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

BOOK 2 OF 5

DATABASE DOCUMENTATION BOOK

OO-ALC

MANPRA

(C5 MAIN LANDING GEAR - WCD'S)

CONTRACT SUMMARY REPORT
15 DECEMBER 1989

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

A-1 23

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

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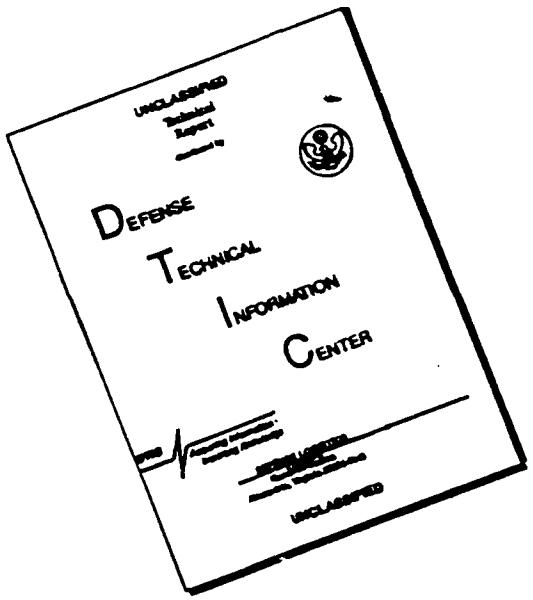

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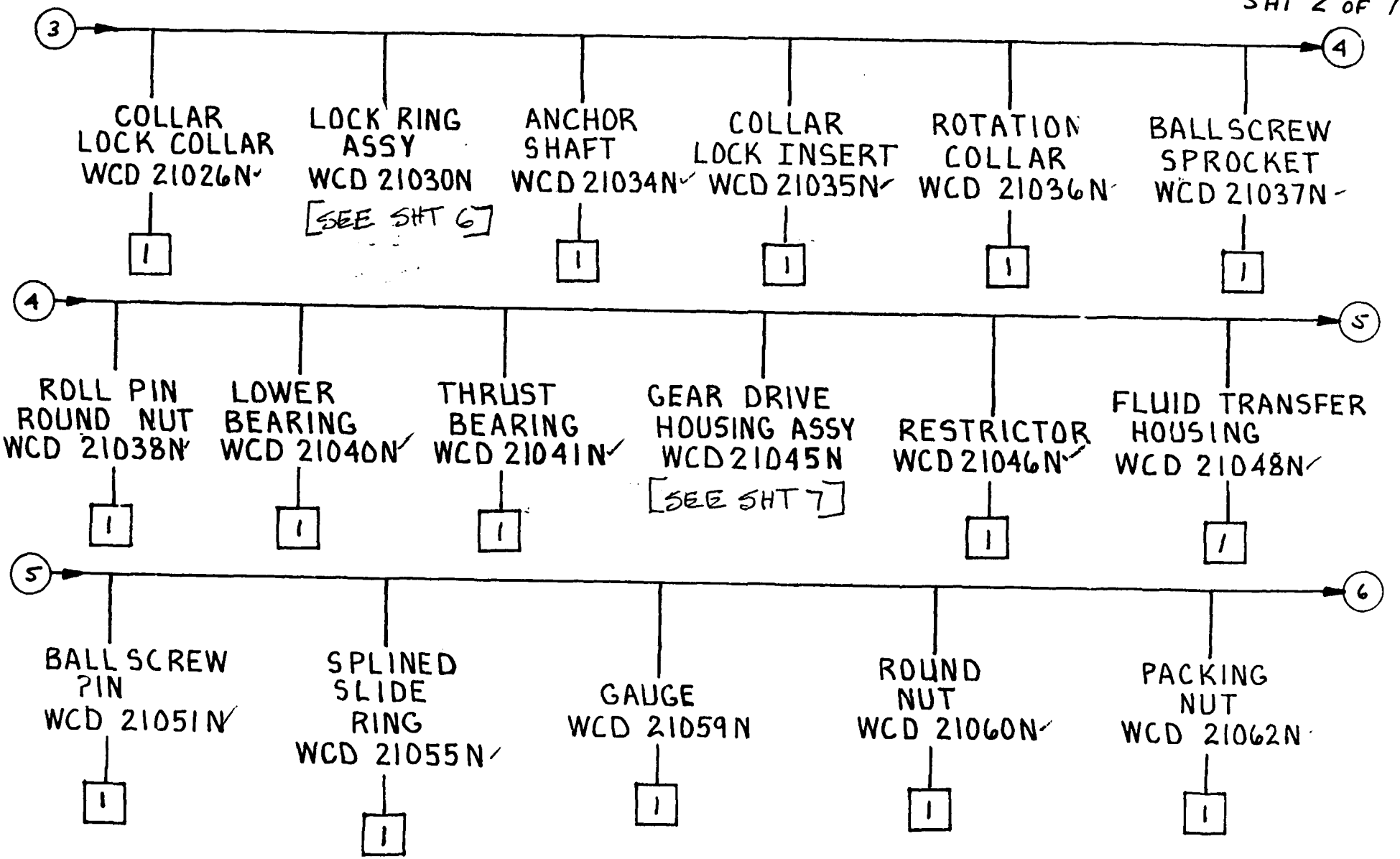
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COLLAR
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ROTATION
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SPROCKET
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ROLL PIN
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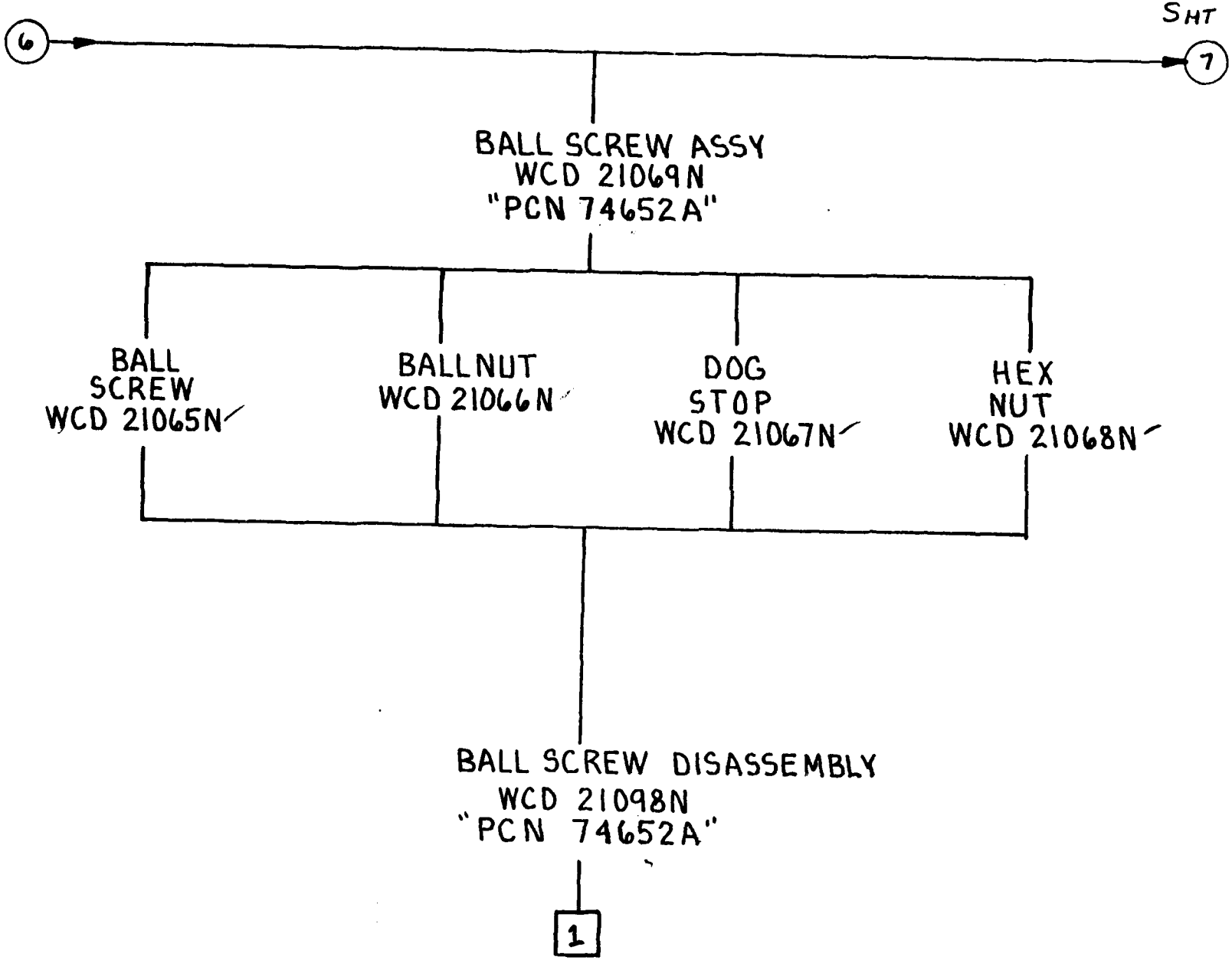
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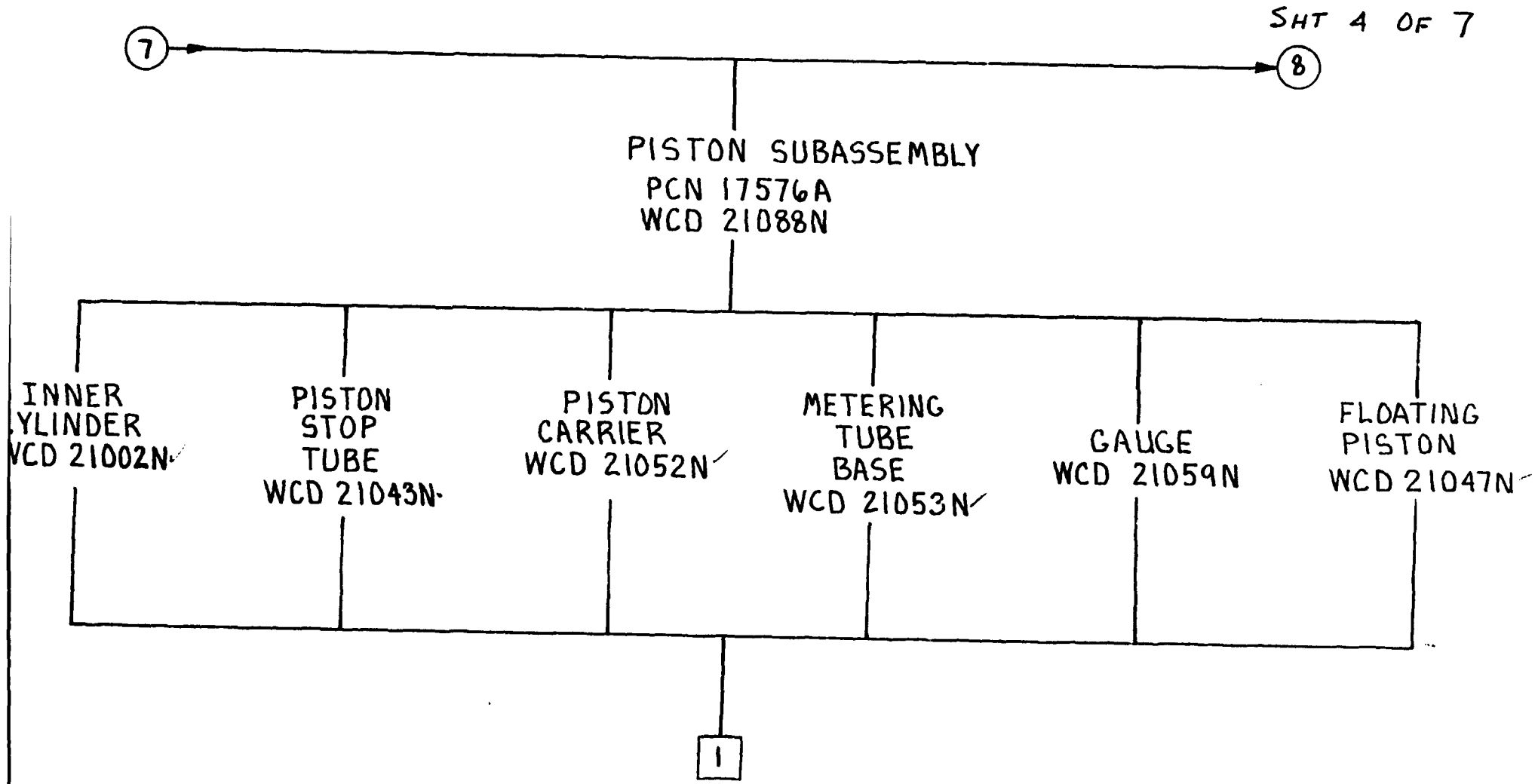
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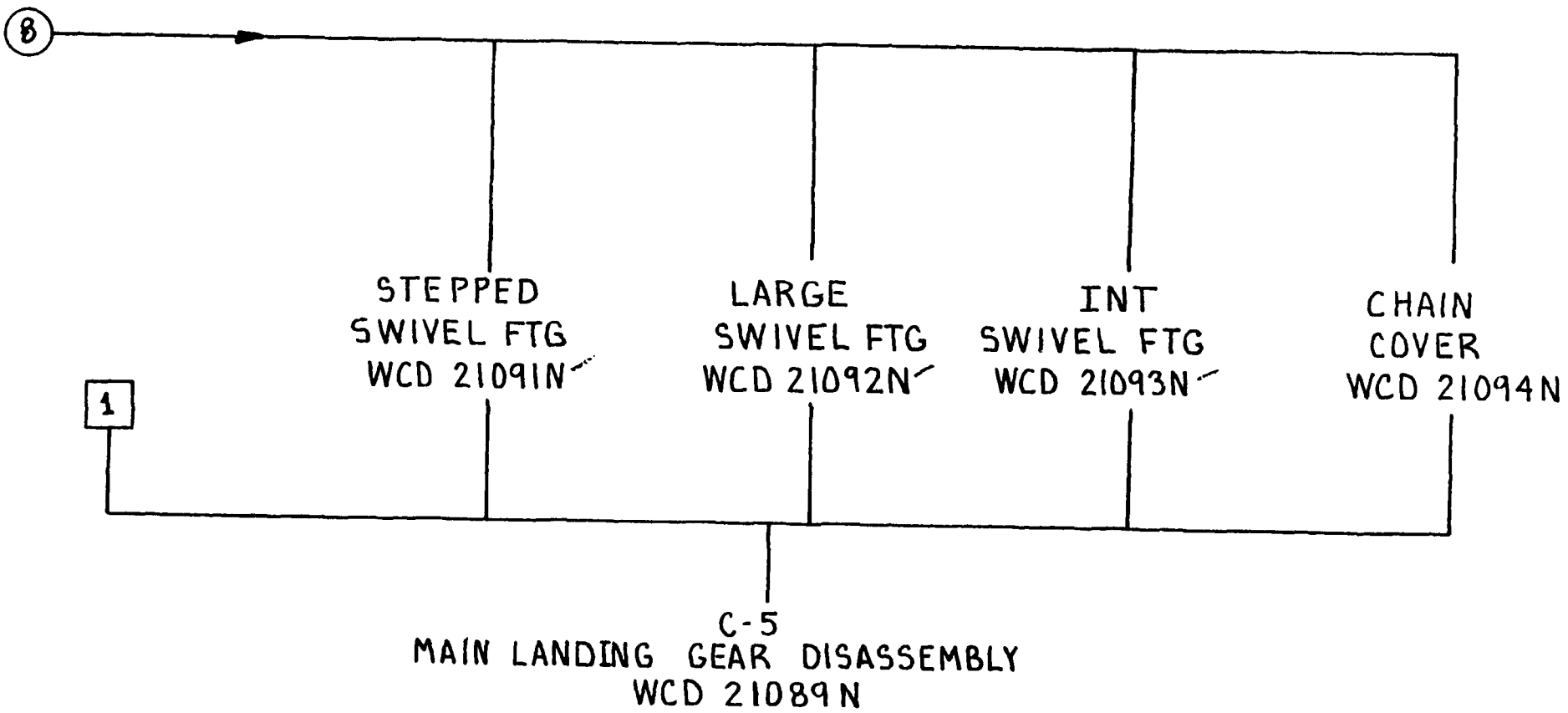
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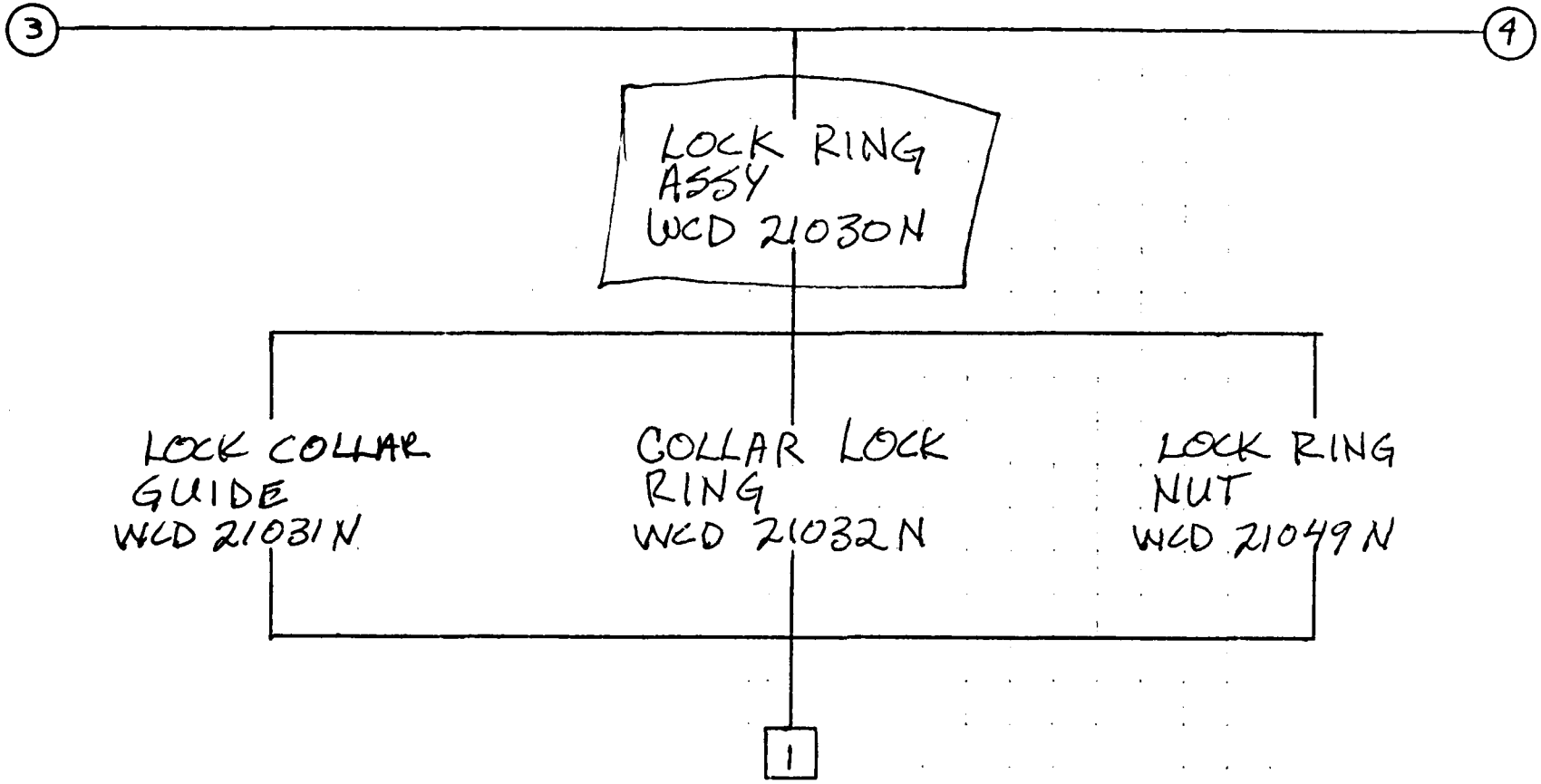
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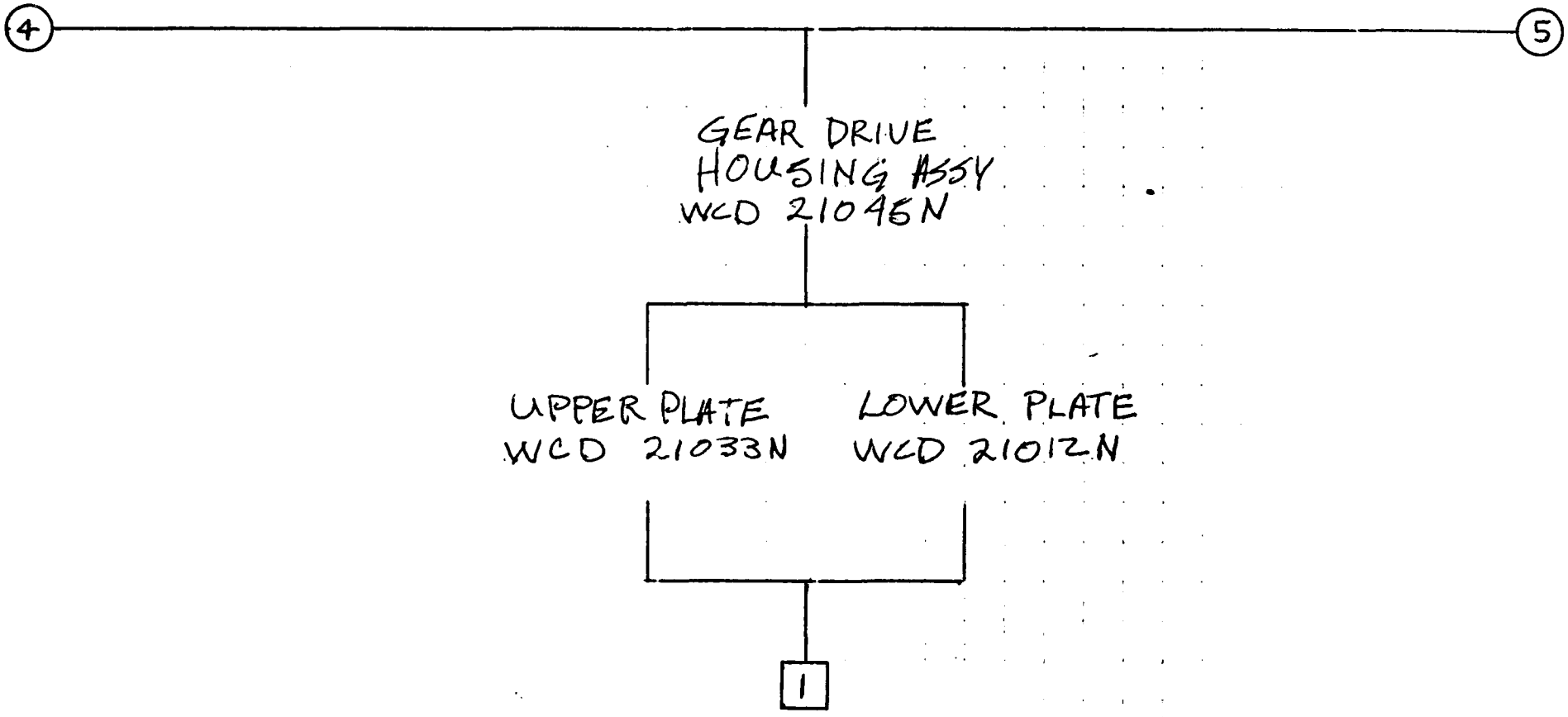
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DBB*8

C5171LG Break

C-5A MLG

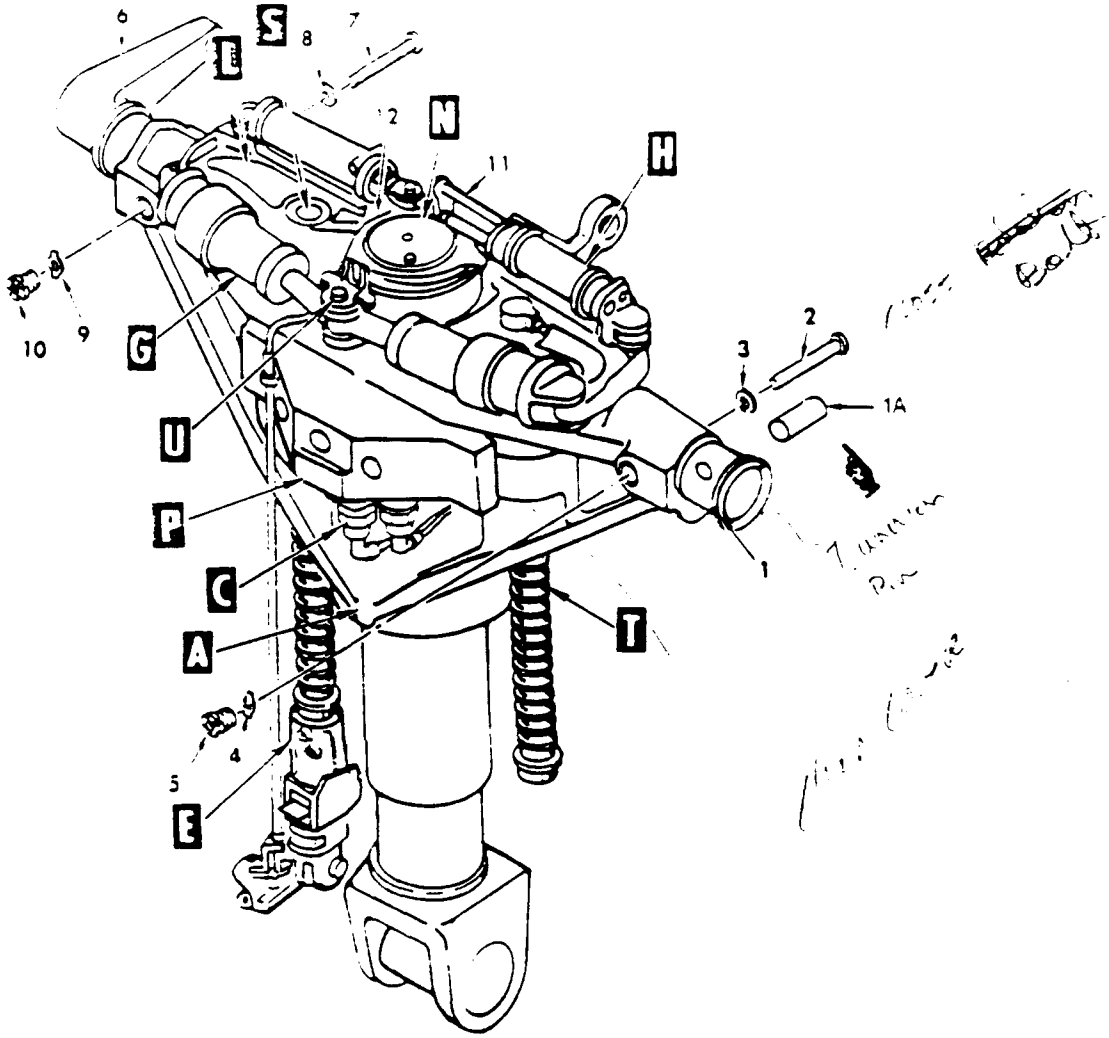

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Figure 2-8. RH Ant Strut Assembly Sheet 1 of 18

