-1-	9484-A23	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	Q
2-1-	9484-A24	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	R
2-1-	9484-A25	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)	1	S
2-1-	28963-4	. PLUG, Straight, threaded	3	
-2	46675	. PLUG, Yellow anodized, straight threaded	2	
-3	MS29512-04	. PACKING, Preformed (KC)	5	A,ZZ, M,N

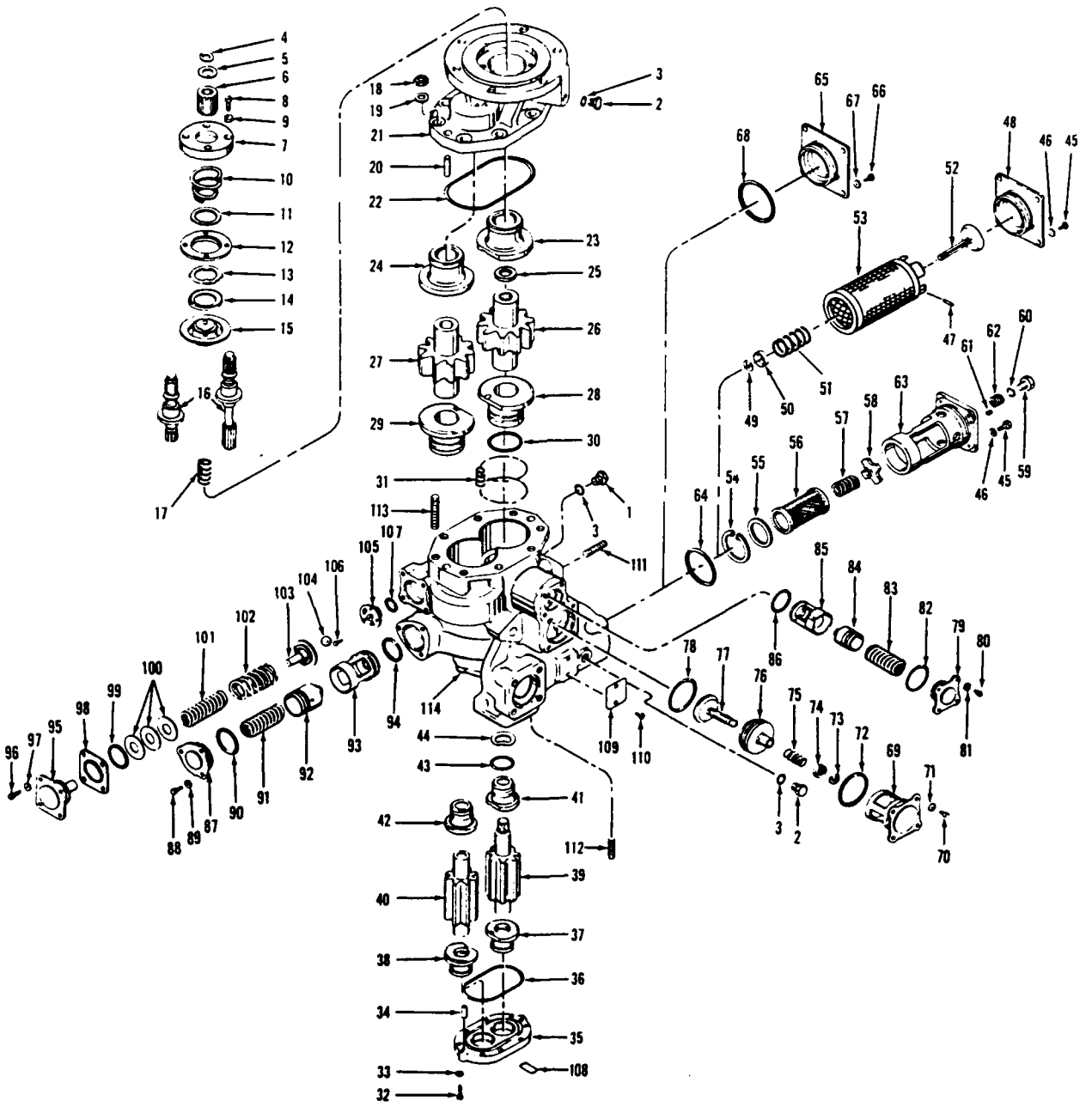

Figure 2-1. Models 9450 and 9484 Two-Stage Fuel Pumps

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)		
2-1-3	MS9020-04	. PACKING, Preformed	5	YY,O, WW
2-1-	74681	. FLANGE ASSEMBLY, Complete	1	A
2-1-	76446	. FLANGE ASSEMBLY, Complete	1	ZZ,YY, XX,WW
-4	5101-46W	. . RING, Retaining (79136) (26286)	1	A
-4	76444	. . RING, Retaining	1	ZZ,YY, XX,WW
-5	27151	. . WASHER, Flat	1	A
-5	76443	. . SHIM	1	
-6	73937	. . SPLINE, Main drive shaft	1	A,B,C, D,E,F M
-6	82561	. . SPLINE, Main drive shaft	1	G,YY,N, O,WW
-7	23929	. . COVER, Drive shaft	1	
		(ATTACHING PARTS)		
-8	AN500-10-10	. . SCREW, Machine	4	
-9	12287	. . CUP, Locking	4	
		-----*-----		
-10	24150	. . SPRING, Conical	1	
-11	23939	. . WASHER, Flat	1	
-12	47149	. . PLATE, Seal	1	
-13	48158	. . WASHER, Key, universal	1	
-14	47167	. . RING, Diaphragm	1	
-15	73909	. . SEAL ASSEMBLY, Diaphragm	1	
-16	74680	. . SHAFT, Main drive	1	A,B,C, D,E,F, M
-16	81375	. . SHAFT, Main drive		G,YY,N, O,WW
-17	23976	. . SPRING, Helical compression	1	
2-1-	23754	. . FLANGE AND DOWEL ASSEMBLY	1	
		(ATTACHING PARTS)		
-18	23866	. . NUT, Plain hexagon	8	
-19	AN960-616	. . WASHER, Flat	8	
		-----*-----		
-20	22609	. . . PIN, Locating	2	
-21	23501	. . . FLANGE	1	
-22	MS29513-243	. PACKING, Preformed	1	A,ZZ, M,N
-22	MS9021-243	. PACKING, Preformed	1	YY,O, WW
2-1-	74549	. BEARING ASSEMBLY, Driving and driven	1	A,B,C
2-1-	78903	. BEARING ASSEMBLY, Driving and driven	1	D,E,F, G,H,I, XX,P
2-1-	71625	. BEARING ASSEMBLY, Driving and driven	1	J,K,Q, R
2-1-	86089	. BEARING ASSEMBLY, Driving and driven	1	L,S

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)		
2-1-23	*74548	. . BEARING, Driving, main outer	1	A,B,C
-23	*78721	. . BEARING, Driving, main outer	1	D,E,F, G,H,I, XX,P
-23	*71623	. . BEARING, Driving, main outer	1	J,K,Q, R
-23	*86090	. . BEARING, Driving, main outer	1	L,S
-24	*74547	. . BEARING, Driven, main outer	1	A,B,C
-24	*78720	. . BEARING, Driven, main outer	1	D,E,F, G,H,I, XX,P
-24	*71620	. . BEARING, Driven, main outer	1	J,K,Q, R
-24	*86091	. . BEARING, Driven, main outer	1	L,S
-25	72844-010	. SPACER, Splined, 0.010 in. thk	AR	
-25	72844-020	. SPACER, Splined, 0.020 in. thk	AR	
-25	72844-030	. SPACER, Splined, 0.030 in. thk	AR	
-25	72844-040	. SPACER, Splined, 0.040 in. thk	AR	
-25	72844-050	. SPACER, Splined, 0.050 in. thk	AR	
2-1-	75234	. GEAR ASSEMBLY, Main driving and driven	1	A,B,C, D,E
2-1-	76489	. GEAR ASSEMBLY, Main driving and driven	1	F,G,YY, XX,WW
-26	75235	. . GEAR, Main driving	1	A,B,C, D,E
-26	76488	. . GEAR, Main driving	1	F,G,YY, XX,WW
-27	24922	. . GEAR, Main driven	1	A,B,C, D,E
-27	76488	. . GEAR, Main driven	1	F,G,YY, XX,WW
-28	74550	. BEARING, Driving, main inner	1	A,B,C
-28	78722	. BEARING, Driving, main inner	1	D,E,F, G,H,I, XX,P
-28	71704	. BEARING, Driving, main inner	1	J,K,Q, R
-28	86092	. BEARING, Driving, main inner	1	L,S
-29	74551	. BEARING, Driven, main inner	1	A,B,C
-29	78723	. BEARING, Driven, main inner	1	D,E,F, G,H,I, XX,P
-29	71705	. BEARING, Driven, main inner	1	J,K,Q, R
-29	86093	. BEARING, Driven, main inner	1	L,S
-30	MS29513-127	. PACKING, Preformed	2	
-31	74151	. SPRING, Helical compression	14	
2-1-	23507	. COVER ASSEMBLY	1	
		(ATTACHING PARTS)		
-32	15050	. SCREW, Socket head cap	8	
-33	2463	. WASHER, Flat	8	
		-----*-----		
-34	22609	. . PIN, Straight headless	2	
-35	23506	. . COVER	1	

ot procurable separately; order NHA.

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)		
2-1-36	MS29513-231	. PACKING, Preformed	1	A,ZZ, M,N
-36	MS9021-231	. PACKING, Preformed	1	YY,O,WW
2-1-	71624	. BEARING ASSEMBLY, Driving and driven	1	
-37	*71618	. . BEARING, Driving, outer	1	
-38	*71617	. . BEARING, Driven, outer	1	
2-1-	75446	. GEAR SET, Driving and driven, boost	1	
-39	75447	. . GEAR, Driving, boost	1	
-40	23517	. . GEAR, Driven, boost	1	
-41	71616	. BEARING, Driving, inner	1	
-42	71619	. BEARING, Driven, inner	1	
-43	MS29513-119	. PACKING, Preformed	2	
-44	23512	. WASHER, Spring	2	
2-1-	74876	. FILTER ASSEMBLY, Complete	1	A,B,C
2-1-	71553	. STRAINER ASSEMBLY, Fuel	1	D,E,F,G YY
		(ATTACHING PARTS)		
-45	14862	. SCREW, Socket head cap	4	A,B,C
-45	MS20074-03-04	. BOLT, Machine	4	D,E,F,G, YY
-46	AN960-10L	. WASHER, Flat	4	A,ZZ,YY
		-----*-----		
-47	74986	. . PIN, Spring	2	A,B,C
-48	74878	. . COVER, Filter	1	A,B,C
-49	26815	. . CLIP, Spring retainer	1	A,B,C
-50	23769	. . WASHER, Cup	1	A,B,C
-51	48054	. . SPRING, Helical compression	1	A,B,C
-52	23509	. . VALVE	1	A,B,C
-53	74877	. . FILTER AND VALVE SEAT ASSEMBLY	1	A,B,C
-54	5000-181W	. . RING, Retaining (79136) (28955-34)	1	D,E,F,G, YY
-55	71559	. . WASHER, Thrust	1	D,E,F,G, YY
-56	71558	. . STRAINER ELEMENT, Fuel	1	D,E,F,G, YY
-57	71557	. . SPRING, Helical compression	1	D,E,F,G, YY
-58	71556	. . SEAT, Spring	1	D,E,F,G, YY
-59	MS9015-04	. . PLUG, Machine thread	1	D,E,F,G, YY
-60	MS29513-015	. . PACKING, Preformed	1	D,E,F,G
-60	MS9021-015	. . PACKING, Preformed	1	YY
2-1-	71554	. . STRAINER ASSEMBLY, Body and inserts	1	D,E,F,G, YY
-61	MS122080	. . . INSERT, Screw thread	2	D,E,F,G, YY
-62	MS124659	. . . INSERT, Screw thread	1	D,E,F,G, YY
-63	71555	. . . BODY, Strainer	1	D,E,F,G, YY
-64	MS29513-134	. PACKING, Preformed	1	A,ZZ
-64	MS9021-134	. PACKING, Preformed	1	YY
-65	26284	. COVER, Filter	1	XX,WW

*Not procurable separately; order NHA.

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)		
		(ATTACHING PARTS)		
2-1-66	MS20074-03-04	. BOLT, Machine	4	XX,WW
-67	AN960-10L	. WASHER, Flat	4	XX,WW
		-----*-----		
-68	MS29513-134	. PACKING, Preformed	1	M,N
-68	MS9021-134	. PACKING, Preformed	1	O,WW
-69	23518	. COVER, "B" Valve	1	
		(ATTACHING PARTS)		
-70	14862	. SCREW, Socket head cap	4	
-71	AN960-10L	. WASHER, Flat	4	
		-----*-----		
-72	MS29513-130	. PACKING, Preformed	1	A,ZZ,M,N
-72	MS9021-130	. PACKING, Preformed	1	YY,O,WW
2-1-	23770	. "B" VALVE ASSEMBLY	1	A,B
2-1-	†76875	. "B" VALVE ASSEMBLY	1	C,D,E,F, G,YY,XX, WW
-73	26815	. . CLIP, Spring retainer	1	A,B
-74	23769	. . WASHER, Valve cup	1	A,B
-75	23772	. . SPRING, Check valve	1	A,B
-76	23519	. . SEAT, Valve	1	A,B
-77	23509	. . VALVE, "B"	1	A,B
-78	MS29513-129	. PACKING, Preformed	1	A,ZZ,M,N
-78	MS9021-129	. PACKING, Preformed	1	YY,O,WW
-79	24276	. COVER, "C" Valve	1	
		(ATTACHING PARTS)		
-80	14862	. SCREW, Socket head cap	4	
-81	AN960-10L	. WASHER, Flat	4	
		-----*-----		
-82	MS29513-024	. PACKING, Preformed	1	A,ZZ,M,N
-82	MS9021-024	. PACKING, Preformed	1	YY,O,WW
-83	24275	. SPRING, Helical compression	1	
-84	24776	. VALVE, "C"	1	
-85	24774	. SEAT, "C" Valve	1	
-86	MS29513-023	. PACKING, Preformed	1	A,ZZ,M,N
-86	MS9021-023	. PACKING, Preformed	1	YY,O,WW
-87	23665	. COVER, "D" Valve	1	
		(ATTACHING PARTS)		
-88	14862	. SCREW, Socket head cap	3	
-89	AN960-10L	. WASHER, Flat	3	
		-----*-----		

† Part No. 76875 differs from Part No. 23770 only in that Part No. 26815 (Index No. 73) is silver-brazed in position, and the "B" valve assembly must be procured as a unit.

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)		
2-1-90	MS29513-125	. PACKING, Preformed	1	A,ZZ,M,N
-90	MS9021-125	. PACKING, Preformed	1	YY,O,WW
-91	23524	. SPRING, "D" Valve	1	
-92	23695	. VALVE, "D"	1	
-93	23694	. SEAT, "D" Valve	1	
-94	MS29513-124	. PACKING, Preformed	1	A,ZZ,M,N
-94	MS9021-124	. PACKING, Preformed	1	YY,O,WW
-95	24482	. COVER, "A" Valve	1	
		(ATTACHING PARTS)		
-96	15050	. SCREW, Socket head cap	4	
-97	AN960-10L	. WASHER, Flat	4	
		-----*-----		
-98	81153	. GASKET, Metal retainer	1	K,L,R,S
-99	MS29513-123	. PACKING, Preformed	1	A,ZZ, M,N
-99	MS9021-123	. PACKING, Preformed	1	YY,O, WW
-100	41081-5	. SHIM, "A" Valve spacer, 0.003 - 0.007 in. thk	AR	
-100	41081-10	. SHIM, "A" Valve spacer, 0.008 - 0.012 in. thk	AR	
-100	41081-20	. SHIM, "A" Valve spacer, 0.018 - 0.022 in. thk	AR	
-100	41081-30	. SHIM, "A" Valve spacer, 0.028 - 0.032 in. thk	AR	
-100	41081-50	. SHIM, "A" Valve spacer, 0.048 - 0.052 in. thk	AR	
-101	24487	. SPRING, "A" Valve inner	1	
-102	24486	. SPRING, "A" Valve outer	1	
-103	24483	. RETAINER, Spring	1	
-104	24484	. BALL, "A" Valve	1	
-105	24485	. SEAT, "A" Valve ball	1	
		(ATTACHING PARTS)		
-106	14849	. SCREW, Socket head cap	4	
		-----*-----		
-107	MS29513-014	. PACKING, Preformed	1	A,ZZ,M,N
-107	MS9021-014	. PACKING, Preformed	1	YY,O,WW
-108	MS9244-01	. DECALCOMANIA	1	
-109	47441	. PLATE, Identification	1	
		(ATTACHING PARTS)		
-110	MS24621-2	. SCREW, Thread forming	2	
		-----*-----		
2-1-	45305	. HOUSING AND STUD ASSEMBLY	1	A,ZZ, H,XX
2-1-	81603	. HOUSING AND STUD ASSEMBLY	1	I,J,K, L,WW
-111	41335-L	. . STUD, Min std size, 0.2779 - 0.2789 in. PD	8	
-111	41335-M	. . STUD, Mean std size, 0.2789 - 0.2799 in. PD	8	
-111	41335-H	. . STUD, Max std size, 0.2799 - 0.2809 in. PD	8	
-111	41335-P003	. . STUD, 0.003 in. oversize, 0.2840 - 2855 in. PD	8	
-111	41335-P006	. . STUD, 0.006 in. oversize, 0.2870 - 0.2885 in. PD	8	

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
		MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)		
2-1-112	23654-L	. . STUD, Min std size, 0.2779 - 0.2789 in. PD	8	
-112	23654-M	. . STUD, Mean std size, 0.2789 - 0.2799 in. PD ...	8	
-112	23654-H	. . STUD, Max std size, 0.2799 - 0.2809 in. PD	8	
-112	23654-P003	. . STUD, 0.003 in. oversize, 0.2840 - 0.2855 in. PD.	8	
-112	23654-P006	. . STUD, 0.006 in. oversize, 0.2870 - 0.2885 in. PD.	8	
-113	23655-L	. . STUD, Min std size, 0.3365 - 0.3376 in. PD	8	
-113	23655-M	. . STUD, Mean std size, 0.3376 - 0.3387 in. PD ...	8	
-113	23655-H	. . STUD, Max std size, 0.3387 - 0.3398 in. PD	8	
-113	23655-P003	. . STUD, 0.003 in. oversize, 0.3422 - 0.3437 in. PD.	8	
-113	23655-P006	. . STUD, 0.006 in. oversize, 0.3452 - 0.3467 in. PD.	8	
-114	45306	. . HOUSING AND PLUG ASSEMBLY	1	A,ZZ, H,XX
-114	81604	. . HOUSING AND PLUG ASSEMBLY	1	I,J,K,L, WW
2-1-	74499	PARTS KIT, Overhaul ("D" Kit)	1	A
2-1-	75861	PARTS KIT, Cure date items ("C" Kit)	1	A
2-1-	86292	PARTS KIT, Cure date items ("C" Kit) (Replaced 82250)	1	K,L
2-1-	91132	PARTS KIT, Cure date items ("C" Kit) (Replaced 86290 and 86292)	1	S, L
2-1-	91135	PARTS KIT, Overhaul ("D" Kit)	1	S
		SHIPPING PACKAGE		
2-2-	NO NUMBER	PACKAGE, Shipping	1	
2-2-	27355	. CONTAINER ASSEMBLY, Metal shipping	1	
-1	AN8026-2	. . CONTAINER, Shipping	1	
-2	NO NUMBER	. . PAD, Tulatex dunnage, 13-1/2 in. dia by 5 in. thk, Type III (density conforming to Military Specification MIL-C-6064)	2	
-3	NO NUMBER	. . PAD, Tulatex dunnage, 7-1/2 by 12-1/4 by 37 in. lg, Type III (density conforming to Military Specification MIL-C-6064)	1	
-4	NO NUMBER	. . SHIPPING ASSEMBLY, Pump	1	
-5	77222	. . . COVER, Shipping (KF)	1	

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTFCL SHEET 1 OF 1

PCN / NSN / PIN 97178A PARENT WCD _____ PARENT WCD DATE [illegible]

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~ HRS
1	8271	8[illegible]	24
2	8271	2[illegible]	24
3	8326	2[illegible]	24
4	8248	2[illegible]	24
5	9007	9010	24
6	9033	9[illegible]	24
7	9040	9041	24
8	9045	9046	24
9	9048	9[illegible]	96
10	10[illegible]	2160	24
			32

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

LSC-20107A

"OUT" DATES PRO..LE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPC B SHEET 1 OF 1

PCN/NSN/PIN 97178A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME ~~(DAYS)~~ HRS
1	8295	8315	0
2	8318	[illegible]	0 "
3	8324	[illegible]	" 0
4	8412	[illegible]	0
5	9013	9013	0
6	9033	[illegible]	0
7	9044	[illegible]	0
8	9052	[illegible]	0
9	9055	9055	0
10	9065	9065	0
			(0)

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

LSC-20109A

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 1 OF 5

PCN
NSN 98021 A WCD CBE COS WCD DATE 88232
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		40									
5	MAT PCB	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											STOCK IN BIN
				PROCESS			BP 09	1		.03					
10	MAT PCB	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP 09	1		.17	OK B0410	1		.17	
15	MAT PCB	CLN	.02	~~TRANSIT~~											
				~~SETUP~~											2% OF PUMPS ARE MATROC; THESE ARE CHECKED AND CLEANED AND SENT TO TEST (CTE COS)
				PROCESS			BP 09	1		1.5	OK B0410	1		1.5	
				TRANSIT											
				SETUP											
				PROCESS											

LSC-2(XX)2C

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 2 OF 5

PCN
NSN 98021 A WCD CRE COS WCD DATE 88232
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
20	MAT PCB	DIS	.98	~~TRANSIT~~											
				~~SETUP~~											
				~~PROCESS~~ PROCESS			BP 01	1		1.5	B0410	1		1.5	
30	MAT PCB	CLN	.98	~~TRANSIT~~											3 MACHINES ALL ID # OC 1178
				~~SETUP~~											
				PROCESS		1.20	BP01	1	-	.20	OC 1178 OC 4947	1 1		.03 .17	
40	MAT PCB	INSP	.98	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP 01	1		1.0	B0410	1		1.0	
50	MAT PCB	NDI	.98	~~TRANSIT~~				N/A							MECHANIC INDICATED THAT HE DOES NOT SEND PARTS OUT FOR PENETRANT OR MAG PARTICLE TESTING
				~~SETUP~~											
				~~PROCESS~~											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATIONAL PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 3 OF 5

PCN NSN 98021 A P/N WCD CBE C05 WCD DATE 88232

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
60	MAT PCB	INSP	.98	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP 09	1		.17	NC 1 B0410	1		.17	
70	MAT PCB	INSP	.98	~~TRANSIT~~				N/A							TIME INCLUDED IN OP 060
				~~SETUP~~											
				~~PROCESS~~											
80	MAT PCB	INSP	.98	~~TRANSIT~~											OLD 080 A, ~~B~~, 080 D, 080 E, 080 F. THEY NO LONGER REPLATE ANY VALVE PARTS.
				~~SETUP~~											
				PROCESS			BP 09	1		.17	OK 1 B0410	1		.17	
81	MAT PCB	PROC	.05	~~TRANSIT~~											OLD 080 B + C (CONDEMING OF PARTS)
				~~SETUP~~											
				PROCESS			BP 09	1		.17	NC 1 B0410	1		.17	
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME R. S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 4 OF 5

PCN NSN 98021 A P/N WCD CBE COS WCD DATE 88 232

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
90	MAT PCB	P.W.	.98	~~TRANSIT~~											MECHANIC MAKES NEW DATA PLATE FOR ALL UNITS EXCEPT MATROC
				~~SETUP~~											
				PROCESS			BP 09	1		.17					
100	MAT PCB	ASSY	.98	~~TRANSIT~~											INCLUDES OLD 100, 110, & 120
				~~SETUP~~											
				PROCESS			BP 09	1		5.0	B0410 or	1		5.0	
130	MAT PCB	P.W.	.98	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP 09	1		.17					
140	MAT PCB	TEST	.98	~~TRANSIT~~											DO ALL OPS FROM CTE COS HERE
				~~PROCESS SETUP~~	60	48									
				PROCESS	40	24									
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MAT PCB SHEET 5 OF 5

PCN
NSN 98021 A
P/N

WCD CRE C05 WCD DATE 88232

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	ASSY	.98	~~TRANSIT~~											SAFETY WIRES + PORT CAPS INSTALLED
				~~SETUP~~											
				PROCESS			BP 09	1		1.0	B0410	1		1.0	
160	MAT PCB	P.W.	.98	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP 09	1		.17					
170	MAT PCB	MOVE	.98	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			BP 09	1		.03					
180	MAT PCB	P.W.	.98	~~TRANSIT~~				N/A							TIME INCLUDED IN 160
				~~SETUP~~											
				~~PROCESS~~											
9999	MAT PCB	OUT		~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24				0					

LSC-2(XM)2C

FLOW PROCESS CHART

SUBJECT PUMP, TWO STAGE FUEL DATE 1 JUN 89

ITEM CODE PCN [X] NSN [ ] P/N [ ] 98021A WCD CBE COS WCD DATE 88232

CHART BEGINS 00 IN

CHART ENDS 9999 OUT PREPARED BY R. S. JONES

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
00	—	○●D□▽	IN			○▷D□▽	
05	—	○●D□▽	RECEIVE/STOCK			○▷D□▽	
10	10	○●D□▽	FROM BIN/P.W.			○▷D□▽	
15	—	●▷D□▽	CLEAN (MATRIC)			○▷D□▽	
20	20	●▷D□▽	DISSMBLE			○▷D□▽	
30	30	●▷D□▽	CLEAN ALL PARTS			○▷D□▽	
40	40	○▷D■▽	VISUAL INSP.			○▷D□▽	
50	50	○▷D■▽	FPI (NOT DONE)			○▷D□▽	
60	60	○▷D■▽	BEARING INSP			○▷D□▽	
70	70	○▷D■▽	INSP MAINS W/OP 60)			○▷D□▽	
80	80A, D, E, F	○▷D■▽	INSP VALVES			○▷D□▽	
81	80 B+C	●▷D□▽	CONDEMN PARTS			○▷D□▽	
90	90	●▷D□▽	CONNECT PLATE + P.W.			○▷D□▽	
100	100, 110, 120	●▷D□▽	ASSEMBLE			○▷D□▽	
130	130	●▷D□▽	TEST P.W.			○▷D□▽	
140	140	●▷D□▽	TEST (3108)			○▷D□▽	
150	100	●▷D□▽	SAFETY WIRES + CAPS			○▷D□▽	
160	160	●▷D□▽	TAG + P.W.			○▷D□▽	
170	170	○●D□▽	TO CONVEYOR			○▷D□▽	
180	180	●▷D□▽	CERT.			○▷D□▽	
9999	—	○▷D□▽	SEAL OUT			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 1 OF 3

PCN
NSN 98021A WCD CTE C05 WCD DATE 88231
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	~~TRANSIT~~											RECEIVED AT TEST LOCATION
				~~SETUP~~											
				PROCESS		40				0					
5	MAT PCB	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP 09	1		0.5	OC0889	1		0.5	
10	MAT PCB	ASSY	1.0	~~TRANSIT~~											MOUNT PUMP ON TEST STAND
				~~SETUP~~											
				PROCESS			DP 09	1		0.5	OC0889	1		0.5	
20	MAT PCB	TEST	1.0	~~TRANSIT~~											5-10% NEED REWORK (MINOR) ON FLOW TEST STAND (15-30 MIN)
				~~SETUP~~											
				PROCESS			DP 09	1		1.0	OC0889	1		1.0	~2% OF TOTAL IS MATRUC
30	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP 09	1		0.10	OC0889	1		0.10	

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 1 OF 3

PCN
NSN 98021 A WCD CTE C05 WCD DATE 88231
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
40	MAT PCB	TEST	1.0	~~TRANSIT~~											INCLUDES OPS 40, 50, 60 & 70 FROM WCD.
				~~SETUP~~											
				PROCESS			DP 09	1		0.5	OC0889	1		0.5	
80	MAT PCB	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP 09	1		0.10	OC0889	1		0.1	
90	MAT PCB	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP 09	1		0.10	OC0889	1		0.1	
100	MAT PCB	P.W.	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP 09	1		0.05					
110	MAT PCB	PROC.	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			DP 09	1		0.03					

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 3 OF 3

PCN NSN 98021 A PIN

WCD CTE COS WCD DATE 88 231

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
120	MAT PCB	ASSY	1.0	~~TRANSIT~~				N/A							TIME INCLUDED IN OP 140
				~~SETUP~~											
				~~PROCESS~~											OP 130 INCLUDED
9999	MAT PCB	OUT	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24				0					
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT TEST - PUMP TWO STAGE FUEL DATE 1 JUN 88

ITEM CODE
PCN [X]
NSN [ ]
P/N [ ]

WCD CTE C05 WCD DATE 88231

98021 A

CHART BEGINS 00 IN

CHART ENDS 9999 OUT PREPARED BY R.S. OLDS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
00	—	○●D□▽	IN			○▷D□▽	
05	~~05~~	●▷D□▽	RECV'D			○▷D□▽	
10	10	●▷D□▽	MOUNT ON STAND			○▷D□▽	
20	20	●▷D□▽	RUN IN & TEST			○▷D□▽	
30	30	○▷D■▽	INSP. FILTER			○▷D□▽	
40	40, 50, 60, 70	●▷D□▽	TEST			○▷D□▽	
80	80	○▷D■▽	INSP. FILTER			○▷D□▽	
90	90	●▷D□▽	LEAK TEST			○▷D□▽	
100	100	●▷D□▽	P.W.			○▷D□▽	
110	110	●▷D□▽	OIL FLUSH/PLUG			○▷D□▽	
120	120, 130	○●D□▽	MINE/FINAL ASSY			○▷D□▽	
9999	—	○●D□▽	SELL OUT			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

FLOW PROCESS CHART

SUBJECT TF33 MANIFOLDS LEFTSIDE DATE 26 MAY 89

ITEM CODE
PCN ■
NSN □
P/N □

WCD CREC04 WCD DATE 89087

98034A (P1) ~~98043A~~
~~98042A (P1)~~ ~~98057A~~

CHART BEGINS IN

CHART ENDS 9999 PREPARED BY S. KOBYLK

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▶D□▽	RECEIVE STOCK TO FLOW	290	290	●◇D□▽	ASSEMBLE
040	040	●◇D□▽	REMOVE WELDING FIXTURE	330	330	●◇D□▽	INSTALL CAPS
041	035	○◇D■▽	DISTORTION CHECK	340	340	●◇D□▽	PAINT NO 2
—	035	○◇D■▽	CHECK THICKNESS	—	320	●◇D□▽	IDENTIFY PART
042	—	○▶D□▽	NON ENGR PARTS SENT FOR TEST	350	350	●◇D□▽	TEST PAINT
043	—	●◇D□▽	2 L NOZZLES	370	370	●◇D□▽	TIGHTEN SLEEVES
044	020	●◇D□▽	REMOVE NOZZLES	—	390	○◇D■▽	CHECK PART
045	020	○◇D■▽	INSPECT PARTS	380	380	●◇D□▽	REMOVE CAPS LAP PART
046	010	●◇D□▽	IDENTIFY & ATTACH PW	400	400	●◇D□▽	CAP PART & BOLT TO FRAME
047	—	○◇D■▽	RED TAG BAD PARTS	410	410	●◇D□▽	CHECK ID
050	050	●◇D□▽	CLEAN PARTS	—	420	●◇D□▽	PAPER WORK
055	055	●◇D□▽	REMOVE HEATSHIELDS	—	435	●◇D□▽	CHECK COMPLIENCE
060	060	○◇D■▽	INSPECT PARTS	440	440	○▶D□▽	PICK UP STATION
090	090	●◇D□▽	REPAIR NOZZLES			○◇D□▽	
100	100	●◇D□▽	REMOVE/REPLACE SLEEVES			○◇D□▽	
110	110	○◇D■▽	INSPECT LUGS			○◇D□▽	
140	140	●◇D□▽	REPAIR LUGS			○◇D□▽	
142	142	●◇D□▽	MACHINE LUGS			○◇D□▽	
145	145	●◇D□▽	REPAIR INLET			○◇D□▽	
150	150	○◇D■▽	INSPECT PARTS			○◇D□▽	
155	155	●◇D□▽	PERFORM MOD.			○◇D□▽	
160	160	●◇D□▽	DISTORTION CHECK BEND STRAIGHT			○◇D□▽	
165	160	○◇D■▽	INSPECT PARTS			○◇D□▽	
—	165	●◇D□▽	INSPECT HEAT-SHIELD & LOCKWIRE			○◇D□▽	
170	170	●◇D□▽	TEST			○◇D□▽	
210	210	●◇D□▽	DRILL HOLES			○◇D□▽	
215	215	●◇D□▽	FLUSH PART			○◇D□▽	
220	220	●◇D□▽	INJECT SILICON			○◇D□▽	
230	230	●◇D□▽	BAKE PART			○◇D□▽	
260	260	●◇D□▽	LAP SEATS			○◇D□▽	
270	270	●◇D□▽	CLEAN PART			○◇D□▽	
280	280	●◇D□▽	MEASURE NOZZLE			○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PRO"LE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN
NSN
P/N 1820-1A

PARENT WCD _____

PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS) HRS
1	8272	8[illegible]	24
2	8302	8[illegible]	24
3	8[illegible]2	8[illegible]3	120
4	8340	8[illegible]	24
5	8347	8[illegible]	24
6	9021	90[illegible]	24
			40

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

LSC-20107A

"OUT" DATES PRO. ILE

NAME _____ ALC OC-ALC DATE 31 MAY 89 NCC MTPCB SHEET 1 OF 1

PCN/NSN/PN 7802,1A PARENT WCD _____ PARENT WCD DATE MTPCB

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS A TIME (DAYS)
1	8298	8 [illegible]	24
2	8 [illegible]	8 :15	24 "
3	8:336	8:36	" 0
4	8 344	8 [illegible]	0
5	8 351	8 :51	0
6	70 [illegible]	[illegible]	0
			(8)

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

LSC-2010A

OPERATION PROFILE

PER H. JOHNSON
WORKED FROM E. TOTTENS Collins

NAME PITUNT ALC OC DATE 060686 RCC MATPCB 50135A, 50136B SHEET 1 OF 4

PCN/ASN/PIN 98031A WCD CBEC06 WCD DATE 89023

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN TIME	1.0	TRANSIT											
				SETUP											
				PROCESS		30									
10	MATP CB	REC	1.0	~~TRANSIT~~											REC, IDT ATTACH PW
				~~SETUP~~											
				PROCESS			AP09	1	100	.5	BEN53	1	100	.5	
20	MATP CB	DIS	1.0	~~TRANSIT~~											AVOID SCRATCH OR MECHANICAL DAMAGE
				~~SETUP~~											
				PROCESS			AP09	1	100		BEN53	1	100		
30	MATP CB	CLN	1.0	~~TRANSIT~~							OC4947	1	100	.2	
				SETUP			AP09	1	100	.4	OC4132	1	100	.2	
				PROCESS											
60	MATP CB	PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS			AP09	1	100	.7	BEN53	1	100	.7	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060689 RCC CBECO6 SHEET 2 OF 4

PCN / ASN / PIN 98031A WCD CBECO6 WCD DATE 89023

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
70	MATP CB	INSP	1.0	~~TRANSIT~~											INSPECT PRIMARY STRAINER.
				~~SETUP~~											
				PROCESS			APO9	1	100	.7	BENCH	1	100	.7	
90	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY ORIFICE SCREEN + BODY
				~~SETUP~~											
				PROCESS			APO9	1	100	4.5	BENCH	1	100	4.5	
100	MATP CB	MOVE	1.0	TRANSIT			APO9	1	100	.3	FENCE	1	100	.3	MOVE TO LAP MASTER
				~~SETUP~~											
				~~PROCESS~~											
110	MATP CB	PROC	1.0	~~TRANSIT~~											LAP SEAL SURFACES
				~~SETUP~~											
				PROCESS			APO9	1	100	1.8	[illegible]	1.0	100	1.8	
120	MATP CB	CLN	1.0	~~TRANSIT~~											CLEAN IN PD-680
				~~SETUP~~											
				PROCESS			APO9	1	100	.1	[illegible]	1	100	.1	

OPERATION PROFILE

NAME P HUNT ALC OC DATE 060689 NCC CBEC06 SHEET 3 OF 4

PCN NSN PN 98031A WCD CBEC06 WCD DATE 89023

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MATP CB	MOV	1.0	TRANSIT			AP09	1	100	.3	—	—	—	—	MOVE TO & REC. FROM TEST. MTNG WCD
				~~SETUP~~											
				~~PROCESS~~											
152	MATP CB	PROC.	1.0	~~TRANSIT~~											VACU-BLAST
				~~SETUP~~											
				PROCESS			AP09	1	100	.2	BEN53	1	100	.2	
155	MATP CB	INSP	1.0	~~TRANSIT~~											VISUAL INSP. NUTS MICR. ALSO.
				~~SETUP~~											
				PROCESS			AP09	1	100	1.6	BEN53	1	100	1.6	
160	MATP CB	ASSY	1.0	~~TRANSIT~~											ASSY FERRULE, SCREEN, SPRING
				~~SETUP~~											
				PROCESS			AP09	1	100	.3	BEN53	1	100	.3	
170	MATP CB	INSP	1.0	~~TRANSIT~~											1
				~~SETUP~~											
				PROCESS			AP09	1	100	.3	BEN53	1	100	.3	

OPERATION IOFILE

NAME P HUNT ALC OC DATE 060689 RCC CBECO6 SHEET 4 OF 4

PCN/ISIT/PIN 98031A WCD CBECO6 WCD DATE 89023

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
175	MATP CB	C/W PW	1.0	~~TRANSIT~~											C/W MAOI 66-36 P. 13.
				~~SETUP~~											
				PROCESS			AP09	1	100	.05	BEN53	1	100	.05	
180	MATP CB	MOVE	1.0	~~TRANSIT~~											MOVE TO ACK UP STATION
				~~SETUP~~											
				~~PROCESS~~			AP09	1	100	.05	BEN53	1	100	.05	
9999	MATP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT 98031A DATE 6/6-89

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

WCD CBECO6 WCD DATE 89023

CHART BEGINS 10

CHART ENDS 180 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●◇D□▽	REC.			○◇D□▽	
20	20	●◇D□▽	DISASSY			○◇D□▽	
30	30	●◇D□▽	CLEAN PER 610			○◇D□▽	
60	60	●◇D□▽	POLISH BORE			○◇D□▽	
70	70	○◇D■▽	VIS INSP. SIR.			○◇D□▽	
90	80	●◇D□▽	ASSY OFFICE			○◇D□▽	
100	100	○◆D□▽	MOVE TO LAPSTOCK			○◇D□▽	
110	110	●◇D□▽	LAPSTOCK SUBASSY			○◇D□▽	
120	120	●◇D□▽	CLEAN			○◇D□▽	
150	150	○◆D□▽	MOVE TO REC.			○◇D□▽	
152	152	●◇D□▽	VACU-BLAST			○◇D□▽	
155	155	○◆D□▽	VIS INSP. PARTS			○◇D□▽	
160	160	●◇D□▽	ASSY FINAL			○◇D□▽	
170	170	○◇D■▽	INSPECT.			○◇D□▽	
175	175	●◇D□▽	CW MACH 60-36			○◇D□▽	
180	180	○◆D□▽	MOVE TO PACK (FG)			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

OPERATIC PROFILE TEST

NAME PHUNT ALC OC DATE 6-2-89 RCC MATPCB SHEET 1 OF 3

PCN
NSN 98031A
P/N
WCD CTEC06 WCD DATE 87112

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MATP CB	IN DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		30									
010	MATP CB	TST	1.0	~~TRANSIT~~											VISUAL CHECK SPRAY PATTERN
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C 0705 0C 0701 0C 0702 0C 0703	1	100 100	.02 .02	
020	MATP CB	TST	1.0	TRANSIT											FLOW RATE
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0 705 0C0 701 0C0 702 0C0 703	1	100	.02	
030	MATP CB	TST	1.0	TRANSIT											300 PSIG - CHK FOR SPRAY STRAIGHTNESS.
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0 705 0C0 701 0C0 702 0C0 703	1	100	.02	
040	MATP CB	TST		~~TRANSIT~~											SPRAY CONE ANGLE.
				~~SETUP~~											
				PROCESS			DP09	1	100	.08	0C0 705 0C0 701 0C0 702 0C0 703	1	100	.02	

OPERATION PROFILE

NAME PHUNT ALC OC DATE 6-2-89 RCC MATPCB SHEET 2 OF 3

PCN
NSN
P/N 98031A WCD CTEC06 WCD DATE 87112

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MATP CB	TEST	1.0	~~TRANSIT~~											SPRAY CONE ALIGNMENT
				~~SETUP~~											
				PROCESS			DP09	1	100	.32	OC 0705 OC 0701 OC 0702 OC 0703	1 1 1 1	100 100 100 100	.32 .32 .32 .32	
060	MATP CB	TEST	1.0	~~TRANSIT~~											REWORK + CALIB ALLOWANCE
				~~SETUP~~											
				PROCESS			DP09	1	100	.68	OC 705 OC 701 OC 702 OC 703	1 1 1 1	100 100 100 100	.17 .17 .17 .17	
070	MATP CB	PW	1.0	~~TRANSIT~~											C/W IAW T.O. TCTO ETC.
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	OC 70-	1	100	.17	
075	MATP CB	PW	1.0	~~TRANSIT~~											C/W MAOI 66-36 PARA. 13
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	OC 70-	1	100	.17	
080	MATP CB	MOVE	1.0	~~TRANSIT~~											MOVE TO FINAL ASSY
				~~SETUP~~											
				PROCESS			DP09	1	100	.17	—		—	—	

OPERATION PROFILE

NAME P HUNT ALC 0C DATE 6-2-89 RCC MATPCB SHEET 3 OF 3

PCN
NSN
PIN 98031A WCD CTEC06 WCD DATE 87112

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
9999	MATP CB	OUT DATE	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS		24									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT PHUNT DATE 6-2-89

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

WCD CTEC06 WCD DATE 87112

CHART BEGINS 98031A OP 10 VISCHECK

CHART ENDS OP 80 MOVE TO ASSY PREPARED BY PHUNT

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	○▷D■▽	SET-UP, VISCHECK			○▷D□▽	
20	20	○▷D■▽	FLOW RATE			○▷D□▽	
30	30	○▷D■▽	300 PSIG SPRAY TEST			○▷D□▽	
40	40	○▷D■▽	SPRAY CONE ANGLE			○▷D□▽	
50	50	○▷D■▽	SPRAY CONE ALIGNMENT			○▷D□▽	
60	60	●▷D□▽	REMOVE + RECALIB			○▷D□▽	
70	70	●▷D□▽	C/W IAW TO	ICTO		○▷D□▽	
75	75	●▷D□▽	P/W C/W MAOI			○▷D□▽	
80	80	○●D□▽	MOVE TO FINAL ASSY			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
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		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN / NSN / P/N 98031A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME ~~(DAYS)~~ HRS
1	[redacted] 8307	8308	24
2	8326	8326	0
3	8340	8340	0
4	8358	8362	96

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

LSC-20107A

"OUT" DATES PRO[illegible]LE

NAME _____ ALC OC-ALC DATE 31MAY89 NCC MTPC 65 SHEET 1 OF 1

PCII/ISN/PIN 98031A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
1	8312	8312	0
2	8328	8330	48
3	8342	8343	74
4	8364	8364	0
			18

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

LSC-2010SA

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MAT CB SHEET 1 OF 9

ITEM CODE PCN 98034A ~~98043A~~ NSN ~~98042A~~ ~~98057A~~ P/N

WCD CBEC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
000	MAT CB	IN	1.0	TRANSIT										
				SETUP										
				PROCESS	0									
010	MAT PCB	REC	1.0	~~TRANSIT~~										80% OF MAN RECEIVED FROM THE "BARN". 20% OF MAN. RECEIVED FROM ENGINE SHOP. RECEIVE 25 AT A TIME FROM "BARN" A MIX OF LEFT/RIGHT MANIFOLDS RECEIVED FIRST PART OF WCD 010
				~~SETUP~~										
				PROCESS		BP09	1	100	.1	BENSS	1	100	.1	
040	CB	REM	1.0	~~TRANSIT~~										REMOVE PART FROM SHIPPING FIXTURE. CHECK FIXTURE FOR DISTURTION
				~~SETUP~~										
				PROCESS		BP09	1	100	.05	BENSS	1	100	.05	WCD 040
041	CB	INSP	1.0	~~TRANSIT~~										INSPECT MANIFOLD FOR DISTORTION. IF MANIFOLDS HAVE NOT BEEN FIELD SEND TO IPCW BLDG 108.
				~~SETUP~~										
				PROCESS		BP09	1	100	.05	BENSS	1	100	.05	WCD 030, 035
042	CB	TEST	.02	~~TRANSIT~~										NON FIELD PAINT GO TO BLDG 3 08 FOR CTEC04 TESTING. IF CHECKED SAT THEN PROCEEDS AS NORMAL. IF CTEC04 PROCEDURE IS USED
				~~SETUP~~										
				PROCESS	24									