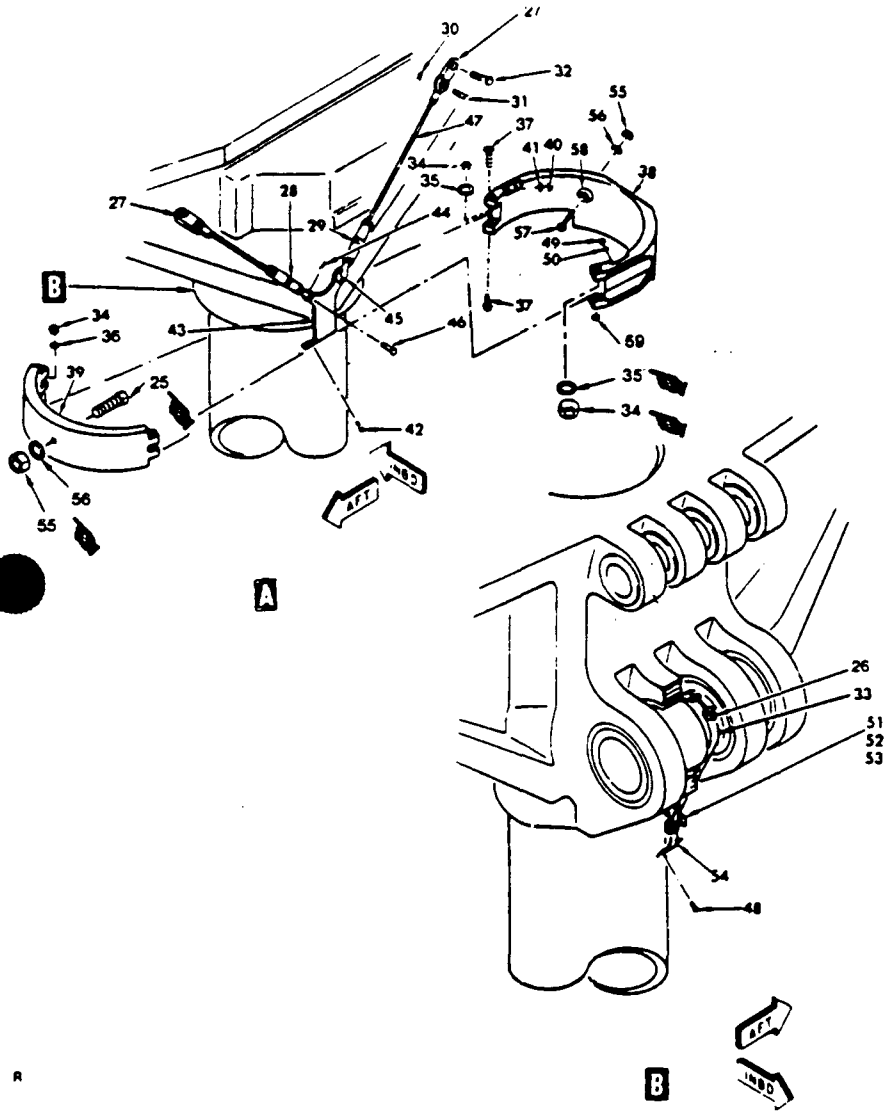

Figure 2-8. RH Aft Strut Assembly (Sheet 2 of 18)

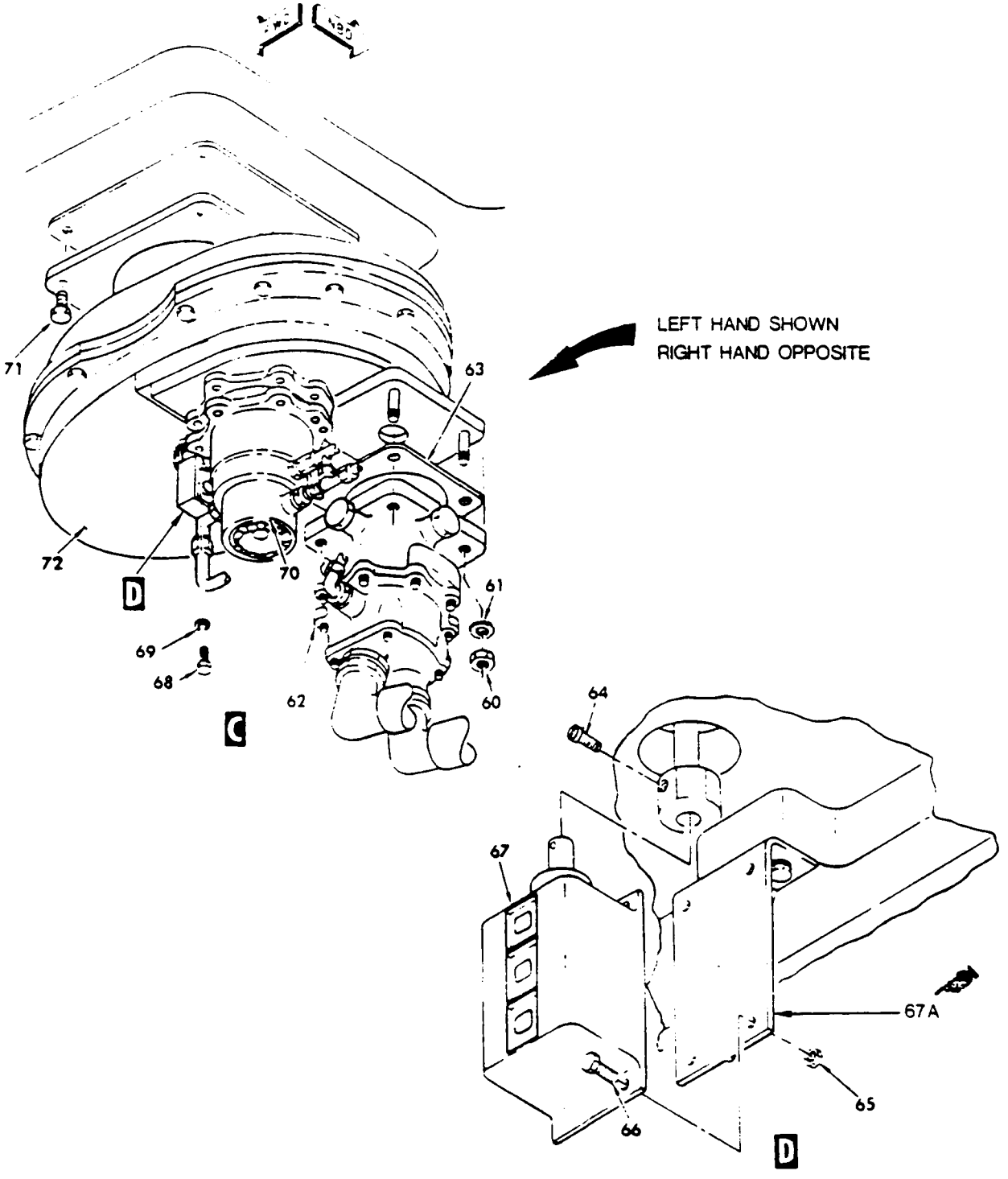

Figure 2-8. RH Aft Strut Assembly (Sheet 3 of 18)

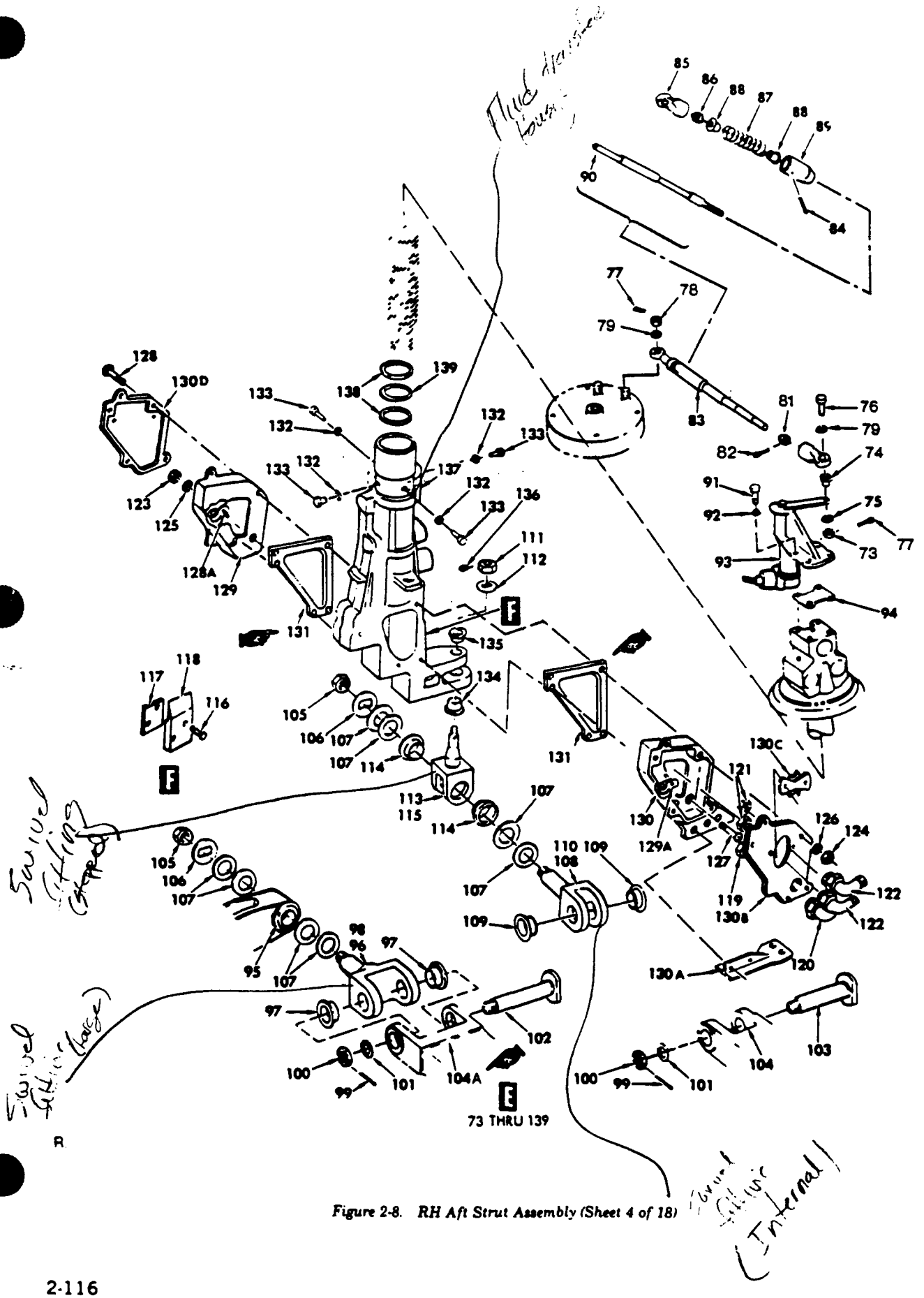

Figure 2-8. RH Aft Strut Assembly (Sheet 4 of 18)

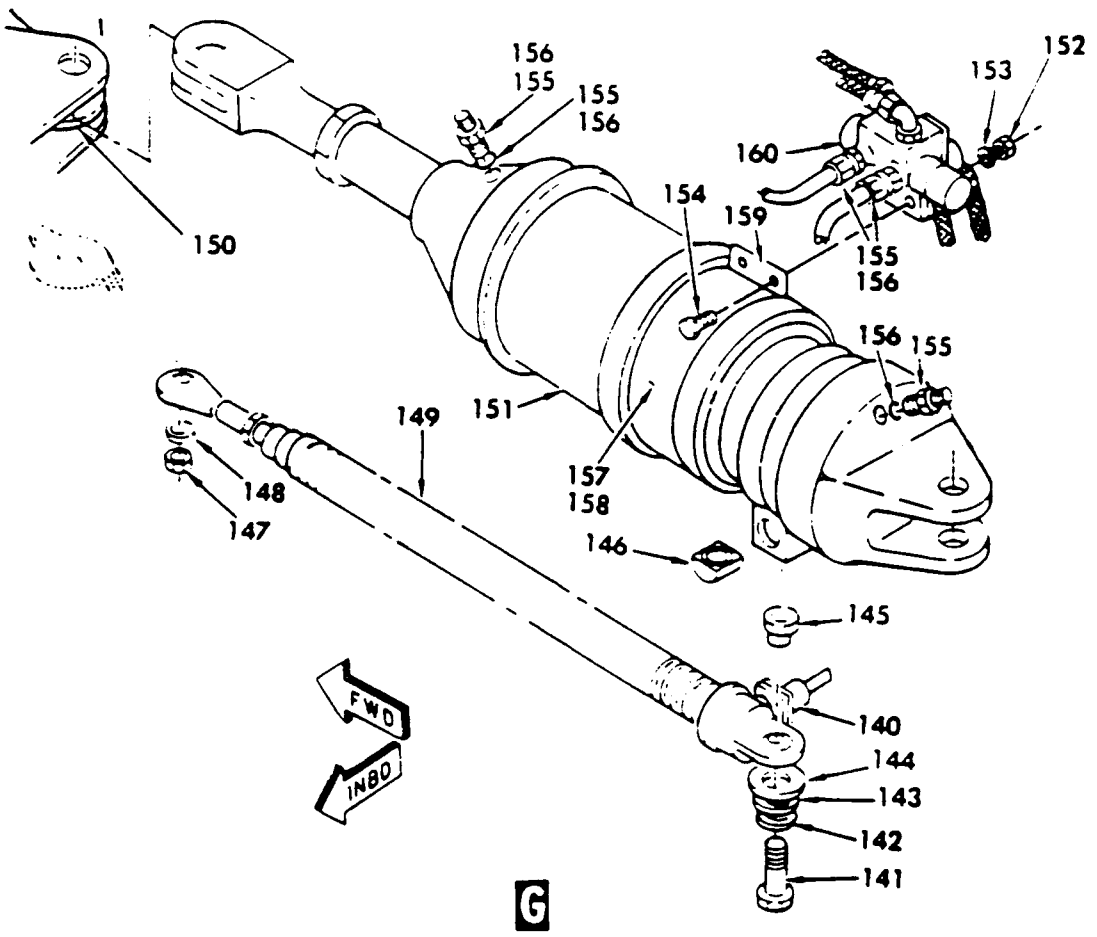

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Figure 2-8. RH Aft Strut Assembly (Sheet 5 of 18)

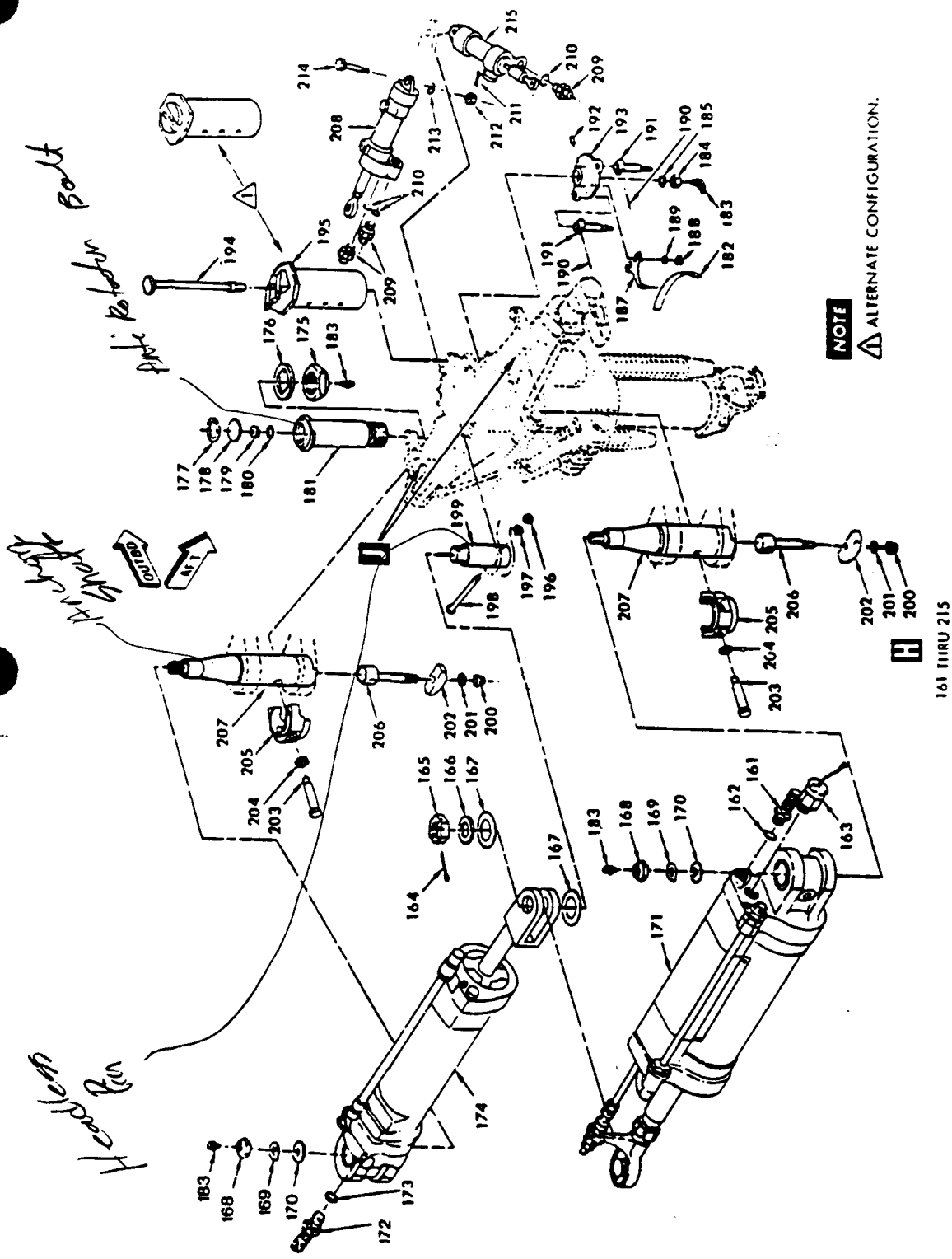

Figure 2-8. RH Aft Strut Assembly (Sheet 6 of 18)

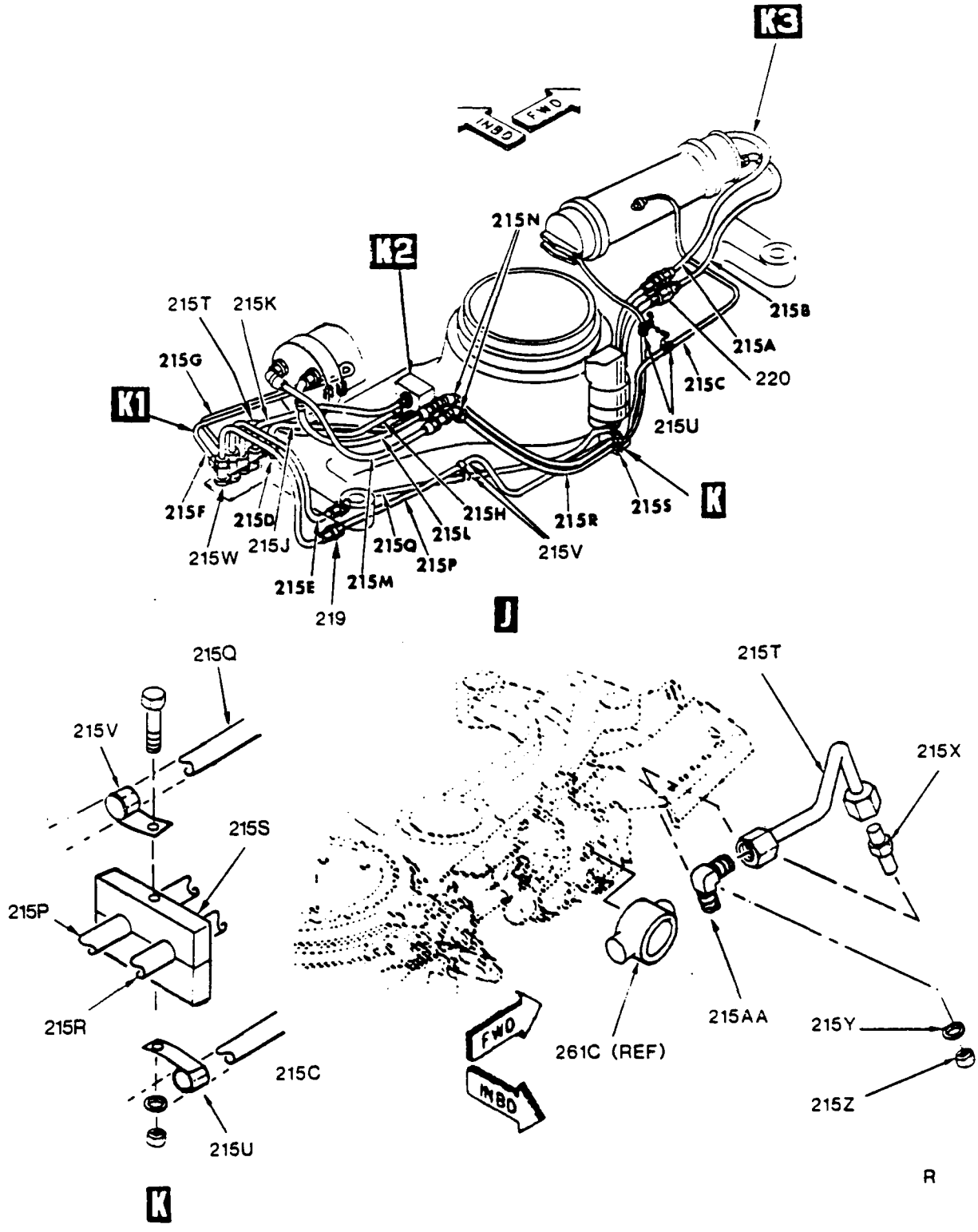

Figure 2-8. RH Aft Strut Assembly (Sheet 7 of 18)

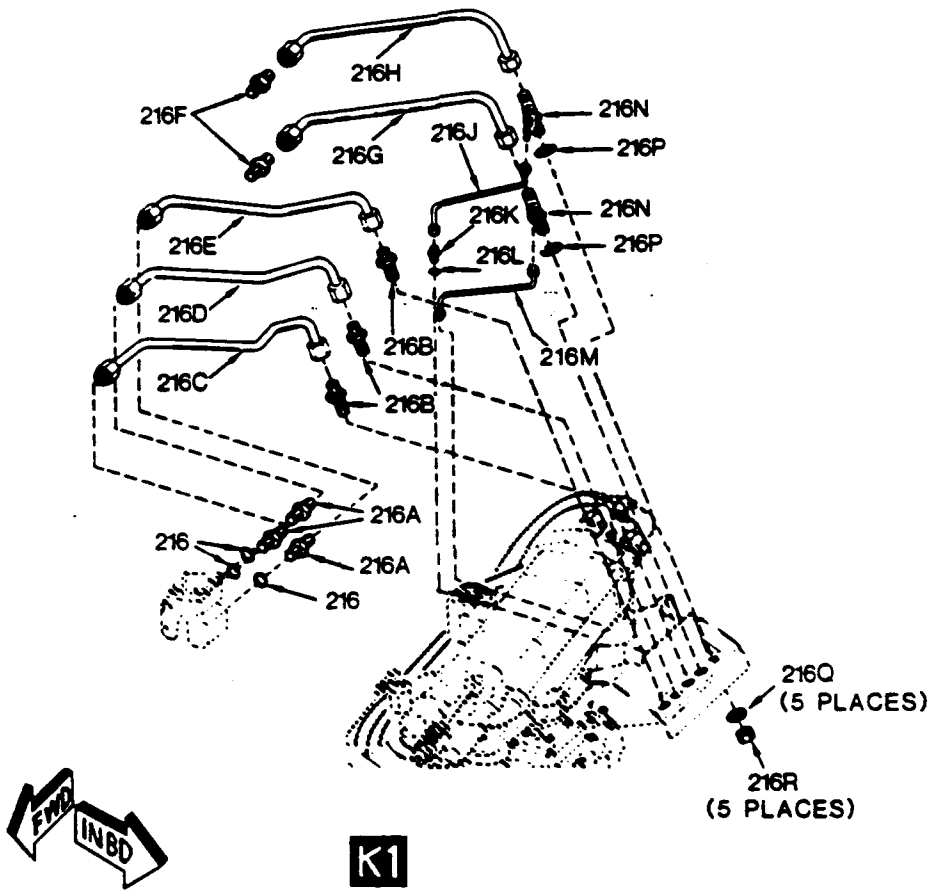

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Figure 2-8. RH Aft Strut Assembly (Sheet 8 of 18)

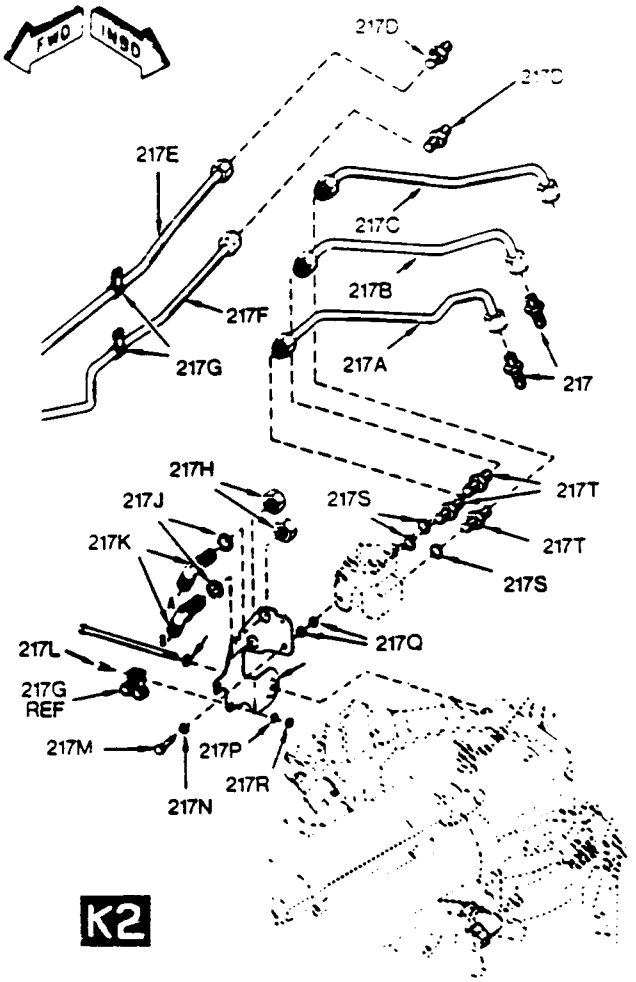

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Figure 2-8. RH Aft Strut Assembly (Sheet 9 of 15)