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 2 OF 9

ITEM CODE (PCN) 98034A ~~98043A~~ NSN ~~98042A~~ 98057A P/N

WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
043	CB	PROC	.98	~~TRANSIT~~										OIL PUT ON NOZZLES AND LEFT ON FOR ONE HOUR TO SATURATE THREADS FOR EASY REMOVAL.
				~~SETUP~~										
				PROCESS	1.0	BP09	1	100	.05	BENSS	1	100	.05	
044	CB	REM	1.0	~~TRANSIT~~										REMOVE NOZZLES IF POSSIBLE. DISCARD OLD SEALS & LOCK TABS
				~~SETUP~~										
				PROCESS		BP09	1	100	.17	BENSS"	1	100	.17	WCD020
045	CB	INSP	1.0	TRANSIT										INSPECT PART FOR CRACKS, STRIPPED THREADS AND FROZEN NOZZLES
				SETUP										
				PROCESS		BP09	1	100	.03	BENSS"	1	100	.03	WCD 020
046	CB	ID	1.0	~~TRANSIT~~										IDENTIFY PARTS AND ATTACH PAPERWORK
				~~SETUP~~										
				PROCESS		BP09	1	100	.05	BENSS	1	100	.05	SECOND PART OF WCD 010
047	CB	INSP	.2	~~TRANSIT~~										20% OF PARTS ARE BEYOND REPAIR. THESE ARE TAGED AND SCRAPPED.
				~~SETUP~~										
				PROCESS		BP09	1	100	.08	BENSS	1	100	.08	

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 3 OF 9

ITEM CODE PCN 98034A ~~98042A~~ ~~98043A~~ NSN ~~98042A~~ ~~98057A~~ P/N WCD CBEC04 WCD DATE 89084

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	CB	CLN	1.0	~~TRANSIT~~						OC3338 OC3348 OC3346	1 1 1	100	1	PARTS ARE BATCHED PROCESSED. THEY ARE PLACED ON RACKS + CLEANED. 2 PARTS PER TANK 2 TANKS AVAIL. PER PROCESS
				SETUP		BP09	1		.12	OC3351 OC3350 OC3349	1 1 1	100	1	
				PROCESS		BP09	1		.3	MCH22	1	100	.6	WCD 050
055	MT PIW	REM	1.0	~~TRANSIT~~						WILLTANK				REMOVE HEAT SHIELD
				~~SETUP~~										
				PROCESS										WCD 055
060	IW	INSP	1.0	TRANSIT										INSPECT FOR METAL CONTENT (GOLD-NICKLE) (COPPER-NICKLE)
				SETUP										
				PROCESS										WCD 060
090	MT PCM	REP	1.0	TRANSIT										REPAIR NOZZLE BODY AS REQUIRED
				SETUP										
				PROCESS										WCD 090
100	CM	REPL	1.0	TRANSIT										REMOVE + REPLACE SLEEVES AS REQUIRED
				SETUP										
				PROCESS										WCD 100

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25 MAY 89 RCC MATCBE SHEET 4 OF 9

ITEM CODE PCN 98034A ~~98043A~~ NSN ~~98042A~~ ~~98057A~~ P/N WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	CM	INSP	1.0	TRANSIT										INSPECT & RECORD LUG THICKNESS
				SETUP										
				PROCESS										WCD 110
120	MT PIW	PROC	1.0	TRANSIT										WELD HEATSHIELDS AND LUGS AS REQUIRED & INSPECT WORK
				SETUP										
				PROCESS										WCD 120
140	MT PCM	REPL	1.0	TRANSIT										REPAIR OR REPLACE LUGS AS REQUIRED
				SETUP										
				PROCESS										WCD 140
142	CM	MACH	1.0	TRANSIT										MACHINE LUGS & RECORD THICKNESS
				SETUP										
				PROCESS										WCD 142
145	CM	REP	1.0	TRANSIT										REPAIR INLET ADAPTER AND BUSHINGS IF REQUIRED
				SETUP										
				PROCESS										WCD 145

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 5 OF 9

ITEM CODE PCN 98034A ~~98043A~~ NSN ~~28043A~~ ~~28057A~~ P/N WCD CRE04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MT PIW	INSP	1.0	TRANSIT										FLUORESCENT PENETRANT INSPEC
				SETUP										
				PROCESS										WCD 150
155	MT PCM	PROC	1.0	TRANSIT										PERFORM FLEX MOUNT MOD IF REQUIRED
				SETUP										
				PROCESS										WCD 155
160	CM	PROC	1.0	TRANSIT										PERFORM DISTORTION CHECK AND COLD BEND.
				SETUP										
				PROCESS	120									WCD 160
165	MAT PCB	INSP	1.0	~~TRANSIT~~										REINSPECT PARTS. BEND ON SPECIAL FIXTURE. LOCKWIRE. INSPECT FOR CRACKS
				SETUP		BP09	1	100	.01	FINGER	1	100	.01	
				PROCESS		BP09	1		.24	FINGER	1		.01	WCD 160+165
170	CB	TEST	1.0	~~TRANSIT~~										TEST PERFORMED BY WIGGLING PART. IF IT WIGGLES REPLACE IT.
				~~SETUP~~										
				PROCESS		BP01	1	100	.1	FINGER	1	100	.1	WCD 170

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25 MAY 89 RCC MATCBE SHEET 6 OF 9

ITEM CODE PCN 98034A ~~98043A~~ NBN ~~98042A~~ 98057A P/N WCD CBECO4 WCD DATE 98087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
210	MT PCM	PROC	1.0	TRANSIT										DRILL HOLES FOR SILICON
				SETUP										
				PROCESS										WCD 210
215	MT PIW	CLN	1.0	TRANSIT										RI FLUSH MANIFOLD
				SETUP										
				PROCESS										WCD 2.5
220	IW	PROC	1.0	TRANSIT										INJECT SILICON
				SETUP										
				PROCESS										WCD 220
230	IW	PROC	1.0	TRANSIT										BAKE MANIFOLD. REMOVE RESIDUE. 4HRS IN WORK 12HR WAIT UNTIL NEXT MORNING
				SETUP										
				PROCESS	16									WCD 230
250	MAT CB	INSP	1.0	~~TRANSIT~~										- INSPECT TAKES ABOUT 5-10 SECONDS
				~~SETUP~~										
				PROCESS		BP09	1	100	.01	[illegible]	1	100	.01	WCD 250

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 7 OF 9

ITEM CODE PCN 98034A ~~98043A~~ NSN 98042A ~~98057A~~ P/N WCD CRECO4 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
260	CB	PROC	1.0	~~TRANSIT~~										BODY SEATS ARE LAPED BY HAND
				~~SETUP~~										
				PROCESS		BP09	1	100	2.0	BENCH	1	100	2.0	WCD 260
270	CB	CLN	1.0	~~TRANSIT~~										- PART IS FLUSHED AND AIR DRYED
				~~SETUP~~										
				PROCESS		BP09	1	100	.25	ULTRASONIC	1	100	.25	WCD 270
280	CB	PROC	1.0	~~TRANSIT~~										MEASURE NOZZLE AND BODY HOUSING DEPTH. SUBTRACT ONE FROM THE OTHER TO DETERMINE WHAT SIZE SEAL IS REQUIRED
				~~SETUP~~										
				PROCESS		BP09	1	100	.4	BENCH	1	100	.4	WCD 280
290	CB	ASSY	1.0	TRANSIT										INSTALL SEALS NOZZLES AND TAB LOCKS
				SETUP										
				PROCESS		BP09	1	100	.5	BENCH	1	100	.5	WCD 290
330	CB	INT	1.0	~~TRANSIT~~										- INSTALL CAPS ON NOZZLES
				~~SETUP~~										
				PROCESS		BP09	1	100	.01	BENCH	1	100	.01	WCD 330

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCISE SHEET 8 OF 9

ITEM CODE PCN 98034A ~~98043A~~ NSN ~~98042A~~ ~~98057A~~ P/N WCD CBEC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
340	CB	FW	1.0	~~TRANSIT~~										IDENTIFY & PROCESS PAPERWORK
				~~SETUP~~										
				PROCESS		BP09	1	100	.09	FENSES	1	100	.09	WCD 320 & 340
350	CB	TEST	1.0	TRANSIT										CONVEYER TO BLDG 3108 FOR TESTING # WCD CTEC04 AND RETURNED BY CONVEYER
				SETUP										
				PROCESS	16									WCD 350
370	CB	PROC	1.0	~~TRANSIT~~										TIGHTEN SEALS, SET TAB LOCKS, PERFORM DISTORTION CHECK BY VISUAL AND FEEL
				~~SETUP~~										
				PROCESS		BP09	1	100	.4	FENSES	1	100	.4	WCD 370 & 390
380	MTB CM	PROC	1.0	TRANSIT										- REMOVE CAPS AND HAND LAP TO A [illegible] FINISH.
				SETUP										
				PROCESS	.25									WCD 380
400	MAT CB	LOAD	1.0	~~TRANSIT~~										- CAP PART AND BOLT TO FIXTURE [illegible]
				~~SETUP~~										
				PROCESS		BP09	1	100	.15	[illegible]	1	100	.15	WCD 400

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 9 OF 9

ITEM CODE PCN 98034A ~~98042A~~ NSN ~~98042A~~ ~~98037A~~ P/N WCD CBLC041 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
410	CB	PW	1.0	~~TRANSIT~~										INSURE PROPER I.D. COMPLETE APTO 349. COMPLY WITH MAOI 66-36 PARA 13.
				~~SETUP~~										
				PROCESS		BP09	1	100	.02	HAND	1	100	.02	WCD 410, 420 & 435
430	CB	INSP	1.0	~~TRANSIT~~										INSPECT
				~~SETUP~~										
				PROCESS		BP09	1	100	.01	HAND	1	100	.01	WCD 430
432	CB	PW	1.0	~~TRANSIT~~										TAG & PROCESS PAPERWORK
				~~SETUP~~										
				PROCESS		BP09	1	100	.04	HAND	1	100	.04	WCD 430
440	CB	MOVE	1.0	TRANSIT										MOVE TO PICK-UP STATION
				~~SETUP~~										
				~~PROCESS~~		BP09	1	100	.01					WCD 440
9999	MAT CB	OUT	1.0	TRANSIT										
				SETUP										
				PROCESS	0									

	FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
	26 - 63	410935	52661	RING-SPL, RTNG 0.938 HSG DIA X 0.075 WALL X 0.042 IN. THK	1		PAFBZN
	- 64	742372	52661	GEARSHAFT-BEVEL, MAIN DRIVE GRBX SHAFT	1		PAFFFP
	- 65	770329	52661	BEARING OPTION-REF NO. ONLY	1		XC—
				ORDER ONE OF THE FOLLOWING			
		741415	52661	BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741416			PAFBZN
		741416	52661	BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741415			PAFBZN
	- 66	742366	52661	SPACER-RING 1.500 ID X 1.860 OD X 0.080 IN. THK	1		PAFZZN
	- 67	742365	52661	SPACER-BRG ACCESS DRIVE GRSHFT	1		PAFZZN
		801659	52661	BEARING ASSEMBLY-GRBX DRIVE SUPERSEDES 742369	1		XB—
	- 68	742368	52661	.HOUSING-GRBX DRIVE BRG	1		PAFBZN
	- 69	802862	52661	.BEARING OPTION-REF NO. ONLY	1		XC—
				ORDER THE FOLLOWING			
				SUPERSEDES 488748			
				OPTION C/O 488747			
				OR 770612			
				PRCMT NO. C/O			
R		798868	52661	BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798869			PAFBZN
R		798869	52661	BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798868			
R							
	- 70	749920	52661	.SPACER ASSEMBLY-GRBX DRIVE BRG	1		PAFZZN
	- 71	MS9390-080	96906	..PIN	1		PADZZN
	- 72	742378	52661	HOUSING-ASSY OF, GRBX DRIVE BRG	1		PAFBZN

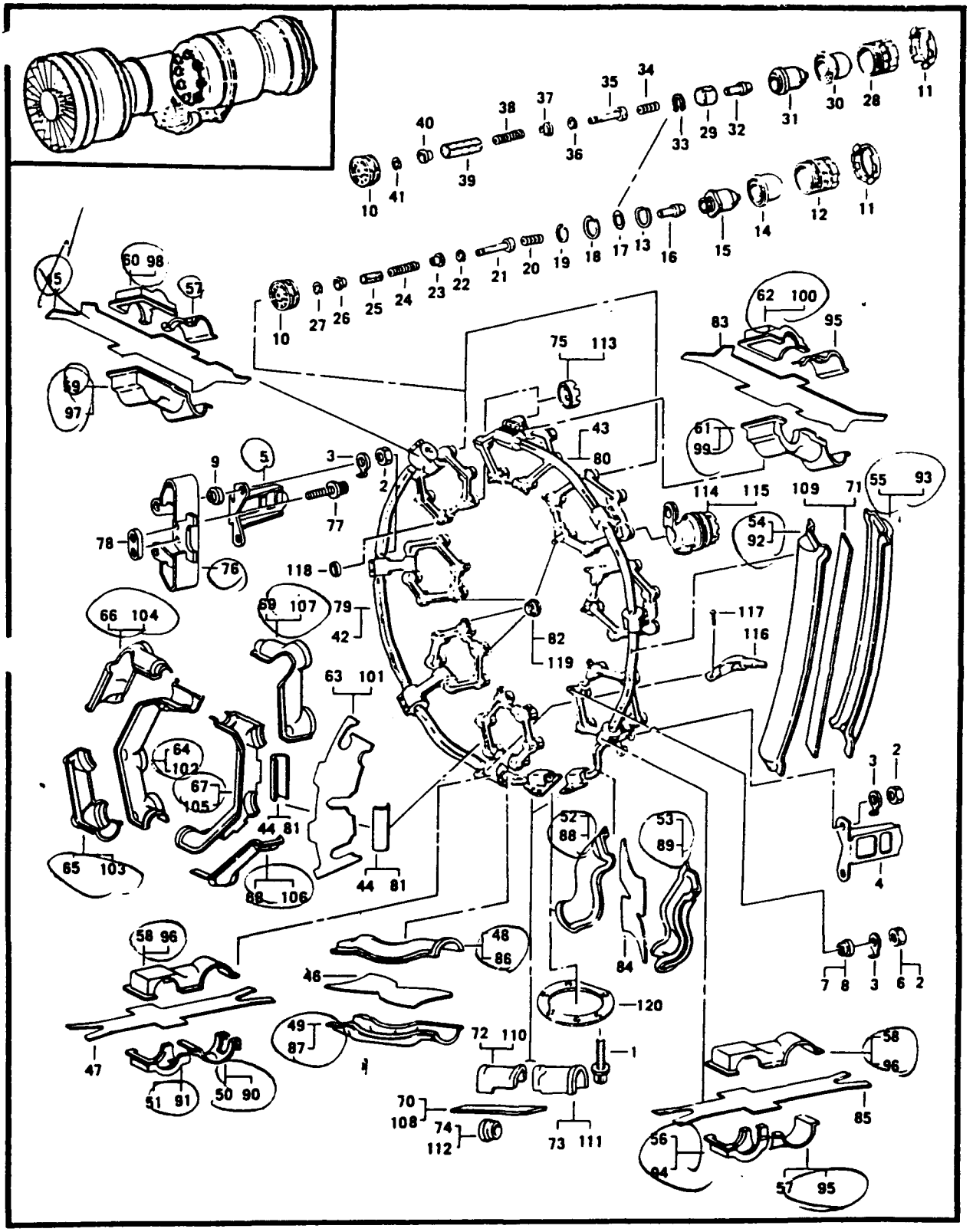

FIGURE 27 - MANIFOLDS-FUEL. NOZZLES-FUEL.

PCN 98034A 98043A
98042A 98057A

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
			MANIFOLDS-FUEL. NOZZLES-FUEL.			
27	483266	52661	MANIFOLD SET-FUEL	1	AS	XB---
	524342	52661	MANIFOLD SET-FUEL	1	B/AT	XB---
- 1	237233	52661	BOLT-MACH, DRILLED DBL HEX ..... 0.3125-24 X 0.500 IN. LONG (AP)	6		PAFZZN
- 2	MS9356-10	96906	NUT (AP) ..... SUPERSEDES AN121527 FOR A ENG	32	AS	PAFZZN
	MS9356-10	96906	NUT (AP) ..... SUPERSEDES AN121527 FOR A ENG	16	AT	PAFZZN
- 3	227340	52661	WASHER-KEY 0.2575 ID X 0.055 (AP)	32		PAFZZN
- 4	435348	52661	BRACKET-COMB CHMBR (AP)	2		PAFZZN
- 5	454391	52661	BRACKET-COMB CHMBR FR (AP)	6		PAFZZN
- 6	MS9357-10	96906	NUT (AP) ..... SUPERSEDES 328835 FOR A ENG	16	B/AT	PAFZZN
- 7	524325	52661	LOCK-FUEL MANF (AP)	16	B/AT	PAFZZN
- 8	490029	52661	LOCK-FUEL NOZ HSG (AP)	16	AS	PAFZZN
- 9	483263	52661	BUSHING-SLV 0.260 X 0.440 X 0.459, ... FLG (AP)	12		PAFZZN
	483268	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, ... RIGHT, PREFERRED U/W 483266 MANF SET	1	AS	PAFDDT
	483267	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, ... LEFT, PREFERRED U/W 483266 MANF SET	1	AS	PAFDDT
	563217	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, ... RIGHT, PREFERRED U/W 524342 MANF SET SUPERSEDES 524311	1	B/AT	PAFDDT
	563215	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, ... LEFT, PREFERRED U/W 524342 MANF SET SUPERSEDES 524340	1	B/AT	PAFDDT
- 10	218406	52661	..SEAL-FUEL NOZ, ALSO REQD FOR SVCE ... REPAIR OF FUEL MANF AND NOZ ASSY	24		PAFZZN
	749885	52661	..SEAL-FUEL NOZ, ALSO REQD FOR SVCE ... REPAIR OF FUEL MANF AND NOZ ASSY	24		PAFZZN
- 11	431839	52661	..WASHER-KEY, FUEL NOZ	24		PAFZZN
	157872	52661	..TABWASHER-FUEL NOZ, AIR FORCE ..... ASSIGNED APPLICATION	48		
	481694	52661	..NOZZLE ASSEMBLY-FUEL, REPAIR KIT ..... 500072 AVAILABLE	24	AU	PAFDDT
- 12	484454	52661	...NUT-FUEL NOZ	1	AU	PAFZZN
	484455	52661	...NOZZLE SET-FUEL	1	AU	ADD---
- 13	267629	52661	....RING-RTNG 0.750 OD X 0.040 WIDE .... X 0.0165 IN. THK	1	AU	KD---
- 14	739595	52661	....NOZZLE-FUEL	1	AU	PADBZN
- 15	739596	52661	....NOZZLE-FUEL	1	AU	PADBZN
- 16	739597	52661	....METERING PLUG-NOZZLE	1	AU	PADBZN
- 17	484452	52661	...STRAINER ELEMENT-SCREEN 0.495	1	AU	KD---

CONTINUED

FIGURE INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27			ID X 0.756 OD X 0.00375 IN. THK			
- 18	267630	52661	...RING-RTNG 0.813 OD X 0.040 WIDE ..... X 0.0165 IN. THK	1	AU	KD----
- 19	267631	52661	...RING-RTNG 0.453 OD X 0.040 WIDE ..... X 0.0165 IN. THK	1	AU	KD----
- 20	267627	52661	...SPRING-HLCPS 0.213 OD X 0.036 ..... IN. DIA WIRE	1	AU	PADZZN
- 21	267626	52661	...SUPPORT-FUEL NOZ	1	AU	PADZZN
- 22	267632	52661	...RING-RTNG 0.312 HSG DIA X 0.015 ..... IN. THK	1	AU	KD----
- 23	267624	52661	...FLANGE-FUEL NOZ	1	AU	PADZZN
- 24	368448	52661	...SPRING-HLCPS 0.246 OD X 0.159 ..... IN. DIA WIRE	1	AU	PADZZN
- 25	484453	52661	...STRAINER ELEMENT-SLV 0.255 X ..... 0.424 IN. LONG	1	AU	PADZZN
- 26	267625	52661	...FLANGE-FUEL NOZ	1	AU	PADZZN
- 27	267623	52661	...RING-RTNG 0.156 SHAFT DIA X ..... 0.025 IN. THK	1	AU	KD----
	500072	52661	..PARTS KIT-REPAIR, FOR REPAIR OF ..... 481694 FUEL NOZ	1	AU	
	663430	52661	..NOZZLE ASSEMBLY-FUEL, REPAIR KIT ..... 546104 AVAILABLE SUPERSEDES 518126	24	B/AV	PAFDDT
- 28	663429	52661	...NUT-FUEL NOZ ..... SUPERSEDES 484454	1	B/AV	PAFZZN
	520202	52661	...NOZZLE ASSEMBLY-FUEL	1	B/AV	ADD---
	749743	52661	....NOZZLE SET-FUEL	1	B/AV	ADD---
- 29	539512	52661	....STRAINER ELEMENT-SLV 0.4881	1	B/AV	PADZZN
- 30	739598	52661	....NOZZLE-FUEL	1	B/AV	PADBZN
- 31	739599	52661	....NOZZLE-FUEL	1	B/AV	PADBZN
- 32	739597	52661	....METERING PLUG-FUEL NOZ	1	B/AV	PADBZN
- 33	520205	52661	....RING-RTNG 0.750 HSG DIA X 0.035 .... IN. THK	1	B/AV	PADZZN
- 34	267627	52661	....SPRING-HLCPS 0.213 OD X 0.036 ..... IN. DIA WIRE	1	B/AV	PADZZN
- 35	267626	52661	....SUPPORT-FUEL NOZ	1	B/AV	PADZZN
- 36	520204	52661	....RING-RTNG, FUEL NOZ	1	B/AV	PADZZN
- 37	267624	52661	....FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 38	368448	52661	....SPRING-HLCPS 0.246 OD X 0.159 ..... IN. DIA WIRE	1	B/AV	PADZZN
- 39	484453	52661	....STRAINER ELEMENT-SLV 0.255 X 0.424	1	B/AV	PADZZN
- 40	267625	52661	....FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 41	520203	52661	....RING-RTNG, FUEL NOZ	1	B/AV	PADZZN
	546104	52661	..PARTS KIT-REPAIR, FOR REPAIR OF ..... 518126 AND 663430 FUEL NOZ ASSY	1	B/AV	PADZZN
- 42	483264	52661	..MANIFOLD-ASSY OF, FUEL, RIGHT	1	AS	XA----
- 43	483265	52661	..MANIFOLD-ASSY OF, FUEL, LEFT	1	AS	XA----
- 44	348338	52661	...SLEEVE HALF-REINFORCING, TUBE	32	AS	PADZZN
- 45	531386	52661	...INSULATION BLANKET-FUEL MANF ..... SUPERSEDES 336534 FOR A ENG	1	AS	XB----
- 46	531388	52661	...INSULATION BLANKET-FUEL MANF ..... SUPERSEDES 219224 FOR A ENG	1	AS	XB----

CONTINUED

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27			SUPERSEDES 511714 FOR A ENG			
- 47	531385	52661	...INSULATION BLANKET-FUEL MANF	3	AS	XB---
			SUPERSEDES 336535 FOR A ENG			
- 48	358279	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 49	358280	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 50	358289	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 51	358291	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 52	358203	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 53	358202	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 54	358288	52661	...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 55	358287	52661	...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 56	358293	52661	...SHIELD-HEAT, LEFT FUEL MANF	3	AS	PADZZN
	358293	52661	...SHIELD-HEAT, RIGHT FUEL MANF	2	AS	PADZZN
- 57	358292	52661	...SHIELD-HEAT, LEFT FUEL MANF	4	AS	PADZZN
	358292	52661	...SHIELD-HEAT, RIGHT FUEL MANF	3	AS	PADZZN
- 58	358290	52661	...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 59	358295	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 60	358294	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 61	358206	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 62	358205	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 63	531384	52661	...INSULATION BLANKET-FUEL MANF	8	AS	XB---
			SUPERSEDES 253818			
- 64	375060	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 65	358286	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 66	375059	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 67	375057	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 68	358281	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 69	375058	52661	...SHIELD-HEAT,FUEL MANF	4	AS	PADZZN
- 70	531389	52661	...INSULATION BLANKET-FUEL MANF	1	AS	XB---
			SUPERSEDES 253819 FOR A ENG			
- 71	531387	52661	...INSULATION BLANKET-FUEL MANF	3	AS	XB---
- 72	358278	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 73	358204	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 74	261803	52661	...FERRULE-FUEL MANF	1	AS	PADZZN
- 75	483776	52661	...SLEEVE-FUEL NOZ	24	AS	PADZZN
	563218	52661	..BRACKET AND MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA---
			SUPERSEDES 525041			
	563216	52661	..BRACKET AND MANIFOLD-ASSY OF, FUEL, LEFT	1	B/AT	XA---
			SUPERSEDES 525040			
- 76	483260	52661	...BRACKET-ASSY OF, FUEL MANF	3	B/AT	PAFBZN
- 77	303328	52661	...BOLT-MACH, DRILLED DBL HEX ..... 0.250-28 X 0.625 IN. LONG	6	B/AT	PAFZZN
- 78	454393	52661	...NUT-PLAIN, MULTIPLE 0.250-28 ..... X 0.560 IN. LONG	3	B/AT	PAFZZN
- 79	525041	52661	...MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA---
- 80	525040	52661	...MANIFOLD-ASSY OF, FUEL, LEFT	1	B/AT	XA---
- 81	348838	52661	...SLEEVE HALF-REINFORCING TUBE	32	B/AT	PADZZN
- 82	524324	52661	....WASHER-SHLDR 0.535 X 0.750	16	B/AT	PADZZN
- 83	531386	52661	....INSULATION BLANKET-FUEL MANF	1	B/AT	XB---
- 84	531388	52661	....INSULATION BLANKET-FUEL MANF	1	B/AT	XB---
- 85	531385	52661	....INSULATION BLANKET-FUEL MANF	3	B/AT	XB---

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27 - 86	358279	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 87	358280	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 88	358203	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 89	358202	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 90	358289	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 91	358291	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 92	358288	52661	....SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 93	358287	52661	....SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 94	358293	52661	....SHIELD-HEAT, LEFT FUEL MANF	3	B/AT	PADZZN
	358293	52661	....SHIELD-HEAT, RIGHT FUEL MANF	2	B/AT	PADZZN
- 95	358292	52661	....SHIELD-HEAT, LEFT FUEL MANF	4	B/AT	PADZZN
	358292	52661	....SHIELD-HEAT, RIGHT FUEL MANF	3	B/AT	PADZZN
- 96	358290	52661	....SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 97	358295	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 98	358294	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 99	358206	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-100	358205	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-101	531384	52661	....INSULATION BLANKET-FUEL MANF	8	B/AT	XB---
-102	375060	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-103	358286	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-104	375059	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-105	375057	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-106	358281	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-107	375058	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-108	531389	52661	....INSULATION BLANKET-FUEL MANF	1	B/AT	XB---
-109	531387	52661	....INSULATION BLANKET-FUEL MANF	3	B/AT	XB---
-110	358278	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
-111	358204	52661	....SHIELD-HEAT, LEFT MANF	1	B/AT	PADZZN
-112	261803	52661	....FERRULE-FUEL MANF	1	B/AT	PADZZN
-113	483776	52661	....SLEEVE-FUEL NOZ	24	B/AT	PADZZN
-114	674002	52661	..HOUSING-ASSY OF, SVCE FIX FOR REWK OF FUEL NOZ ASSY	1		
-115	674003	52661	..HOUSING-ASSY OF, SVCE FIX FOR REWK OF FUEL NOZ ASSY	1		
-116	253759	52661	..PROBE-PB, RIGHT FUEL MANF	1		PAFZZN
-117	AN123176	81352	..RIVET-RIGHT FUEL MANF	1		PAFZZN
-118	515359	52661	..SPACER-RING 0.551 X 0.755 X 0.135, SVCE FIX FOR REWK OF 483264 OR 483265 FUEL MANF ASSY	8		
-119	524324	52661	..WASHER-SHLDR 0.535 X 0.750, SVCE FIX FOR REWK OF 483264 OR 483265 FUEL MANF ASSY	16		PADZZN
-120	457128	52661	GASKET-FUEL MANF INLET ADPTR	1		PAFZZN

DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 1 OF 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHG WCO	CHG WCO DATE	P/N
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358279	98034A 98043A 98042A 98057A S1		
PCN NSN P/N					PCN NSN P/N 35820	S2		
PCN NSN P/N					PCN NSN P/N 35829	S3		
PCN NSN P/N					PCN NSN P/N 35829/	S4		
PCN NSN P/N					PCN NSN P/N 358203	S5		
PCN NSN P/N					PCN NSN P/N 358202	S6		
PCN NSN P/N					PCN NSN P/N 358288	S7		
PCN NSN P/N					PCN NSN P/N 358287	S8		
PCN NSN P/N					PCN NSN P/N 358293	S9		
PCN NSN P/N					PCN NSN P/N 358293	S10		
PCN NSN P/N					PCN NSN P/N 358292	S11		
PCN NSN P/N					PCN NSN P/N 358292	S12		

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DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 ACC MATPCB SHEET 2 OF 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. P/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358290	98634A 98043A 98042A 98057A S13		
PCN NSN P/N					PCN NSN P/N 358295	S14		
PCN NSN P/N					PCN NSN P/N 358294	S15		
PCN NSN P/N					PCN NSN P/N 358206	S16		
PCN NSN P/N					PCN NSN P/N 358205	S17		
PCN NSN P/N					PCN NSN P/N 375060	S18		
PCN NSN P/N					PCN NSN P/N 358286	S19		
PCN NSN P/N					PCN NSN P/N 375059	S20		
PCN NSN P/N					PCN NSN P/N 375057	S21		
PCN NSN P/N					PCN NSN P/N 358281	S22		
PCN NSN P/N					PCN NSN P/N 375058	S23		
PCN NSN P/N					PCN NSN P/N 358278	S24		

LSC-2(XP)5A

DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 3 OF 6

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. S/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN 358204 P/N	98034A 98043A 98042A 98057A 525		
PCN NSN P/N					PCN 483776 NSN P/N ~~5266~~	526		
PCN NSN P/N					PCN 563216 NSN ~~5266~~ P/N	527		
PCN NSN P/N					PCN NSN 483260 P/N	528		
PCN NSN P/N					PCN NSN 525041 P/N	529		
PCN NSN P/N					PCN NSN 525040 P/N	530		
PCN NSN P/N					PCN NSN 358279 P/N	531		
PCN NSN P/N					PCN NSN 358280 P/N	532		
PCN NSN P/N					PCN NSN 358203 P/N	533		
PCN NSN P/N					PCN NSN 35802 P/N	534		
PCN NSN P/N					PCN NSN 358289 P/N	535		
PCN NSN P/N					PCN NSN 358291 P/N	536		

LSC-2(XP)SA

DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 NCC MATPCB SHEET 4 OF 6

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. P/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358288	98034A 98043A 98042A 98057A 537		
PCN NSN P/N					PCN NSN P/N 358287	538		
PCN NSN P/N					PCN NSN P/N 358293	539		
PCN NSN P/N					PCN NSN P/N 358293	540		
PCN NSN P/N					PCN NSN P/N 358292	541		
PCN NSN P/N					PCN NSN P/N 358290	542		
PCN NSN P/N					PCN NSN P/N 358295	543		
PCN NSN P/N					PCN NSN P/N 358294	544		
PCN NSN P/N					PCN NSN P/N 358206	545		
PCN NSN P/N					PCN NSN P/N 358205	546		
PCN NSN P/N					PCN NSN P/N 375060	547		
PCN NSN P/N					PCN NSN P/N 358286	548		

LSC-20XP/5A

DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 5 OF 15

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 375059	98034A 98043A 549 98042A 98057A		
PCN NSN P/N					PCN NSN P/N 375057	550		
PCN NSN P/N					PCN NSN P/N 358281	551		
PCN NSN P/N					PCN NSN P/N 375058	552		
PCN NSN P/N					PCN NSN P/N 358278	553		
PCN NSN P/N					PCN NSN P/N 358204	554		
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-2(XP)SA

TF 33 MANIFOLD

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/7/89 RCC MATAB SHEET 1 OF 4

ITEM CODE (PCN) NSN P/N 98034A, ~~98042A~~, ~~98045A~~, ~~98057A~~ WCD CTEC04 WCD DATE 87110

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
IN	MAT REC	IN DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	32									
010		GFEC	1.0	~~TRANSIT~~	0.1	OP07	001	100	01					
				~~SETUP~~										
				PROCESS										
020		SA	.33 (ONCE/SHIFT)	~~TRANSIT~~	0.4			100	0.4	OC 1132	001	100	9.4	SET UP TEST STAND ONCE/DAY. MOISTURE FACTOR IS VIOLATED FAIL THROUGHOUT OF 3-5 MANIFOLDS SEE UAT 012 OC 1133
			.13	SETUP										
				~~PROCESS~~										
030		LOAD	1.0	~~TRANSIT~~	.31			100	.01	OC 1132	001	100	.01	MOUNT ONE MANIFOLD HALF ON TEST STAND. (ONLY ONE SET OF HOSES IS AVAILABLE, SO TWO HALVES CANNOT BE DONE TOGETHER. UP 1133
				SETUP										
				~~PROCESS~~										
040		SA	.40 .25 SEE COMMENTS	~~TRANSIT~~	.1			100	.1					CHANGE CLAMP TIPS AT BEGINNING OF SHIFT ALWAYS THEREAFTER AS REQUIRED FOR WEARING. (.25 - 2 MIN SETUP ONLY) (.40 - SETUP PLUS CLEARANCE)
				SETUP										
				~~PROCESS~~										

OPERATION PROFILE

NAME E. TOTTEN ALC 0C DATE 5/7/89 RCC MATRB SHEET 3 OF 4

ITEM CODE (PCN) NSN 98034A, ~~98042A~~, P/N ~~98043A~~, ~~98059A~~ WCD CTEC04 WCD DATE 87110

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	~~INCOMING~~	0.2	QP09	001	100	0.2	OC 1132	001	100	0.2	REMOVE PROTECTIVE CAPS OF OC 1133
				~~SETUP~~										
				PROCESS										
060		PROC	1.0	~~INCOMING~~	0.02			100	0.02				0.02	INSTALL CLAMPS ON NOZZLES
				~~SETUP~~										
				PROCESS										
070		TEST	1.0	~~INCOMING~~	0.02			100	0.02				0.02	PERFORM NOZZLE SNAP TESTS: FLOW & SPEAK; SECONDARY TESTS THAN PRIMARY (ASSUME NO FAIL. IF FAIL INSTALL CAPS ON BAD NOZZLE(S))
				~~SETUP~~										
				PROCESS										
080		TEST	1.0	~~INCOMING~~	0.12			100	0.12				0.12	PERFORM INTERNAL LEAK TEST. IF FAIL FOR OTHER THAN NOZZLE RETURN REJECTED TO SUBASSY. IF NOZZLE FAIL GO TO 120.
				~~SETUP~~										
				PROCESS										
090	↓	TEST	1.0	~~INCOMING~~	0.2			100	0.2				0.2	PERFORM EXTERNAL LEAK TEST. IF NOZZLE FAIL, GO TO 120.
				~~SETUP~~										
				PROCESS		↓	↓			↓	↓	↓		(CAGE FAILURE)

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/9/89 RCC MATAB SHEET 3 OF 4

ITEM CODE (PCN) NSN P/N 98034A, ~~98042A~~, ~~98043A~~, 98057A WCD CTEC04 WCD DATE 87110

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MBT BAB	PROC	1.0	[illegible]	0.02	AJ09	001	100	0.02	OC 1172	001	100	0.02	REMOVE NOZZLE CLAMPS
				SETUP										
				PROCESS										OF DC
110		PROC	.8	[illegible]	0.05			1.0	0.05			1.0	0.05	BARE FACE NOZZLE SEATS IF INTERNAL LEAK TEST FAILED. (ISOLATE LEAKING NOZZLES.)
				SETUP	3.5			98.5	3.5			98.5	3.5	
				PROCESS	6.0			0.5	6.0			0.5	6.0	
120		REPL	.80	[illegible]	0.05			100	0.05			100	0.05	REPLACE NOZZLE AND SEAL IF SPRAY TEST, INTERNAL OR EXTERNAL LEAK TEST FAILS AND NOZZLE IS CAUSE. (TIME TO REPLACE SINGLE NOZZLE)
				SETUP										
				PROCESS										
130		CLEAN	1.0	[illegible]	0.8			100	0.8			100	0.8	OIL FLUSH MANIFOLD — REMOVE RESIDUAL FUEL
				SETUP										
				PROCESS										
140		PROC	1.0	[illegible]	0.01			100	0.01			100	0.01	INSTALL HEAD GASKET FOR TRANSIT.
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/9/89 RCC MATACB SHEET 4 OF 4

ITEM CODE PCN 98034A ~~98034A~~, NSN ~~98034A~~, P/N ~~98034A~~, WCD CTEC04 WCD DATE 87110

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCB	UNLD	1.0	~~TRANSIT~~	0.01	DP09	001	100	0.01					REMOVE MANIFOLD FROM TEST STAND AND PLACE ON CART.
				~~SETUP~~										
				PROCESS										
160		(PLI)	1.0	~~TRANSIT~~	0.05			100	0.05					COMPLETE PAPERWORK
				~~SETUP~~										
				PROCESS										
170		MOVE	1.0	TRANSIT	0.1			50	0.1					MOVE MANIFOLD TO PICK UP AREA IN BLDG 3108 (MONORAIL) PLACE ON CONVEYOR.
				~~SETUP~~	0.2			50	0.2					
				~~PROCESS~~										
9999		OUT DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	36									
				TRANSIT										COMMENT: SEVERAL TIMES DURING OPERATION OPERATOR MUST SWAB EXCESS OIL OFF OF FLOOR AT TEST STAND
				SETUP										
				PROCESS										

17, 18, 19, 20 B

FLOW PROCESS CHART

SUBJECT TF33 MANIFOLD DATE 5/7/89

ITEM CODE PCN NSN P/N

WCD CTEC04 WCD DATE 87110

98034A, ~~98042A~~, ~~98043A~~, ~~98045A~~

CHART BEGINS

CHART ENDS PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010		○●D□▽	RECEIVE & MOVE MANIFOLD TO TEST STA.			○◇D□▽	
020		○◇●□▽	SETUP TEST MANIFOLD			○◇D□▽	
030		●◇D□▽	MOUNT MANIFOLD ON TEST STAND			○◇D□▽	
040		○◇●□▽	CHANGE NOZZLE CLAMP TIPS			○◇D□▽	
050		●◇D□▽	REMOVE NOZZLE CAPS			○◇D□▽	
060		●◇D□▽	INSTALL NOZZLE CLAMPS			○◇D□▽	
070	010	●◇D□▽	PERFORM SPRAY TEST			○◇D□▽	
080	020	●◇D□▽	PERFORM INTERNAL LEAK TEST			○◇D□▽	
090	010, 040	●◇D□▽	PERFORM EXTERNAL LEAK TEST			○◇D□▽	
100		●◇D□▽	REMOVE NOZZLE CLAMPS			○◇D□▽	
110	025	●◇D□▽	FLAME FACE NOZZLE SEATS			○◇D□▽	
120		●◇D□▽	REPLACE NOZZLE AND SEAL			○◇D□▽	
130		●◇D□▽	OIL FLUSH MANIFOLD			○◇D□▽	
140		●◇D□▽	INSTALL HEAD GASKET			○◇D□▽	
150		●◇D□▽	REMOVE MANIFOLD FROM TEST STAND			○◇D□▽	
160		●◇D□▽	COMPLETE PAPERWORK			○◇D□▽	
170		○●D□▽	MOVE MANIFOLD TO PICKUP AREA			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
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		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

DISASSEMBLY/ASSEMBLY P..OFILE

NAME KOBYLIC ALC OC-ALC DATE 01JUN89 RCC MATCBE SHEET ___ OF ___

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
(PCN) 98034A ~~98043A~~ ~~98012A~~ NSN P/N ~~98034A~~	CRECO4	89087	044	290	(PCN) NSN P/N			N
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
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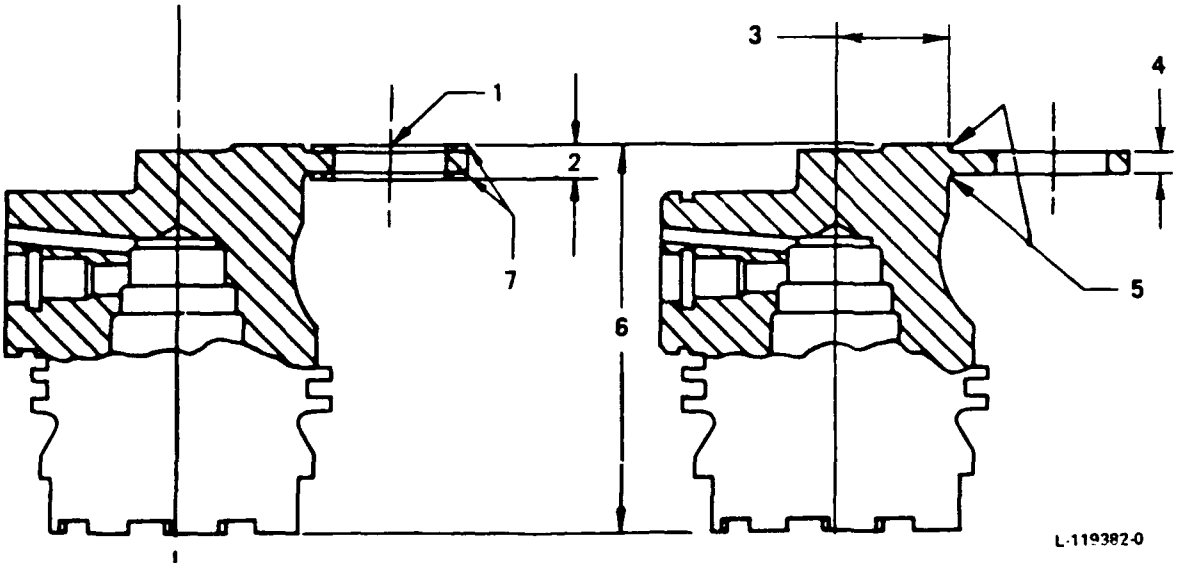
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

LSC-2XXXJA

TABLE 2. FUEL MANIFOLD DISTORTION LIMITS

Location Measurement	Acceptable As Is	Cold Bend	Cold Bend and Stress-relief
Inner nozzle cluster lugs to mounting surface	0.188 inch	0.312 inch	0.750 inch
Variations between inner lugs of each cluster	0.094 inch	0.219 inch	0.281 inch
Outer nozzle cluster lugs to mounting surface	0.062 inch	0.188 inch	0.250 inch
Variations between outer nozzle cluster lugs on each cluster	0.094 inch	0.156 inch	0.219 inch
Nozzle bodies to mounting lugs	0° 45'	1° 30'	-
Distance A. (See figure 3.)	20.160 ±0.500 inch	20.160 ±0.625 inch	20.160 ±2.000 inch
Distance B. (See figure 3.)	11.615 ±0.060 inch	11.615 ±0.185 inch	11.615 ±0.375 inch
Inner lug hole centers alignment with fixture holes	0.094 inch	0.156 inch	0.188 inch
Outer lug hole centers alignment with fixture holes	0.031 inch	0.062 inch	-
Misalignment of inlet flange with fixture	0.080 inch	0.080 - 0.160 inch	0.160 - 0.375 inch



1. 0.542 - 0.552 inch diameter through hole
2. 0.177 - 0.181 inch
3. 0.550 - 0.570 inch
4. 0.060 - 0.070 inch for parent metal buildup; 0.150 - 0.157 inch for hardface buildup
5. 0.016 - 0.047 inch radius
6. 1.945 - 1.955 inches
7. Weld build up (hardface overlay)