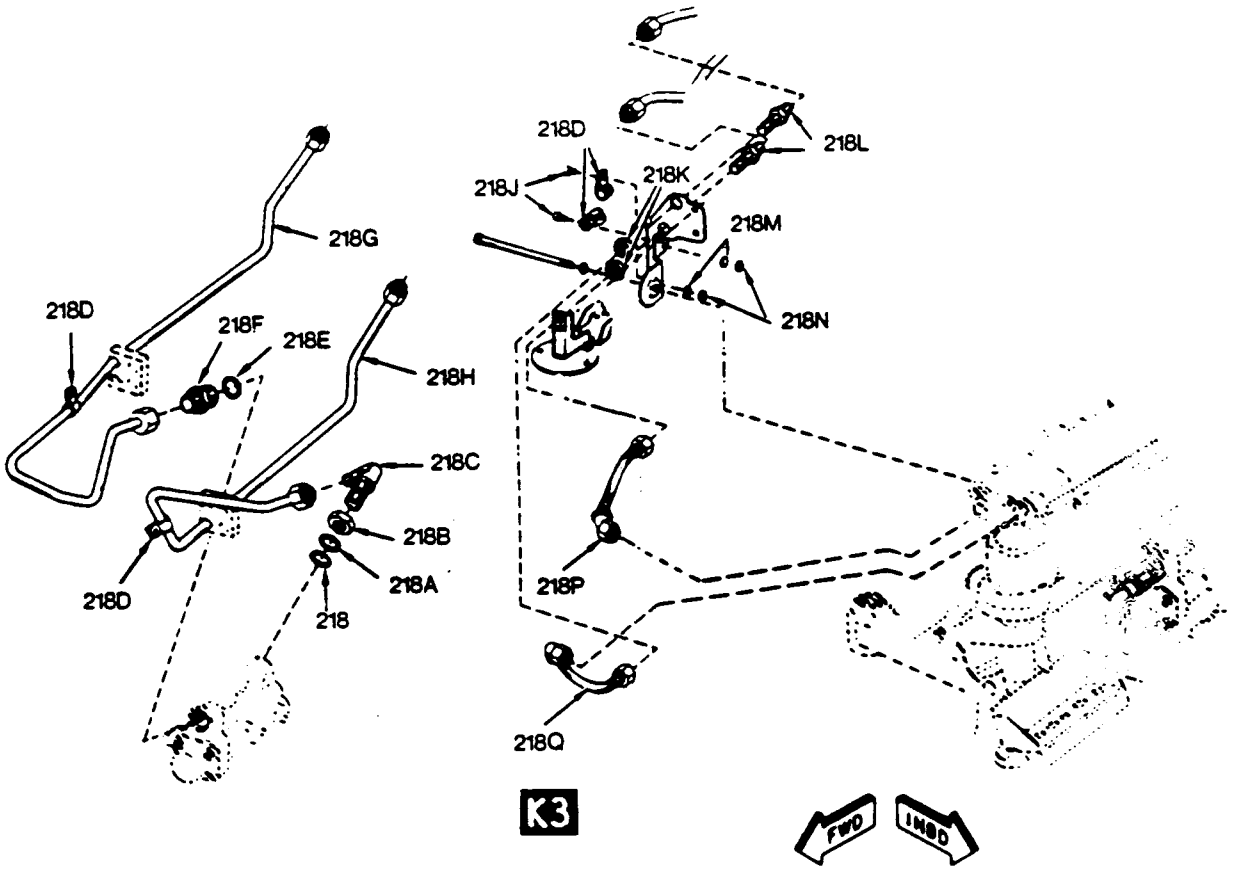

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Figure 2-8. RH Aft Strut Assembly (Sheet 10 of 18)

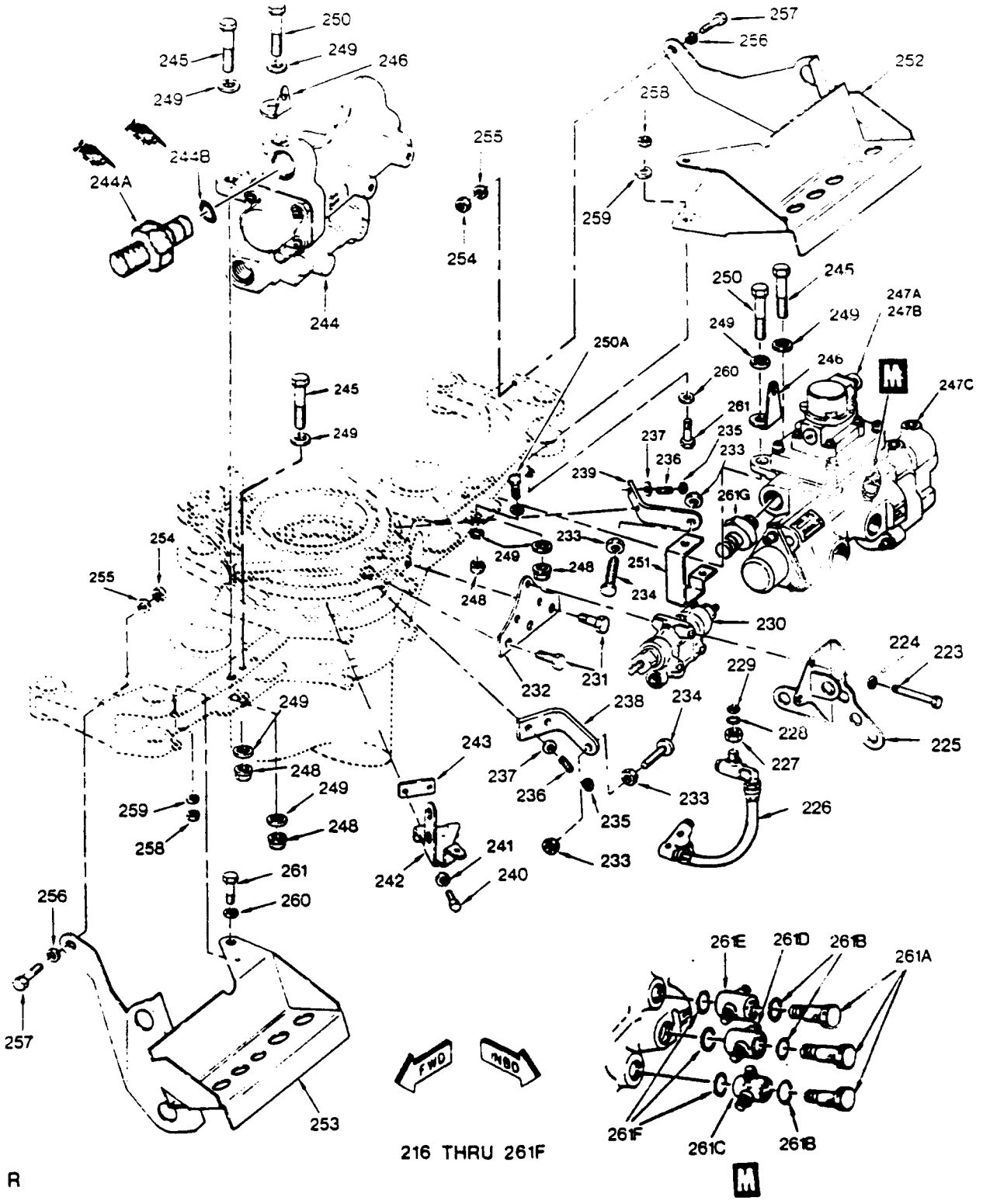

Figure 2-8. RH Aft Strut Assembly (Sheet 11 of 18)

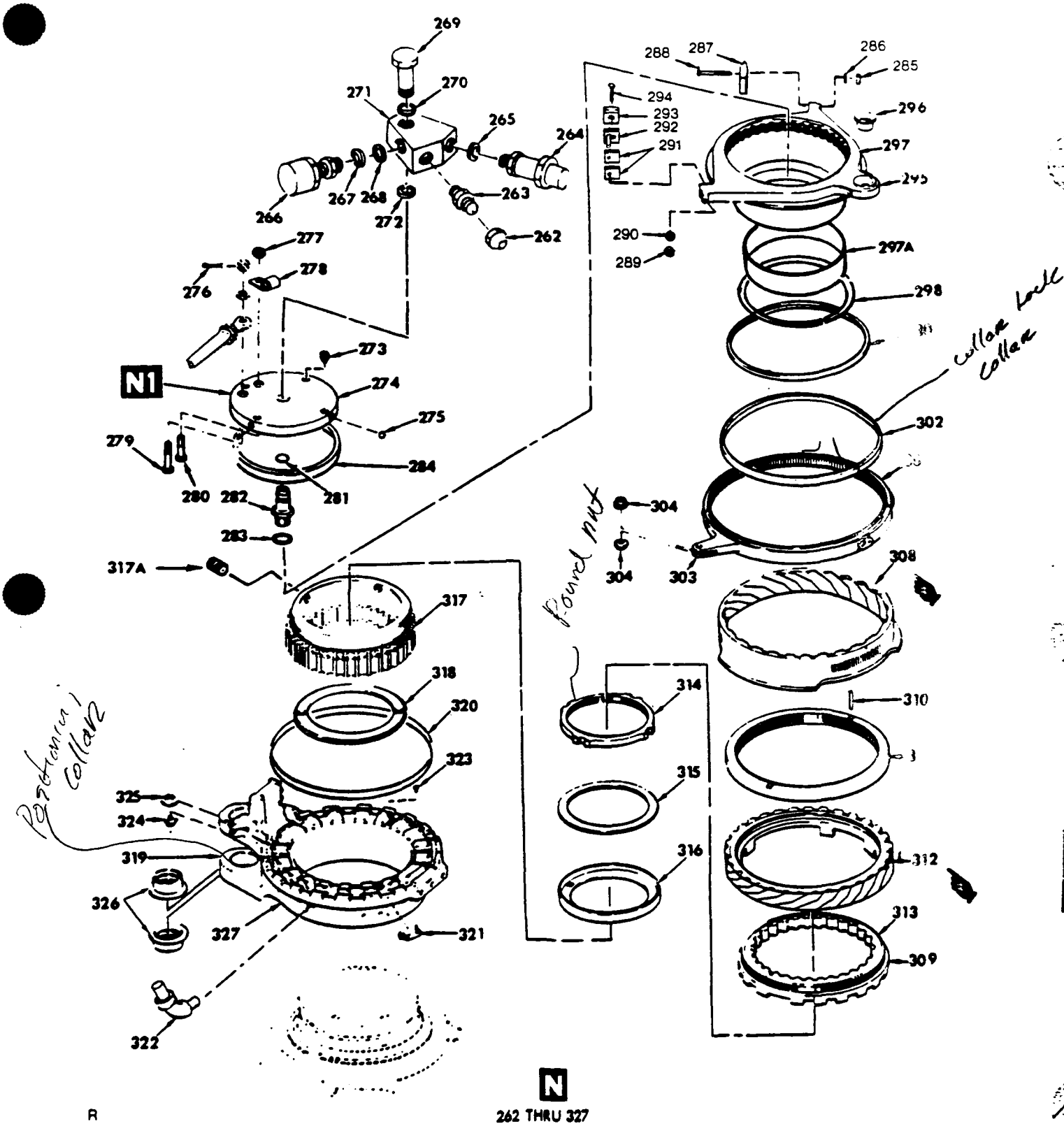

Figure 2-8. RH Aft Strut Assembly (Sheet 12 of 18)

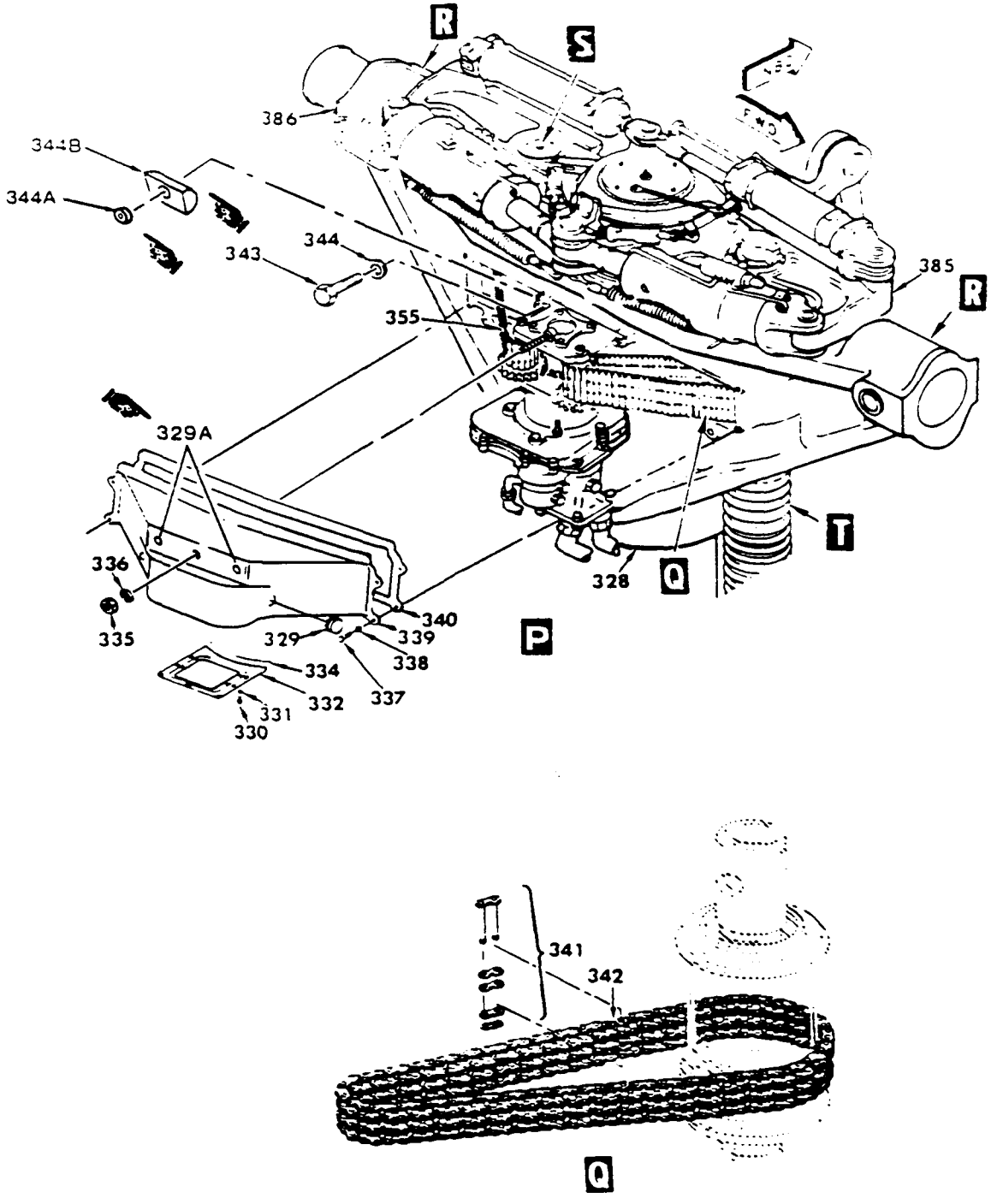

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Figure 2-8. RH Aft Strut Assembly (Sheet 13 of 18)

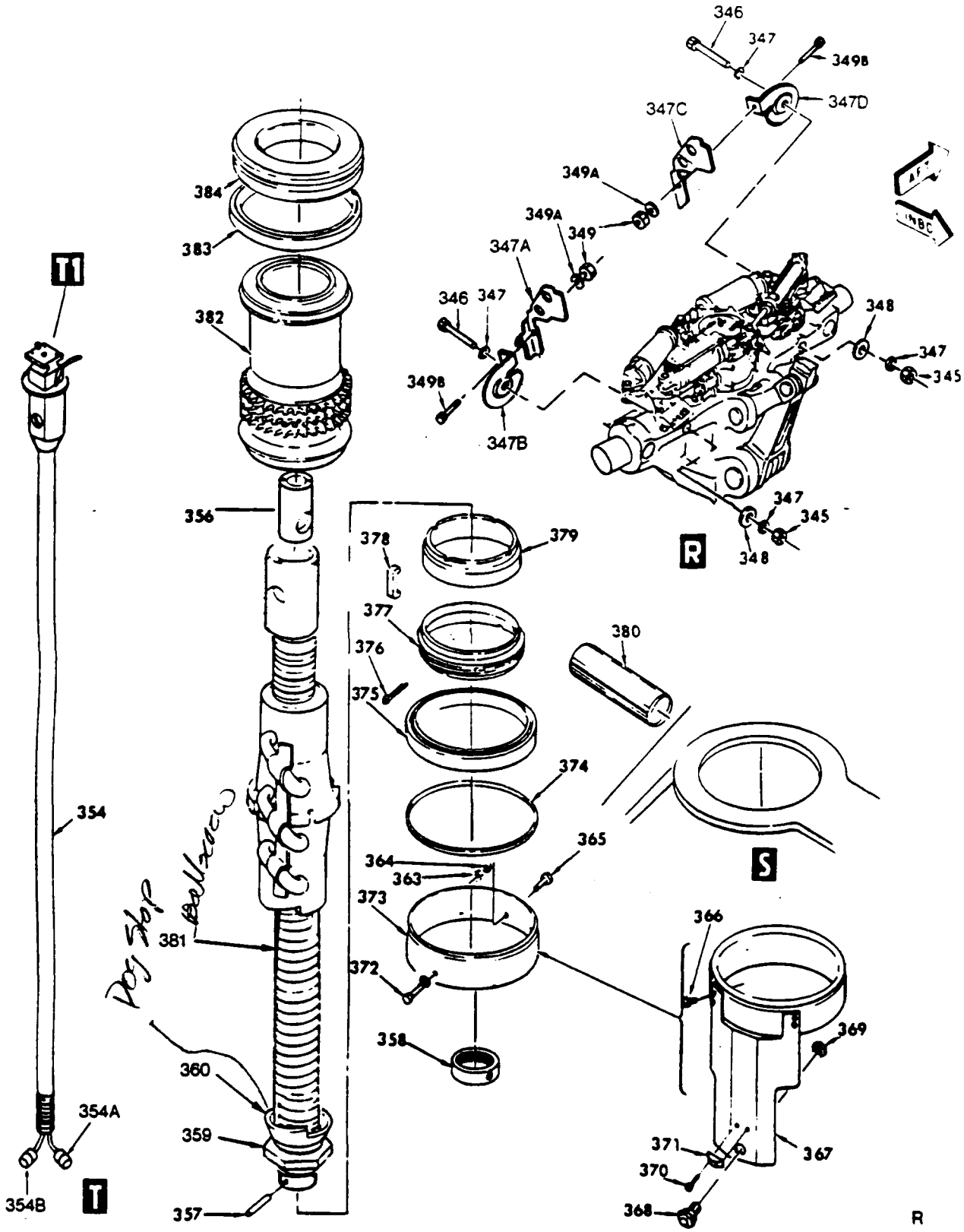
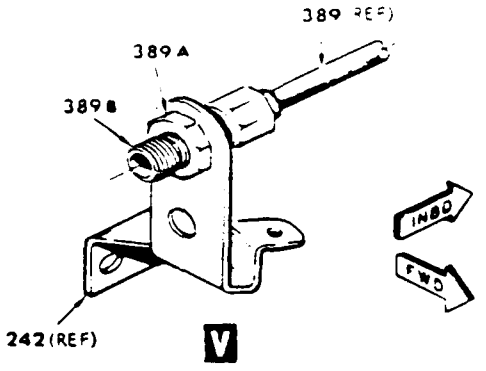


Figure 2-8. RH Aft Strut Assembly (Sheet 14 of 18)



NOTE

2 USE P/N 4G1468B-01A BOLT WITH THIS CONFIGURATION APEX SHAFT.

3 USE P/N 4G1377T-101A BOLT WITH THIS CONFIGURATION APEX SHAFT.

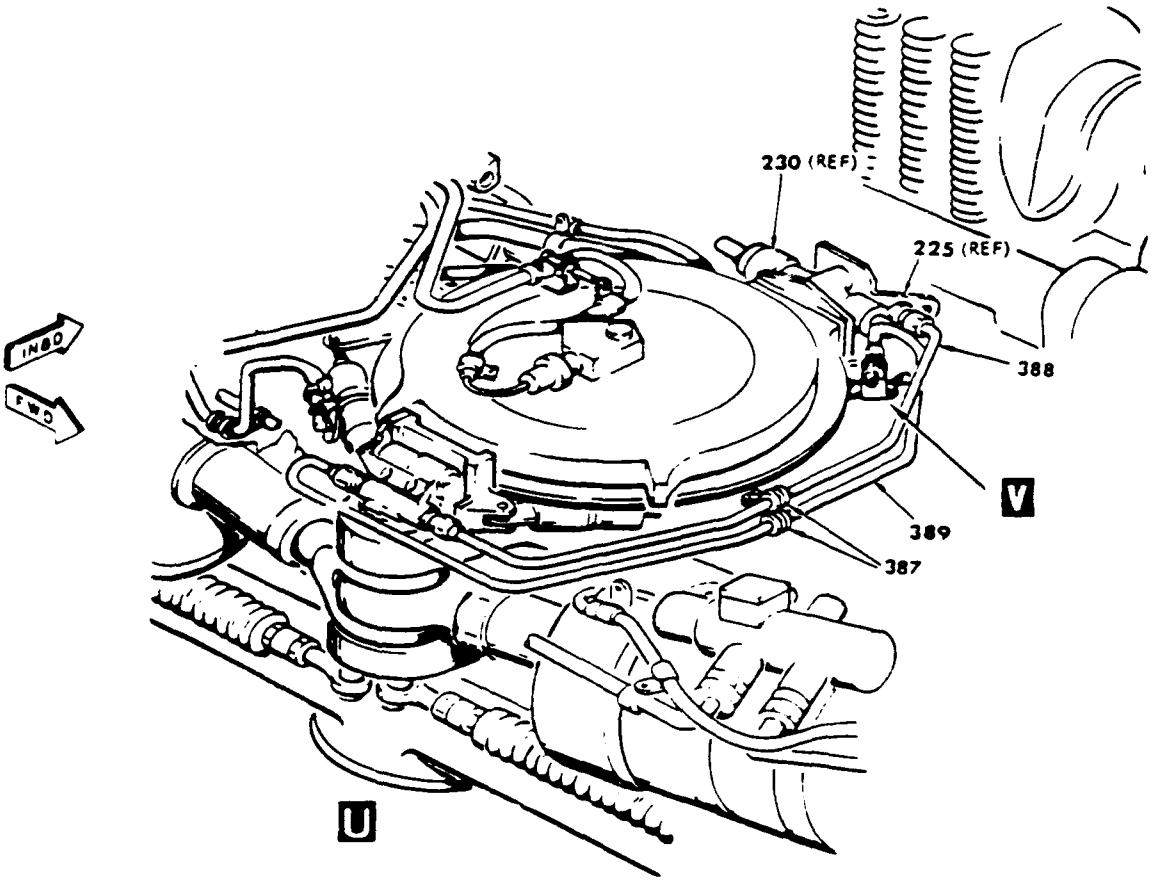


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Figure 2-8. RH Aft Strut Assembly (Sheet 15 of 18)

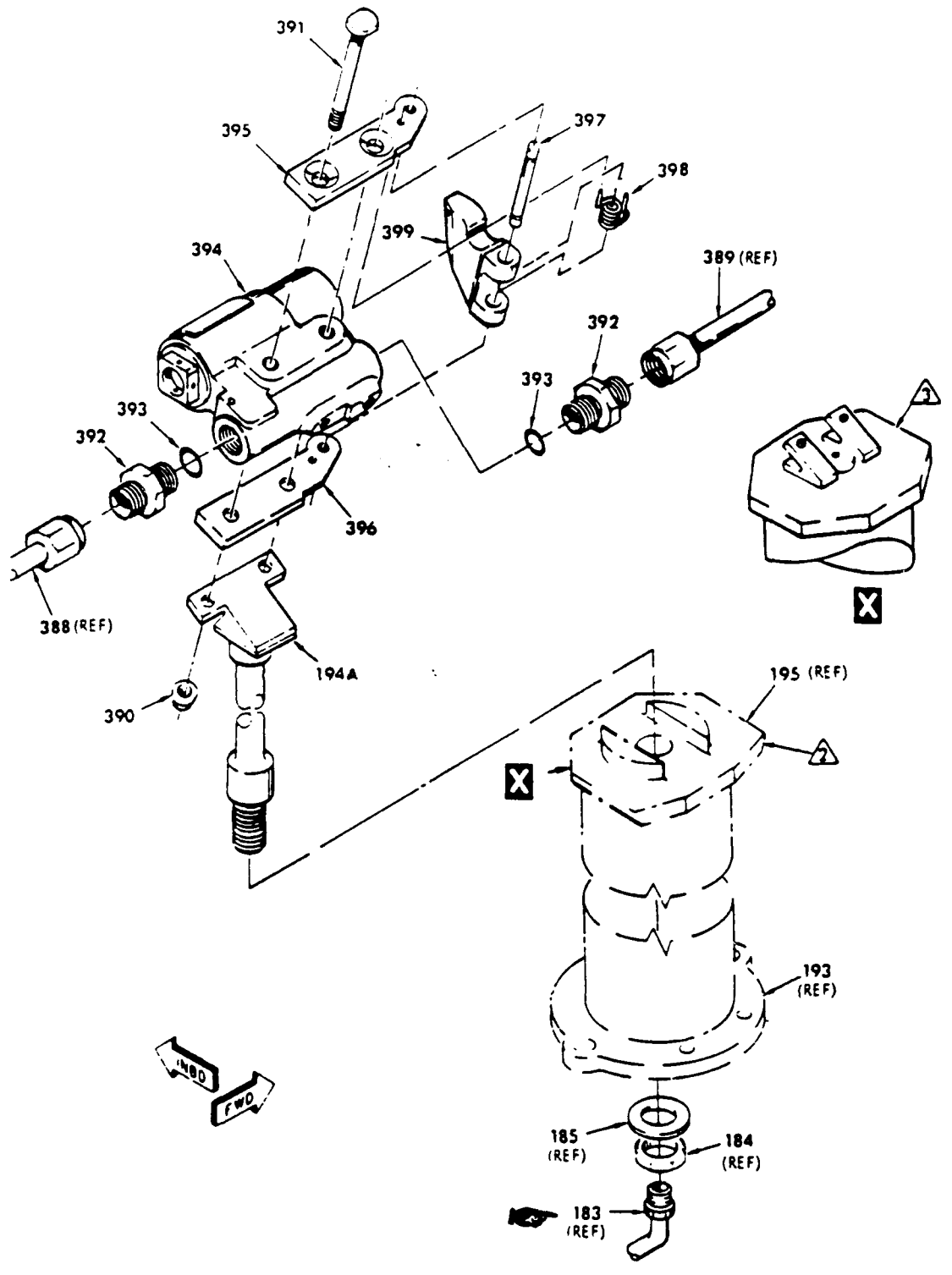

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Figure 2-8. RH Aft Strut Assembly (Sheet 16 of 18)

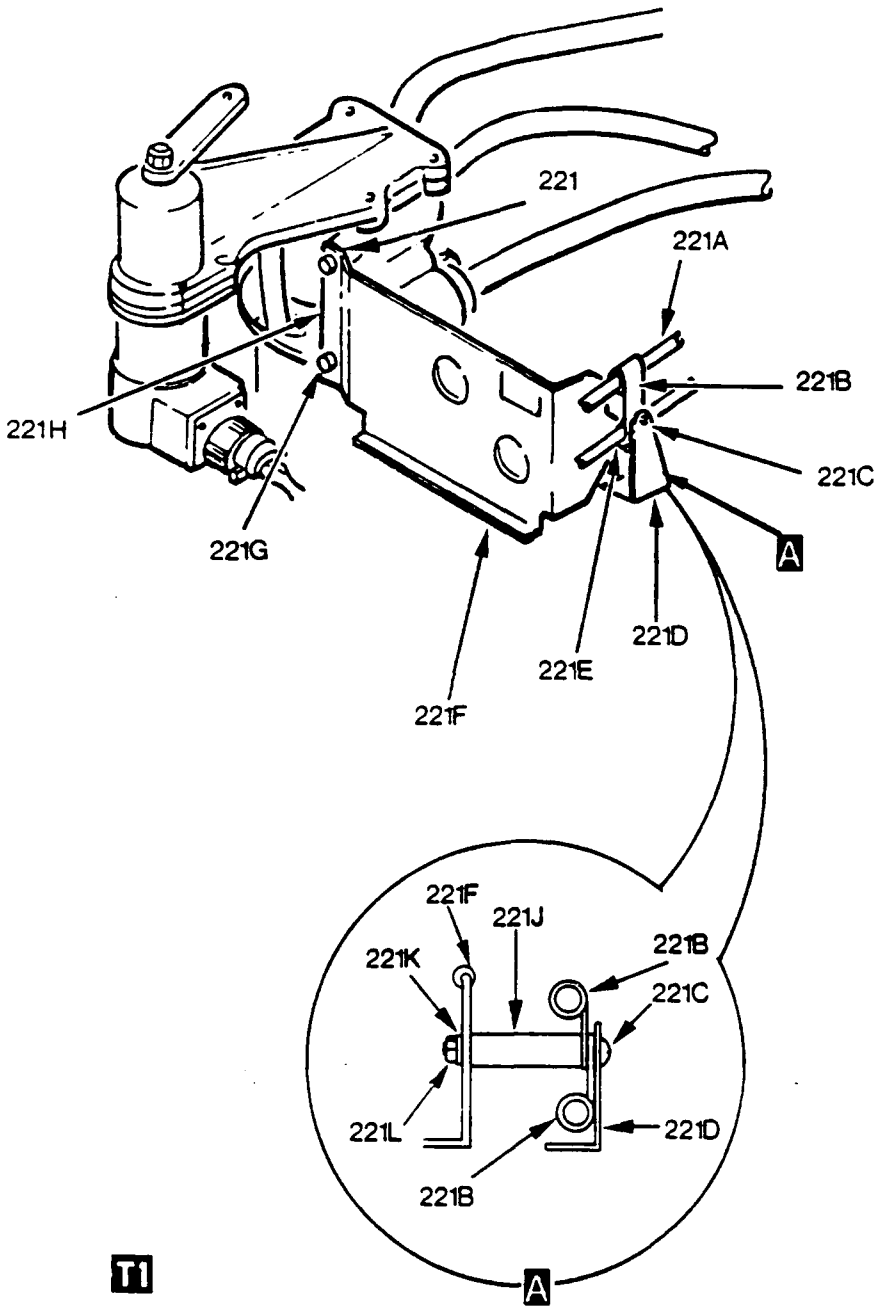

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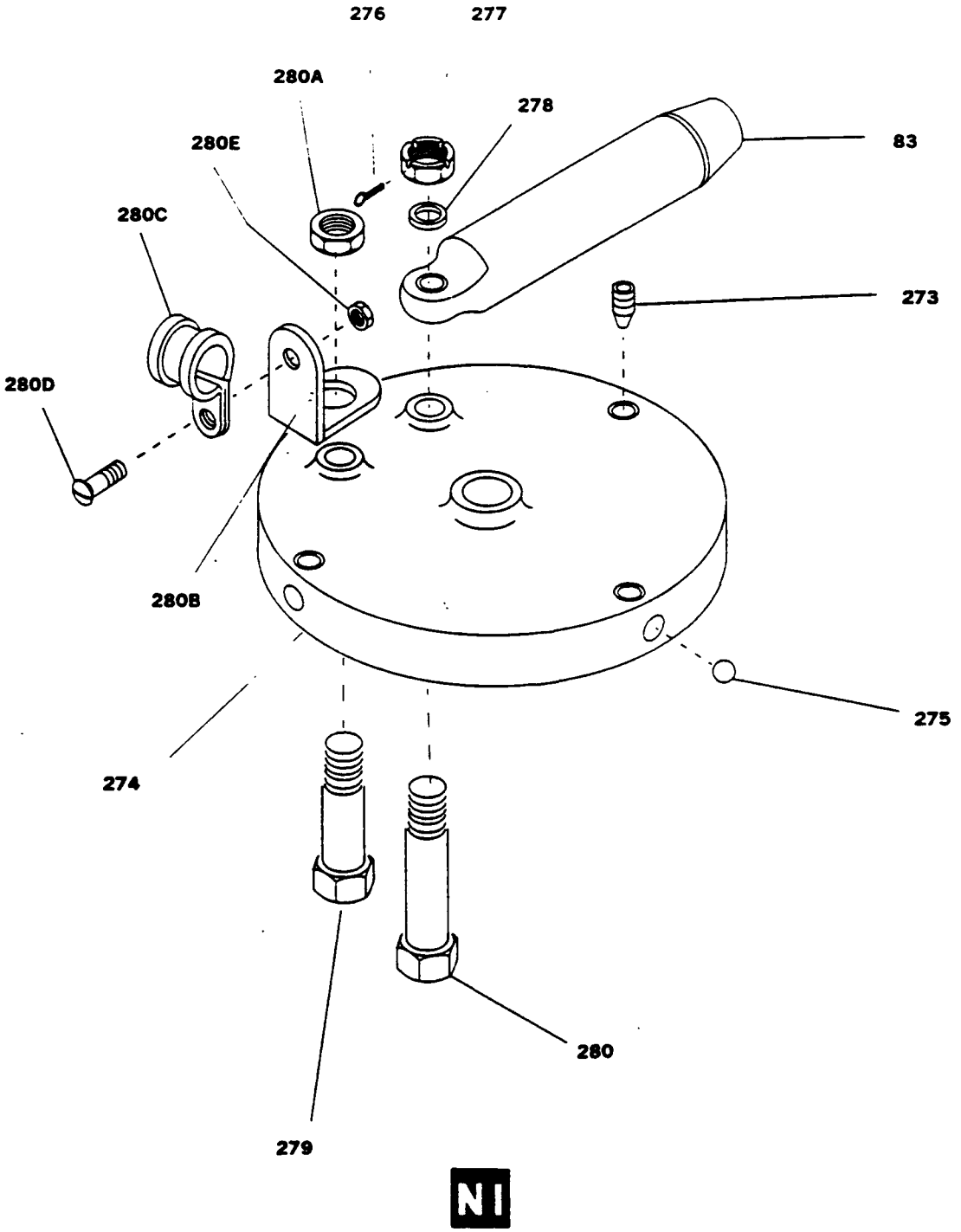
Figure 2-8 RH Aft Strut Assembly (Sheet 17 of 18)



V

Figure 2-8. RH Aft Strut Assembly (Sheet 18 of 18)

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-	4G11400-139A	98897	STRUT ASSEMBLY, RH AFT (See figure 2-1 for NHA)	REF		XA
-1	4G12400-101A	98897	. TRUNNION PIN	1		PADDD
-1A	4G13999-101A	98897	. SLEEVE, Shipping	1		PAOZZ
-2	4G13347-101A	98897	. BOLT (AP)	1		PAOZZ
-3	AN960C3616	88044	. WASHER (AP)	1		PAOZZ
-4	4G13346-101A	98897	. WASHER, Lock (AP)	1		PAOZZ
-5	4G13332-101A	98897	. NUT (AP)	1		PAOZZ
-6	NO NUMBER		. RETRACT ARM, Built-up instl (see figure 2-9)	NP		PAOZZ
-7	4G13347-101A	98897	. BOLT (AP)	1		PAOZZ
-8	AN960C3616	88044	. WASHER (AP)	1		PAOZZ
-9	4G13346-101A	98897	. WASHER, Lock (AP)	1		PAOZZ
-10	4G13332-101A	98897	. NUT (AP)	1		PAOZZ
-11	4G11008-123A	98897	. TUBING INSTL, LH fwd (see figure 2-1 for NHA) (See figure 2-3 for breakdown)	REF		XC
-12	4869130-105A	98897	. WIRING INSTL (See figure 2-1 for NHA) (See figure 2-15 for breakdown)	REF		PADLD
-13	DELETED					
-14	DELETED					
-15	DELETED					
-16	DELETED					
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-24	DELETED					
-25	NAS1634-16	80205	. SCREW	1		PAOZZ
-26	Z1200	72962	. NUT	1		PAOZZ
-27	4G14359-101A	98897	. CLIP	2		PAOZZ
-28	MS21251B5S	96906	. TURNBUCKLE (See figure 2-1 for NHA)	2		PAOZZ
-29	MS21256-1	96906	. CLIP (See figure 2-1 for NHA)	4		PAOZZ
-30	MS24665-132	96906	. PIN, Cotter (see figure 2-1 for NHA)	2		PAOZZ
-31	MS20392-2C13	96906	. PIN, Clevis (see figure 2-1 for NHA)	2		PAOZZ
-32	NAS1106-20D	80205	. BOLT (See figure 2-1 for NHA)	2		PAOZZ
-33	4G11005-121A	98897	. CLAMP (See figure 2-1 for NHA)	1		PAFFF
-34	MS21042-6	96906	. NUT (See figure 2-1 for NHA)	4		PAOZZ
-35	AN960D616	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ
-36	AN960D616L	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ
-37	NAS2806-20	80205	. SCREW (See figure 2-1 for NHA)	4		PAOZZ
-38	4G14354-107A	98897	. COLLAR, Forward (see figure 2-1 for NHA)	1		PAFZZ
-39	4G14355-103A	98897	. COLLAR, Aft (see figure 2-1 for NHA)	1		PAFZZ
-40	MS21042-4	96906	. NUT (See figure 2-1 for NHA)	2		PAOZZ
-41	AN960D416	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ
-42	NAS1634-9	80205	. SCREW (See figure 2-1 for NHA)	2		PAOZZ
-43	4G14364-107A	98897	. PLATE ASSEMBLY (See figure 2-1 for NHA)	1		PAFFF
-44	MS24665-132	96906	. PIN, Cotter (see figure 2-1 for NHA)	2		PAOZZ
-45	MS21252-5LS	96906	. CLEVIS (See figure 2-1 for NHA)	2		PAOZZ
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-47	LS5964R24-0122	98897	. CABLE (See figure 2-1 for NHA)	2		PAOZZ
-48	NAS1624-9	80205	. SCREW (See figure 2-1 for NHA)	2		PAOZZ
-49	MS21042-4	96906	. NUT (See figure 2-1 for NHA)	2		PAOZZ
-50	AN960D416	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ
-51	MS21042-4	96906	. NUT (See figure 2-1 for NHA)	1		PAOZZ
-52	AN960D416	88044	. WASHER (See figure 2-1 for NHA)	1		PAOZZ
-53	NAS1634-3	80205	. SCREW (See figure 2-1 for NHA)	1		PAOZZ
-54	4G14366-101A	98897	. PLATE ASSEMBLY (See figure 2-1 for breakdown)	1		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-55	MS21042-4	96906	. NUT	3		PAOZZ
-56	AN960D416	88044	. WASHER	3		PAOZZ
-57	NAS1634-21	80205	. SCREW	2		PAOZZ
-58	4G14367-101A	98897	. PLUG (See figure 2-1 for NHA)	3		PAOZZ
-59	LS3859-6-26	98897	. BUSHING (See figure 2-1 for NHA)	2		PAFZZ
-60	MS21042-5	96906	. NUT (See figure 2-4 for NHA)	4		PAOZZ
-61	AN960D516	88044	. WASHER (See figure 2-4 for NHA)	4		PAOZZ
-62	68030	75250	. MOTOR, Hydraulic (see figure 2-4 for NHA) (LAC spec 4G94032-101A)	1		PAFLD
	68030-03	75250	. MOTOR, Hydraulic (see figure 2-4 for NHA) (LAC spec 4G94032-101B) (preferred spare for part No. 68030) (see T.O. 9H10-3-48-3)	1		PAFLD
-63	4G11019-105A	98897	. SPACER (See figure 2-4 for NHA)	1		PAOZZ
-64	MS35265-41	96906	. SCREW (See figure 2-4 for NHA)	1		PAOZZ
-65	MS21042-06	96906	. NUT (See figure 2-4 for NHA)	4		PAOZZ
-66	NAS601-8P	80205	. SCREW (See figure 2-4 for NHA)	4		PAOZZ
-67	743133-002	79142	. COUNTER (See figure 2-4 for NHA)	1		PAFZZ
-67A	42252D35	00426	. BRACKET ANGLE	1		PAOZZ
-68	AN4H10A	88044	. BOLT	5		PAOZZ
-69	AN960PD416	88044	. WASHER	5		PAOZZ
-70	42252E220	00426	. BRAKE ASSEMBLY (LAC spec 4G94033-105A) (see T.O. 16G1-150-3)	1		PAFLD
-71	NAS1306-5	80205	. BOLT (See figure 2-4 for NHA)	4		PAOZZ
-72	42252R150	00426	. GEARBOX ASSEMBLY (LAC spec 4G94033-103A) (see T.O. 16G1-150-3) (see figure 2-4 for NHA)	1		PAFLD
-73	AN320-3	88044	. NUT	1		PAOZZ
-74	LS607-11	98897	. SPACER	1		PAFZZ
-75	AN960-10	88044	. WASHER	1		PAOZZ
-76	AN23-23	88044	. SCREW	1		PAOZZ
	AN23-22	88044	. SCREW (Alternate)	1		PAOZZ
-77	MS24665-153	96906	. PIN, Cotter	2		PAOZZ
-78	MS17826-3	96906	. NUT (AN320-3 suitable substitute)	1		PAOZZ
-79	AN960PD10L	88044	. WASHER	2		PAOZZ
-80	DREFS3	81376	. ROD END	1		PAFZZ
	FR-3DE	81376	. ROD END (Alternate)	1		PAFZZ
-81	NAS509-4	80205	. NUT	1		PAOZZ
-82	NAS559-1	80205	. LOCK	1		PAOZZ
-83	4G14512-101A	98897	. PUSH ROD ASSEMBLY	1		PAFFF
-84	MS35674-17	96906	. . PIN	1		PAOZZ
-85	4G14510-101A	98897	. . ROD END	1		PAFZZ
-86	MS21042-4	96906	. . NUT	1		PAOZZ
-87	LC059G12MW	98897	. . SPRING	1		PAFZZ
-88	4G14509-101A	98897	. . RETAINER	2		PAOZZ
-89	4G14511-101A	98897	. . CYLINDER	1		PAFZZ
-90	4G14508-101A	98897	. . PUSH ROD	1		PAFFF
-91	NAS1304-6H	80205	. BOLT	4		PAOZZ
-92	LS5984S4M	98897	. WASHER	4		PAOZZ
-93	4G14515-101A	98897	. SYNCHRO TRANSMITTER	1		PAFLD
-94	4G13864-101A	98897	. SHIM	1		PAFZZ
-95	4G12033-101A	98897	. FITTING	1		PAFFF
-96	4G12584-101A	98897	. FITTING ASSEMBLY	1		PAOFF
-97	MS21241-12A010	96906	. . BEARING	2		PAOZZ
-98	4G12584-103A	98897	. . FITTING	1		XA
-99	MS24665-372	96906	. PIN, Cotter	2		PAOZZ
-100	AN320-10	88044	. NUT	2		PAOZZ
-101	AN960-1016	88044	. WASHER	2		PAOZZ
-102	4G13802-101A	98897	. BOLT, Special	1		PAOZZ
-103	4G13802-103A	98897	. BOLT, Special	1		PAOZZ
-104	4G12029-105A	98897	. LINK ASSEMBLY, Touchdown	REF		PAFBZ
-104A	4G94025-103A	98897	. 7 PORT VALVE (Source control for vendor part No. 38880-1) (99643)	REF		PAFDD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-105	MS21083D8	96906	. NUT	2		PAOZZ
-106	4G13798-101A	98897	. WASHER, Special	2		PAOZZ
-107	4G13799-101A	98897	. WASHER, Flat	8		PAOZZ
-108	4G12585-101A	98897	. FITTING ASSEMBLY	1		PAOFF
-109	MS21241-12A010	96906	. . BEARING	2		PAOZZ
-110	4G12585-103A	98897	. . FITTING	1		XA
-111	MS21083D5	96906	. NUT	1		PAOZZ
-112	4G13803-101A	98897	. WASHER, Special	1		PAOZZ
-113	4G12586-101A	98897	. FITTING ASSEMBLY	1		PAOFF
-114	MS21241-12A010	96906	. . BEARING	2		PAOZZ
-115	4G12586-103A	98897	. . FITTING	1		XA
-116	AN502-10-16	88044	. BOLT (See figure 2-4 for NHA)	2		PAOZZ
-117	4G11019-107A	98897	. SPACER (See figure 2-4 for NHA)	1		PAFZZ
-118	4G14394-101A	98897	. CAM (See figure 2-4 for NHA)	1		PAFZZ
-119	AN3066-6	88044	. NUT (Not shipped with gear)	1		PAOZZ
-120	AN3063-6	88044	. ELBOW (Not shipped with gear)	1		PAOZZ
-121	AN3066-8	88044	. NUT (Not shipped with gear)	2		PAOZZ
-122	AN3063-8	88044	. ELBOW (Not shipped with gear)	2		PAOZZ
-123	MS25082-3	96906	. NUT (Not shipped with gear)	3		PAOZZ
-124	MS21042-3	96906	. NUT (Not shipped with gear)	2		PAOZZ
-125	MS35338-43	96906	. WASHER	3		PAOZZ
-126	AN960D10	88044	. WASHER (Not shipped with gear)	2		PAOZZ
-127	NAS603-30P	80205	. SCREW	3		PAOZZ
-128	NAS603-72P	80205	. SCREW	2		PAOZZ
-128A	AN735D14	88044	. CLAMP	1		PAOZZ
	MS24693S31	96906	. SCREW (AP)	1		PAOZZ
	NAS43DD1-28	80205	. SPACER (AP)	1		PAOZZ
	MS25082-1	96906	. NUT (AP)	1		PAOZZ
	MS21042-06	96906	. NUT (AP)	1		PAOZZ
-129	4869017-101A	98897	. JUNCTION BOX	1		PAFZZ
-129A	AN735D14	88044	. CLAMP	1		PAOZZ
	MS24693S31	96906	. SCREW (AP)	1		PAOZZ
	NAS43DD1-28	80205	. SPACER (AP)	1		PAOZZ
	MS25082-1	96906	. NUT (AP)	1		PAOZZ
	MS21042-06	96906	. NUT (AP)	1		PAOZZ
-130	4869016-102A	98897	. JUNCTION BOX	1		PAFZZ
-130A	4869024-101A	98897	. BRACKET	1		PAFZZ
	NAS603-10P	80205	. SCREW (AP)	3		PAOZZ
	AN960D10	88044	. WASHER (AP)	3		PAOZZ
	MS21042-3	96906	. NUT (AP)	3		PAOZZ
-130B	4869020-101A	98897	. COVER ASSEMBLY (Not shipped with gear)	1		PAOZZ
	4869020-103A	98897	. GASKET (Not shipped with gear) (AP)	1		PAOZZ
	NAS601-10P	80205	. SCREW (Not shipped with gear) (AP)	3		PAOZZ
	AN960D6	88044	. WASHER (Not shipped with gear) (AP)	3		PAOZZ
	MS21042-06	96906	. NUT (Not shipped with gear) (AP)	3		PAOZZ
-130C	4869021-101A	98897	. PLATE ASSEMBLY (Not shipped with gear)	1		PAFZZ
	NAS601-6P	80205	. SCREW (Not shipped with gear) (AP)	2		PAOZZ
-130D	4869019-102A	98897	. COVER ASSEMBLY	1		PAFZZ
	NAS601-10P	80205	. SCREW (AP)	3		PAOZZ
	AN960D6	88044	. WASHER (AP)	3		PAOZZ
	MS21042-06	96906	. NUT (AP)	3		PAOZZ
-131	4B69022-101A	98897	. GASKET	2		PAFZZ
-132	4G13988-101A	98897	. CLIP, Pin retainer	4		PAOZZ
-133	4G13800-101A	98897	. PIN, Retainer	4		PAOZZ
-134	MS21241-12A012	96906	. BEARING	1		PAOZZ
-135	MS21241-08A012	96906	. BEARING	1		PAOZZ
-136	MS21241-09F1-15	96906	. INSERT	2		PAOZZ
-137	4G12583-103A	98897	. HOUSING, Fluid transfer	1		PAFLD
-138	MS28774-126	96906	. RETAINER	12		PAOZZ
-139	MS28775-126	96906	. PACKING	6		PAOZZ
-140	MS24266R1085SN	96906	. CONNECTOR	2		PAOZZ
-141	NAS1104-18	80205	. BOLT (See figure 2-1 for NHA)	2		PAOZZ
-142	AN960C416L	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-143	AN960C616L	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ
-144	R5	92830	. WASHER (See figure 2-1 for NHA)	2		PAFZZ
-145	4G13790-101A	98897	. SPACER (See figure 2-1 for NHA)	2		PAFZZ
-146	NAS577-4A	80205	. NUT (See figure 2-1 for NHA)	2		PAOZZ
-147	MS21042-3	96906	. NUT (See figure 2-1 for NHA)	2		PAOZZ
-148	AN960C10L	88044	. WASHER (See figure 2-1 for NHA)	2		PAOZZ
-149	GM515200-1	22863	. TRANSDUCER (See figure 2-1 for NHA)	2		PAOBZ
	4524-2701	18730	. TRANSDUCER (Preferred spare for GM515200-1)	2		PAOBZ
-150	4G31003-101B	98897	. CYLINDER, Positioning (see T.C. 4A6-6-3)	1		PAFLD
-151	4G31003-103B	98897	. CYLINDER, Positioning (see T.O. 4A6-6-3)	1		PAFLD
-152	MS21042-3	96906	. NUT (See figure 2-1 for NHA)	4		PAOZZ
-153	AN960C10L	88044	. WASHER (See figure 2-1 for NHA)	4		PAOZZ
-154	NAS1303-6	80205	. BOLT (See figure 2-1 for NHA)	4		PAOZZ
-155	MS[illegible]902-6	96906	. UNION (See figure 2-1 for NHA)	8		PAOZZ
-156	MS28778-6	96906	. PACKING (See figure 2-1 for NHA)	8		PAOZZ
-157	4G13085-123A	98897	. PAD (See figure 2-1 for NHA)	4		MFFZZ
-158	420-75-625SH	98625	. CLAMP (See figure 2-1 for NHA)	4		PAFFF
	MS21042-4	96906	. . NUT	1		PAOZZ
-159	4G14250-101A	98897	. BRACKET (See figure 2-1 for NHA)	2		PAFZZ
-160	2690079	92003	. VALVE (See T.O. 4BA4-100-3) (see figure 2-1 for NHA)	2		PAFZZ
-161	9R2220-1	99240	. VALVE, Restrictor	1		PAFZZ
-162	MS28778-8	96906	. PACKING	1		PAOZZ
-163	404EN64-6	91929	. SWITCH	1		PAFZZ
-164	MS24665-378	96906	. PIN, Cotter	1		PAOZZ
-165	55NE4717-162	72962	. NUT (AN320-16 suitable substitute)	1		PAOZZ
-166	AN960-1616	88044	. WASHER	1		PAOZZ
-167	4G13904-101A	98897	. SHIM	2		PAOZZ
-168	55LH7644-108	72962	. NUT	2		PAOZZ
-169	4G13372-101A	98897	. WASHER, Keyed	2		PAOZZ
-170	4G13370-101A	98897	. SPACER	2		PAOZZ
-171	4G11478-109A	98897	. CYLINDER, Normal rotation (see T.O. 9H2-2-100-43)	1		PAFLD
-172	MS21924J8	96906	. UNION	1		PAOZZ
-173	MS28778-8	96906	. PACKING	1		PAOZZ
-174	4G11481-101C	98897	. CYLINDER, Emergency rotation (see T.O. 9H2-2-100-53)	1		PAFLD
-175	55LH7644-202	72962	. NUT	2		PAOZZ
-176	4G13617-101A	98897	. WASHER, Anti-rotation	2		PAFZZ
-177	MS16625-1137	96906	. RING, Snap	2		PAOZZ
-178	4G13618-101A	98897	. DISC, Grease seal	2		MFFZZ
-179	4G13392-101A	98897	. PLUG, Grease retainer	2		PAOZZ
-180	MS28775-017	96906	. PACKING	2		PAOZZ
-181	4G12433-101A	98897	. BOLT, Special	2		PAFDD
-182	4G13791-101A	98897	. PROTRACTOR, Pos indicator	1		PAOZZ
-183	MS15001-4	96906	. FITTING	5		PAOZZ
-184	NAS1291X8	80205	. NUT	1		PAOZZ
-185	AN960-816	88044	. WASHER	1		PAOZZ
-186	DELETED					
-187	4G13792-101A	98897	. POINTER, Pos indicator	1		PAOZZ
-188	NAS1191-3P6	80205	. SCREW	2		PAOZZ
-189	AN960-10L	88044	. WASHER	2		PAOZZ
	4G12660-101A	98897	. PLUG, Apex shaft, assembly	1		PAOZZ
-190	4G13766-101A	98897	. . PIN	2		PAOZZ
-191	4G13345-101A	98897	. . TRANSDUCER MOUNT FITTING	2		PAOZZ
-192	4G13767-101A	98897	. . PIN ANTI-ROTATION	1		XAFZZ
-193	4G13949-101A	98897	. . PLUG	1		PAOZZ
-194	4G13771-101A	98897	. BOLT, Special	1		PAFFF
-194A	4G14633-101A	98897	. BOLT	1		PAFZZ
-195	4G13561-101A	98897	. SHAFT, Apex	1		PAFDD
-196	MS21042-4	96906	. NUT	1		PAOZZ
-197	AN960-416	88044	. WASHER	1		PAOZZ
-198	NAS1104-52	80205	. BOLT	1		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-199	4G13646-1038	98897	. PIN, Headless	1		PAFBZ
	856045-01	98747	. PIN, Headless, (preferred spare for 4G13646-1038)	1		PAFBZ
-200	H29649-6	15653	. NUT	2		PAOZZ
-201	AN960-616	88044	. WASHER	2		PAOZZ
-202	4G13379-101A	98897	. PLATE, Shaft retainer	2		PAOZZ
-203	4G13376-103A	98897	. BOLT, Special	2		PAOZZ
-204	AN960PD816	88044	. WASHER	2		PAOZZ
-205	4G13378-101A	98897	. SPACER	2		PAOZZ
	4G13378-103A	98897	. SPACER (Preferred spare for 4G13378-101A)	2		PAOZZ
-206	4G13377-101A	98897	. FITTING, Retainer shaft	2		PAOZZ
-207	4G13366-101A	98897	. SHAFT, Rotation cylinder	2		PAOZZ
-208	4G11454-101D	98897	. LOCK CYLINDER, Normal	1		PAFDD
-209	MS21902J4	96906	. UNION	3		PAOZZ
-210	MS28778-4	96906	. PACKING	3		PAOZZ
-211	MS24665-153	96906	. PIN, Cotter	4		PAOZZ
-212	AN320-4	88044	. NUT	4		PAOZZ
-213	AN960-416	88044	. WASHER	4		PAOZZ
-214	NAS1104-13D	80205	. BOLT	4		PAOZZ
-215	4G14563-101A	98897	. CYLINDER ASSEMBLY (See T.O. 9H2-2-100-13)	1		PAFDD
-215A	MS27372H0240124	96906	. HOSE ASSEMBLY	1		PAOZZ
-215B	MS27373H0172000	96906	. HOSE ASSEMBLY	1		PAOZZ
-215C	T4G04104-165A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215D	T4G04104-125A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215E	T4G04104-127A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215F	T4G04104-129A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215G	T4G04104-131A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215H	T4G04104-133A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215J	T4G04104-135A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215K	T4G04104-137A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215L	MS27371H0176	96906	. HOSE ASSEMBLY	1		PAOZZ
-215M	MS27371H0214	96906	. HOSE ASSEMBLY	1		PAOZZ
-215N	AS1010J0810	81343	. ELBOW	2		PAOZZ
-215P	4G12517-101A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215Q	4G12518-101A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215R	4G12520-101A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215S	4G12559-101A	98897	. BLOCK ASSEMBLY, Clamp	1		PAOZZ
	4G12559-101B	98897	. BLOCK ASSEMBLY, Clamp (preferred spare for 4G12559-101A)	1		PAOZZ
	NAS1303-20	80205	. BOLT (AP)	1		PAOZZ
	LS5984S3M	98897	. WASHER PLAIN (Reduced OD) (AP)	1		PAOZZ
	MS21042-3	96906	. NUT (AP)	1		PAOZZ
-215T	T4G04104-143A	98897	. TUBE ASSEMBLY	1		MFOZZ
-215U	MS21919WDG10	96906	. CLAMP	3		PAOZZ
	MS24678-10	96906	. SCREW (AP)	2		PAOZZ
	LS5984S3M	98897	. WASHER (AP)	2		PAOZZ
	MS21042-3	96906	. NUT (AP)	2		PAOZZ
-215V	MS21919WDG8	96906	. CLAMP	3		PAOZZ
	MS24678-12	96906	. SCREW (AP)	1		PAOZZ
	LS5984S3M	98897	. WASHER (AP)	1		PAOZZ
	MS21042-3	96906	. NUT (AP)	1		PAOZZ
-215W	STSPB202J080804	98897	. TEE	2		PAOZZ
-215X	2-01096F0806	11328	. UNION	1		PAOZZ
-215Y	2-03014F08	11328	. NUT (AP)	1		PAOZZ
-215Z	NAS814-8	80205	. CAP	1		PAOZZ
-215AA	ER2833J06	11328	. ELBOW	1		PAOZZ
-216	MS28778-8	96906	. PACKING	3		PAOZZ
-216A	MS21902J8	96906	. UNION	3		PAOZZ
-216B	MS21924J8	96906	. UNION	3		PAOZZ
-216C	T4G04104-133A	98897	. TUBE ASSEMBLY	1		MFOZZ
-216D	T4G04104-137A	98897	. TUBE ASSEMBLY	1		MFOZZ
-216E	T4G04104-135A	98897	. TUBE ASSEMBLY	1		MFOZZ
-216F	MS21902J8	96906	. UNION	2		PAOZZ
-216G	T4G04104-127A	98897	. TUBE ASSEMBLY	1		MFOZZ