Figure 5. Worn Inner Mounting Lug - Inspection and Repair

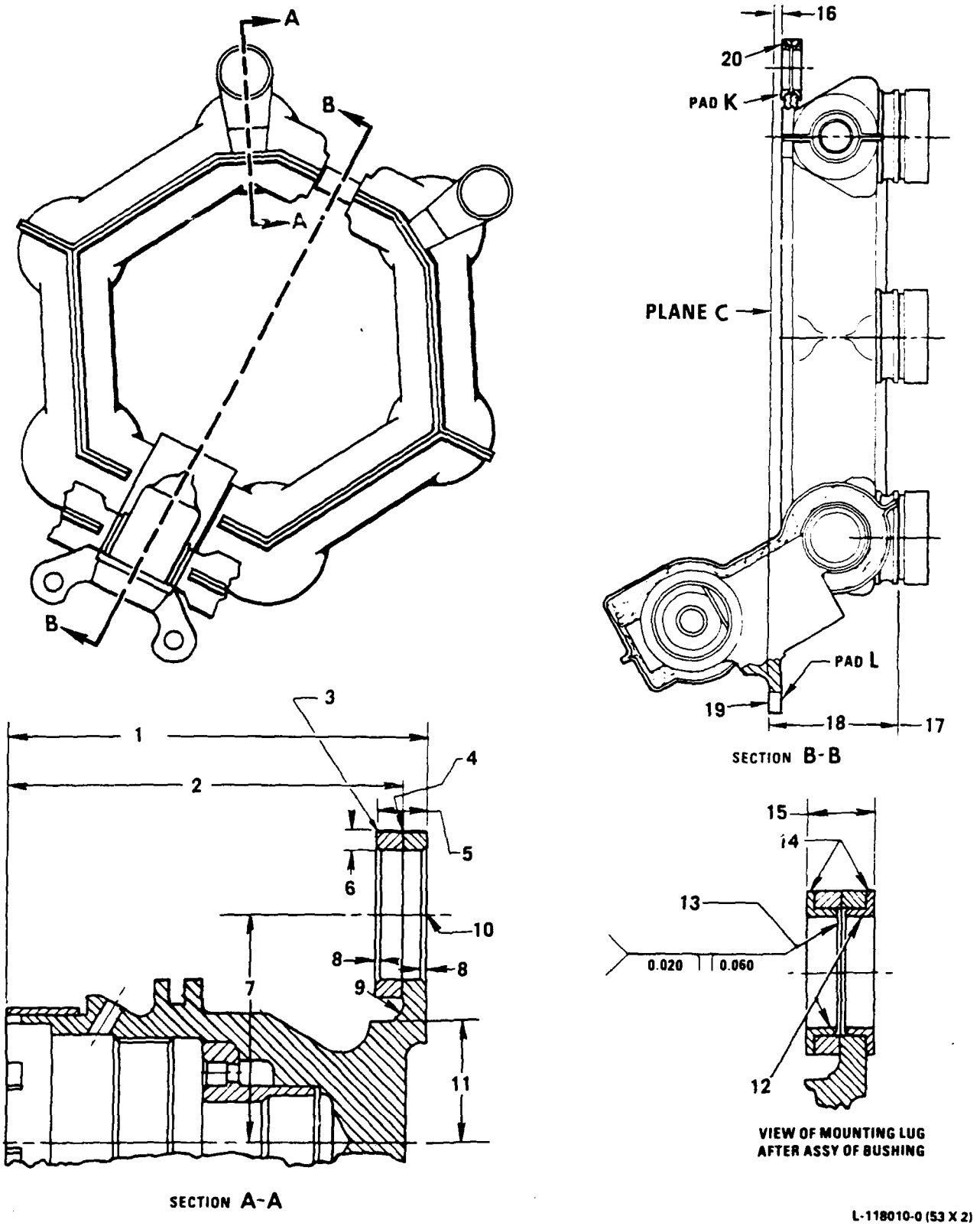
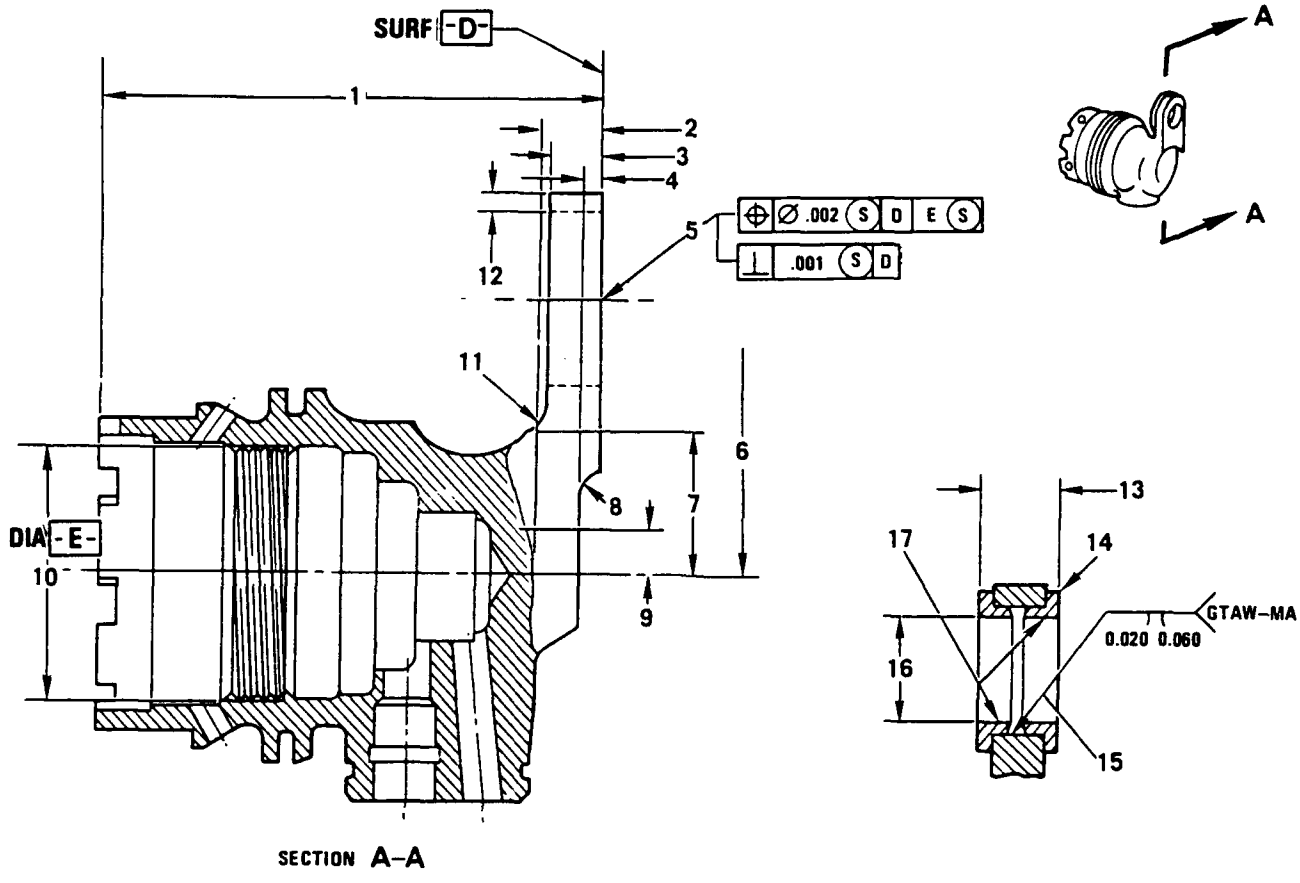
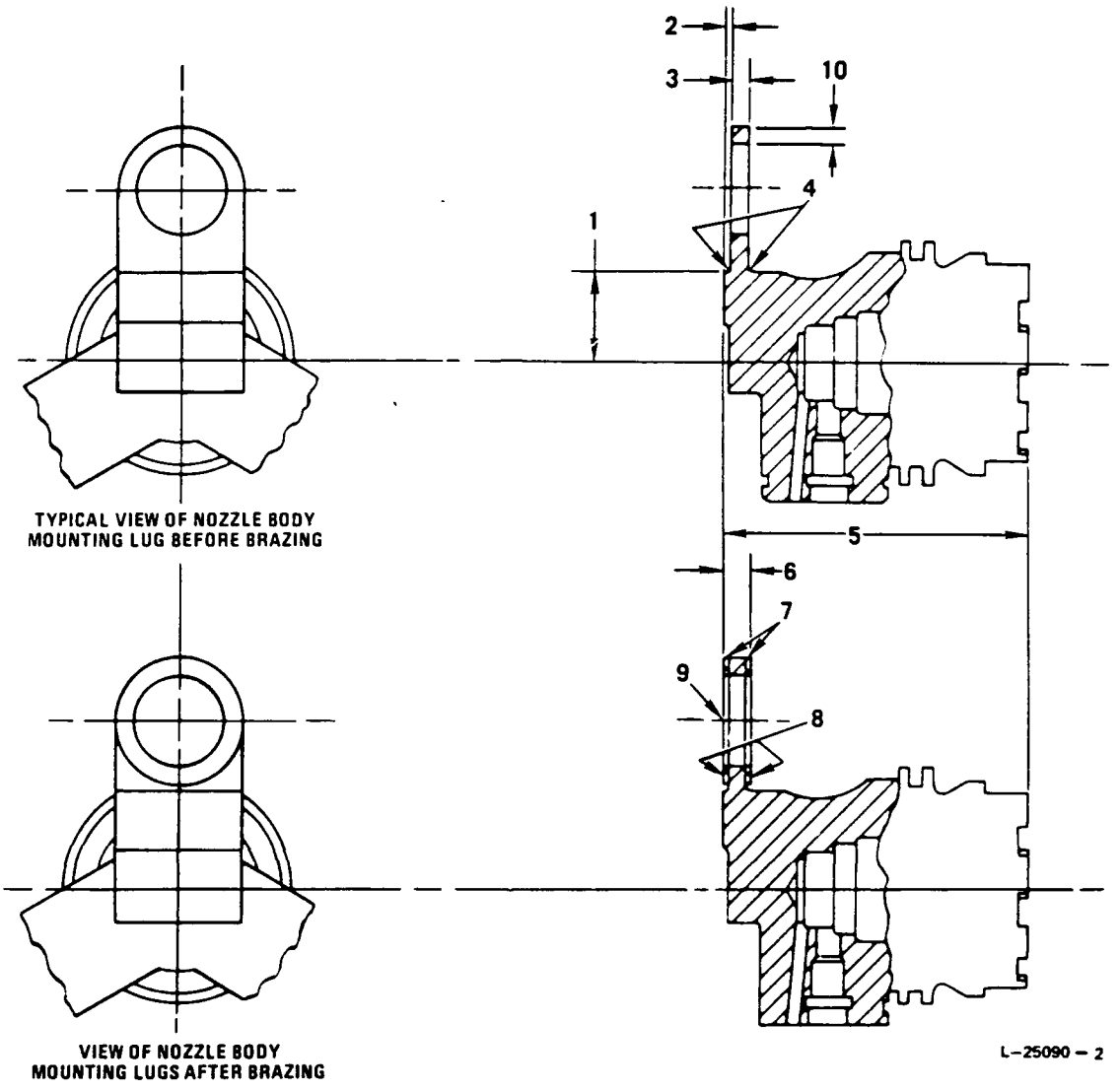


Figure 6. Inner Mounting Lug Bushings Incorporating Spacer - Inspection and Repair



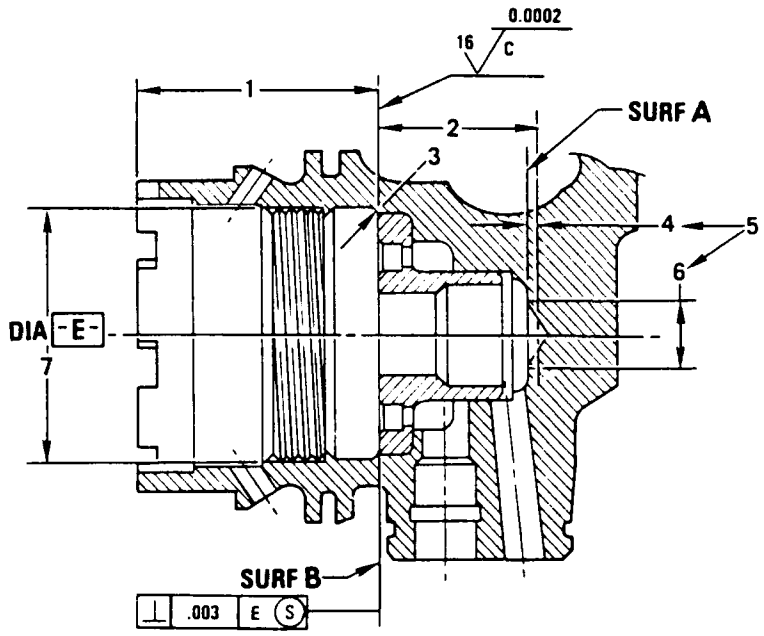
1. 1.912 to 1.918 inches
2. 0.235 to 0.255 inch
3. 0.229 to 0.231 inch
4. 0.075 to 0.095 inch
5. 0.5935 to 0.5945 inch diameter through. Chamfer 90° ±2° inclusive to 0.620 to 0.640 inch diameter, both sides.
6. 1.038 inches
7. 0.550 to 0.570 inch
8. 0.047 to 0.078 inch radius
9. 0.150 inch gage
10. Pitch diameter of threads
11. 0.047 to 0.078 inch radius
12. 0.050 inch minimum thickness (P-7A, PW-100A);
    0.070 inch minimum thickness (P-3, -5, -9, -11A, PW-102, -102A, -103)
13. 0.295 to 0.305 inch
14. PN 524324 bushing, 16 required
15. Two places, 180° ±5° apart
16. 0.520 inch minimum diameter through
17. Weld shall not extend above these surfaces.

Figure 7. Inner Mounting Lug Bushings Not Incorporating Spacers - Inspection and Repair



1. 0.550 to 0.570 inch
2. 0.025 to 0.035 inch
3. 0.115 to 0.125 inch
4. 0.016 to 0.047 inch
5. 1.945 to 1.955 inches
6. 0.177 to 0.181 inch
7. Braze area.
8. Reinforcing plate located within 0.010 inch of true position
9. 0.542 to 0.552 inch diameter through hole
10. 0.050 inch minimum thickness

Figure 8. Inner Mounting Lugs Incorporating Reinforcing Plate - Inspection and Repair



1. 0.937 inch maximum after finishing. Maintain 0.906 inch minimum diameter.
2. 0.568 inch minimum
3. 0.005 to 0.015 inch modified radius
4. 0.015 inch maximum
5. After finishing Surface B, machine Surface A within these limits, as required, to maintain dimension(2).
6. 0.220 to 0.240 inch diameter
7. Pitch diameter of threads

Figure 11. Fuel Manifold Nozzle Body Seal Seat - Repair

(2) Complete lapping using PWA 8575 lap tool and Corundum 302 1/2E grit lapping compound, or equivalent. Restore original surface finish to Surface B per figure 11.

(3) Check Surface B using AF 7825139 air gage spindle and AF 7825140 master gage assembly or AF 8147845 dial indicator.

(4) Relap if Surfaces A and B are not in same plane within 0.0005 inch.

(5) If seal depth(1, figure 11) exceeds 0.932 inches, tap nozzle body per paragraph 27 and add additional thread to nozzle body threads.

(6) After final lapping, clean and flush manifolds per paragraphs 5 and 6.

14. WORN NOZZLE BODIES (WITH SLEEVES REMOVED) - REPAIR. (See Figures 12 through 14.)

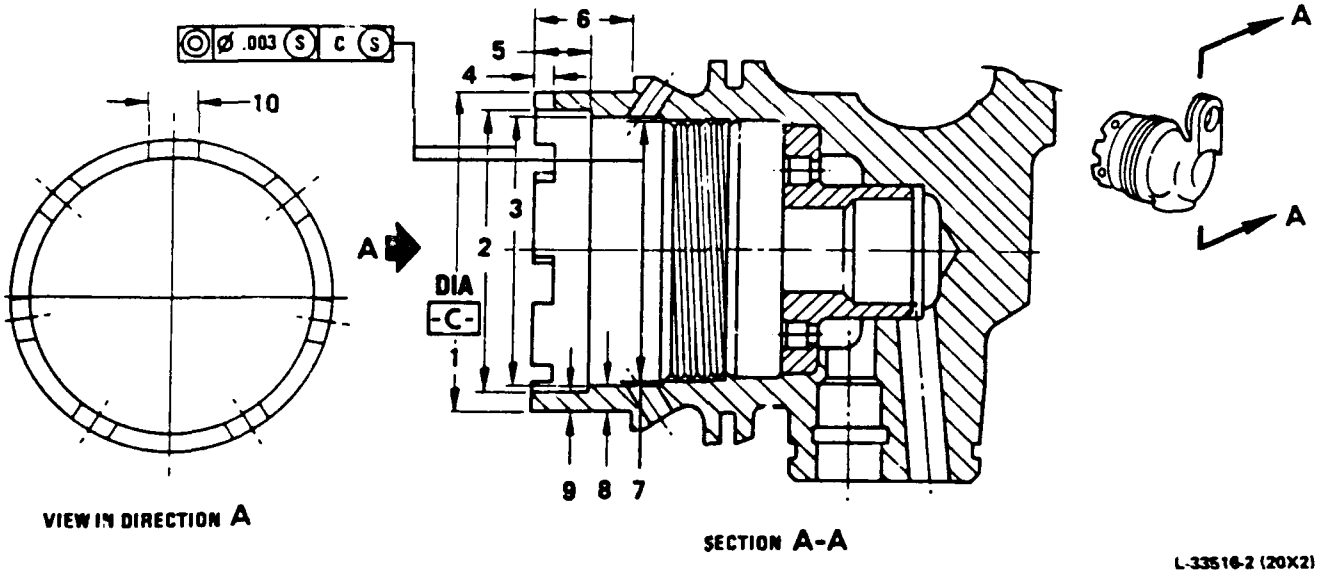
CAUTION

Prevent entry of dirt, machine chips, and other foreign materials into manifold.

NOTE

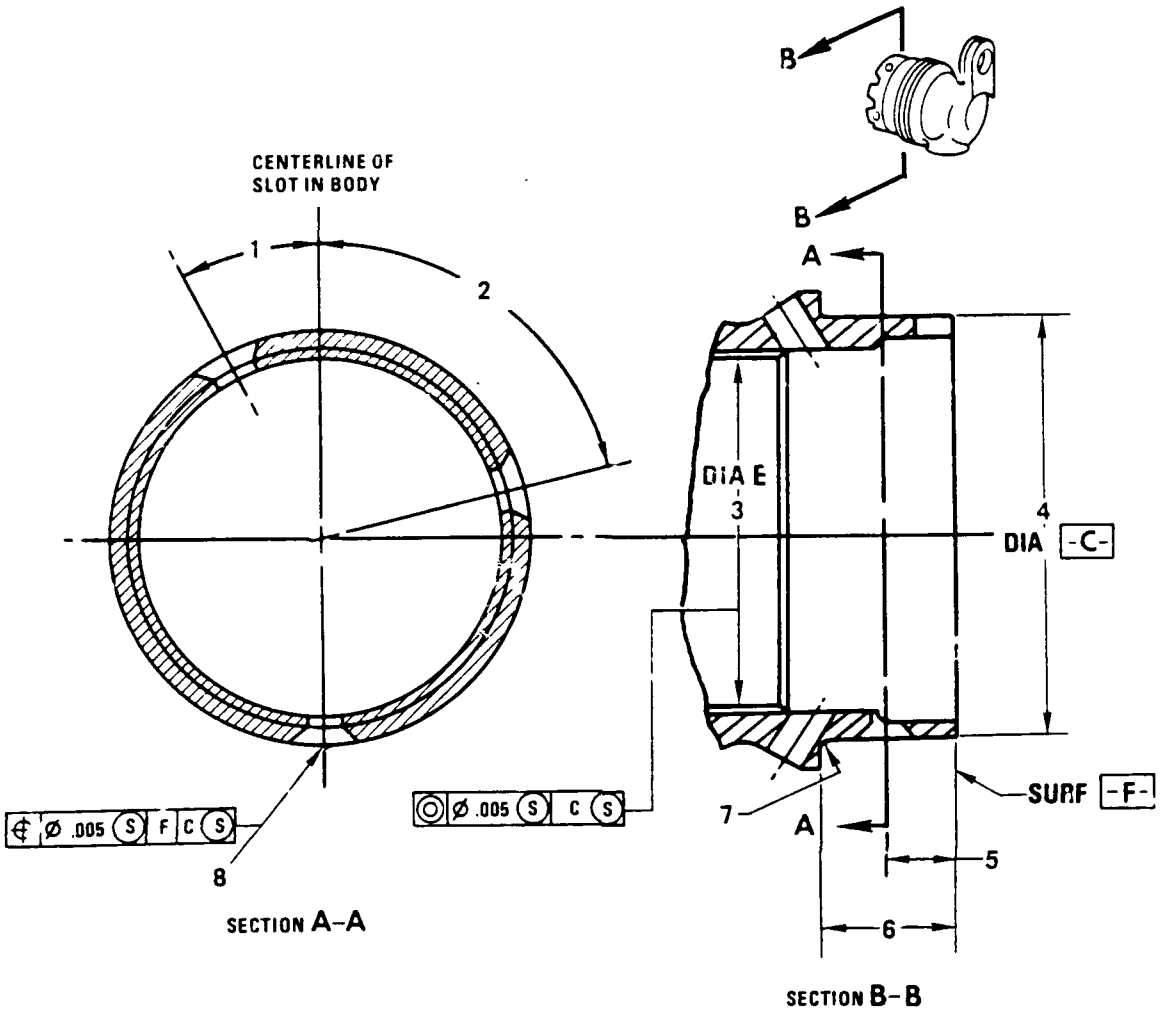
This procedure shall be used for all parts exceeding wear limits per figure 12.

a. Clamp PWA 16667 holding fixture to base of radial drill, or equivalent. Spindle of machine shall be equipped with locking floating tool holder.



1. 1.160 to 1.161 inch diameter
2. 1.070 to 1.080 inch diameter
3. 1.010 to 1.014 inch diameter
4. 0.070 to 0.080 inch, 7 places
5. 0.210 to 0.220 inch
6. 0.358 to 0.362 inch
7. Pitch diameter of threads
8. 0.080 to 0.091 inch
9. 0.040 inch minimum wall thickness
10. 0.176 to 0.180 inch. 7 slots equally spaced and located within 0.005 inch either side of true position in relation to diameter(2). Angular relation to features not important.

Figure 12. Nozzle Body Outside Diameter - Repair



1. 25° 43'
2. 77° 9'
3. 1.00 - 28 NS thread, 0.9790 inch pitch diameter
4. 1.160 - 1.161 inch diameter
5. 0.200 inch
6. 0.358 - 0.362 inch
7. 0.005 - 0.020 inch radius
8. Three holes, equally spaced and located as shown.
   0.136 - 0.146 inch diameter through.
   Chamfer 90° ±5° to 0.178 - 0.198 inch diameter.