FIG & INDEX NO	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-216H	T4G04104-125A	98897	. TUBE ASSEMBLY	1		MFOZZ
-216J	T4G04104-129A	98897	. TUBE ASSEMBLY	1		MFOZZ
-216K	MS21902J4	96906	. UNION	1		PAOZZ
-216L	MS28778-4	96906	. PACKING	1		PAOZZ
-216M	T4G04104-131A	98897	. TUBE ASSEMBLY	1		MFOZZ
-216N	STSPB202J080804	98897	. TEE	2		PAOZZ
-216P	AN960PD1216	88044	. WASHER	2		PAOZZ
-216Q	AN924-8D	88044	. NUT	5		PAOZZ
-216R	NAS814-8	80205	. CAP	5		PAOZZ
-217	MS21924J8	96906	. UNION	3		PAOZZ
-217A	T4G04104-133A	98897	. TUBE ASSEMBLY	1		MFOZZ
-217B	T4G04104-137A	98897	. TUBE ASSEMBLY	1		MFOZZ
-217C	T4G04104-135A	98897	. TUBE ASSEMBLY	1		MFOZZ
-217D	MS21902J8	96906	. UNION	2		PAOZZ
-217E	4G12517-101A	98897	. TUBE ASSEMBLY	1		MFOZZ
-217F	4G12518-101A	98897	. TUBE ASSEMBLY	1		MFOZZ
-217G	MS21919WDG8	96906	. CLAMP	2		PAOZZ
-217H	AN924-8D	88044	. NUT	2		PAOZZ
-217J	AN960PD1216	88044	. WASHER	2		PAOZZ
-217K	STSPB102J0810	98897	. ELBOW	2		PAOZZ
-217L	MS24678-12	96906	. SCREW	1		PAOZZ
-217M	NAS1304-4H	80205	. BOLT	2		PAOZZ
-217N	AN960-416	88044	. WASHER	2		PAOZZ
-217P	LS598453M	98897	. WASHER	1		PAOZZ
-217Q	AN960-416	88044	. WASHER (Maximum 2 used as shim)	2		PAOZZ
-217R	MS21042-3	96906	. NUT	1		PAOZZ
-217S	MS28778-8	96906	. PACKING	3		PAOZZ
-217T	MS21902J8	96906	. UNION	3		PAOZZ
-218	MS28778-10	96906	. PACKING	1		PAOZZ
-218A	MS28773-10	96906	. RETAINER	1		PAOZZ
-218B	AN6289J10	88044	. NUT	1		PAOZZ
-218C	MS21908J10	96906	. ELBOW	1		PAOZZ
-218D	MS21919WDG10	96906	. CLAMP	2		PAOZZ
-218E	MS28778-10	96906	. PACKING	1		PAOZZ
-218F	9R2220-3	99240	. RESTRICTOR VALVE	1		PAOZZ
-218G	T4G04104-165A	98897	. TUBE ASSEMBLY	1		MFOZZ
-218H	4G12520-101A	98897	. TUBE ASSEMBLY	1		MFOZZ
-218J	MS24678-10	96906	. SCREW	2		PAOZZ
-218K	AN924-8D	88044	. NUT	2		PAOZZ
-218L	MS21924J8	96906	. UNION	2		PAOZZ
-218M	LS5984S3M	98897	. WASHER	2		PAOZZ
-218N	MS21042-3	96906	. NUT	2		PAOZZ
-218P	MS27373H0172000	96906	. HOSE ASSEMBLY	1		PAOZZ
-218Q	MS27372H0240124	96906	. HOSE ASSEMBLY	1		PAOZZ
-219	MS21902J8	96906	. UNION	2		PAOZZ
-220	MS21924J8	96906	. UNION	2		PAOZZ
-221	AN960-416	88044	. WASHER (Maximum of 6)	6		PAOZZ
-221A	T4G04101-173A	98897	. TUBE	REF		MFOZZ
-221B	MS21919WDG4	96906	. CLAMP	2		PAOZZ
-221C	NAS1633-11	80205	. SCREW	1		PAOZZ
	NAS603-16P	80205	. SCREW (Preferred spare for NAS1633-11)	1		PAOZZ
-221D	4G13708-101A	98897	. BRACKET	1		PAOZZ
-221E	T4G04101-165A	98897	. TUBE	REF		MFOZZ
-221F	4B69012-103A	98897	. BRACKET (RH fwd)	1		PAOZZ
	4B69012-101A	98897	. BRACKET (RH aft)	1		PAOZZ
-221G	NAS1304-4H	80205	. BOLT	2		PAOZZ
	NAS1304-2H	80205	. BOLT (Optional, no spacers)	2		PAOZZ
-221H	4B69008-113A	98897	. SPACER	1		PAOZZ
-221J	4B69008-115A	98897	. SPACER (Altered from NAS43DD3-22)	1		PAOZZ
-221K	AN960C10L	88044	. WASHER	1		PAOZZ
-221L	STSCD006-06	98897	. NUT	1		PAOZZ
	MS21042-3	96906	. NUT (Preferred spare for STSCD006-06)	1		PAOZZ
-222	DELETED					
-223	NAS1304-22H	80205	. BOLT	3		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-224	LS5984S4M	98897	. WASHER, Plain	3		PAOZZ
-225	4G13725-101A	98897	. BRACKET, Sequence valve	1		PAOZZ
-226	179-50076	14798	. HOSE ASSEMBLY	1		PAOZZ
-227	AN6289J4	88044	. NUT	1		PAOZZ
-228	MS28773-04	96906	. RETAINER	1		PAOZZ
-229	MS28778-4	96906	. PACKING	1		PAOZZ
-230	4G12645-101G	98897	. VALVE ASSEMBLY, Sequence interlock, (see T.O. 9H8-9-35-3)	1		PAFDD
-231	NAS1306-1H	80205	. BOLT	2		PAOZZ
-232	4G13661-101A	98897	. PLATE, Mounting	1		PAOZZ
-233	NAS509-4	80205	. NUT	4		PAOZZ
-234	4G13574-101A	98897	. SCREW, Adjusting	2		PAOZZ
-235	NAS509-4	80205	. NUT	4		PAOZZ
-236	4G14406-101A	98897	. SCREW, Headless	4		PAOZZ
-237	AN960PD416L	88044	. WASHER	4		PAOZZ
-238	4G13572-103A	98897	. BRACKET	1		PAOZZ
-239	4G13572-104A	98897	. BRACKET	1		PAOZZ
-240	NAS1304-1HW	80205	. BOLT	2		PAOZZ
-241	AN960-416	88044	. WASHER	2		PAOZZ
-242	4G12536-101A	98897	. BRACKET	1		PAOZZ
-243	4G13337-101A	98897	. PLATE	1		PAOZZ
-244	4G11441-101A	98897	. MANIFOLD ASSEMBLY, Rotation (see T.O. 9H8-27-4-3)	1		PAFDD
	4G13701-101A	98897	. MANIFOLD ASSEMBLY, Rotation (see T.O. 9H8-27-4-3) (preferred spare for 4G11441-101A)	1		PAFDD
-244A	9R2220-3	99240	. VALVE, Restrictor	REF		PAOZZ
-244B	MS28778-10	96906	. PACKING (AP)	REF		PAOZZ
-245	NAS6205-13D	80205	. BOLT	3		PAOZZ
-246	4G13708-101A	98897	. BRACKET	2		PAOZZ
-247	4G11458-103A	98897	. MANIFOLD ASSEMBLY, Pos and servo valve	1		XC
-247A	DELETED					
-247B	22266780	81873	. . VALVE ASSEMBLY SERVO	1		PAFDD
-247C	4G12539-101A	98897	. . MANIFOLD ASSEMBLY, Positioning	1		PAFDD
-248	MS21042-5	96906	. NUT	6		PAOZZ
-249	AN960-516	88044	. WASHER	12		PAOZZ
-250	NAS6205-15D	80205	. BOLT	2		PAOZZ
-250A	NAS1305-14	80205	. BOLT	1		PAOZZ
-251	4G12043-101B	98897	. BRACKET	1		PAOZZ
-252	4G12042-101A	98897	. BRACKET ASSEMBLY, Plumbing	1		PAOZZ
-253	4G12042-102A	98897	. BRACKET ASSEMBLY, Plumbing	1		PAOZZ
-254	MS21042-4	96906	. NUT	2		PAOZZ
-255	LS5984S4M	98897	. WASHER	2		PAOZZ
-256	AN960-416	88044	. WASHER	2		PAOZZ
-257	NAS1104-12	80205	. BOLT	2		PAOZZ
-258	MS21042-4	96906	. NUT	4		PAOZZ
-259	LS5984S4M	98897	. WASHER, Lock	4		PAOZZ
-260	AN960-416	88044	. WASHER (Alternate for part No. LS5984S4M)	4		PAOZZ
-261	NAS1104-8	80205	. BOLT	4		PAOZZ
-261A	4G14360-101A	98897	. BOLT	3		PAOZZ
-261B	MS28775-115	96906	. PACKING	3		PAOZZ
-261C	4G14361-101A	98897	. BODY	1		PAOZZ
-261D	4G14363-101A	98897	. BODY	1		PAOZZ
-261E	4G14362-101A	98897	. BODY	1		PAOZZ
-261F	MS28778-10	96906	. PACKING	3		PAOZZ
-261G	STSR8001D0810	98897	. CHECK VALVE	1		PADZZ
	GA7461D0810	50276	. CHECK VALVE (Alternate for STSR8001D0810)	1		PADZZ
-262	MS28013-1	96906	. CAP, Valve	1		PAOZZ
-263	MS28889-1	96906	. VALVE ASSEMBLY, Air fill	1		PAOZZ
-264	705617	24038	. SWITCH, Pressure	1		PAOZZ
	01-705617	24038	. SWITCH, Pressure (alternate)	1		PAOZZ
-265	MS28778-4	96906	. PACKING	1		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-266	G3714	34830	. GAGE, Pressure (see figure 2-1 for NHA)	REF		PAFZZ
	1000-38	24708	. GAGE, Pressure (alternate)	REF		PAFZZ
-267	MS28778-4	96906	. PACKING	1		PAOZZ
-268	LS4764-4	98897	. O-RING	1		PAFZZ
-269	NAS551-5H	80205	. BOLT	1		PAOZZ
-270	MS28775-012	96906	. PACKING	1		PAOZZ
-271	4G14322-101B	98897	. FITTING	1		PAFZZ
-272	MS24690	96906	. O-RING	1		PAOZZ
-273	4G13793-101A	98897	. SCREW, Headless	4		PAOZZ
-274	4G13761-101A	98897	. PLATE, Cover	1		PAOZZ
-275	MS19060-26	96906	. BALL	4		PAOZZ
-276	MS24665-153	96906	. COTTER PIN	1		PAOZZ
-277	MS17826-3	96906	. NUT	1		PAOZZ
-278	AN960PD10L	88044	. WASHER	2		PAOZZ
-279	NAS1303-14D	80205	. BOLT	1		PAOZZ
-280	NAS1303-21D	80205	. BOLT	1		PAOZZ
-280A	MS21042-3	96906	. NUT	1		PAOZZ
-280B	AN743B12	88044	. BRACKET	1		PAOZZ
-280C	MS21919WDG7	96906	. CLAMP	1		PAOZZ
-280D	NAS603-8P	80205	. SCREW	1		PAOZZ
-280E	MS21042-3	96906	. NUT	1		PAOZZ
-281	MS28775-116	96906	. PACKING	1		PAOZZ
-282	4G13524-105A	98897	. STANDPIPE	1		PAFZZ
-283	MS28778-12	96906	. PACKING	1		PAOZZ
-284	4G13419-101A	98897	. NUT, Stop plate	1		PAOZZ
-285	MS21042-4	96906	. NUT	1		PAOZZ
-286	AN960-416	88044	. WASHER	1		PAOZZ
-287	4G13391-101A	98897	. WEDGE	1		PAOZZ
-288	NAS1624-24	80205	. SCREW	1		PAOZZ
-289	MS21042-4	96906	. NUT	1		PAOZZ
-290	AN960-416	88044	. WASHER	1		PAOZZ
-291	4G13769-101A	98897	. SHIM, Stop pad	AR		PAOZZ
-291A	8852948-01	98747	. SPACER, Stop pad	AR		PAOZZ
-291B	8852948-03	98747	. SPACER, Stop pad	AR		PAOZZ
-292	4G12471-101A	98897	. PLATE ASSEMBLY	1		PAOZZ
-293	4G13768-103A	98897	. PAD, Stop	1		PAFFF
	856081-01	98897	. PAD, Stop (preferred spare for 4G13768-103A)	1		PAOZZ
-294	4G13770-101A	98897	. BOLT	1		PAOZZ
-295	4G11453-101B	98897	. PLATE ASSEMBLY, Stop	1		PAFLD
-296	4G13575-103A	98897	. . BUSHING	1		PADZZ
	4G13575-105A	98897	. . BUSHING (preferred spare for 4G13575-103A)	1		PAOZZ
-297	4G11453-103B	98897	. . PLATE, Stop	1		XA
-297A	4G14605-101A	98897	. . BUSHING, Repair	1		PADZZ
-298	4G13420-101A	98897	. WASHER, Segment	2		PAOZZ
-299	DELETED					
-300	DELETED					
-301	4G19074-101A	98897	. BEARING, Thrust	1		PAFZZ
-302	4G13608-101A	98897	. WIPER, Felt	1		PAOZZ
-303	4G11447-101A	98897	. COLLAR ASSEMBLY, Lock actuator	1		PAFLD
-304	4G13609-103A	98897	. . BUSHING, Flanged	4		PADZZ
	4G13609-105A	98897	. . BUSHING, Flanged (preferred spare for 4G13609-103A)	4		PADZZ
-305	4G11447-103A	98897	. . COLLAR, Lock actuator	1		PAFLD
-306	DELETED					
-307	DELETED					
-308	4G13563-103A	98897	. . INSERT	1		PAFDD
-309	4G12636-101A	98897	. RING ASSEMBLY, Lock	1		PAFDD
-310	4G13683-101A	98897	. . PIN	2		PAOZZ
-311	4G13571-101A	98897	. . NUT, Round	1		PAFZZ
-312	4G13569-101A	98897	. . GUIDE	1		XAFZZ
-313	4G13412-101A	98897	. . RING, Lock	1		PAOZZ
-314	4G13614-101A	98897	. NUT, Round	1		PAOZZ
-315	4G13970-101A	98897	. WASHER	1		PAOZZ
-316	4G13613-101A	98897	. WASHER, Cup	1		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-317	4G13565-101B	98897	COLLAR, Rotation	1		PAOZZ
-317A	8341244-01	98897	INSERT, Rotation collar (used with 4G13565-101A rotation collar only)	4		PAOZZ
-318	KJT111099V	50632	. WASHER, Segment (LAC spec 4G94432-103A)	2		PAOZZ
	4G94432-103A	98897	. WASHER, Segment	2		PAOZZ
-319	4G11476-101B	98897	. COLLAR ASSEMBLY, Positioning	1		PAFDD
	4G11476-107A	98897	. COLLAR ASSEMBLY, Positioning	1		PAFDD
-320	4G12434-101A	98897	. . WASHER, Thrust	1		PAFZZ
-321	4G13311-101A	98897	. . PLUG (Used with 4G11476-101B only)	18		PAOZZ
-322	MS15001-4	96906	. . FITTING	2		PAOZZ
-323	4G13312-101A	98897	. . PIN	3		PADZZ
-324	4G13609-103A	98897	. . BEARING, Flanged	2		PADZZ
	4G13609-105A	98897	. . BEARING, Flanged (preferred spare for 4G13609-103A)	2		PADZZ
-325	4G13338-103A	98897	. . BEARING, Flanged	2		PADZZ
-326	4G13610-103A	98897	. . BEARING, Flanged	2		PADZZ
	4G13610-105A	98897	. . BEARING, Flanged (preferred spare for 4G13610-103A)	2		PADZZ
-327	4G11476-103A	98897	. . COLLAR, Positioning (used with 4G11476-101B)	1		XA
	4G11476-109A	98897	. . COLLAR, Positioning (used with 4G11476-107A)	1		XA
-328	NO NUMBER		. PISTON INSTL (See figure 2-10)	NP		XA
-329	SS48175	61864	. PLUG, Cover	2		PAFZZ
-329A	SS48155	61864	. PLUG, Cover	2		PAOZZ
-330	NAS1304-1HW	80205	. BOLT	4		PAOZZ
-331	4G13669-101A	98897	. WASHER	4		PAOZZ
-332	4G12436-107A	98897	. PLATE ASSEMBLY	1		PAOZZ
-333	4G12436-109A	98897	. . PLATE	1		XA
-334	4G12436-105A	98897	. . SEAL	1		MFFZZ
-335	MS21042-4	96906	. NUT	1		PAOZZ
-336	AN970-4	88044	. WASHER	1		PAOZZ
-337	MS21295-50	96906	. BOLT (See figure 2-1 for NHA)	6		PAOZZ
	NAS1351C4LN14	80205	. SCREW (Preferred spare for MS21295-50)	6		PAOZZ
-338	AN960-416	88044	. WASHER (See figure 2-1 for NHA)	6		PAOZZ
-339	4G12627-107B	98897	. COVER (See figure 2-1 for NHA)	1		PAFFF
-340	4G12627-105A	98897	. SEAL, Cover (See figure 2-1 for NHA)	1		MFFZZ
-341	TRIPLE 148C/L	72625	. LINK, Connecting	2		PAFZZ
	E50CLRC50-3CL	72625	. LINK, Connecting (alternate)	2		PAFZZ
-342	TRIPLE 148	72625	. CHAIN	2		PAFZZ
-343	NAS1308-26	80205	. BOLT	4		PAOZZ
-344	AN960-816	88044	. WASHER	4		PAOZZ
-344A	4G13687-101A	98897	. SHIM	AR		PAOZZ
-344B	NAS577-8A	80205	. NUT	4		PAOZZ
-345	MS21042-5	96906	. NUT (See figure 2-4 for NHA)	2		PAOZZ
-346	AN5-66A	88044	. BOLT (See figure 2-4 for NHA)	2		PAOZZ
-347	MS27183-12	96906	. WASHER (See figure 2-4 for NHA)	4		PAOZZ
-347A	4G13706-102A	98897	. BRACKET LH	1		PAOZZ
	4G12049-102A	98897	. BRACKET LH (Preferred spare for 4G13706-102A)	1		PAOZZ
-347B	4G12050-102A	98897	. COVER (Used with 4G12049-102A)	1		PAFZZ
-347C	4G13706-101A	98897	. BRACKET RH	1		PAOZZ
	4G12049-101A	98897	. BRACKET RH (Preferred spare for 4G13706-101A)	1		PAFZZ
-347D	4G12050-101A	98897	. COVER (Used with 4G12049-101A)	1		PAFZZ
-348	4G13606-101A	98897	. COVER, Pin	2		PAOZZ
	4G12048-101A	98897	. COVER, Pin (preferred spare for 4G13606-101A)	2		PAFZZ
-349	MS21042-3	96906	. NUT (Used with 4G12049-101A and -102A)	2		PAOZZ
-349A	AN960-10	88044	WASHER (Used with 4G12049-101A and -102A)	2		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-349B	NAS1103-4	80205	. BOLT (Used with 4G12049-101A and -102A)	2		PAOZZ
-350	DELETED					
-351	DELETED					
-352	DELETED					
-353	DELETED					
-354	4G12657-101B	98897	. INSERT ASSEMBLY, Elect & hyd service (aft ballscrew only)	1		PADLD
	4G12051-101A	98897	. INSERT ASSEMBLY, Elect & hyd service (aft ballscrew only) (preferred spare for 4G12657-101B)	1		PADLD
-354A	KPSE65057-392	71468	. . CONNECTOR PLUG	1		PAOZZ
-354B	KPSE65057-392W	71468	. . CONNECTOR PLUG	1		PAOZZ
-355	4G11416-101B	98897	. BALLSCREW DRIVE HOUSING ASSEMBLY	1		PADLD
	4G11416-101C	98897	. BALLSCREW DRIVE HOUSING ASSEMBLY (Preferred spare for 4G11416-101B)	1		PADLD
-356	B15576-12	00293	. ADAPTER (Used with B15576 only) (fwd ballscrew only)	1		PAFZZ
	246-15	2J558	. ADAPTER (Used with AB-246-000 only) (fwd ballscrew only)	1		PAFZZ
-357	4G13335-101A	98897	. PIN, Retaining (fwd ballscrew only)	1		PAOZZ
-358	102C1050	62793	. NUT, Retaining (alternate 4G14647-101A)	2		PAFZZ
-359	B15576-10	00293	. NUT, Hex	2		PAOZZ
-360	B15576-13R	06298	. STOP, Dog	2		PAFZZ
-361	DELETED					
-362	DELETED					
-363	MS21042-6	96906	. NUT	2		PAOZZ
-364	AN960-616	88044	. WASHER	4		PAOZZ
-365	NAS1106-20D	80205	. BOLT	2		PAOZZ
-366	NAS1303-1H	80205	. BOLT (See figure 2-4 for NHA)	4		PAOZZ
-367	4G14392-101B	98897	. BRACKET (See figure 2-4 for NHA)	1		PAFZZ
-368	422EN1-2	91929	. SWITCH (See figure 2-4 for NHA)	1		PAFZZ
-369	MS21042-3	96906	. NUT (See figure 2-4 for NHA)	2		PAOZZ
-370	NAS623-3-7	80205	. BOLT (See figure 2-4 for NHA)	2		PAOZZ
-371	4G14391-101A	98897	. STOP (See figure 2-4 for NHA)	1		PAFZZ
-372	NAS1106-15	80205	. BOLT	2		PAOZZ
-373	4G13600-101A	98897	. RING, Retainer	2		PAOZZ
-374	4G13694-101A	98897	. SHIM	2		PAOZZ
	4G13694-103A	98897	. SHIM, Preferred spare, use in lieu of 4G13694-101A	2		PAOZZ
-375	B7402B	80648	. BEARING, Lower radial	2		PAFZZ
	11613001	32828	. BEARING, Lower radial (alternate for B7402B) (LASC 4G94406-101A)	2		PAFZZ
-376	MS24665-368	96906	. PIN, Cotter	2		PAOZZ
-377	4G13431-101A	98897	. NUT, Round	2		PAFZZ
-378	4G13696-101A	98897	. KEY	8		PAOZZ
-379	4G13688-101	98897	. SPACER, Keyed	2		PAOZZ
-380	4G13605-103A	98897	. PIN, Ballscrew	2		PAOZZ
-381	AB-246-000	2J558	. BALLSCREW ASSEMBLY (See T.O. 16G3-2-80-3) (LAC spec 4G94034-101B)	2		PADLD
	B15576B	00293	. BALLSCREW ASSEMBLY (See T.O. 16G3-2-80-3) (LAC spec 4G94034-101B)	2		PADLD
-382	4G13586-101A	98897	. SPROCKET	2		PAOZZ
-383	B7401B	80648	. BEARING, Upper radial (LAC spec 4G94405-101A)	2		PAFZZ
	11612001	32828	. BEARING, Upper radial (alternate for B7401B) (LAC spec 4G94405-101A)	2		PAFZZ
-384	B7374B	80648	. BEARING, Thrust (LAC spec 4G94404-101A)	2		PAFZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	
2-8-384	52RT02	03489	. BEARING, Thrust (alternate for 873748) (LAC spec 4G94404-101A)	2		
-385	4G11415-107A	98897	. CYLINDER ASSEMBLY, Outer (see figure 2-12)	1		
	4G11415-107C	98897	. CYLINDER ASSEMBLY, Outer (see figure 2-12) (preferred spare for 4G11415-107A)	1		
-386	NO NUMBER		. YOKE AND SIDE BRACE ASSEMBLY (See figure 2-13)	NP		
-387	4G19093-107A	98897	. CLAMP (Make from MS21919DG4)	1		
	AN502-416-16	88044	. SCREW	1		
	NAS43DD4-32	80205	. SPACER	1		
-388	4G14639-101A	98897	. TUBE ASSEMBLY	1		
-389	4G14638-101A	98897	. TUBE ASSEMBLY	1		
-389A	AN924-4D	88044	. NUT	1		
-389B	MS21924J4	96906	. UNION	1		
-390	MS21042-4	96906	. NUT	2		
-391	4G13968-103A	98897	. BOLT	2		
-392	MS21902J4	96906	. UNION	2		
-393	MS28778-4	96906	. PACKING	2		
-394	4G12443-101A	98897	. VALVE ASSEMBLY (See T.O. 9H8-9-40-3	1		
-395	4G13487-101A	98897	. PLATE	1		
-396	4G13487-102A	98897	. PLATE	1		
-397	4G13488-101A	98897	. PIN	1		
-398	4G13967-101A	98897	. SPRING	1		
-399	4G14634-101A	98897	. LEVER	1		

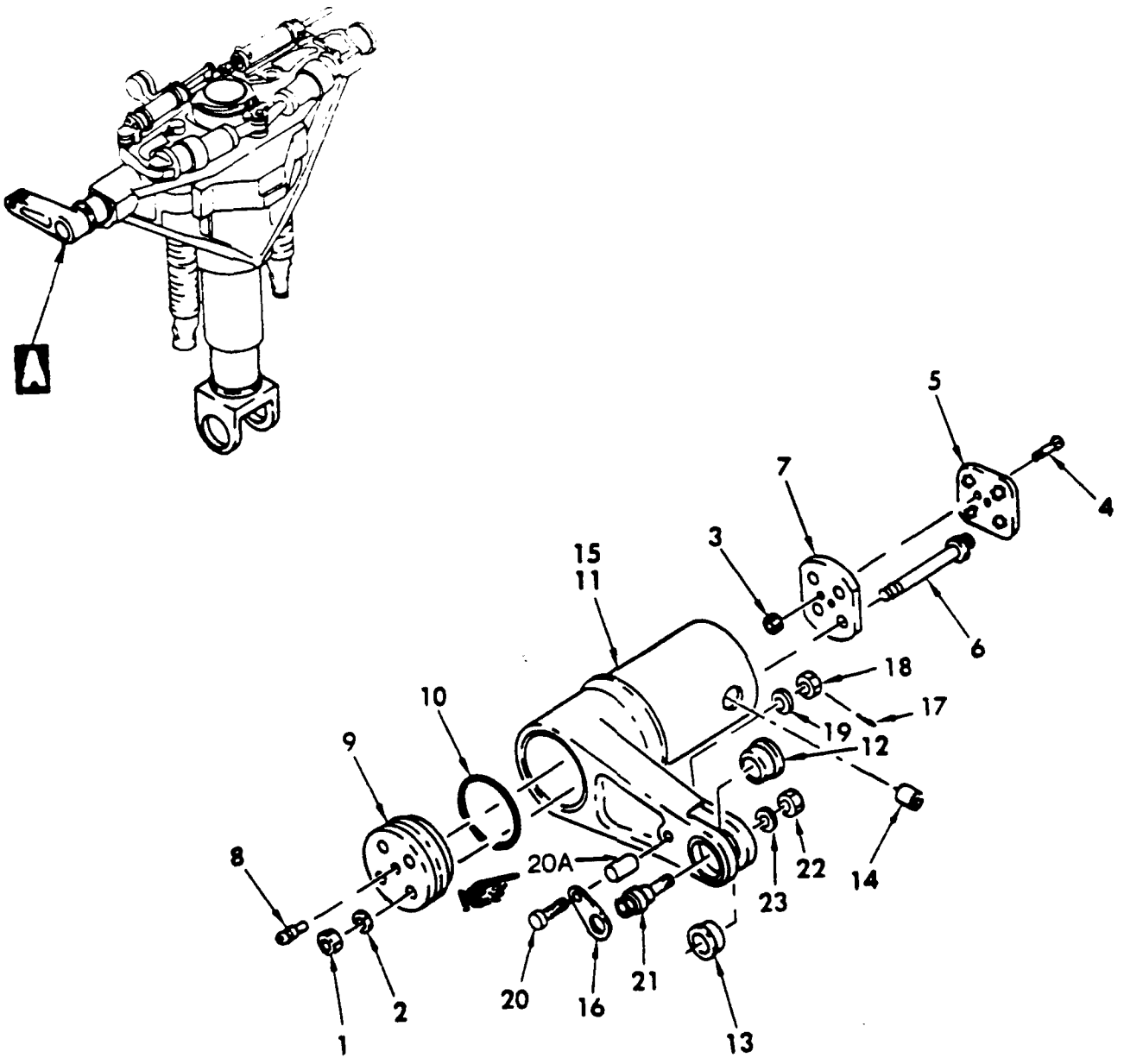

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Figure 2-9. Retract Arm Built-up Instl

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-9-	NO NUMBER		RETRACT ARM BUILT-UP INSTL (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		X
-1	LS35154-7	98897	. NUT	4		PAFZZ
-2	LFLH7559-3	98159	. WASHER (Alternate 70631-1032 or 2230-7)	4		PAFZZ
-3	H39269-3	15853	. NUT	2		PAFZZ
-4	NAS603-24P	80205	. SCREW	2		PAFZZ
-5	4G14505-101A	98897	. LOCK PLATE	1		PAOZZ
-6	MS21250-07100	96906	. BOLT	4		PAFZZ
-7	4G14507-101A	98897	. RETAINER	1		PAFZZ
-8	MS15001-1	96906	. FITTING, Grease	1		PAOZZ
-9	4G14506-101A	98897	. DIAPHRAGM	1		PAFZZ
-10	MS28775-431	96906	. PACKING	1		PAFZZ
-11	4G11448-107A	98897	. RETRACT ARM ASSEMBLY	1		PAFLD
-12	4G13530-103A	98897	. . BUSHING, Flanged	1		PADZZ
	4G13530-105A	98897	. . BUSHING, Flanged (preferred spare for -103A)	1		PADZZ
-13	4G13529-103A	98897	. . BUSHING, Flanged	1		PADZZ
	4G13529-105A	98897	. . BUSHING, Flanged (preferred spare for -103A)	1		PADZZ
-14	4G14606-101A	98897	. . BUSHING	2		PADZZ
-15	4G11448-109A	98897	. . RETRACT ARM	1		PADLL
-16	4G13647-101A	98897	. LOCK PLATE	1		PAOZZ
-17	MS24665-304	96906	. PIN, Cotter	1		PAOZZ
-18	MS17826-8	96906	. NUT	1		PAOZZ
-19	AN960-816	88044	. WASHER	1		PAOZZ
-20	AN8-23	88044	. BOLT	1		PAOZZ
-20A	66C33001-03ST02	98747	. BUSHING, Repair	1		PADZZ
	8631422-01	98747	. BUSHING, Repair (preferred, spare for 66C33001-03ST02)	1		PADZZ
-21	4G13648-101A	98897	. PIN, Eccentric	1		PAFZZ
	4G13648-103A	98897	. PIN, Eccentric (preferred spare for 4G13648-101A)	1		PAFZZ
-22	MS21803D20	96906	. NUT	1		PAOZZ
-23	AN960-2116	88044	. WASHER	1		PAOZZ

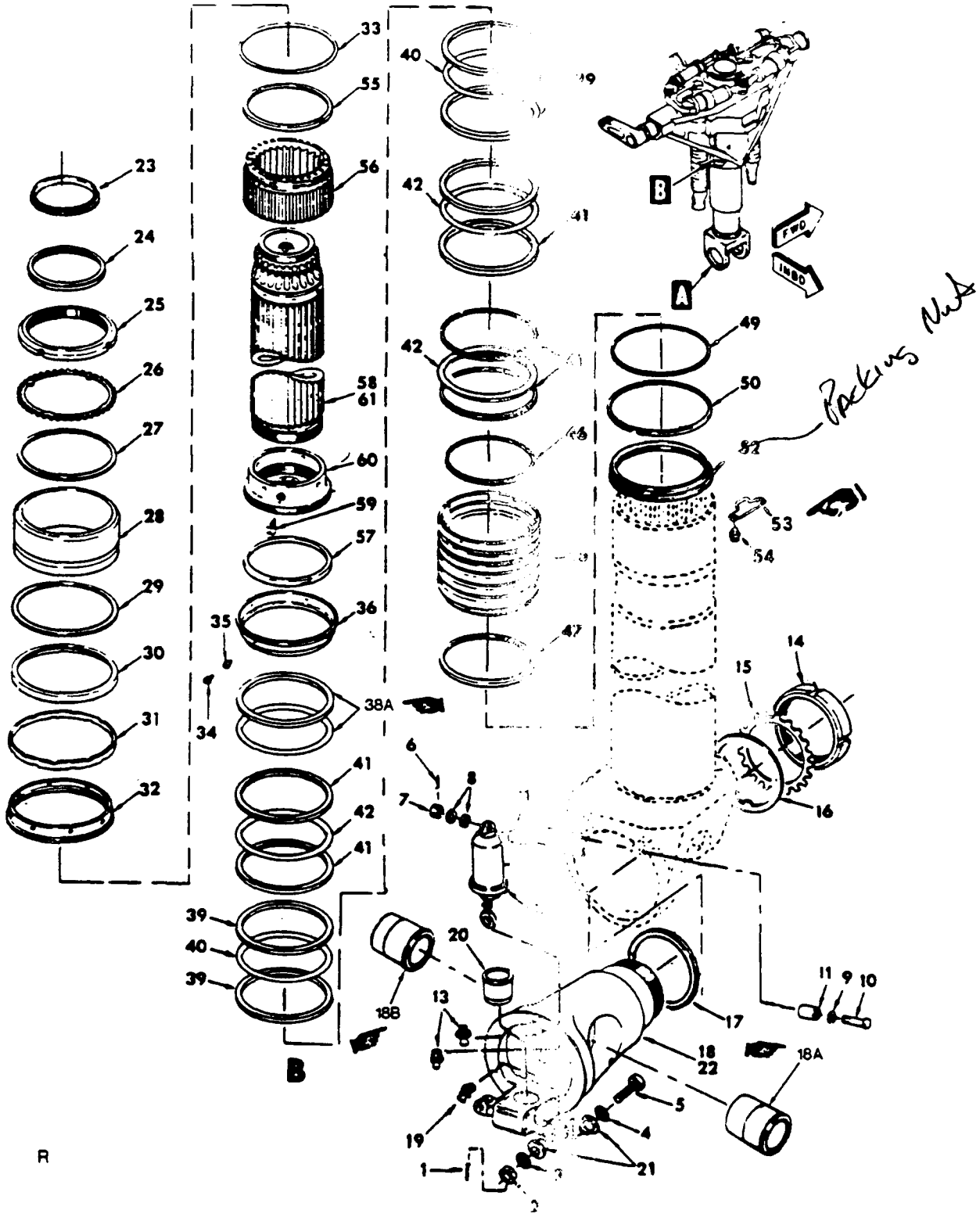


Figure 2-10. Piston Installation (Sheet 1 of 2)

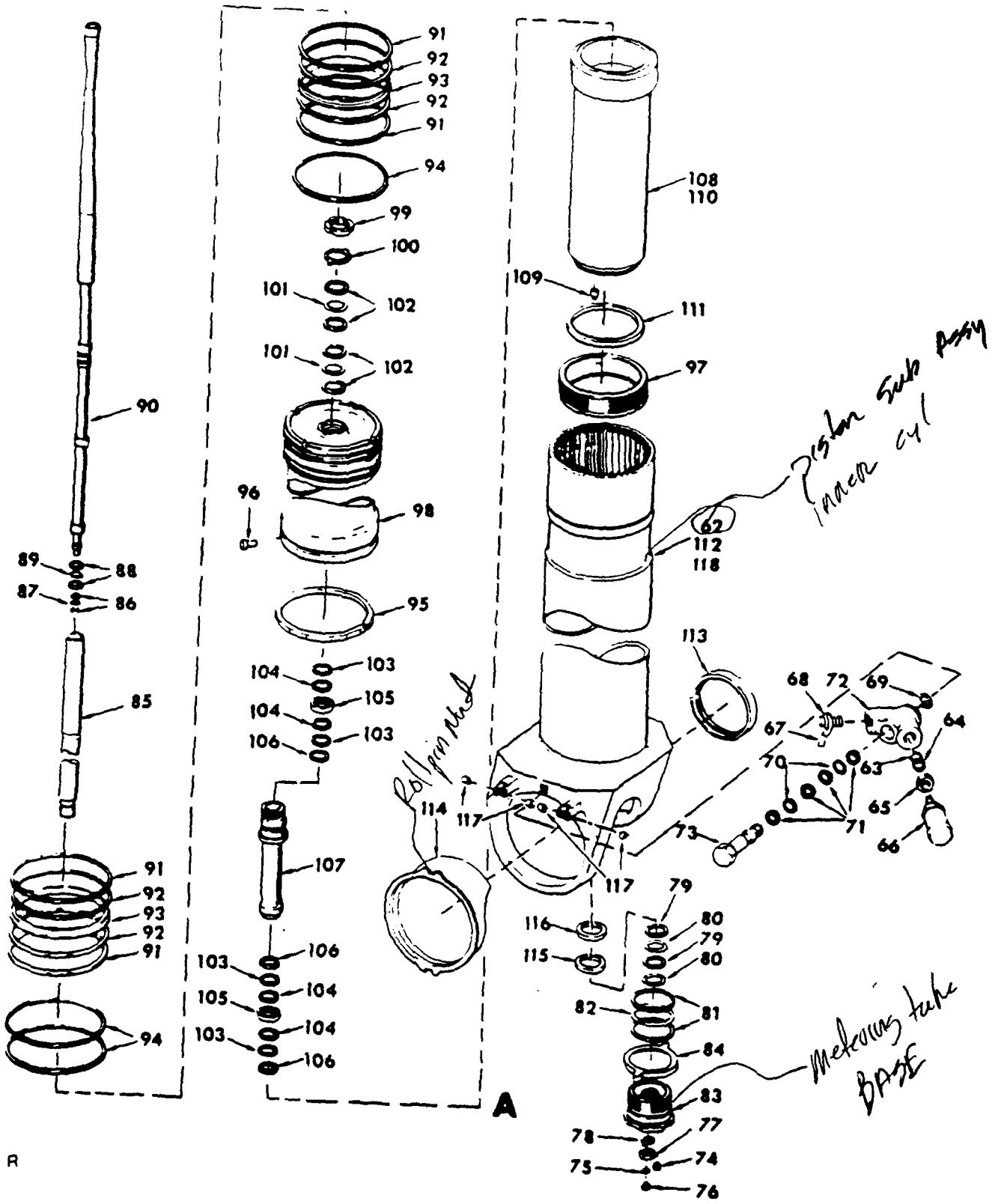


Figure 2-10. Piston Installation Sheet 2 of 2

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-10-	NO NUMBER		PISTON INSTALLATION (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		
-1	MS24665-300	96906	. PIN, Cotter	2		PAOZZ
-2	MS17826-6	96906	. NUT (AN320-8 Suitable substitute)	2		PAOZZ
-3	AN960-616	88044	. WASHER	4		PAOZZ
-4	MS20002C6	96906	. WASHER	2		PAOZZ
-5	68485-6-020	56878	. BOLT (LAC spec STSBG001A06D020)	2		XBFZZ
	VS2979A06D020	92215	. BOLT (Alternate for 68485-6-020)	2		PAOZZ
	BM3210-6A20D	85495	. BOLT (Alternate for 68485-6-020)	2		PAOZZ
	PBF1042A6D20	27624	. BOLT (Alternate for 68485-6-020)	2		PAOZZ
	AIC2264A06D020	06725	. BOLT (Alternate for 68485-6-020)	2		PAOZZ
	VAL23602-6DS20	06710	. BOLT (Alternate for 68485-6-020)	2		PAOZZ
-6	MS24665-302	96906	. PIN, Cotter	2		PAOZZ
-7	MS17826-8	96906	. NUT (AN320-8 Suitable substitute)	2		PAOZZ
-8	AN960-816	88044	. WASHER	4		PAOZZ
-9	MS20002C8	96906	. WASHER	2		PAOZZ
-10	68485-8-024	56878	. BOLT	2		PAOZZ
-11	4G13492-101A	98897	. BUSHING	4		PAOZZ
-12	4G14551-101B	98897	. ROLL POSITIONER (See T.O. 4AA1-7-3) (see figure 2-1 for NHA)	2		PAFLD
-13	MS15001-1	96906	. FITTING	3		PAOZZ
-14	4G13782-101A	98897	. NUT, Round	1		PAOZZ
-15	4G13783-101A	98897	. WASHER, Lock	1		PAOZZ
-16	4G13784-101A	98897	. WASHER, Thrust	1		PAOZZ
-17	4G13700-101A	98897	. WASHER, Thrust	1		PAFLD
-18	4G11439-107B	98897	. ROLL PIN ASSEMBLY	1		PAFLD
	4G11439-113A	98897	. ROLL PIN ASSEMBLY (preferred spare for 4G11439-107B)	1		PAFLD
	7729278	98897	. ROLL PIN ASSEMBLY - PARTS KIT (7729278-90, -110, -130, -150, -170 kits are interchangeable and alternate for 4G11439-113A and 4G13402-101C and 4G13403-101C combined)	1		PAFLD
	7729278		. ROLL PIN ASSEMBLY (Alternate for 4G11439-107B)	1		PAFLD
-18A	4G13402-101B	98897	. . GUDGEON SPACER (Inboard)	1		PADZZ
	4G13402-101C	98897	. . GUDGEON SPACER (Inboard) (preferred alternate for 4G13402-101B	1		PADZZ
-18B	4G13403-101B	98897	. . GUDGEON SPACER (Outboard)	1		PADZZ
	4G13403-101C	98897	. . GUDGEON SPACER (Outboard) (preferred alternate for 4G13403-101B	1		PADZZ
-19	MS15001-1	96906	. . FITTING	1		PAOZZ
-20	4G13544-103A	98897	. . BUSHING	1		PADZZ
-21	4G13407-103A	98897	. . BUSHING	4		PADZZ
-22	4G11439-109B	98897	. . ROLL PIN	1		PAFLD
-23	LS35196-1	98897	. SEAL	1		PAFZZ
-24	78863	09455	. RING, Thrust (LAC spec 4G94433-101A)	1		PAFZZ
-25	4G13499-101A	98897	. RING, Threaded retainer	1		PAOZZ
-26	4G13503-101A	98897	. WASHER, Lock	1		PAOZZ
-27	4G13502-101A	98897	. SHIM, Upper bearing	1		PAFZZ
-28	4G13504-101A	98897	. BEARING, Sleeve	1		PAOZZ
	4G9405-101B	98897	. BEARING, Sleeve (preferred spare for 4G13504-101A)	1		PAOZZ
-29	4G13509-101A	98897	. SHIM, Bearing	1		PAFZZ
-30	4G13507-101A	98897	. SPACER, Snubber	1		PAOZZ
-31	4G13508-101A	98897	. VALVE, Snubber	1		PAOZZ
-32	4G13506-101A	98897	. SLEEVE, Lock	1		PAOZZ
-33	4G13505-101A	98897	. RING, Lock	1		PAOZZ
-34	4G13435-101A	98897	. SCREW, Nylon	4		PAOZZ
-35	4G13434-101A	98897	. PIN, Lock	4		PAOZZ
-36	4G13433-101A	98897	. RETAINER, Packing	1		PAOZZ
-37	S12561-451	97820	. SEAL, Channel	1		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-10-38	AN6227-78	88044	. PACKING	1		PAOZZ
-38A	S34468P5	97820	SEAL ASSEMBLY (3 PIECE)	1		PAOZZ
-39	7451FT2P3	72902	. RETAINER	4		PAOZZ
-40	7451FT160A	72902	. PACKING	2		PAOZZ
-41	745A2MT2N	72902	. RETAINER	6		PAOZZ
-42	745A2MT987	72902	. PACKING	3		PAOZZ
-43	DELETED					
-44	DELETED					
-45	4G94448-105A	98897	. BEARING, Sleeve	1		PAFDD
	4G94448-105B	98897	. BEARING, Sleeve (preferred spare for 4G94448-105A)	1		PAFDD
-46	4G53767-105A	98897	. WIPER, Felt (make from part No. MS28932-1 or part No. CF206) (8305-00-495-6765)	1		MOOZZ
-47	351-45100-312A	72902	. SCRAPER	1		PAFZZ
-48	DELETED					
-49	4G13703-101A	98897	. WASHER, Special	1		PAOZZ
-50	4G13436-101A	98897	. RING, Bearing retainer	1		PAOZZ
-51	DELETED					
-52	4G13437-101B	98897	. NUT, Packing	1		PAOZZ
	4G13437-105A	98897	. NUT, Packing (preferred spare for 4G13437-101B)	1		PAOZZ
-53	4G14648-101A	98897	. RETAINER, Key, lock	2		PAOZZ
-54	4G13686-101A	98897	. BOLT	4		PAOZZ
-55	4G13501-101A	98897	. RING, Lock	1		PAOZZ
-56	4G13496-103A	98897	. RING, Splined slide	1		PAOBZ
-57	4G13495-101A	98897	. RING, Piston	1		PAOZZ
-58	4G12432-101A	98897	. TUBE ASSEMBLY, Splined	1		PADLD
-59	4G13440-101A	98897	. . SCREW, Lock	1		PAOZZ
	8341160-01	98747	. . SCREW, Lock (preferred, spare for 4G13440-101A)	1		PAOZZ
-60	4G12408-101A	98897	. . RESTRICTOR	1		PADZZ
-61	4G13413-101A	98897	. . TUBE, Splined	1		XA
-61A	8240768-01	98747	. . INSERT (Repair) (AR)	1		PADZZ
-61B	MS28775-125	96906	. . PACKING (Repair) (AR)	1		PADZZ
-62	7926445	98747	. PISTON AND CHAMBER ASSEMBLY	1		PAOLD
-63	MS28778-4	96906	. . PACKING	1		PAOZZ
-64	MS28773-04	96906	. . RETAINER	1		PAOZZ
-65	1-03076C4	70195	. . NUT, Locking	1		PAOZZ
-66	G3714	03936	. . GAGE (Ref 4G94407-101A)	1		PAFZZ
	1000-38	24708	. . GAGE, Pressure (alt)	1		PAFZZ
-67	8631382-01	98747	. . PLATE, Warning	1		PAOZZ
-68	MS28889-1	96906	. . VALVE	1		PAOZZ
-69	MS28778-5	96906	. . PACKING	1		PAOZZ
-70	MS28775-013	96906	. . PACKING	2		PAOZZ
-71	MS28774-013	96906	. . RETAINER	4		PAOZZ
-72	4G13522-101A	98897	. . FITTING, Gage and valve	1		PAOZZ
	8121312-01	98747	. . FITTING, Gage (alt)	1		PAOZZ
-73	4G13679-101A	98897	. . BOLT, Special	1		PAOZZ
-74	20261SL475	10989	. . PLUG, Filter	1		PAOZZ
-75	MS28778-2	96906	. . PACKING	1		PAOZZ
-76	AN814-26	88044	. . PLUG	1		PAOZZ
-77	NAS509-12	80205	. . NUT	1		PAOZZ
-78	4G13521-101A	98897	. . WASHER, Lock	1		PAOZZ
-79	MS28774-218	96906	. . RETAINER	2		PAOZZ
-80	AN6227-23	88044	. . PACKING	2		PAOZZ
-81	MS28774-346	96906	. . RETAINER	2		PAOZZ
-82	AN6227-49	88044	. . PACKING	1		PAOZZ
-83	4G13519-101A	98897	. . BASE, Metering tube	1		PAFZZ
-84	4G13520-101A	98897	. . CUP, Locking	1		PAOZZ
-85	4G13518-101A	98897	. . TUBE, Lower metering	1		PADZZ
-86	MS28774-114	96906	. . RETAINER	2		PADZZ
-87	AN6227-12	88044	. . PACKING	1		PADZZ
-88	MS28774-214	96906	. . RETAINER	2		PADZZ
-89	AN6227-19	88044	. . PACKING	1		PADZZ
-90	4G13390-101A	98897	. . TUBE, Upper metering	1		PADZZ
-91	44C8MK2N	72902	. . RING, Backup	4		PADZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-10-92	44C8MR2T	72902	. . RING, Backup	4		PADZZ
-93	44C8MTE160A	72902	. . PACKING, Preformed	2		PADZZ
	744F8MTE-160-4780	72902	. . PACKING ASSEMBLY, Preformed (1st oversize)	2		PAOZZ
-94	4G53767-101A	98897	. . WIPER, Felt (make from part No. MS28932-1 or part No. CF206) (8305-00-495-6765	3		MOOZZ
-95	4G13676-101A	98897	. . RING, Piston	1		PADZZ
-96	4G13513-101A	98897	. . PIN, Shoulder lock	1		PADZZ
-97	4G13512-101A	98897	. . RING, Threaded stop	1		PADZZ
-98	4G13510-101A	98897	. . PISTON, Floating, standard	1		PADZZ
	8412565-01	98847	. . PISTON, Floating (use for 1st oversize)	1		PADZZ
	8412565-03	98747	. . PISTON, Floating (use for 2nd oversize)	1		PADZZ
-99	4G13515-101A	98897	. . NUT	1		PADZZ
-100	4G13516-101A	98897	. . WASHER	1		PADZZ
-101	AN6230-8	88044	. . PACKING	2		PADZZ
	MS28775-230	96906	. . PACKING (Preferred spare for AN6230-8	2		PADZZ
-102	MS28774-230	96906	. . RETAINER	4		PADZZ
-103	326FK2N	72902	. . RING, Backup	4		PADZZ
-104	326FR2T	72902	. . RING, Backup	4		PADZZ
-105	326FTE160A	72902	. . PACKING, Preformed	2		PADZZ
-105A	7326FTE-160-P5	72902	. . T-SEAL ASSEMBLY	1		PADZZ
-105B	7326FTE-964-4780	72902	. . T-SEAL ASSEMBLY (Preferred spare for 7326FTE-160-P5)	1		PADZZ
-106	4G53767-109A	98897	. . WIPER, Felt (make from part No. MS28932-1 or part No. CF206) (8305-00-495-6765)	3		MDDZZ
-107	4G13514-101A	98897	. . CARRIER	1		PADZZ
-108	4G12409-101B	98897	. . TUBE ASSEMBLY	1		PADDD
-109	4G13662-101A	98897	. . . PIN, Locating	1		PADZZ
	4G19051-103A	98897	. . . PIN, Locating (preferred spare for 4G13662-101A)	1		PADZZ
-110	4G12409-103A	98897	. . . TUBE	1		PADBZ
-111	4G13677-101A	98897	. . PACKING	1		PADZZ
-112	4G11414-107A	98897	. . PISTON ASSEMBLY	1		PADLD
	7926446-10	98747	. . PISTON ASSEMBLY, Std	1		PADLD
	7926446-30	98747	. . PISTON ASSEMBLY (1st oversize)	1		PADLD
	7926-446-50	98747	. . PISTON ASSEMBLY (2nd oversize)	1		PADLD
-113	4G13491-103A	98897	. . . BUSHING	1		PADZZ
	4G13491-105A	98897	. . . BUSHING (Preferred spare for -103A)	1		PADZZ
-114	4G13490-117A	98897	. . . BUSHING (Preferred spare for -105A and -109A)	1		PADZZ
	8020270-30	98747	. . . BUSHING, Field repair	1		PAFZZ
-115	4G14599-101A	98897	. . . BUSHING, Special	1		PADZZ
	7926422-01	98747	. . . BUSHING, Special alt repair	1		PADZZ
-116	ARP568-047	81343	. . . PACKING	1		PADZZ
-117	4G14604-101A	98897	. . . BUSHING, Special	4		PADZZ
-118	4G11414-109A	98897	. . . PISTON	1		PADLD