Figure 13. Nozzle Body Outside Diameter - Repair

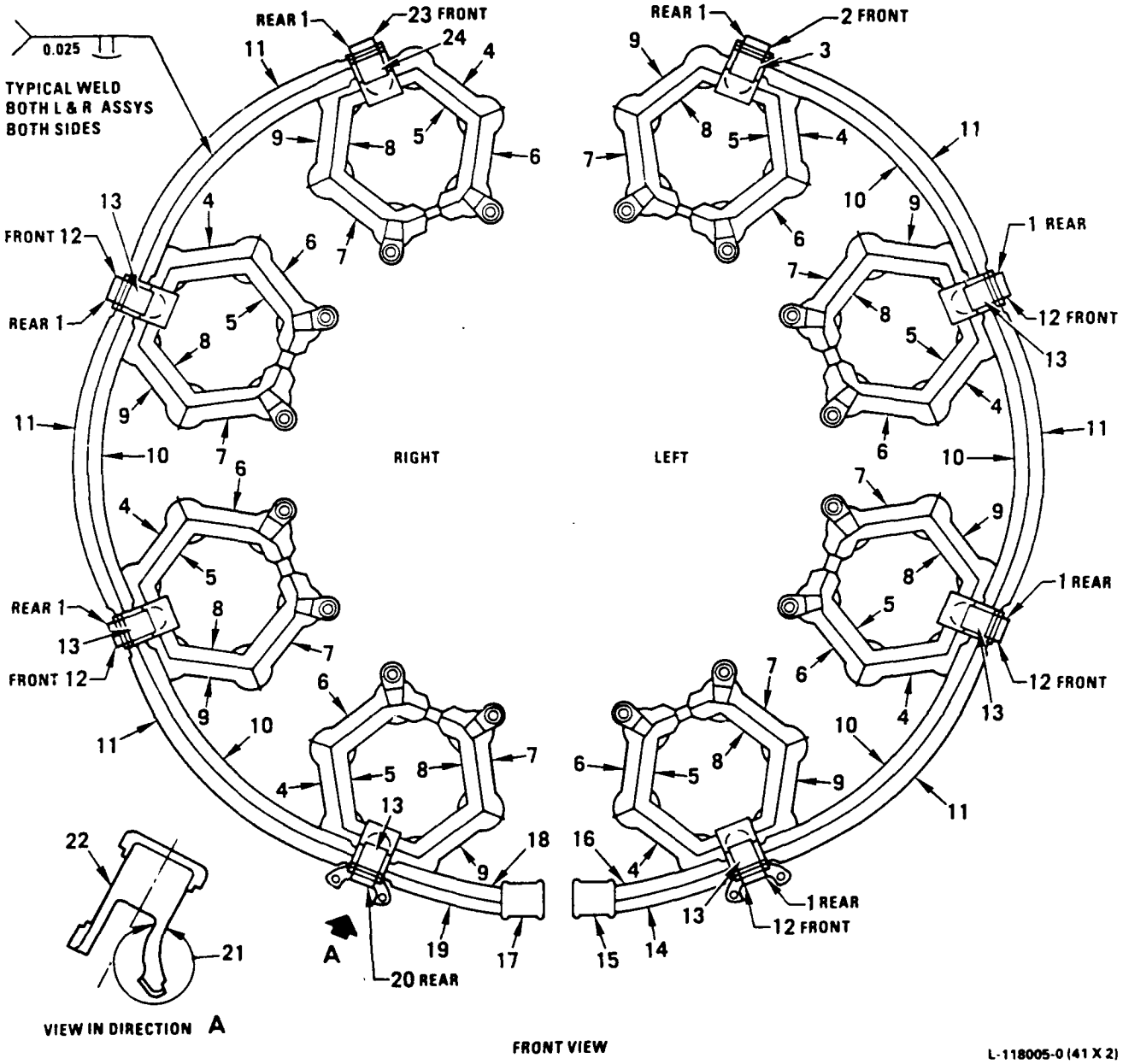


Figure 15. Location of Fuel Manifold Heat Shields

Legend to figure 15

	Heat Shield Part No.	Units Per Right Manifold and Nozzle Assembly	Units Per Left Manifold and Nozzle Assembly
1.	358292	3	4
2.	358205	0	1
3.	358206	0	1
4.	358286	4	4
5.	375060	4	4
6.	375059	4	4
7.	375058	4	4
8.	375057	4	4
9.	358281	4	4
10.	358288	3	3
11.	358287	3	3
12.	358293	2	3
13.	358290	3	3
14.	358202	0	1
15.	358204	0	1
16.	358203	0	1
17.	358278	1	0
18.	358279	1	0
19.	358280	1	0
20.	358289	1	0
21.	Enclosed area may be twisted 90° counter-clockwise to allow assembly of heat shield. Twist back after assembly.		
22.	358291	1	0
23.	358294	1	0
24.	358295	1	0

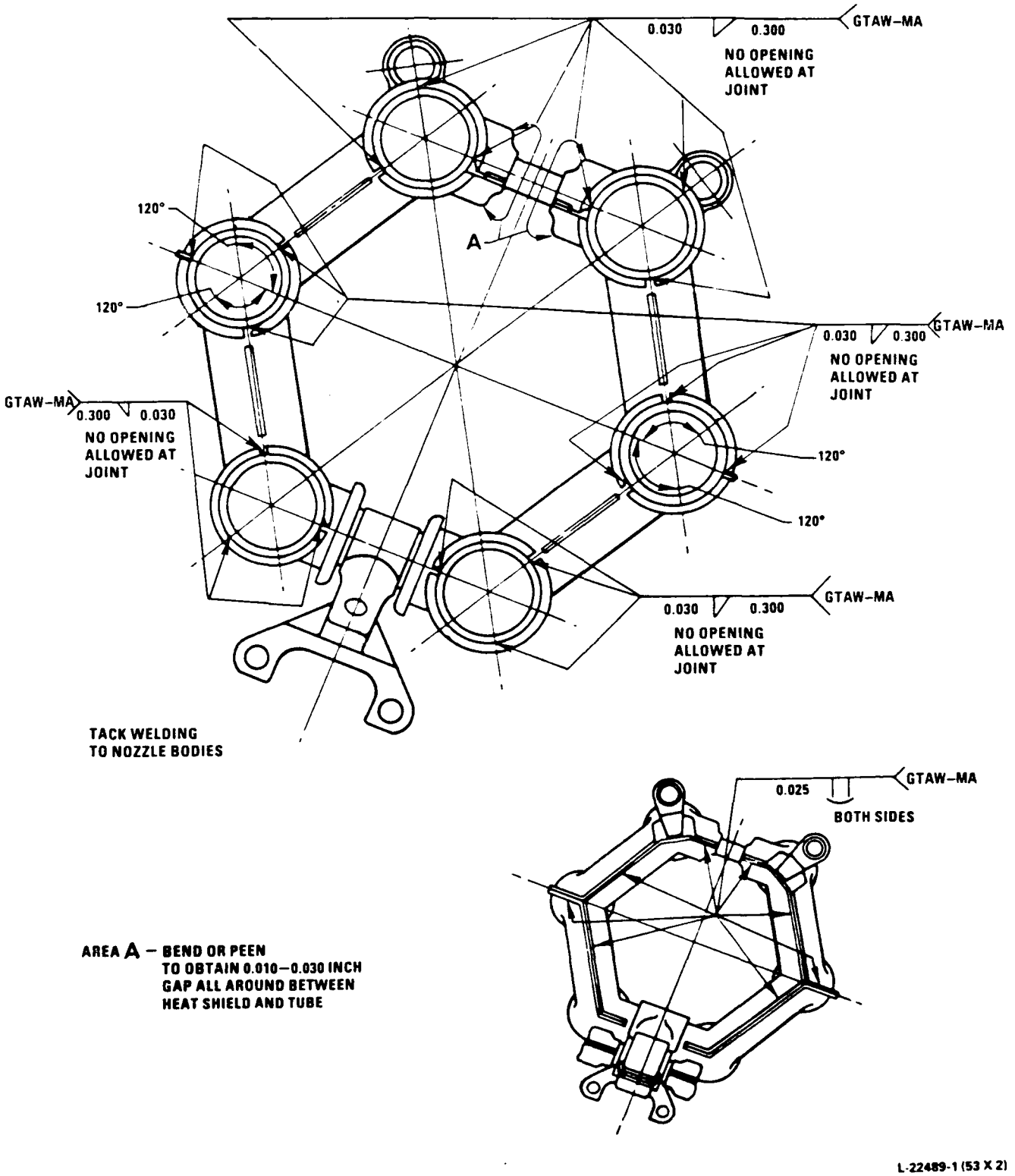


Figure 16. Welding of Clusters (Typical) Eight Places

CAUTION

- Due to variations in heat shields and fuel line details and because of distorted or dented heat shields, caution shall be taken in drilling holes. Refer to assembly drawing when in doubt. Holes may deviate from this drawing only to avoid hitting fuel lines.

- After drilling, examine fuel tubes through hole to ensure tube has not been damaged.

(2) Secure manifold to PWA 6983, PWA 8376 or PWA 17921 fixture. Drill holes in manifold shielding as shown in figure 18, Sheets 1 through 3. Drill only to depth required.

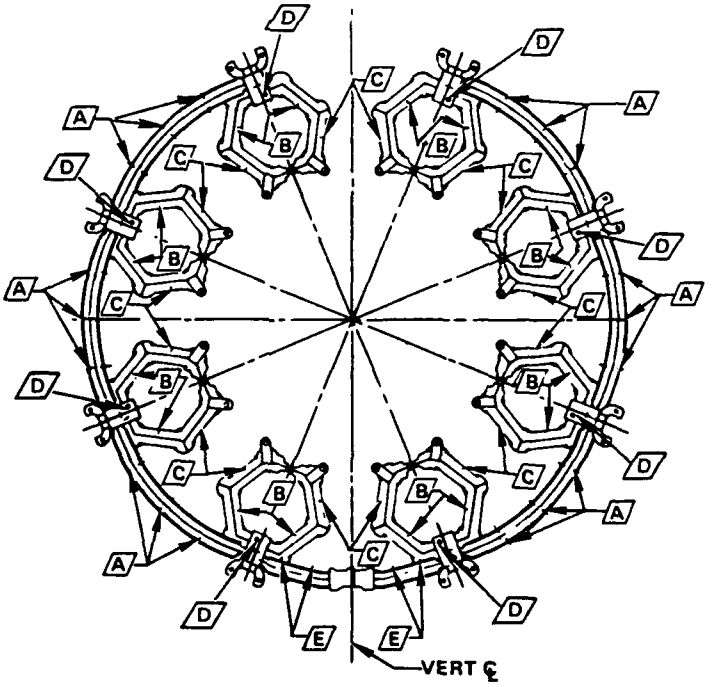
(3) Use PWA 407 sealant (DC 93-118) to insulate and seal heatshields.

NOTE

- Any manifold that shows evidence of chemical residue before or during the injection of the insulating sealant shall be flushed with water and air before injection continues. (See paragraph 6.)

- If sealant already injected into any area is disturbed by water or air flushing, the area can be reinjected.

(4) Inject insulating sealant at 50 to 60 psig in sequence per figure 18 using air-powered sealant gun, Semco Model 250, or equivalent, with plastic nozzle cut to accommodate diameter of holes.



TYPICAL FRONT VIEW
OF LEFT & RIGHT MANIFOLD ASSEMBLY L-43943-1 (26 X 2)

Figure 18. Fuel Manifold Heat Shield Insulation - Installation (Sheet 1)

(5) Inject sealant until it extrudes from crevices at end of shielding and adjacent hole, or until no voids are evident. Repeat procedure for each segment or cluster of shielding.

(6) Cure manifold assembly in oven at 350° - 400°F (177° - 204°C) for minimum of 20 minutes.

NOTE

Heat shield openings may be welded closed if necessary.

(7) Remove all protruding sealant from openings and exterior of manifold.

g. Repaired manifolds shall meet all test requirements of paragraph 34.

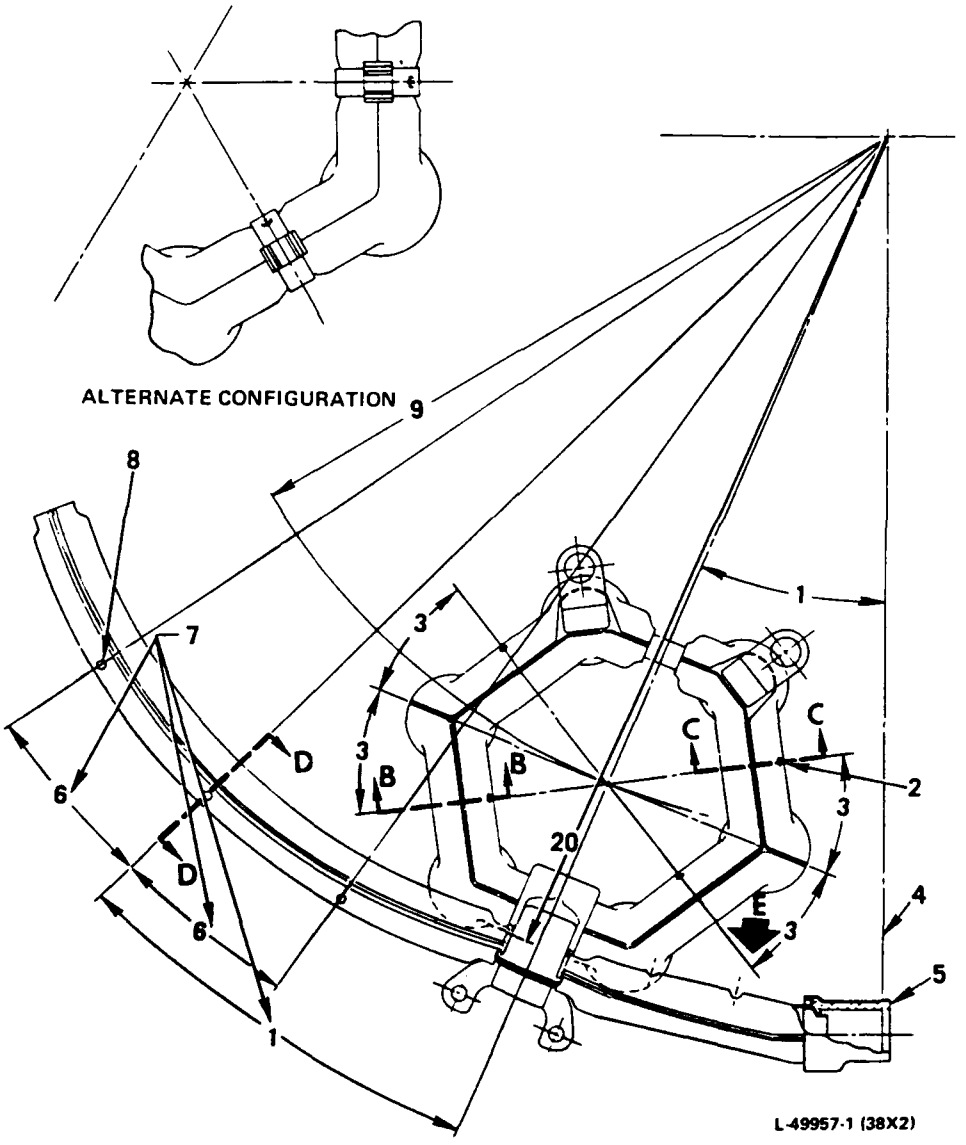


Figure 18. Fuel Manifold Heat Shield Insulation - Installation (Sheet 2)

i. Grind or machine per T.O. 2J-TF33-53-1, WP 013 00 to remove slight bulges in manifold to manifold mating faces caused by installation of bushings.

j. Use corundum 302 1/2E lapping compound and lap manifold adapters as necessary per T.O. 2J-TF33-53-1, WP 013 00 to obtain surface finish and flatness requirements per figure 19.

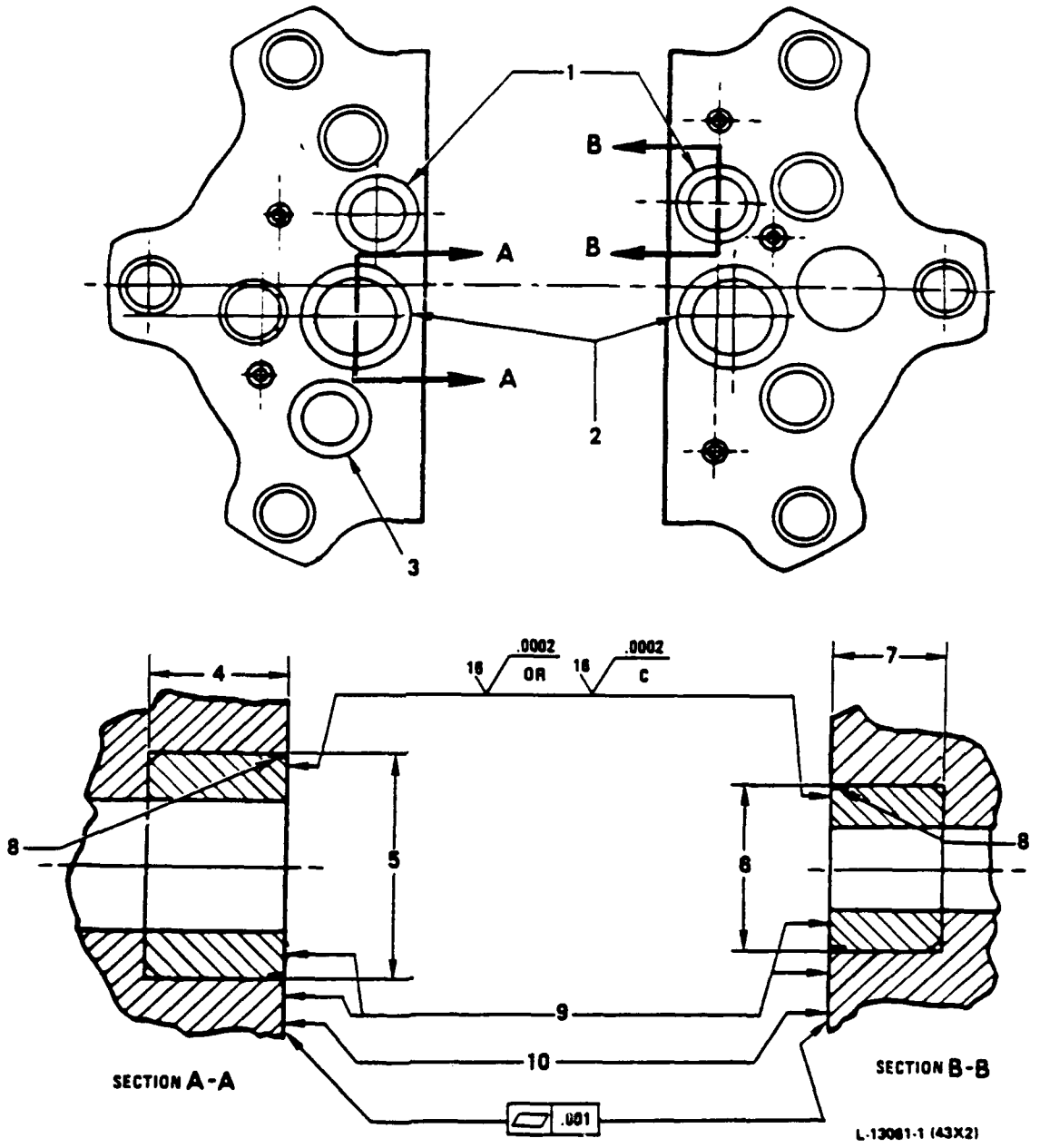
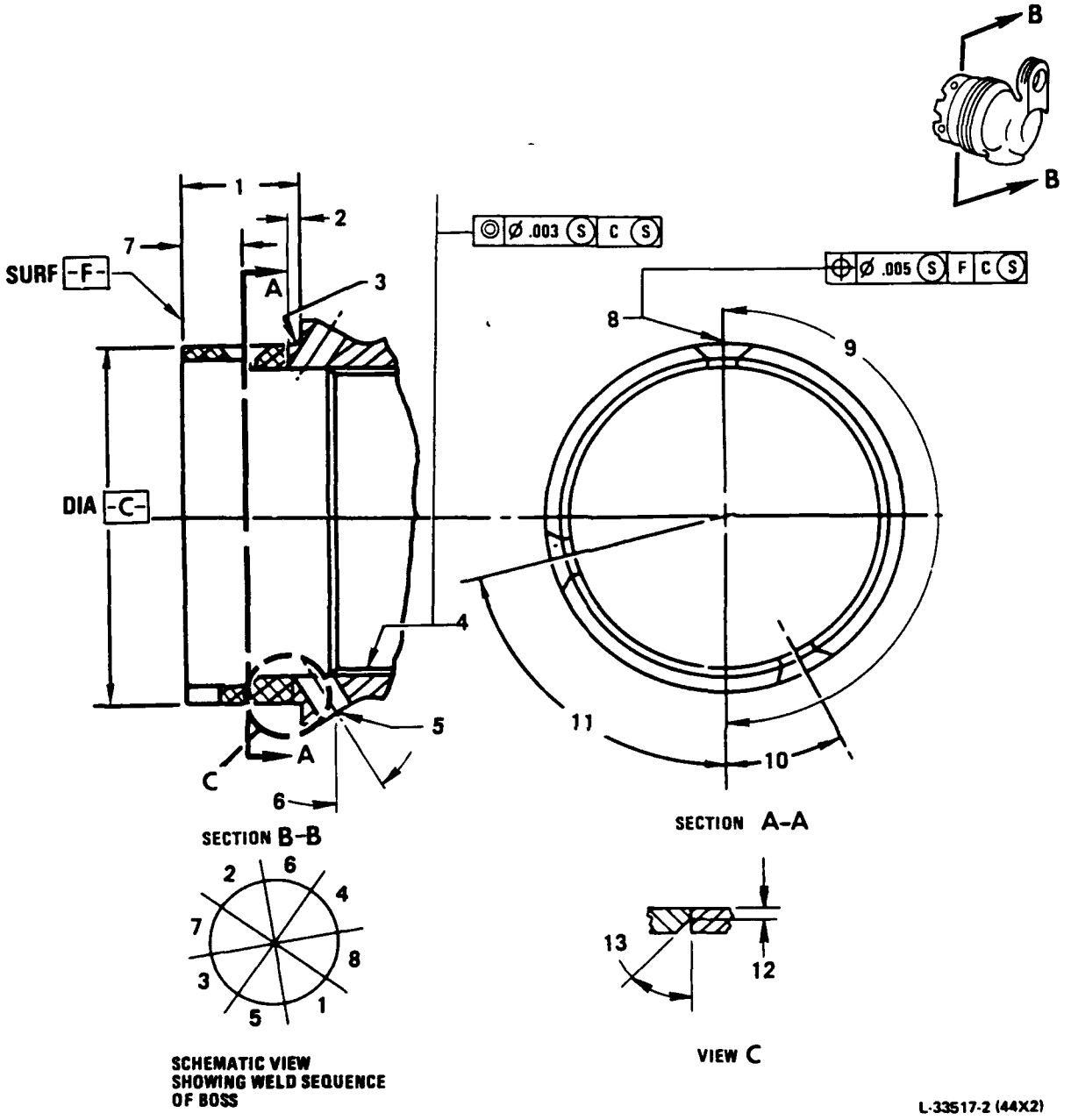


Figure 19. Inlet Adapter Bushing - Repair and Replacement



1. 0.358 - 0.362 inch
2. 0.060 inch minimum
3. 0.031 - 0.047 inch radius
4. 1.000-28NS thread, 0.9790 inch PD
5. 0.111 - 0.116 inch diameter. 20 holes
6. 35° ±1°
7. 0.200 inch
8. Three holes equally spaced and located as shown.
9. 180 degrees from centerline of slot
10. 25° 43'
11. 77° 9'
12. 0.030 - 0.050 inch
13. 45° ±5°

0.136 - 0.146 inch diameter through. Chamfer 90° ±5° to 0.178 - 1.198 inch diameter.

Figure 20. Nozzle Body Boss - Repair and Replacement

29. FUEL MANIFOLD INLET ADAPTER - REPAIR. (See Figure 21.)

a. Reject part if manifold inlet flange grinding repairs result in flange plate finished thickness less than 0.260 inch.

NOTE

Flange measurements shall be made adjacent to diffuser case outer bolt-holes. Surfaces shall be free of defects, raised or irregular material or casting number, etc. that affect measurements. (See figure 21.)

Any surface pits, chips, or voids are permissible if removable while grinding or lapping manifold adapter to the required surface finish and flatness requirements.