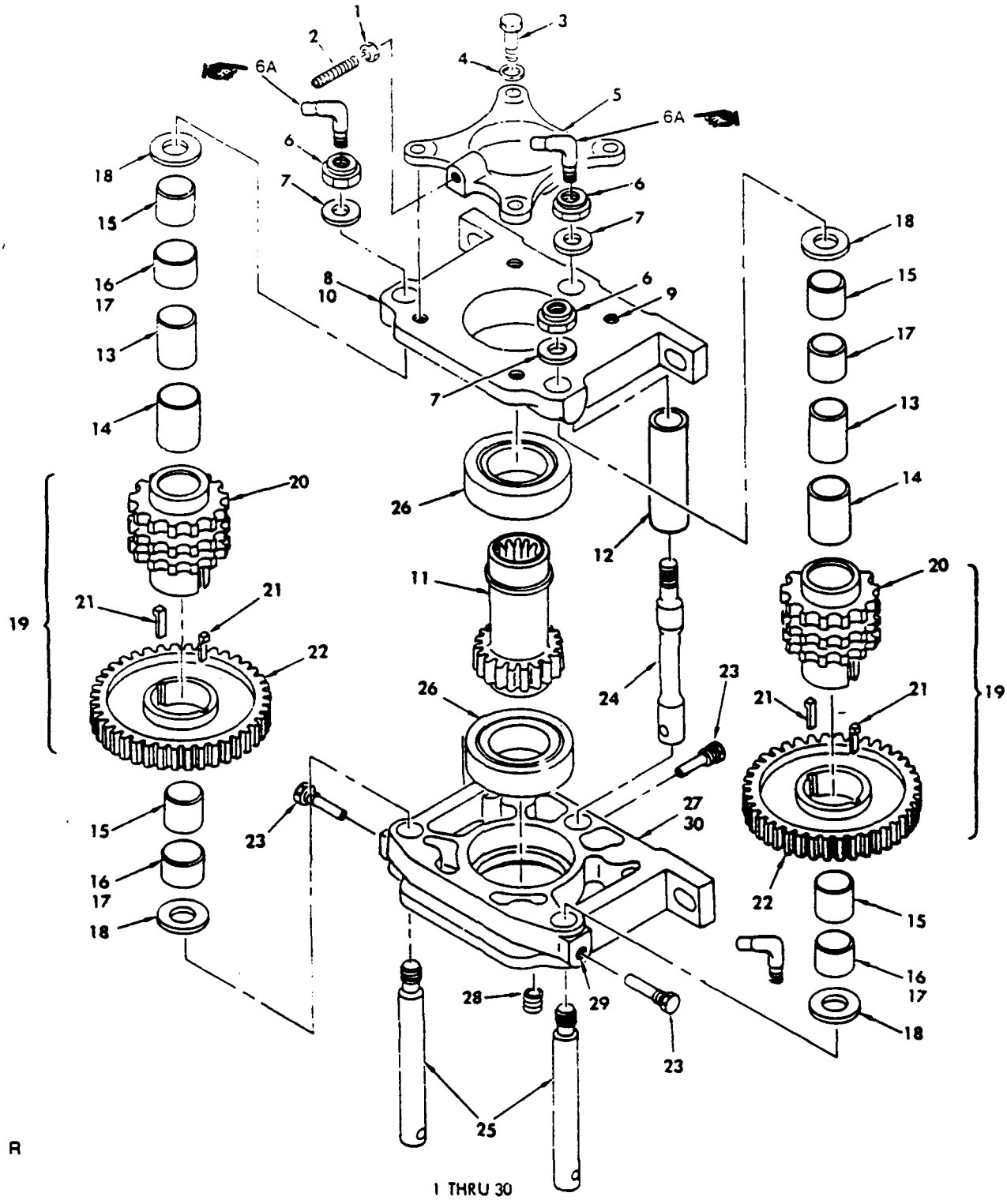
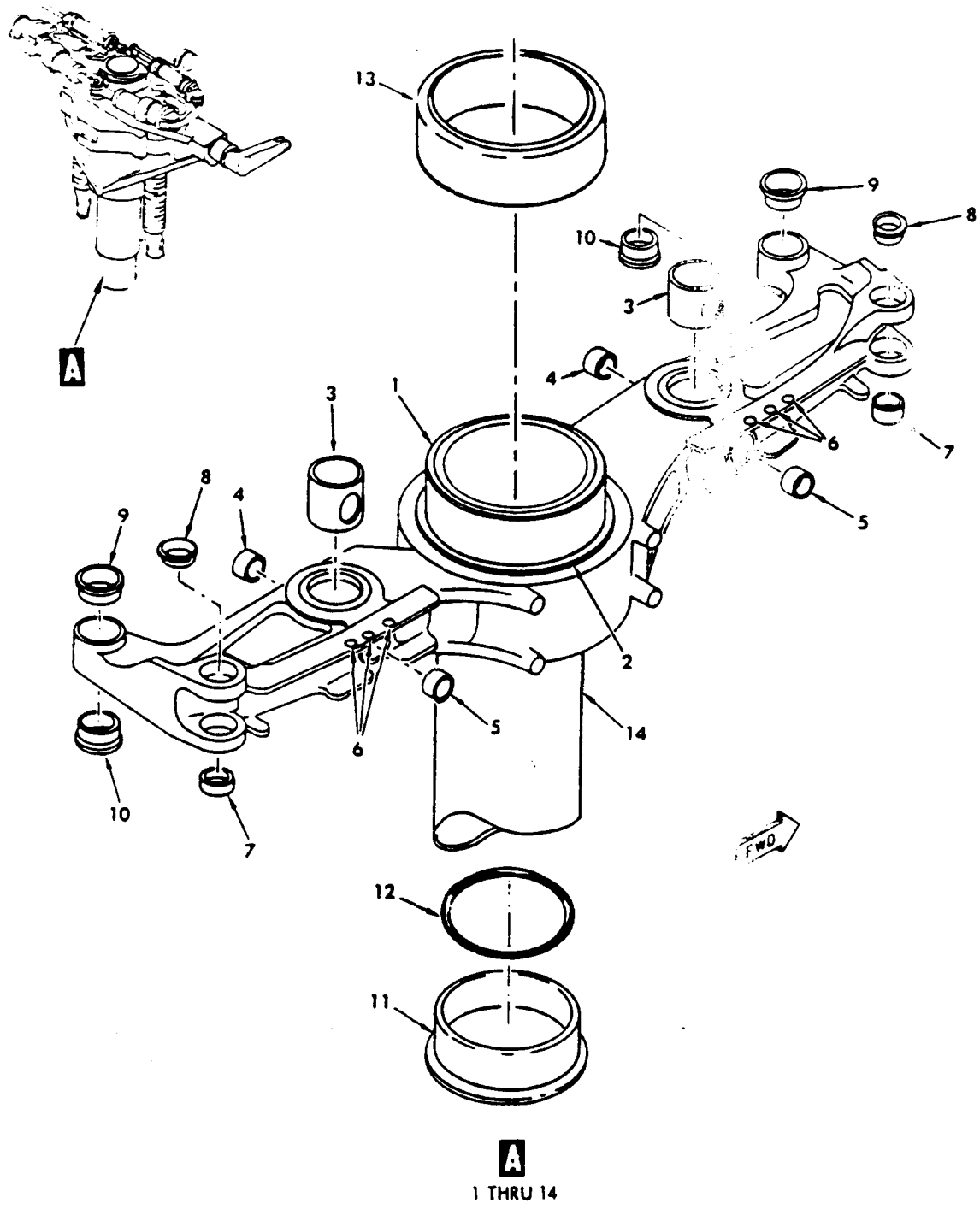


Figure 2-11. Ballscrew Drive Housing Assembly

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-11-	4G11416-101B	98897	BALLSCREW DRIVE HOUSING ASSEMBLY (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		PAFFF
	4G11416-101C	98897	BALLSCREW DRIVE HOUSING ASSEMBLY (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		PAFFF
-1	NAS1423-4	80205	. NUT	1		PAOZZ
-2	4G13812-101A	98897	. STUD (See figure 2-1 for NHA)	REF		PAFZZ
-3	AN6H6A	88044	. BOLT	4		PAOZZ
-4	AN960PD616L	88044	. WASHER	4		PAOZZ
-5	4G13560-101A	98897	. RETAINER, Gear	1		PAOZZ
-6	MS20364-918	96906	. NUT	3		PAOZZ
-6A	MS15001-4		. FITTING, Grease	2		PAOZZ
-7	AN960PD916	88044	. WASHER	3		PAOZZ
-8	4G12423-101A	98897	. PLATE ASSEMBLY, Upper	1		PAFFF
-9	MS124738	96906	. . INSERT	4		PAOZZ
-10	4G12423-103A	98897	. . PLATE, Upper	1		PAFFF
-11	4G13598-101A	98897	. GEAR, Drive	1		PAOZZ
-12	4G13668-101A	98897	. SPACER	1		PAFZZ
-13	4G13604-101A	98897	. SPACER, Bearing race	2		PAFZZ
-14	4G13667-101A	98897	. SPACER, Bearing	2		PAFZZ
-15	MS17130-7	96906	. RACE	4		PAOZZ
	8742944-01	98747	. RACE, (Preferred spare for MS17130-07)	4		PAOZZ
-16	DELETED					
-17	MS17131-30	96906	. BEARING	4		PAOZZ
-18	4G13603-101A	98897	. WASHER, Thrust	4		PAOZZ
-19	4G12435-101A	98897	. SPROCKET ASSEMBLY, Drive	2		PAOZZ
-20	4G13601-101A	98897	. . SPROCKET	2		XA
-21	4G13670-101A	98897	. . KEY, Sprocket	4		PAFZZ
-22	4G13602-101A	98897	. . GEAR	2		XA
-23	4G13666-101A	98897	. BOLT	3		PAOZZ
-24	4G13678-101A	98897	. SHAFT, Threaded	1		PAFFF
-25	4G13665-103A	98897	. SHAFT, Threaded	2		PAOZZ
	7829287-01	98747	. SHAFT, Threaded, alt	2		PAOZZ
-26	209SZZ	38443	. BEARING	2		PAOZZ
-27	4G13558-101A	98897	. PLATE ASSEMBLY, Lower housing	2		PAFZZ
-28	MS124738	96906	. . INSERT	4		PAOZZ
-29	MS124736	96906	. . INSERT	3		PAOZZ
-30	4G13558-103A	98897	. . PLATE, Lower housing	1		XA



R

Figure 2-12. Outer Cylinder Assembly

FIG & INDEX NO	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	TS R	USABLE ON CODE	SMR CODE
2-12-	4G11415-107A	98897	CYLINDER ASSEMBLY, OUTER (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	FF		PAFDD
	4G11415-107C	98897	CYLINDER ASSEMBLY, OUTER (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	FF		PAFDD
-1	4G13611-103A	98897	. BEARING, Sleeve	1		PADZZ
	7729790-01	98747	. BEARING, Sleeve, repair	1		PADZZ
-2	4G13612-101A	98897	. BEARING, Thrust	1		PADZZ
	4G13612-103A	98897	. BEARING (Preferred spare for -101A)	1		PADZZ
-3	4G13588-105A	98897	. BUSHING, Sleeve	2		PADZZ
	4G14609-101A	98897	. BUSHING, Flanged Repair	2		PADZZ
-4	4G13591-103A	98897	. BUSHING, Sleeve	2		PADZZ
	4G13591-105A	98897	. BUSHING (Preferred spare for -103A)	2		PADZZ
-5	4G13672-103A	98897	. BUSHING, SLEEVE	2		PADZZ
	4G13672-105A	98897	. BUSHING (Preferred spare for -103A)	2		PADZZ
-6	4G13673-103A	98897	. BUSHING, Flanged	6		PADZZ
	4G13673-105A	98897	BUSHING (Preferred spare for -103A)	6		PADZZ
-7	4G13385-103A	98897	. BUSHING, Sleeve	2		PADZZ
	4G13385-105A	98897	. BUSHING (Preferred spare for -103A)	2		PADZZ
-8	4G13382-103A	98897	. BEARING, Flanged	2		PADZZ
	4G13382-105A	98897	. BUSHING (Preferred spare for -103A)	2		PADZZ
	4G13382-109A	98897	. BUSHING (Preferred spare for 4G13382-105A)	2		PADZZ
-9	4G13675-103A	98897	. BEARING, Flanged	2		PADZZ
	4G13675-109A	98897	. BUSHING, (Preferred spare for -101A and -103A)	2		PADZZ
-10	4G13675-107A	98897	. BEARING, Flanged	2		PADZZ
	4G13675-109A	98897	. BUSHING (Preferred spare for -105A and -107A)	2		PADZZ
-11	4G14598-101A	98897	. BUSHING, Special ID repair	1		PADZZ
-12	2-171S604-70	38597	. PACKING (Used with repair 4G14598-101A)	1		PADZZ
-13	4G14597-101A	98897	. BUSHING, Special OD Repair	1		PADZZ
-14	4G11415-109A	98897	. CYLINDER, Outer	1		PADZZ

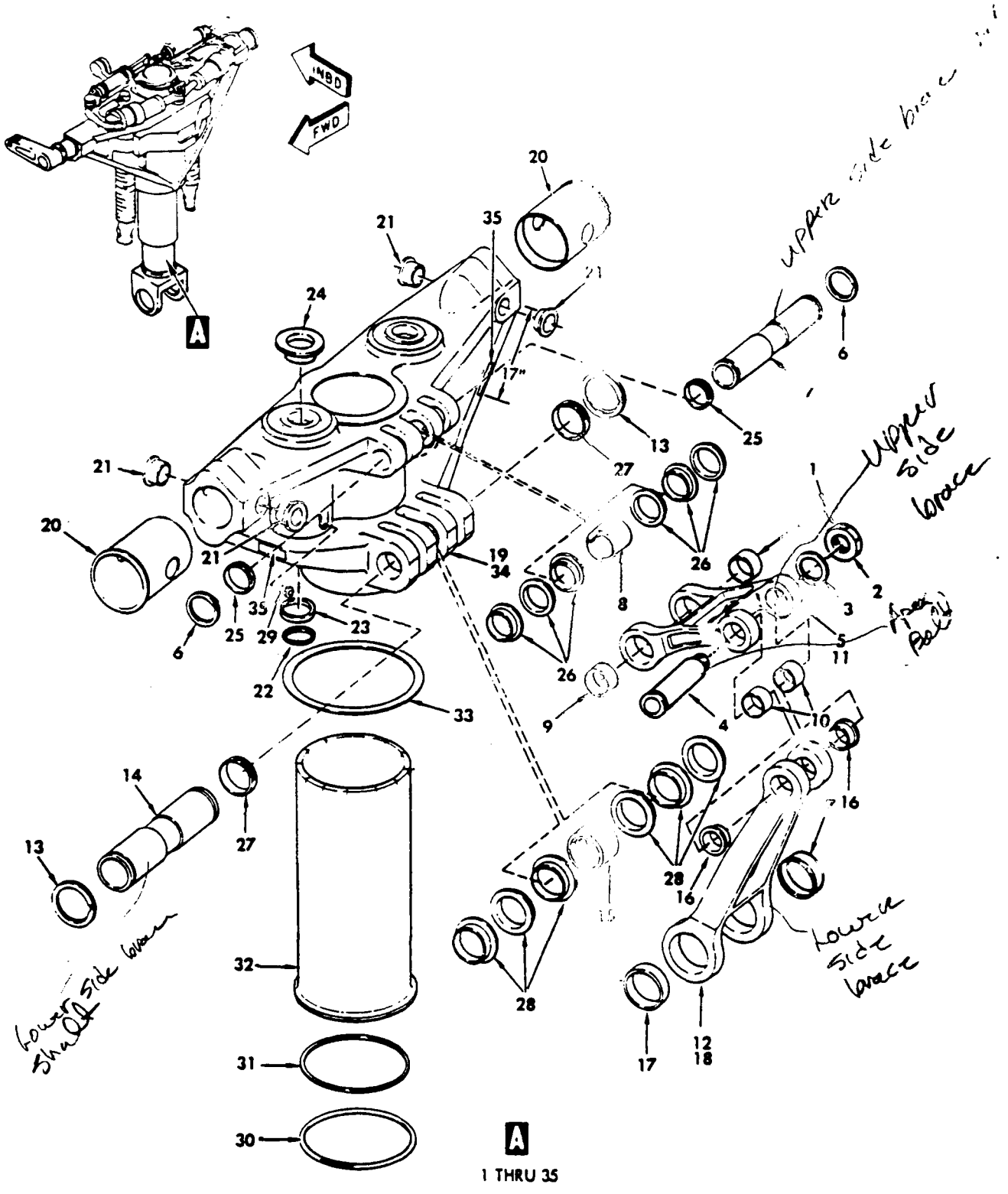


Figure 2-13. Yoke and Side Brace Assembly

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-13-	NO NUMBER		YOKE AND SIDE BRACE ASSEMBLY (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		XA
-1	MS24665-439	96906	. PIN, Cotter	1		PAOZZ
-2	4G13525-101A	98897	. NUTS	1		PAOZZ
-3	4G13756-101A	98897	. WASHER	1		PAOZZ
-4	4G13537-101A	98897	. BOLT, Apex	1		PAFDD
-5	4G11436-107A	98897	. ARM ASSEMBLY, Upper side brace	1		PAFLD
-6	RS318CD	80756	. RING, Retaining (AP)	2		PAFZZ
-7	4G13538-101A	98897	. SHAFT, Upper (AP)	1		PAFDD
-8	4G13540-101A	98897	. RING, Upper split retainer (AP)	1		PAFZZ
-9	4G13533-103A	98897	. . BUSHING, Sleeve	2		PADZZ
	4G13533-105A	98897	. . BUSHING (Preferred spare for -103A)	2		PADZZ
	8412410-01	98747	. . BUSHING, Flanged (single face repair)	2		PADZZ
	8412410-03	98747	. . BUSHING, Flanged (dual face repair)	4		PADZZ
-10	4G13534-103A	98897	. . BUSHING, Flanged			PADZZ
	4G13534-105A	98897	. . BUSHING (Preferred spare for -103A)	2		PADZZ
-11	4G11436-109A	98897	. . ARM, Upper side brace	1		XA
-12	4G11435-101A	98897	. ARM ASSEMBLY, Lower side brace	1		PAFLD
-13	RS450CD	80756	. RING, Retaining (AP)	2		PAFZZ
-14	4G13539-101A	98897	. SHAFT, Lower (AP)	2		PAFDD
-15	4G13541-101A	98897	. RING, Lower split retainer (AP)	1		PAFZZ
-16	4G13536-103A	98897	. . BUSHING, Flanged	2		PADZZ
	4G13536-105A	98897	. . BUSHING (Preferred spare for -103A)	4		PADZZ
-17	4G13535-103A	98897	. . BUSHING, Sleeve	2		PADZZ
	4G13535-105A	98897	. . BUSHING (Preferred spare for -103A)	2		PADZZ
	8412410-05	98747	. . BUSHING, Flanged (single face repair)	2		PADZZ
	8412410-07	98747	. . BUSHING, Flanged (dual face repair)	4		PADZZ
-18	4G11435-103A	98897	. . ARM, Lower side brace			XA
-19	4G11430-113B	98897	. YOKE ASSEMBLY	1		PADLD
	4G11430-119A	98897	. YOKE ASSEMBLY (Preferred spare for 4G11430-113B)	1		PADLD
-20	4G13595-103A	98897	. . BUSHING	2		PADZZ
	4G13595-105A	98897	. . BUSHING (Preferred spare for -103A)	2		PADZZ
-21	4G13597-103A	98897	. . BUSHING, Flanged	4		PADZZ
	4G13597-105A	98897	. . BUSHING (Preferred spare for 103A)	4		PADZZ
-22	4G13348-101A	98897	. . RETAINER	1		PAFZZ
-23	4G13697-101A	98897	. . WASHER	1		PAFZZ
-24	4G13762-103A	98897	. . BUSHING, Flanged	2		PADZZ
	4G19063-101A	98897	. . BUSHING ASSEMBLY (Preferred spare for 4N13762-103A)	2		PADZZ
	4G19063-107A	98897	. . BUSHING (Preferred spare for -101A)	2		PADZZ
-25	4G13649-105A	98897	. . BUSHING, Sleeve	2		PADZZ
	4G13649-107A	98897	. . BUSHING (Preferred spare for -105A)	2		PADZZ
-26	4G13592-103A	98897	. . BUSHING, Flanged	6		PADZZ
	4G13592-107A	98897	. . BUSHING (Preferred spare for -103A)	6		PADZZ
-27	4G13650-105A	98897	. . BUSHING, Sleeve	2		PADZZ
	4G13650-107A	98897	. . BUSHING (Preferred spare for -105A)	2		PADZZ
-28	4G13593-103A	98897	. . BUSHING, Flanged	6		PADZZ
	4G13593-107A	98897	. BUSHING (Preferred spare for -103A)	6		PADZZ
-29	4G13729-103A	98897	. . BUSHING, Flanged	4		PADZZ

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-30	4G13763-101A	98897	. . SCRAPER, Ring (Ref MS28776-70)	1		PAFFF
-31	MS29513-279	96906	. . PACKING	1		PAOZZ
-32	90725	09455	. . BEARING (Ref 4G94449-101A)	1		PADZZ
	07-311-200-891E-001	09455	. . BEARING (Preferred spare for 90725)	1		PADZZ
-33	4G13695-101A	98897	. . WASHER, Thrust	1		PADZZ
-34	4G11430-115A	98897	. . YOKE	1		XA
-35	4G14368-101A	98897	. CHAFE GUARD (Make from STM 23-603 Class 2, Grade 80)	AR		PAOZZ

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8412565-01	2-10-98
8412565-03	2-10-98
856081-01	2-5-293
	2-6-293
	2-7-293
	2-8-293
8631382-01	2-10-67
8742944-01	2-11-15

PART NUMBER	FIG & INDEX NO.
8852948-01	2-5-291
	2-6-291
	2-7-291
	2-8-291
8852948-03	2-5-291
	2-6-291
	2-7-291
	2-8-291
9R2220-1	2-5-161
	2-6-161
	2-7-161
	2-8-161
9R2220-2	2-5-222W
	2-7-222W
9R2220-3	2-6-218F
	2-8-218F
900-452-5451-1004	2-16-1
	2-16-9
	2-16-71
900-452-5451-1604	2-16-48
	2-16-60
900010-32C	2-2-15A
	2-3-15A
90725	2-13-32
9905-9	2-4-21
9906-9	2-4-20
9907-44	2-4-19

* U. S. GOVERNMENT PRINTING OFFICE: 1988 -673-075/ 80153
01-30-1989

STL=STEEL
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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	10	4611020-105A	1620010054192	98897	C-5A MLG STRUT ASSY L/H AFT	1	EA										
	.1	4611430-113B	1620001753939	98897	.YOKE ASSY	1	EA										
	..2	4613695-101A	5365001309219	98897	..THRUST WASHER	1	EA										
	..2	MS29513-279	5330002150319	96906	..PACKING, PREFORMED	1	EA										
	..2	4613763-101A	1620001793978	98897	..SCRAPER RING	1	EA										
	..2	4614368-101A	1620010109123	98897	..CHAFE GUARD	2	EA										
	..2	4611430-115A	N.S.L.	98897	...YOKE	1											
	...3	4613995-103A	3120001922052	98897	...TRUNNION BUSHING	1	EA										
	...3	4613595-105A	3120010536149	98897	...TRUNNION BUSHING (O.S)	2	AR EA					ALT					
	...3	4613597-103A	3120001355642	98897	...TRUNNION CROSS PIN BUSHING	4	EA										
	...3	4613597-105A	3120010533041	98897	...TRUNNION CROSSING BUSHING (O.S.)	4	AR EA					ALT					
	...3	4619063-101A	3120010031430	98897	...BALL SCREW BUSHING ASSY	2	EA										
	4	4619063-105A	3120000000077	98897	....NUT PLAIN ROUND	2	EA										
	4	MS18063-25	N.S.L.	96906	....SET SCREW	2											
	4	4619063-103A	3120010051325	98897	....BUSHING SLEEVE	2	EA										
	...3	4619063-107A	3120010530502	98897	...BALL SCREW BUSHING ASSY (O.S.)	2	AR EA					ALT					
	4	4619063-105A	3120000000077	98897	....NUT, PLAIN ROUND	2	EA										
	4	MS1863-25	N.S.L.	96906	....SET SCREW	2											
	...3	4613729-103A	3120011313572	98897	...BUSHING, BALL SCREW ATTACH	4	EA										
	...3	4613729-105A	3120010536151	98897	...BUSHING, BALL SCREW ATTACH (O.S.)	4	AR EA					ALT					
	...3	4613649-105A	3120004996308	98897	...BUSHING, UPSIDE BRACE LUG	2	EA										
	...3	4613649-107A	3120010536154	98897	...BUSHING, UPSIDE BRACE LUG (O.S.)	2	AR EA					ALT					
	...3	4613592-103A	3120001313566	98897	...BUSHING, FLANGED BRACE LUG UPSIDE	6	EA										
	...3	4613592-107A	3120010536152	98897	...BUSHING,FLANGED BR LUG UPSIDE(O.S.	6	AR EA					ALT					
	...3	4613650-105A	3120004770756	98897	...BUSHING, LO SIDE BRACE LUG	2	EA										
	...3	4613650-107A	3120010536146	98897	...BUSHING, LO SIDE BRACE LUG (O.S.)	2	AR EA					ALT					
	...3	4613593-103A	3120001313567	98897	...BUSHING FLANGED LOW SIDE BRACE LU	6	EA										
	...3	4613593-107A	3120010536150	98897	...BUSHG FLANGED LOWSIDE BR LUG (O.S	6	AR EA					ALT					
	...3	07-311-200-891E-001	3120002392816	09455	...CENTER BUSHING	1	EA					INT					
	...3	4694449-101A	3120002392816	98897	...BEARING SLEEVE	1	EA										
	...3	MS21208F4-20	5340002904497	96906	...INSERT	6	EA										
	.1	4612400-101A	1620001162099	98897	.TRUNNION PIN	1	EA										
	.1	4613999-101A	5365001994606LE	98897	.SHIPPING SPACER	1	EA										
	.1	4611436-107A	1620001157388	98897	.UPPER SIDE BRACE ASSY	1	EA										
	..2	4611436-109A	N.S.L.	98897	..UPSIDE BRACE ARM	1											
	..2	4613533-103A	3120001313552	98897	..BUSHING, FLANGED	2	EA										
	..2	4613533-105A	3120010533043	98897	..BUSHING, FLANGED (O.S.)	2	AR EA					ALT					
	..2	8412410-01	3120011814133	98747	..BUSHING,FLANGED SINGLE FACE REPAIR	2	AR EA										
	..2	8412410-03	N.S.L.	98747	..BUSHING, FLANGED DUAL FACE REPAIR	2	AR					ALT					
	..2	4613534-103A	N.S.L.	98897	..BUSHING, FLANGED	2											
	..2	4613534-105A	3120010530503	98897	..BUSHING, FLANGED (O.S.)	2	AR EA					ALT					
	.1	4611435-101A	1620001157387	98897	.LOWER SIDE BRACE ASSY	1	EA										
	..2	4611435-107A	N.S.L.	98897	..LOWER SIDE BRACE ASSY												