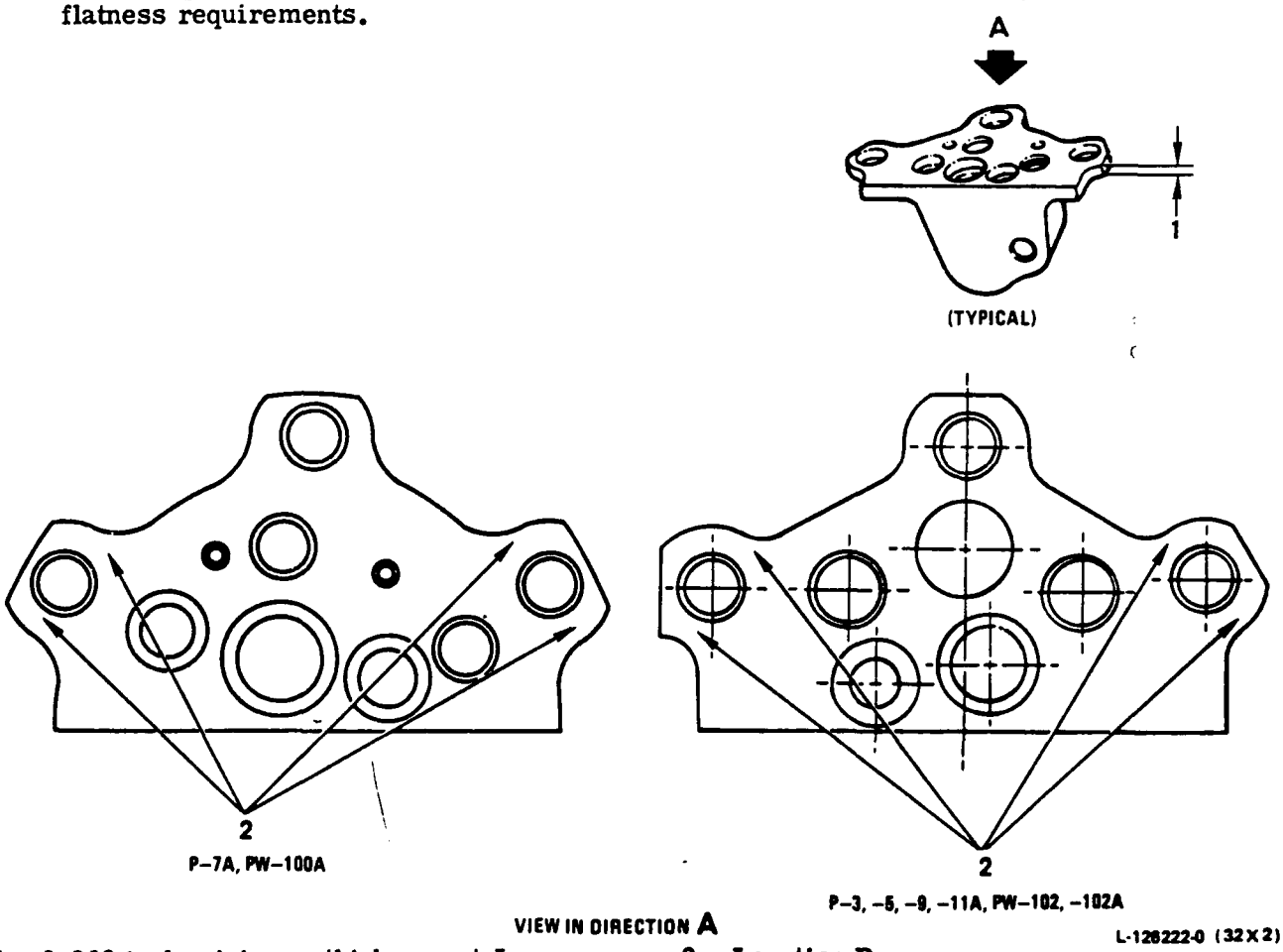
b. Accept manifold flanges measuring 0.260 inch or more with no further rework required, if following criteria are met:

(1) Ferrule hole depths are 0.145 inch or greater.

(2) Flange surface finish is 32AA.

c. Reject manifolds with flanges that do not measure up to 0.260 inch or with ferrule depths less than 0.145 inch.

d. Pits, chips, or voids that extend from bushing sealing surface ID maximum of 0.015 inch wide and 0.015 inch deep are permissible when reworked to smooth contour (blend two times width/depth minimum). Refer to T.O. 2J-TF33-53-1, WP 013 00.



1. 0.260 inch minimum thickness at Location B
2. Location B

Figure 21. Fuel Manifold Inlet Flange Measurements

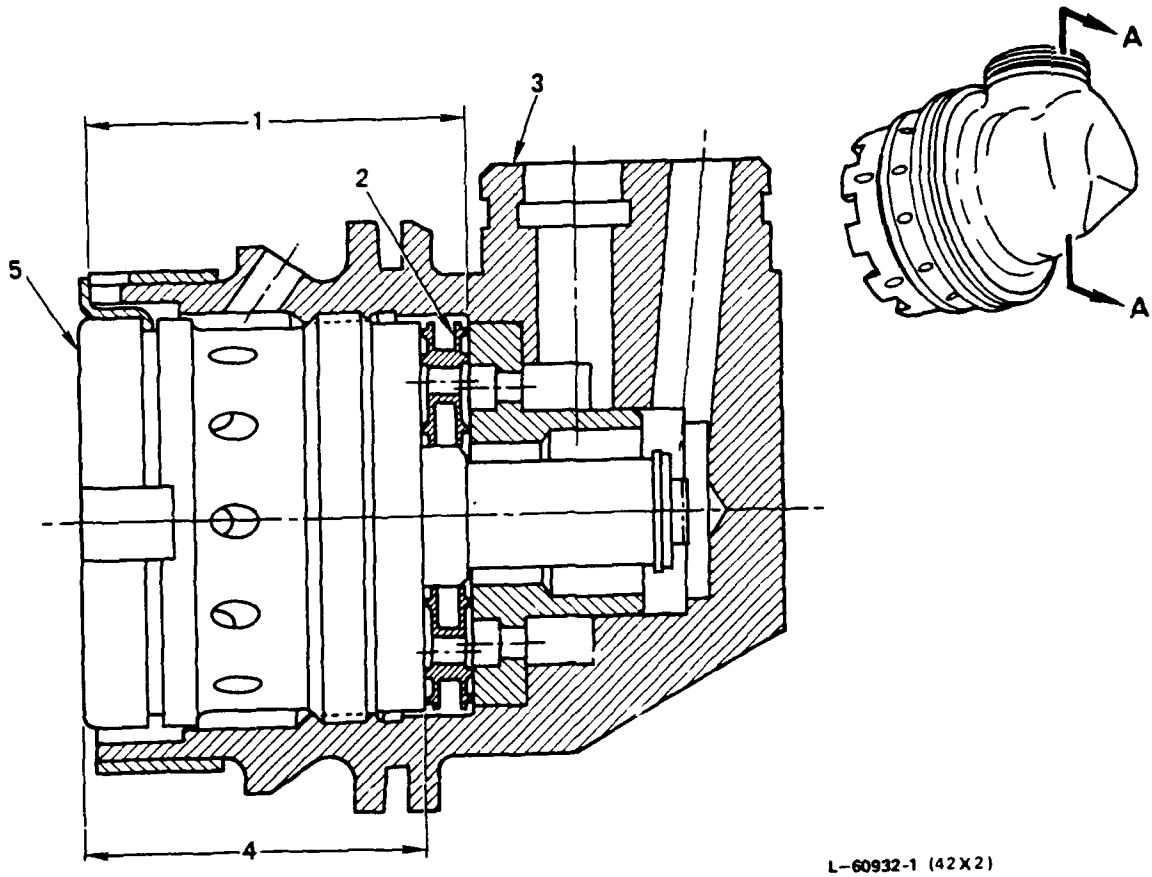


Figure 23. Fuel Nozzle - Installation

"IN" DATES PROFILE

NAME _____ ALC OC-ALC DATE 31MAY89 RCC MTPCB SHEET 1 OF 1

PCN / NSN / P/N 98034A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)
1	8279	8279	0
2	8305	8308	72
3	8307	8308	24
4	8320	8322	48
5	8355	8355	0
6	9020	9023	72
7	9039	9041	48
8	9054	9054	0
9	9054	9055	24
10	9060	9061	24
			32

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

LSC-20107A

"OUT" DATES PRO..LE

NAME _____ ALC OC-ALC DATE 31 MAY 89 RCC MTPCB SHEET 1 OF 1

PCII /ISII PII [redacted]98034A PARENT WCD _____ PARENT WCD DATE _____

OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS) HRS
1	8297	8298	24
2	8330	8333	72
3	8323	8326	72
4	8340	8340	0
5	9006	9009	72
6	9041	9041	0
7	9059	9061	48
8	9066	9066	0
9	9069	9072	72
10	9074	9074	0
			36

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

LSC-20108A

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 1 OF 9

ITEM CODE PCN ~~98053A~~ ~~98043A~~ NSN 98042A ~~98053AJ~~ P/N WCD CRECO4 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
000	MAT CB	IN	1.0	TRANSIT										
				SETUP										
				PROCESS	0									
010	MAT PCB	REC	1.0	TRANSIT										80% OF MAN. RECEIVED FROM THE "BARN". 20% OF MAN. RECEIVED FROM ENGINE SHOP. RECEIVE 25 AT A TIME FROM "BARN"
				SETUP										
				PROCESS		BP09	1	100	.1	HAND-5	1	100	.1	A MIX OF LEFT/RIGHT MANIFOLDS RECEIVED FIRST PART OF WCD 010
040	CB	REM	1.0	TRANSIT										REMOVE PART FROM SHIPPING FIXTURE. CHECK FIXTURE FOR DISTORTION
				SETUP										
				PROCESS		BP09	1	100	.05	HAND	1	100	.05	WCD 040
041	CB	INSP	1.0	TRANSIT										INSPECT MANIFOLD FOR DISTORTION. IF MANIFOLDS HAVEN'T BEEN FIELD SEND TO (PCN) BLDG 3108.
				SETUP										
				PROCESS		BP09	1	100	.05	HAND	1	100	.05	WCD 030+035
042	CB	TEST	.02	TRANSIT										NON FIELD PARTS GO TO BLDG 3108 FOR CTECO4 TESTING. IF CHECKED SAT THEY MANIFOLDS ARE SOLD. TESTING CTECO4 PROCEDURE IS USED
				SETUP										
				PROCESS	24									

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 2 OF 9

ITEM CODE PCN ~~98044A~~ ~~98043A~~ NSN 98042A ~~98057A~~ P/N WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
043	CB	PROC	.98	TRANSIT										OIL PUT ON NOZZLES AND LEFT ON FOR ONE HOUR TO SATURATE THREADS FOR EASY REMOVAL.
				~~SETUP~~										
				PROCESS	1.0	BP09	1	100	.05	FENCE	1	100	.05	
044	CB	REM	1.0	TRANSIT										REMOVE NOZZLES IF POSSIBLE. DISCARD OLD SEALS + LOCK TABS
				~~SETUP~~										
				PROCESS		BP09	1	100	.17	FENCE	1	100	.17	WC0020
045	CB	INSP	1.0	TRANSIT										INSPECT PART FOR CRACKS, STRIPPED THREADS AND FROZEN NOZZLES
				SETUP										
				PROCESS		BP09	1	100	.03	FENCE	1	100	.03	WCD 020
046	CB	ID	1.0	TRANSIT										IDENTIFY PARTS AND ATTACH PAPERWORK
				SETUP										
				PROCESS		BP09	1	100	.05	FENCE	1	100	.05	SECOND PART OF WC 010
047	CB	INSP	.2	TRANSIT										20% OF PARTS ARE BEYOND REPAIR. THEY ARE RED TAGGED AND SCRAPPED.
				SETUP										
				PROCESS		BP09	1	100	.08	FENCE	1	100	.08	

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 3 OF 9

ITEM CODE PCN ~~98074A~~ ~~98043A~~ NSN 98042A ~~98097A~~ P/N WCD CRECO4 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	CB	CLN	1.0	~~TRANSIT~~						0C3338 100 0C3348 V 0C3346 100		100		PARTS ARE BATCHED PROCESSED. THEY ARE PLACED ON RACKS & CLEANED. 2 PARTS PER TANK 2 TANKS AVAIL. PER PROCESS
				SETUP		BP09	1		.12	0C3351 100 0C3350 100 0C3349 100		100		
				PROCESS		BP09	1		.3	[illegible] TANK	1	100	.6	WCD 050
055	MT PIW	REM	1.0	TRANSIT										REMOVE HEAT SHIELD
				SETUP										
				PROCESS										WCD 055
060	IW	INSP	1.0	TRANSIT										INSPECT FOR METAL CONTENT (GOLD-NICKLE) (COPPER-NICKLE)
				SETUP										
				PROCESS										WCD 060
090	MT PCM	REP	1.0	TRANSIT										REPAIR NOZZLE BODY AS REQUIRED
				SETUP										
				PROCESS										WCD 090
100	CM	REPL	1.0	TRANSIT										REMOVE + REPLACE SLEEVES AS REQUIRED
				SETUP										
				PROCESS										WCD 100

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25 MAY 89 RCC MATCBE SHEET 4 OF 9

ITEM CODE PCN ~~98034A~~ ~~98043A~~ NSN 98042A ~~98057A~~ P/N WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	CM	INSP	1.0	TRANSIT										INSPECT & RECORD LUG THICKNESS
				SETUP										
				PROCESS										WCD 110
120	MT PIW	PROC	1.0	TRANSIT										WELD HEATSHIELDS AND LUGS AS REQUIRED & INSPECT WORK
				SETUP										
				PROCESS										WCD 120
140	MT PCM	REPL	1.0	TRANSIT										REPAIR OR REPLACE LUGS AS REQUIRED
				SETUP										
				PROCESS										WCD 140
142	CM	MACH	1.0	TRANSIT										MACHINE LUGS & RECORD THICKNESS
				SETUP										
				PROCESS										WCD 142
145	CM	REP	1.0	TRANSIT										REPAIR INLET ADAPTER AND BUSHINGS IF REQUIRED
				SETUP										
				PROCESS										WCD 145

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 5 OF 9

ITEM CODE PCN ~~98034A~~ ~~98043A~~ NSN 98042A ~~98057A~~ P/N WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MT PIW	INSP	1.0	TRANSIT										FLUORESCENT PENETRANT INSPEC.
				SETUP										
				PROCESS										WCD 150
155	MT PCM	PROC	1.0	TRANSIT										PERFORM FLEX MOUNT MOD IF REQUIRED
				SETUP										
				PROCESS										WCD 155
160	CM	PROC	1.0	TRANSIT										PERFORM DISTORTION CHECK AND COLD BEND.
				SETUP										
				PROCESS	120									WCD 160
165	MAT PCB	INSP	1.0	TRANSIT										REINSPECT PARTS. BEND ON SPECIAL FIXTURE. LOCKWIRE. INSPECT FOR CRACKS
				SETUP		BP09	1	100	.01	FENSE	1	100	.01	
				PROCESS		BP09	1		.24	FENSE	1		.01	WCD 160 + 165
170	CB	TEST	1.0	~~TRANSIT~~										TEST PERFORMED BY WIGGLING PART. IF IT "WIGGLES" REPLACE IT.
				~~SETUP~~										
				PROCESS		BP01	1	100	.1	FENSE	1	100	.1	WCD 170

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25 MAY 89 RCC MATCBE SHEET 6 OF 9

ITEM CODE PCN ~~98034A~~ ~~98043A~~ NSN PIN 98042A ~~98057A~~ WCD CRECO4 WCD DATE 98087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
210	MT PCM	PROC	1.0	TRANSIT										DRILL HOLES FOR SILICON
				SETUP										
				PROCESS										WCD 210
215	MT PIW	CLN	1.0	TRANSIT										REFLUSH MANIFOLD
				SETUP										
				PROCESS										WCD 215
220	IW	PROC	1.0	TRANSIT										INJECT SILICON
				SETUP										
				PROCESS										WCD 220
230	IW	PROC	1.0	TRANSIT										BAKE MANIFOLD. REMOVE RESIDUE. 4HRS IN WORK 12HR WAIT UNTIL NEXT MORNING
				SETUP										
				PROCESS	16									WCD 230
250	MAT CB	INSP	1.0	~~TRANSIT~~										- INSPECT TAKES ABOUT 5-10 SECONDS
				~~SETUP~~										
				PROCESS		BP09	1	100	.01	CLNC	1	100	.01	WCD 250

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 7 OF 9

ITEM CODE PCN ~~98034A~~ ~~98043A~~ NSN P/N 98042A ~~98057A~~ WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
260	CB	PROC	1.0	~~TRANSIT~~										BODY SEATS ARE LAPPED BY HAND
				~~SETUP~~										
				PROCESS		BP09	1	100	2.0	FEN55	1	100	2.0	WCD 260
270	CB	CLN	1.0	~~TRANSIT~~										- PART IS FLUSHED AND AIR DRIED
				~~SETUP~~										
				PROCESS		BP09	1	100	.25	WD 1MIK	1	100	.25	WCD 270
280	CB	PROC	1.0	~~TRANSIT~~										MEASURE NOZZLE AND BODY HOUSING DEPTH. SUBTRACT ONE FROM THE OTHER TO DETERMINE WHAT SIZE SEAL IS REQUIRED
				~~SETUP~~										
				PROCESS		BP09	1	100	.4	FEN55	1	100	.4	WCD 280
290	CB	ASSY	1.0	TRANSIT										INSTALL SEALS NOZZLES AND TAB LOCKS
				SETUP										
				PROCESS		BP09	1	100	.5	FEN55	1	100	.5	WCD 290
330	CB	INT	1.0	~~TRANSIT~~										- INSTALL CAPS ON NOZZLES
				~~SETUP~~										
				PROCESS		BP09	1	100	.01	FIN55	1	100	.01	WCD 330

OPERATION PROFILE

NAME KoBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 8 OF 9

ITEM CODE PCN ~~98037A~~ ~~98045A~~ RSN 98012A P/N ~~98057A~~ WCD CREC04 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
340	CB	PW	1.0	TRANSIT										IDENTIFY & PROCESS PAPERWORK
				~~SETUP~~										
				PROCESS		BP09	1	100	.09	BEN55	1	100	.09	WCD 320 & 340
350	CB	TEST	1.0	TRANSIT										CONVEIER TO BLDG 3108 FOR TESTING # WCD CTEC04 AND RETURED BY CONVEYER
				SETUP										
				PROCESS	16									WCD 350
370	CB	PROC	1.0	TRANSIT										TIGHTEN SEALS, SET TAB LOCKS, PERFORM DISTORTION CHECK BY VISUAL AND FEEL
				SETUP										
				PROCESS		BP09	1	100	.4	BEN55	1	100	.4	WCD 370 & 390
380	MTB CM	PROC	1.0	TRANSIT										- REMOVE CAPS AND HAND LAP TO A FINE FINISH.
				SETUP										
				PROCESS	.25									WCD 380
400	MAT CB	LOAD	1.0	TRANSIT										- CAP PART AND BOLT TO FIXTURE FRAME
				SETUP										
				PROCESS		BP09	1	100	.15	BEN55	1	100	.15	WCD 400

OPERATION PROFILE

NAME KOBYLK ALC OC-ALC DATE 25MAY89 RCC MATCBE SHEET 9 OF 9

ITEM CODE PCN ~~98034A~~ ~~98043A~~ NSN 98042A ~~98057A~~ P/N WCD CRECO4 WCD DATE 89087

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
410	CB	PW	1.0	~~TRANSIT~~										INSURE PROPER ID. COMPLETE APTO 349, COMPLY WITH MAOI 66-36 PARA 13.
				SETUP										
				PROCESS		BP09	1	100	.02	FENSS	1	100	.02	WCD 410, 420 & 435
430	CB	INSP	1.0	~~TRANSIT~~										INSPECT
				~~SETUP~~										
				PROCESS		BP09	1	100	.01	FENCE	1	100	.01	WCD 430
432	CB	PW	1.0	~~TRANSIT~~										TAG & PROCESS PAPERWORK
				~~SETUP~~										
				PROCESS		BP09	1	100	.04	FENSS	1	100	.04	WCD 430
440	CB	MOVE	1.0	TRANSIT										MOVE TO PICK-UP STATION
				SETUP										
				~~PROCESS~~		BP09	1	100	.01					WCD 440
9999	MAT CB	OUT	1.0	TRANSIT										
				SETUP										
				PROCESS	0									

FLOW PROCESS CHART

SUBJECT TF33 MANIFOLDS LEFTSIDE DATE 26 MAY 99

ITEM CODE
PCN ■
N&N □
P/N □

WCD CREC04 WCD DATE 89097

~~98034A~~ (P7) ~~98043A~~
98042A (P7) ~~98057A~~

CHART BEGINS IN

CHART ENDS 9999 PREPARED BY S. KOBYLK

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▶D□▽	RECEIVE + MOVE TO TESTING S.	290	290	●▷D□▽	ASSEMBLE
040	040	◎▷D□▽	REMOVE PISTON SEALING ELEMENT	330	330	◎▷D□▽	INSTALL CAPS
041	030	○▷D▨▽	DISTORTION CHECK	340	340	●▷D□▽	PAPERWORK
—	035	○▷D■▽	CHECK THICKNESS	—	320	●▷D□▽	IDENTIFY PART
042	—	○▶D□▽	NON-DESTRUCTIVE TEST	350	350	◎▷D□▽	TEST PART
043	—	◎▷D□▽	OIL NOZZLES	370	370	●▷D□▽	TIGHTEN SLEEVES
044	020	◎▷D□▽	REMOVE NOZZLES	—	390	○▷D■▽	CHECK PART
045	020	○▷D■▽	INSPECT PARTS	380	380	●▷D□▽	REMOVE CAPS LAP PART
046	010	◎▷D□▽	IDENTIFY + ATTACH TAG	400	400	◎▷D□▽	CAP PART + MOVE TO EXAMINE
047	—	○▷D▨▽	RED TAG BAD PARTS	410	410	●▷D□▽	CHECK ID
050	050	◎▷D□▽	CLEAN PARTS	—	420	◎▷D□▽	PAPER WORK
055	055	◎▷D□▽	REMOVE HEATSHIELDS	—	435	●▷D□▽	CHECK COMPLIENCE
060	060	○▷D■▽	INSPECT PARTS	440	440	○▶D□▽	PICK UP STATION
090	090	●▷D□▽	REPAIR NOZZLES			○▷D□▽	
100	100	●▷D□▽	REMOVE/REPLACE SLEEVES			○▷D□▽	
110	110	○▷D■▽	INSPECT LUGS			○▷D□▽	
140	140	●▷D□▽	REPAIR LUGS			○▷D□▽	
142	142	●▷D□▽	MACHINE LUGS			○▷D□▽	
145	145	●▷D□▽	REPAIR INLET			○▷D□▽	
150	150	○▷D■▽	INSPECT PARTS			○▷D□▽	
155	155	●▷D□▽	PERFORM MOD.			○▷D□▽	
160	160	●▷D□▽	DISTORTION CHECK BEND STRAIGHT			○▷D□▽	
165	160	○▷D■▽	INSPECT PARTS			○▷D□▽	
—	165	●▷D□▽	INSPECT HEAT-SHIELD + LOCKWIRE			○▷D□▽	
170	170	●▷D□▽	TEST			○▷D□▽	
210	210	●▷D□▽	DRILL HOLES			○▷D□▽	
215	215	●▷D□▽	FLUSH PART			○▷D□▽	
220	220	●▷D□▽	INJECT SILICON			○▷D□▽	
230	230	●▷D□▽	BAKE PART			○▷D□▽	
260	260	●▷D□▽	LAP SEATS			○▷D□▽	
270	270	●▷D□▽	CLEAN PART			○▷D□▽	
280	280	◎▷D□▽	MEASURE NOZZLE			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

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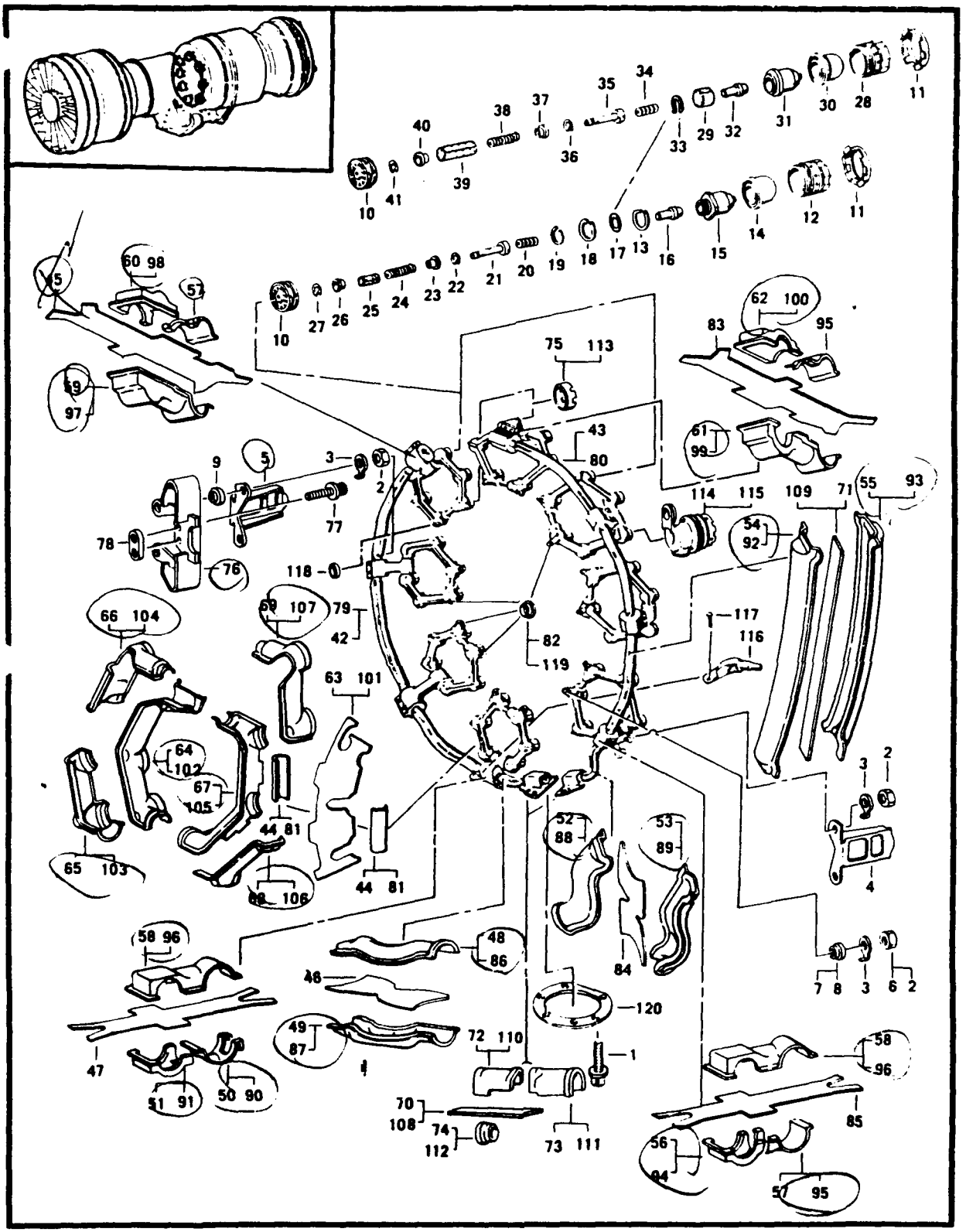

FIGURE 27 - MANIFOLDS-FUEL. NOZZLES-FUEL.

PCN 98034A 98043A
98042A 98057A

	FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SM
	26 - 63	410935	52661	RING-SPL, RTNG 0.938 HSG DIA X 0.075 WALL X 0.042 IN. THK	1		PAFBZN
	- 64	742372	52661	GEARSHAFT-BEVEL, MAIN DRIVE GRBX SHAFT	1		PAFFFP
	- 65	770329	52661	BEARING OPTION-REF NO ONLY ORDER ONE OF THE FOLLOWING	1		XC----
		741415	52661	BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741416			PAFBZN
		741416	52661	BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741415			PAFBZN
	- 66	742366	52661	SPACER-RING 1.500 ID X 1.860 OD X 0.080 IN. THK	1		PAFZZN
	- 67	742365	52661	SPACER-BRG ACCESS DRIVE GRSHFT	1		PAFZZN
		801659	52661	BEARING ASSEMBLY-GRBX DRIVE SUPERSEDES 742369	1		XB----
	- 68	742368	52661	HOUSING-GRBX DRIVE BRG	1		PAFBZN
	- 69	802862	52661	BEARING OPTION-REF NO. ONLY ORDER THE FOLLOWING SUPERSEDES 488748 OPTION C/O 488747 OR 770612 PRCMT NO. C/O	1		XC----
R		798868	52661	BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798869			PAFBZN
R R		798869	52661	BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798868			
	- 70	749920	52661	SPACER ASSEMBLY-GRBX DRIVE BRG	1		PAFZZN
	- 71	MS9390-080	96906	PIN	1		PADZZN
	- 72	742378	52661	HOUSING-ASSY OF, GRBX DRIVE BRG	1		PAFBZN

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
			MANIFOLDS-FUEL. NOZZLES-FUEL.			
27	483266	52661	MANIFOLD SET-FUEL	1	AS	XB----
	524342	52661	MANIFOLD SET-FUEL	1	B/AT	XB----
- 1	237233	52661	BOLT-MACH. DRILLED DBL HEX 0.3125-24 X 0.500 IN. LONG (AP)	6		PAFZZN
- 2	MS9356-10	96906	NUT (AP) SUPERSEDES AN121527 FOR A ENG	32	AS	PAFZZN
	MS9356-10	96906	NUT (AP) SUPERSEDES AN121527 FOR A ENG	16	AT	PAFZZN
- 3	227340	52661	WASHER-KEY 0.2575 ID X 0.055 (AP)	32		PAFZZN
- 4	435348	52661	BRACKET-COMB CHMBR (AP)	2		PAFZZN
- 5	454391	52661	BRACKET-COMB CHMBR FR (AP)	6		PAFZZN
- 6	MS9357-10	96906	NUT (AP) SUPERSEDES 328835 FOR A ENG	16	B/AT	PAFZZN
- 7	524325	52661	LOCK-FUEL MANF (AP)	16	B/AT	PAFZZN
- 8	490029	52661	LOCK-FUEL NOZ HSG (AP)	16	AS	PAFZZN
- 9	483263	52661	BUSHING-SLV 0.260 X 0.440 X 0.459. FLG (AP)	12		PAFZZN
	483268	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, RIGHT, PREFERRED U/W 483266 MANF SET	1	AS	PAFDDT
	483267	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, LEFT, PREFERRED U/W 483266 MANF SET	1	AS	PAFDDT
	563217	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, RIGHT, PREFERRED U/W 524342 MANF SET SUPERSEDES 524341	1	B/AT	PAFDDT
	563215	52661	.MANIFOLD AND NOZZLE-ASSY OF, FUEL, LEFT, PREFERRED U/W 524342 MANF SET SUPERSEDES 524340	1	B/AT	PAFDDT
- 10	218406	52661	..SEAL-FUEL NOZ, ALSO REQD FOR SVCE REPAIR OF FUEL MANF AND NOZ ASSY	24		PAFZZN
	749885	52661	..SEAL-FUEL NOZ, ALSO REQD FOR SVCE REPAIR OF FUEL MANF AND NOZ ASSY	24		PAFZZN
- 11	431839	52661	..WASHER-KEY, FUEL NOZ	24		PAFZZN
	157872	52661	..TABWASHER-FUEL NOZ, AIR FORCE ASSIGNED APPLICATION	48		
	481694	52661	..NOZZLE ASSEMBLY-FUEL, REPAIR KIT 500072 AVAILABLE	24	AU	PAFDDT
- 12	484454	52661	...NUT-FUEL NOZ	1	AU	PAFZZN
	484455	52661	...NOZZLE SET-FUEL	1	AU	ADD---
- 13	267629	52661	....RING-RTNG 0.750 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD----
- 14	739595	52661	....NOZZLE-FUEL	1	AU	PADBZN
- 15	739596	52661	....NOZZLE-FUEL	1	AU	PADBZN
- 16	739597	52661	....METERING PLUG-NOZZLE	1	AU	PADBZN
- 17	484452	52661	...STRAINER ELEMENT-SCREEN 0.495	1	AU	KD----

CONTINUED

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27			ID X 0.756 OD X 0.00375 IN. THK			
- 18	267630	52661	...RING-RTNG 0.813 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD----
- 19	267631	52661	...RING-RTNG 0.453 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD----
- 20	267627	52661	...SPRING-HLCPS 0.213 OD X 0.036 IN. DIA WIRE	1	AU	PADZZN
- 21	267626	52661	...SUPPORT-FUEL NOZ	1	AU	PADZZN
- 22	267632	52661	...RING-RTNG 0.312 HSG DIA X 0.015 IN. THK	1	AU	KD----
- 23	267624	52661	...FLANGE-FUEL NOZ	1	AU	PADZZN
- 24	368448	52661	...SPRING-HLCPS 0.246 OD X 0.159 IN. DIA WIRE	1	AU	PADZZN
- 25	484453	52661	...STRAINER ELEMENT-SLV 0.255 X 0.424 IN. LONG	1	AU	PADZZN
- 26	267625	52661	...FLANGE-FUEL NOZ	1	AU	PADZZN
- 27	267623	52661	...RING-RTNG 0.156 SHAFT DIA X 0.025 IN. THK	1	AU	KD----
	500072	52661	..PARTS KIT-REPAIR, FOR REPAIR OF 481694 FUEL NOZ	1	AU	
	663430	52661	..NOZZLE ASSEMBLY-FUEL, REPAIR KIT 546104 AVAILABLE SUPERSEDES 518126	24	B/AV	PAFDDT
- 28	663429	52661	...NUT-FUEL NOZ SUPERSEDES 484454	1	B/AV	PAFZZN
	520202	52661	...NOZZLE ASSEMBLY-FUEL	1	B/AV	ADD---
	749743	52661	....NOZZLE SET-FUEL	1	B/AV	ADD---
- 29	539512	52661	....STRAINER ELEMENT-SLV 0.4881	1	B/AV	PADZZN
- 30	739598	52661	....NOZZLE-FUEL	1	B/AV	PADBZN
- 31	739599	52661	....NOZZLE-FUEL	1	B/AV	PADBZN
- 32	739597	52661	....METERING PLUG-FUEL NOZ	1	B/AV	PADBZN
- 33	520205	52661	....RING-RTNG 0.750 HSG DIA X 0.035 IN. THK	1	B/AV	PADZZN
- 34	267627	52661	....SPRING-HLCPS 0.213 OD X 0.036 IN. DIA WIRE	1	B/AV	PADZZN
- 35	267626	52661	....SUPPORT-FUEL NOZ	1	B/AV	PADZZN
- 36	520204	52661	....RING-RTNG, FUEL NOZ	1	B/AV	PADZZN
- 37	267624	52661	....FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 38	368448	52661	....SPRING-HLCPS 0.246 OD X 0.159 IN. DIA WIRE	1	B/AV	PADZZN
- 39	484453	52661	....STRAINER ELEMENT-SLV 0.255 X 0.424	1	B/AV	PADZZN
- 40	267625	52661	....FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 41	520203	52661	....RING-RTNG, FUEL NOZ	1	B/AV	PADZZN
	546104	52661	..PARTS KIT-REPAIR, FOR REPAIR OF 518126 AND 663430 FUEL NOZ ASSY	1	B/AV	PADZZN
- 42	483264	52661	..MANIFOLD-ASSY OF, FUEL, RIGHT	1	AS	XA----
- 43	483265	52661	..MANIFOLD-ASSY OF, FUEL, LEFT	1	AS	XA----
- 44	348838	52661	...SLEEVE HALF-REINFORCING, TUBE	32	AS	PADZZN
- 45	531386	52661	...INSULATION BLANKET-FUEL MANF SUPERSEDES 336534 FOR A ENG	1	AS	XB----
- 46	531388	52661	...INSULATION BLANKET-FUEL MANF SUPERSEDES 219224 FOR A ENG	1	AS	XB----

CONTINUED

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27 - 86	358279	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 87	358280	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 88	358203	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 89	358202	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 90	358289	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 91	358291	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 92	358288	52661	....SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 93	358287	52661	....SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 94	358293	52661	....SHIELD-HEAT, LEFT FUEL MANF	3	B/AT	PADZZN
	358293	52661	....SHIELD-HEAT, RIGHT FUEL MANF	2	B/AT	PADZZN
- 95	358292	52661	....SHIELD-HEAT, LEFT FUEL MANF	4	B/AT	PADZZN
	358292	52661	....SHIELD-HEAT, RIGHT FUEL MANF	3	B/AT	PADZZN
- 96	358290	52661	....SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 97	358295	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 98	358294	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 99	358206	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-100	358205	52661	....SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-101	531384	52661	....INSULATION BLANKET-FUEL MANF	8	B/AT	XB----
-102	375060	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-103	358286	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-104	375059	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-105	375057	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-106	358281	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-107	375058	52661	....SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-108	531389	52661	....INSULATION BLANKET-FUEL MANF	1	B/AT	XB----
-109	531387	52661	....INSULATION BLANKET-FUEL MANF	3	B/AT	XB----
-110	358278	52661	....SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
-111	358204	52661	....SHIELD-HEAT, LEFT MANF	1	B/AT	PADZZN
-112	261803	52661	....FERRULE-FUEL MANF	1	B/AT	PADZZN
-113	483776	52661	....SLEEVE-FUEL NOZ	24	B/AT	PADZZN
-114	674002	52661	..HOUSING-ASSY OF, SVCE FIX FOR REWK OF FUEL NOZ ASSY	1		
-115	674003	52661	..HOUSING-ASSY OF, SVCE FIX FOR REWK OF FUEL NOZ ASSY	1		
-116	253759	52661	..PROBE-PB, RIGHT FUEL MANF	1		PAFZZN
-117	AN123176	81352	..RIVET-RIGHT FUEL MANF	1		PAFZZN
-118	515359	52661	..SPACER-RING 0.551 X 0.755 X 0.135, SVCE FIX FOR REWK OF 483264 OR 483265 FUEL MANF ASSY	8		
-119	524324	52661	..WASHER-SHLDR 0.535 X 0.750, SVCE FIX FOR REWK OF 483264 OR 483265 FUEL MANF ASSY	16		PADZZN
-120	457128	52661	GASKET-FUEL MANF INLET ADPTR	1		PAFZZN

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27			SUPERSEDES 511714 FOR A ENG			
- 47	531385	52661	...INSULATION BLANKET-FUEL MANF	3	AS	XB----
			SUPERSEDES 336535 FOR A ENG			
- 48	358279	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 49	358280	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 50	358289	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 51	358291	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 52	358203	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 53	358202	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 54	358288	52661	...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 55	358287	52661	...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 56	358293	52661	...SHIELD-HEAT, LEFT FUEL MANF	3	AS	PADZZN
	358293	52661	...SHIELD-HEAT, RIGHT FUEL MANF	2	AS	PADZZN
- 57	358292	52661	...SHIELD-HEAT, LEFT FUEL MANF	4	AS	PADZZN
	358292	52661	...SHIELD-HEAT, RIGHT FUEL MANF	3	AS	PADZZN
- 58	358290	52661	...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 59	358295	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 60	358294	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 61	358206	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 62	358205	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 63	531384	52661	...INSULATION BLANKET-FUEL MANF	8	AS	XB----
			SUPERSEDES 253818			
- 64	375060	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 65	358286	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 66	375059	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 67	375057	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 68	358281	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 69	375058	52661	...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 70	531389	52661	...INSULATION BLANKET-FUEL MANF	1	AS	XB----
			SUPERSEDES 253819 FOR A ENG			
- 71	531387	52661	...INSULATION BLANKET-FUEL MANF	3	AS	XB----
- 72	358278	52661	...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 73	358204	52661	...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 74	261803	52661	...FERRULE-FUEL MANF	1	AS	PADZZN
- 75	483776	52661	...SLEEVE-FUEL NOZ	24	AS	PADZZN
	563218	52661	..BRACKET AND MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA----
			SUPERSEDES 525041			
	563216	52661	..BRACKET AND MANIFOLD-ASSY OF, FUEL, LEFT	1	B/AT	XA----
			SUPERSEDES 525040			
- 76	483260	52661	...BRACKET-ASSY OF, FUEL MANF	3	B/AT	PAFBZN
- 77	303328	52661	...BOLT-MACH, DRILLED DBL HEX 0.250-28 X 0.625 IN. LONG	6	B/AT	PAFZZN
- 78	454393	52661	...NUT-PLAIN, MULTIPLE 0.250-28 X 0.560 IN. LONG	3	B/AT	PAFZZN
- 79	525041	52661	...MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA----
- 80	525040	52661	...MANIFOLD-ASSY OF, FUEL, LEFT	1	B AT	XA----
- 81	348838	52661	...SLEEVE HALF-REINFORCING TUBE	32	B/AT	PADZZN
- 82	524324	52661	....WASHER-SHLDR 0.535 X 0.750	16	B/AT	PADZZN
- 83	531386	52661	....INSULATION BLANKET-FUEL MANF	1	B/AT	XB----
- 84	531388	52661	....INSULATION BLANKET-FUEL MANF	1	B/AT	XB----
- 85	531385	52661	....INSULATION BLANKET-FUEL MANF	3	B/AT	XB----

DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 1 OF 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358279	98034A 98043A 98042A 98057A S1		
PCN NSN P/N					PCN NSN P/N 35820	S2		
PCN NSN P/N					PCN NSN P/N 35829	S3		
PCN NSN P/N					PCN NSN P/N 358291	S4		
PCN NSN P/N					PCN NSN P/N 358203	S5		
PCN NSN P/N					PCN NSN P/N 358202	S6		
PCN NSN P/N					PCN NSN P/N 358288	S7		
PCN NSN P/N					PCN NSN P/N 358287	S8		
PCN NSN P/N					PCN NSN P/N 358293	S9		
PCN NSN P/N					PCN NSN P/N 358293	S10		
PCN NSN P/N					PCN NSN P/N 358292	S11		
PCN NSN P/N					PCN NSN P/N 358292	S12		

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DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 2 OF 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY. P/N
ITEM NUMBER	WCB	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358290	98634A 98043A 98042A 98057A S13		
PCN NSN P/N					PCN NSN P/N 358295	S14		
PCN NSN P/N					PCN NSN P/N 358294	S15		
PCN NSN P/N					PCN NSN P/N 358206	S16		
PCN NSN P/N					PCN NSN P/N 358205	S17		
PCN NSN P/N					PCN NSN P/N 375060	S18		
PCN NSN P/N					PCN NSN P/N 358286	S19		
PCN NSN P/N					PCN NSN P/N 375059	S20		
PCN NSN P/N					PCN NSN P/N 375057	S21		
PCN NSN P/N					PCN NSN P/N 358281	S22		
PCN NSN P/N					PCN NSN P/N 375058	S23		
PCN NSN P/N					PCN NSN P/N 358278	S24		

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DISASSEMBLY/ASSEMBLY ...OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 3 OF 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY S/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHG'D WCD	CHG'D WCD DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358204	98034A 98043A 98042A 98057A 525		
PCN NSN P/N					PCN 483776 NSN P/N ~~526~~	526		
PCN NSN P/N					PCN 563216 NSN P/N ~~526~~	527		
PCN NSN P/N					PCN NSN 483260 P/N	528		
PCN NSN P/N					PCN NSN 525041 P/N	529		
PCN NSN P/N					PCN NSN 525040 P/N	530		
PCN NSN P/N					PCN NSN 358279 P/N	531		
PCN NSN P/N					PCN NSN 358280 P/N	532		
PCN NSN P/N					PCN NSN 358203 P/N	533		
PCN NSN P/N					PCN NSN 35802 P/N	534		
PCN NSN P/N					PCN NSN 358289 P/N	535		
PCN NSN P/N					PCN NSN 358291 P/N	536		

LSC-2(XP)SA

DISASSEMBLY/ASSEMBLY . . . FILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 4 OF 16

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY P/N
ITEM NUMBER	WCB	WCB DATE			ITEM NUMBER	CHILD WCB	CHILD WCB DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 358288	98034A 98043A 98042A 98057A S37		
PCN NSN P/N					PCN NSN P/N 358287	S38		
PCN NSN P/N					PCN NSN P/N 358293	S39		
PCN NSN P/N					PCN NSN P/N 358293	S40		
PCN NSN P/N					PCN NSN P/N 358292	S41		
PCN NSN P/N					PCN NSN P/N 358290	S42		
PCN NSN P/N					PCN NSN P/N 358295	S43		
PCN NSN P/N					PCN NSN P/N 358294	S44		
PCN NSN P/N					PCN NSN P/N 358206	S45		
PCN NSN P/N					PCN NSN P/N 358205	S46		
PCN NSN P/N					PCN NSN P/N 375060	S47		
PCN NSN P/N					PCN NSN P/N 358286	S48		

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DISASSEMBLY/ASSEMBLY . . . OFILE

NAME PHUNT ALC OC DATE 6-16-89 RCC MATPCB SHEET 5 OF 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASSY P/N
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
PCN 98034A 98043A NSN P/N 98042A 98057A	CBEC04	88097	55	290	PCN NSN P/N 375059	98034A 98043A 549 98042A 98057A		
PCN NSN P/N					PCN NSN P/N 375057	550		
PCN NSN P/N					PCN NSN P/N 358281	551		
PCN NSN P/N					PCN NSN P/N 375058	552		
PCN NSN P/N					PCN NSN P/N 358278	553		
PCN NSN P/N					PCN NSN P/N 358204	554		
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			
PCN NSN P/N					PCN NSN P/N			

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