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	8412410-07	N.S.L.	98747	..BUSHING, FLANGED DUAL FACE REPAIR	4						ALT					
	.1	[redacted]	1620001164434	98747	.SHAFT, UPPER SIDE BRACE	1	EA										
	.1	4613540-101A	5365002203152	98897	.RETAINER, SPLIT RING	1	EA										
	.1	RS318CD	5365002291255	98897	.RETAINING RING	2	EA										
	.1	[redacted]	1620001164435	98897	.SHAFT, LOWER SIDE BRACE	1	EA										
	.1	4613541-101A	5365002203153	98897	.RETAINER, SPLIT RING	1	EA										
	.1	RS450CD	5365002291254	98897	.RETAINING RING	2	EA										
	.1	[redacted]	1620001164433	98897	.BOLT, APEX	1	EA										
	.1	4613756-101A	5310001321826	98897	.WASHER	1	EA										
	.1	4613525-101A	3110002203018	98897	.NUT	1	EA										
	.1	MS24665-439	5310002368370	96906	.COTTER, PIN	1	EA										
	.1	[redacted]	1620001153490	98897	.RETRACT ARM ASSY	1	EA										
	..2	LS35154-7	5310004024687	98897	..NUT	4	EA										
	..2	LFLH7559-3	5310004028831	98897	..WASHER, SPECIAL	4	EA										
	..2	70361-1032	N.S.L.	98897	..NUT	1											
	..2	2230-7	5330005765121	98159	..SPECIAL WASHER W/PACKING	4	EA										
	..2	H39269-3	5310000366931	98897	..NUT	2	EA										
	..2	NAS603-24P	5305009200852	98897	..SCREW	2	EA										
	..2	4614505-105A	5340001008840	98897	..LOCK PLATE	1	EA										
	..2	MS21250-07100	5306010818926	98897	..BOLT	4	EA										
	..2	4614507-101A	5340000476257	98897	..RETAINER	1	EA										
	..2	MS15001-1	4730000504203	96906	..FITTING, LUBRICATION	1	EA										
	..2	4614506-101A	5340002655184	98897	..DIAPHRAM	1	EA										
	..2	MS28775-431	5330008473562	96906	..PACKING, PREFORMED	1	EA										
	...3	4611448-109A	N.S.L.	98897	...RETRACT ARM	1											
	...3	4613530-105A	3120010533044	98897	...BUSHING, FLANGED	1	EA										
	...3	4613529-103A	3120001357863	98897	...BUSHING, FLANGED	1	EA										
	...3	4613529-105A	3120010536147	98897	...BUSHING, FLANGED (O.S.)	1	AR EA					ALT					
	...3	4614606-101A	3120010536153	98897	...BUSHING, SLEEVE	2	EA										
	...3	66C33001-03ST02	3120011791480	98747	...BUSHING, RIG PIN	2	EA										
	.1	[redacted]	5306004541547	98897	.BOLT, TRUNNION CROSS PIN	2	EA										
	.1	AN960C3616	5365008338491	88044	.WASHER	2	EA										
	.1	4613346-101A	5310004839500	98897	.WASHER, KEY LOCK	2	EA										
	.1	4613332-101A	5310001351430	98897	.NUT, SPECIAL	2	EA										
	.1	MS21392-2C13	5315008258657	96906	.CLEVIS PIN	2	EA										
	.1	MS24665-132	5315008392329	96906	.COTTER, PIN	4	EA										
	.1	LS5964R24-0122	4010001702967	98897	.CABLE	2	EA										
	.1	MS21256-1	5340006197031	96906	.CLIP	4	EA										
	.1	MS21251B5S	5340000679878	96906	.TURN BUCKLE BODY	2	EA										
	.1	MS21252-5LS	5340000680531	96906	.CLEVIS	2	EA										
	.1	MS20392-3C15	5315000642699	96906	.CLEVIS PIN	2	EA										
	.1	4614364-107A	1620010880616	98897	.PLATE ASSY	1	EA										
71	..2	MS21042-4	5310008071468	96906	..NUT, SELF LOCKING	1	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	MS2806-20	5305001080879	80205	.SCREW, MACHINE	4	EA										
	.1	AN960D161L	5310001872395	88044	.WASHER, FLAT	4	EA										
	.1	LS3859-6-26	3120001738520	88044	.BUSHING, SLEEVE	2	EA										
	.1	AN960D616	5310001671726	88044	.WASHER, FLAT	4	EA										
	.1	MS21042-6	5310008101786	96906	.NUT, SELF LOCKING	4	EA										
	.1	4614366-103A	1620010074010	98897	.PLATE	1	EA										
	.1	4614366-105A	1620010880616	98896	.PAD	2	EA										
	.1	4611005-121A	1560007772603	98896	.CLAMP	1	EA										
	.1	AN960D416	5310001849001	88044	.WASHER, FLAT	1	EA										
	.1	MS1634-3	5305002429395	80205	.SCREW, MACHINE	1	EA										
	.1	MS21044N4	5310008775796	96906	.NUT	1	EA										
	.1	4614354-105A	1620004795766	98896	.LGE HALF FWD COLLAR	1	EA										
	.1	4614355-101A	1620004795776	98897	.SM HALF FWD COLLAR	1	EA										
	.1	4615354-107A	1620004795775	98897	.LGE HALF AFT COLLAR	1	EA										
	.1	4614355-103A	1620004814671	98897	.SM HALF AFT COLLAR	1	EA										
	.1	4611416-101B	1620003175536	98897	.GEAR DRIVE ASSY	1	EA										
	..2	4613558-101A	1620004212101	98897	..PLATE ASSY LOWER HSG	1	EA										
	...3	4613558-103A	N.S.L.	98897	...PLATE, LOWER	1											
	...3	4614610-101A	N.S.L.	98747	...BUSHING, 1ST O.S.	1	AR										
	...3	4614610-103A	N.S.L.	98747	...BUSHING, 2ND O.S.	1	AR					ALT					
	...3	4614610-105A	N.S.L.	98747	...BUSHING, 3RD O.S.	1	AR					ALT					
	...3	MS24738	5340010314286	96906	...INSERT (HELICOIL)	3	EA										
	...3	MS124736	5340002904497	96906	...INSERT (HELICOIL)	4	EA										
	..2	4612423-101A	1620004182976	98897	..PLATE ASSY UPPER HSG	1	EA										
	...3	4614610-101A	N.S.L.	98747	...BUSHING, 1ST O.S.	1	AR										
	...3	4614610-103A	N.S.L.	98747	...BUSHING, 2ND O.S.	1	AR					ALT					
	...3	4614610-105A	N.S.L.	98747	...BUSHING, 3RD O.S.	1	AR					ALT					
	...3	MS24738	5340010314286	96906	...INSERT (HELICOIL)	4	EA										
	..2	7829287-01	1620011565804	98897	..SHAFT, THREADED	2	EA										
	..2	4613678-101A	1620001166217	98897	..SHAFT, THREADED (ALUM)	1	EA										
	..2	20922	3110001145989	38443	..BEARING	2	EA										
	..2	4613666-101A	5306001321818	98897	..BOLT, SPECIAL	3	EA										
	..2	4613603-101A	5310001265734	98897	..WASHER, THRUST	4	EA										
	..2	MS17131-30	3110001570535	96906	..BEARING (ROLLER NEEDLE)	4	EA										
	..2	MS17130-7	3110003649616	96906	..RACE, BEARING	4	EA										
	..2	4613667-101A	5365001357845	98897	..SPACER SLEEVE	2	EA										
	..2	4613604-101A	5365001793976	98896	..SPACER, BEARING RACE	2	EA										
	..2	AN960PD916	5310001872402	88044	..WASHER, FLAT	3	EA										
	..2	4613668-101A	5365001357846	98897	..SPACER, SLEEVE	1	EA										
	..2	4612435-101A	1620001162103	98897	..SPROCKET, ASSY	2	EA										
	...3	4613601-101A	N.S.L.	98897	...SPROCKET	2											
	...3	4613602-101A	N.S.L.	98897	...GEAR	2											
	...3	4613670-101A															

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNB NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	4613598-101A	3040001166241	98897	..DRIVE GEAR	1	EA										
	..2	MS15001-4	4730000504207	96906	..FITTING, LUBRICATION	2	EA										
	.1	NAS1308-26	5306007642208	80205	.BOLT, SHEAR	4	EA										
	.1	AN960-816	5310001670823	88044	.WASHER, FLAT	4	EA										
	.1	4613687-101A	5365001309216	98897	.SHIM	4	EA										
	.1	NAS577-89	5310008021268	80205	.BARREL NUT	4	EA										
	.1	4G94034-101A	1620001486466	00293	.BALLSCREW ASSY	2	EA										
	..2	B15576-2R	N.S.L.	00293	..BALL NUT	1											
	...3	66C33001-107ST	3120010731954	98747	...CROSS PIN BUSHING (O.S.)	2	AR EA										
	...3	B15576-1	N.S.L.	00293	...SCREW	1											
	..2	B15576-12	1620010064606	00293	..ADAPTER	1	EA										
	..2	B8562-1A	1620010294408	00293	..BALL BEARING	187	EA										
	..2	MS1959-2424	3110001006159	96906	..BALL BEARING	187	EA					INT					
	..2	B8562-1A05	N.S.L.	00293	..BALL BEARING (0.0005)(O.S.)	187	AR					ALT					
	..2	B8562-1A10	N.S.L.	00293	..BALL BEARING (0.001)(O.S.)	187	AR					ALT					
	..2	B8562-1A20	N.S.L.	00293	..BALL BEARING (0.002)(O.S.)	187						ALT					
	..2	B8562-1A30	N.S.L.	00293	..BALL BEARING (0.003)(O.S.)	187						ALT					
	..2	B15576-7R	N.S.L.	00293	..SCRAPER	1											
	..2	B15576-14R	1620010064607	00293	..SCRAPER	1	EA										
	..2	B15576-9	5315010053596	00293	..DRIVE PIN (SCRAPER)	4	EA										
	..2	B15576-8	5330010049089	00293	..SEAL, FELT	1	EA										
	..2	MS28775-240	5330006181603	96906	..PACKING, PREFORMED	1	EA										
	..2	AN6230-18	5330001943733	88044	..PACKING, PREFORMED	1	EA					INT					
	..2	B15576-4R	1620010065359	00293	..DEFLECTOR (YOKE)	4	EA										
	..2	B15576-3R	1620010063304	00293	..TUBE, BALL RETURN	2	EA										
	..2	B15576-5R	1620010065357	00293	..TUBE, BALL RETURN	1	EA										
	..2	B15576-6	1620010065358	00293	..TUBE CLAMP	1	EA										
	..2	MS99360-12	5310008645279	96906	..HEX NUT	4	EA										
	..2	MS15001-4	4730000504207	96906	..FITTING, LUBRICATION	1	EA										
	..2	B15576-13R	1620010064608	00293	..DOG STOP	1	EA										
	..2	B15576-10	5310010060370	00293	..HEX NUT	1	EA										
	..2	B15576-11	N.S.L.	00293	..NAME PLATE	1											
	..2	67C30171-03	N.S.L.	98747	..NAME PLATE DECAL	1						ALT					
	.1	4613696-101A	1620001309235	98897	.KEY	8	EA										
	.1	4613586-101A	1620001166213	98897	.SPROCKET	2	EA										
	.1	4613688-101A	5365001309217	98897	.KEYED SPACER	2	EA										
	.1	4613431-101A	5365001994594	98897	.ROUND NUT	2	EA										
	.1	MS24665-368	5315002368357	96906	.COTTER PIN	2	EA										
	.1	B7374B	3110001177277	80648	.BEARING, RADIAL THRUST	2	EA										
	.1	52RT02	3110010556197	40920	.BEARING, RADIAL THRUST	2	EA					INT					
	.1	B7401B	3110001177278LH	80657	.BEARING, RADIAL	2	EA										
	.1	11612001	3110010556195	32828	.BEARING, RADIAL	2	EA					INT					
	.1	B7402B	3110001177284LH	80657	.BEARING, RADIAL	2	EA										

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17576A

ROUTED ITEMS	LDN LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	1.1	4614392-101B	1620001954823	98897	.BRACKET	1	EA										
	1.1	4614391-101A	1620001031027	98897	.STOP	1	EA										
	1.1	NAS623-3-7	5305006168217	80205	.BOLT	2	EA										
	1.1	MS21042-3	5310008071467	96906	.NUT, SELF LOCKING	2	EA										
	1.1	4869151-121A	5340011566463	98897	.BRACKET	1	EA										
	1.1	NAS603-8P	5305008660937	80205	.SCREW, MACHINE	2	EA										
	1.1	MS21042-08	5310008071466	96906	.NUT, SELF LOCKING	2	EA										
	1.1	442EM1-12	5930001153350	91929	.SWITCH, SENSITIVITY	1	EA										
	1.1	NAS1106-200	5306006806161	80205	.BOLT, SHEAR	2	EA										
	1.1	NAS1106-15	5306008345951	80205	.BOLT, SHEAR	2	EA										
	1.1	AN960-616	5310001670821	88044	.WASHER, FLAT	6	EA										
	1.1	MS21042-6	5310008101786	96906	.NUT, SELF LOCKING	4	EA										
	1.1	4614359-101A	1620011273185	98897	.CLIP	2	EA										
	1.1	XT155503-X80P	3020001796885	72625	.CHAIN, ROLLER	2	EA										
	1.1	50-3CL	3020002318720	80204	.LINK, ROLLER CHAIN	2	EA										
	1.1	4612627-105A	5330012468759LE	98897	.GASKET	1	EA										
	1.1	4812627-107A	1620001469314	98897	.COVER, CHAIN	1	EA										
	1.1	AN960D416L	5310001670740	88044	.WASHER, FLAT	10	EA										
	1.1	NAS1304-7H	5306006806164	80205	.BOLT, SHEAR	6	EA										
	1.1	SS48175	5340002708535	61864	.BUTTON, PLUG	2	EA										
	1.1	JD1191	5340007028534	29215	.BUTTON, PLUG	2	EA					INT					
	1.1	NAS451-56	5340002904532	80205	.BUTTON, PLUG	2	EA					ALT					
	1.1	AN970-4	5310001670766	88044	.WASHER	1	EA										
	1.1	MS21042-4	5310008071468	96906	.NUT, SELF LOCKING	1	EA										
	1.1	4612436-105A	N.S.L.	98747	.GASKET	1											
	1.1	4612436-107A	1620002307138	98897	.PLATE	1	EA										
	1.1	NAS1304-2	5306008072954	80205	.BOLT MACHINE	1	EA										
	1.1	NAS1304-1HH	5306006876357	80205	.BOLT, MACHINE	4	EA										
	1.1	AN960C416L	5310002058924	88044	.WASHER, SPECIAL	4	EA										
	1.1	4613669-101A	5310005351280	98897	.WASHER	4	EA										
	1.1	42252R151	1620000090878	82402	.GEAR BOX	1	EA										
	1.1	42252E220	1620001220474	82402	.BRAKE, HYDRAULIC	1	EA										
	1.1	AN4H10A	5306001821958	88044	.BOLT, MACHINE	5	EA										
	1.1	MS35265-41	5305006229475	96906	.SCREW, MACHINE	1	EA										
	1.1	NAS601-8P	5305008420241	80205	.SCREW, MACHINE	4	EA										
	1.1	MS21042-06	5310008071465	96906	.NUT, SELF LOCKING	4	EA										
	1.1	743133-002	6680000040061	50044	.COUNTER	1	EA										
	1.1	68030	1620000794630	75250	.HYDRAULIC MOTOR	1	EA										
	1.1	4611019-105A	5365002317178	98897	.SPACER	1	EA										
	1.1	MS21042-5	5310006071469	96906	.NUT, SELF LOCKING	6	EA										
	1.1	AN960D516	5310001872399	88044	.WASHER, FLAT	4	EA										
	1.1	STSPB317F0808	4730000902782	98897	.UNION	2	EA										
	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	4614390-101A	4820000039553	98897	.VALVE	1	EA										
	.1	MS28778-6	5330008045695	96906	.PACKING, PREFORMED	1	EA										
	.1	STSPB224F060804	N.S.L.	98897	.TEE	1											
	.1	4671138F060804	4730ND0506316	98897	.TEE	1	EA										
	.1	T4604105-113A	N.S.L.	98747	.TUBE L/H MLG ONLY	1											
	.1	T4604105-133A	N.S.L.	98747	.TUBE, DRAIN LINE	1											
	.1	STSPB116F0404	4730001505783	98897	.ELBOW	1	EA										
	.1	MS21908-4	4730005416479	96906	.ELBOW	1	EA										
	.1	MB9058-04	5330008121105	96906	.PACKING, PREFORMED	1	EA										
	.1	AN6289-4	4730002776372	88055	.NUT	4	EA										
	.1	T4604105-115A	N.S.L.	98747	.TUBE L/H MLG ONLY	1											
	.1	STSPB312F0404	4730006138557	98897	.UNION	1	EA										
	.1	STSPB231F040604	4730000900780	98897	.TEE	1	EA										
	.1	NAS676V5H	5306009176248	80205	.BOLT SPECIAL	4	EA										
	.1	T4604105-117A	N.S.L.	98747	.TUBE L/H MLG ONLY	1											
	.1	T4604105-103A	N.S.L.	98747	.TUBE L/H MLG ONLY	1											
	.1	T4604105-105A	N.S.L.	98747	.TUBE L/H MLG ONLY	1											
	.1	STSPB315F0606	4730002391144	98897	.UNION	1	EA										
	.1	STSPB315F0808	4730001764474	98897	.UNION	2	EA										
	.1	4614389-102A	1620001031028	98897	.BRACKET L/H MLG ONLY	1	EA										
	.1	4612048-101A	N.S.L.	98897	.PIN, COVER	2											
	.1	4613606-101A	5310011307318	98897	.PIN, COVER	2	EA					INT					
	.1	NAS1070-516	5310000814219	98897	.WASHER, FLAT	2	EA										
	.1	4614396-101A	5306000047409	98897	.ROD, THREADED ENDS	1	EA										
	.1	4614393-102B	1620001469575	98897	.BRACKET L/H MLG ONLY	1	EA										
	.1	MS21919D66	5340005434394	96906	.CLAMP	1	EA										
	.1	MS21919D68	5340005980597	96906	.CLAMP	2	EA										
	.1	NAS1133-3	5306006853606	80205	.SCREW, MACHINE	2	EA										
	.1	MS21042-3	5310008071467	96906	.NUT, SELF LOCKING	4	EA										
	.1	NAS603-8P	5305008660937	80205	.SCREW, MACHINE	4	EA										
	.1	MS21919WD67	5340002008559	96906	.CLAMP	4	EA										
	.1	MS21919WD68	5340002915345	96906	.CLAMP	1	EA										
	.1	MS21919WD66	5340005980146	96906	.CLAMP	1	EA										
	.1	AN3066-6	5975002085413	81350	.NUT	1	EA										
	.1	AN3064-6	5975005486514	88044	.CONNECTOR	1	EA										
	.1	4869142-121A	1620011168979	98897	.CONDUIT	1	EA										
	.1	4611415-107A	1620004463776	98897	.OUTER CYLINDER ASSY	1	EA										
	..2	4611415-109A	N.S.L.	98897	..OUTER CYL (BARE)	1											
	..2	4613611-103A	3120002291531	98897	..BEARING, SLEEVE	1	EA										
	..2	4614597-101A	3120010535656	96897	..BUSHING, SPECIAL O.D.	1	AR	EA				ALT					
	..2	4613612-101A	3120001922160	98897	..BEARING THRUST	1		EA									
	..2	4613612-103A	3120010533042	98897	..BEARING, THRUST (OVERSIZE)	1	AR	EA				ALT					
	..2	4613588-103A	3120002203157	98897	..BOLT SCREW BUSHING												

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	4613672-105A	3120010539971	98897	..CROSSPIN BUSHING O.S.	2 AR	EA					ALT					
	..2	4613673-103A	3120001793968	98897	..BUSHING, FLANGED	6	EA										
	..2	4613673-105A	3120010539972	98897	..BUSHING, FLANGED O.S.	6 AR	EA					ALT					
	..2	4613385-103A	3120002456469	98897	..BUSHING, SLEEVE	2	EA										
	..2	4613385-105A	3120010536171	98897	..BUSHING, SLEEVE O.S.	2 AR	EA					ALT					
	..2	4613382-103A	3120004437543	98897	..BUSHING, FLANGED	2	EA										
	..2	4613382-105A	3120010546339	98897	..BUSHING, FLANGED O.S.	2 AR	EA					ALT					
	..2	4613675-103A	3120001355645	98897	..BUSHING, FLANGED	4	EA										
	..2	4613675-107A	3120012352131	98897	..BUSHING, FLANGED O.S.	4 AR	EA					ALT					
	..2	4613675-109A	3120010562212	98897	..BUSHING, FLANGED O.S.	4 AR	EA					ALT					
	...3	4614598-101A	3120010539970	98897	...BUSHING, SPECIAL I.D.	1	EA										
	...3	2-171S604-70	5330001521358	02697	...PACKING, PREFORMED	1	EA										
	.1	B15576-12	1620010064606	00293	.ADAPTER	1	EA										
	.1	4612657-101A	1620001755395	98897	.ELECT INSERT ASSY	1	EA										
	.1..	MS21902-J8	4730007201587	96906	.BULKHEAD UNION	3	EA										
	..2	MS28775-126	5330007021048	96906	..PACKING, PREFORMED	6	EA										
	..2	MS28774-126	5330008009721	96906	..RETAINER	12	EA										
	..2	4613988-101A	1620001994602	98897	..CLIP, NYLON	4	EA										
	..2	4613800-101A	5315001308928	98897	..PIN, RETAINER	4	EA										
	..2	102C150-1	5310000018383	62793	..NUT, RETAINER	1	EA										
	..2	4612583-103A	1620001157419	98897	..FLUID TRANSFER HSG ASSY	1	EA										
	...3	4614394-101A	1620001030976	98897	...CAM	1	EA										
	...3	4611019-107A	5365002356232	98897	...SPACER	1	EA										
	...3	AN502-10-16	5305001509208	88044	...SCREW, MACHINE	2	EA										
	4	468101	5340010812644	92555	....PLUG, PIN (LEE)	5	EA										
	4	478101	5340003684713	92555	....PLUG, PIN (LEE) O.S.	5 AR	EA					ALT					
	4	MS21209F1-15	5340008007874	96906	....INSERT (HELICOIL)	2	EA										
	4	MS21241-12A012	3120005148651	96906	....BUSHING, FABROID LINED (LG)	1	EA										
	5	66C3000-53A01	3120010697638	98747	.....SLEEVE (LG., RPR)	1	EA										
	5	MS21241-12A06	N.S.L.	....*	.....BUSHING, FABROID LINED (LG RPR)	1											
	4	MS21241-08A012	3120004041675	96906	....BUSHING, FABROID LINED (SM)	1	EA										
	5	66C33000-57A01	3120010728265	98747	.....SLEEVE (SM, RPR)	1	EA										
	5	MS21241-08A06	N.S.L.	....*	.....BUSHING, FABROID LINED (SM RPR)	1											
	4	N.P.L.	N.S.L.	98747	....BUSHING, LOCK PINS (4130 STEEL)	4 AR											
	.1	4869022-101A	5330001716444	98897	.CORK GASKET	2	EA										
	.1	4869017-101A	5975001565734	98897	.JUNCTION BOX R/H	1	EA										
	.1	4869016-102A	5975001565737	98897	.JUNCTION BOX R/H	1	EA										
	.1	4869017-102A	5975001565731	98897	.JUNCTION BOX L/H	1	EA										
	.1	4869016-101A	5975001565726	98897	.JUNCTION BOX L/H	1	EA										
	.1	MA6603-30P	5305009270101	80205	.SCREW, MACHINE	3	EA										
	.1	MS35338-43	5310000453296	96906	.WASHER, LOCK	3	EA										
	.1	MS25082-3	5310000656930	96906	.NUT	3	EA										
	.1	AA735014	5340001930127	88044	.CLAMP	2	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	MS25082-1	5310006806627	96906	.NUT	2	EA										
	.1	MS21042-6	5310008101786	96906	.NUT	2	EA										
	.1	4869024-101A	1620011143291	98897	.BRACKET	1	EA										
	.1	NAS603-8P	5305008660937	80205	.SCREW, MACHINE	3	EA										
	.1	AN960D10	5310008510913	88044	.WASHER, FLAT	3	EA										
	.1	NAS813-10	5340008465593	80205	.SHIPPING PLUG	3	EA										
	.1	MS21042-3	5310008071467	96906	.NUT, SELF LOCKING	3	EA										
	.1	4612586-101A	1620001157398	98897	.FITTING ASSY, STEPPED SWIVEL	1	EA										
	..2	MS21241-12A10	3120001941656	96906	..BUSHING, FABROID LINED	2	EA										
	..2	4812586-103A	N.S.L.	98897	..FITTING, STEPPED SWIVEL	1											
	.1	4613803-101A	5310004206443	96897	.SPECIAL WASHER	1	EA										
	.1	MS21083D5	5310000167181	96906	.NUT SELF LOCKING	1	EA										
	.1	4612585-101A	1620001157397	98897	.FITTING ASSY INTERMEDIATE SWIVEL	1	EA										
	..2	MS21241-12A010	3120001941656	96906	..BUSHING FABROID LINED	2	EA										
	..2	4612585-103A	N.S.L.	98897	..FITTING INTERMEDIATE SWIVEL	1											
	.1	4613799-101A	5310001323941	98897	.WASHER, FLAT	8	EA										
	.1	4613798-101A	5310002283963	98897	.SPECIAL WASHER	2	EA										
	.1	NAS811-5A	5340008194643	80205	.SHIPPING PLUG	4	EA										
	.1	MS21083-D8	5310009489760	96906	.NUT, SELF LOCKING	1	EA										
	.1	4612584-101A	1620001157396	98897	.FITTING ASSY LGE SWIVEL	1	EA										
	..2	MS21241-12A010	3120001941656	96906	..BUSHING, FABROID LINED	2	EA										
	..2	4612584-103A	N.S.L.	98897	..FITTING LARGE SWIVEL	1											
	.1	MS17826-8	5310009618396	96906	.NUT, SELF LOCKING	1	EA										
	.1	4613802-101A	5306001321819	98897	.BOLT, SPECIAL	2	EA										
	.1	AN960-1016	5310001670825	88044	.WASHER	2	EA										
	.1	AN320-10	5310001768114	88044	.NUT	2	EA										
	.1	MS24665-372	5315000590491	96906	.COTTER PIN	2	EA										
	.1	AE702976-2	4720004068631	00624	.HOSE ASSY	1	EA										
	..2	AE941176	N.S.L.	00624	..BEARING ASSY	1											
	..2	AE12108-002	5330008375029	00624	..PACKING, PREFORMED	1	EA										
	..2	22558-110	N.S.L.	....*	..PACKING PREFORMED	1											
	..2	AE702984-2	N.S.L.	....*	..HOSE	1											
	..2	2-01595F0606	4730004919569	11328	..ELBOW	1	EA										
	..2	MS28778-6	5330008045695	96906	..PACKING PREFORMED	1	EA										
	.1	4612039-101B	1620000083981	98897	.STAND PIPE ASSY	1	EA										
	..2	T4604100-111A	N.S.L.	98747	..TUBE	1											
	..2	MS35489-10	5325001849846	96906	..GROMMET	1	EA										
	..2	MS35489-42	5325001850003	96906	..GROMMET	3	EA										
	..2	4611016-105A	1620010074010	98897	..SLEEVE, NYLON	3	EA										
	..2	NAS1105-7D	5306007022513	80205	..BOLT	1	EA										
	..2	4614312-101A	1620011162355	98897	..WASHER FLAT	1	EA										
	..2	MS21042-5	5310008071469	96906	..NUT, SELF LOCKING	1	EA										
	..2	2-01090F0606	4730004202805	11328	..UNION	1	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTD 22 ACTION
	.1	4612048-101A	N.S.L.	98897	.PIN COVER	2						SUB					
	.1	4B69130-107A	1620011309237	98897	.ELECT HARNESS ASSY	1	EA										
	.1	AN5-66A	5306001509543	88044	.BOLT	2	EA										
	.1	MS27183-12	5310000814219	96906	.WASHER, FLAT	4	EA										
	.1	MS21042-5	5310008071469	96906	.NUT, SELF LOCKING	2	EA										
	.1	4614122-101A	1620002516754	98897	.PIN COVER, TEAR DROP	2	EA										
	.1	4614308-103C	N.S.L.	98897	.SENSOR MOUNT L/H	1											
	.1	4614308-103B	1620004853750	98897	.SENSOR MOUNT L/H	1	EA					SUB					
	.1	NAS6204-9H	5306010779729	80205	.BOLT	1	EA										
	.1	NAS34DD4-28	5365006335554	80205	.SPACER	1	EA										
	.1	NAS1304-2H	5306000788607	80205	.BOLT, MACHINE	2	EA										
	.1	NAS1070-516	5310000814219	80205	.WASHER, FLAT	4	EA										
	.1	NAS603-12	5305001658610	80205	.SCREW, MACHINE	2	EA										
	.1	AN960-416	5310001411795	88044	.WASHER, FLAT	27	EA										
	.1	MS21042-4	5310008071468	96906	.NUT, SELF LOCKING	24	EA										
	.1	LS5984S4M	5310009619414	98897	.WASHER, SPECIAL	12	EA										
	.1	1-899-15	6340001150701	98897	.CENTERING SENSOR	1	EA										
	.1	4613129-101A	5365011304039	98897	.SHIM	13	EA										
	.1	AN743B12	5340008274417	88044	.ANGLE BRACKET	1	EA										
	.1	NAS603-8P	5305008660937	80205	.SCREW, MACHINE	1	EA										
	.1	MS21042-3	5310008071467	96906	.NUT, SELF LOCKING	45	EA										
	.1	MS21219W0G-7	5340002008559	96906	.CLAMP	1	EA										
	.1	NAS603-16P	5305009272068	80205	.SCREW, MACHINE	1	EA										
	.1	4B69142-101A	1620011126591	98897	.CONDUIT	2	EA										
	.1	GS830AB4	5970000631495	26512	.SHRINK TUBING 1/2"	1	FT										
	.1	4B69013-101A	1620001719615	98897	.BRACKET, RECEPTICLE	1	EA										
	.1	NAS1304-4H	5306008072958	80205	.BOLT MACHINE	2	EA										
	.1	AN3064-8	5975005046751	88044	.CONNECTOR	1	EA										
	.1	AN3066-8	5975002085413	88044	.NUT, LOCKING	1	EA										
	.1	AN843B12	5340008274417	88044	.ANGLE BRACKET	1	EA										
	.1	NAS43DD3-48	5365002940580	80205	.SPACER SLEEVE	1	EA										
	.1	MS21919W0G-7	5340002008559	96906	.CLAMP	2	EA										
	.1	NAS603-18P	5305009952124	80205	.SCREW, MACHINE	1	EA										
	.1	4611476-103A	1620001157415	98897	.POSITIONING COLLAR ASSY	1	EA										
	..2	MS15001-4	4730000504207	96906	..FITTING, LUBRICATION	2	EA										
	..2	4613311-101A	5340004865968	98897	..PLUG PROTECTIVE	18	EA										
	..2	4612434-101A	1620001162102	98897	..THRUST, WASHER	1	EA										
	..2	4613312-101A	3120004105272	98897	..PIN	2	EA										
	...3	4613609-105A	3120010536145	98897	...BUSHING, FLANGED O.S.	2	AR EA					ALT					
	...3	4613338-103A	3120002565208	98897	...BUSHING, FLANGED	2	EA										
	...3	4613610-103A	3120001922079	98897	...BUSHING, FLANGED	2	EA										
	...3	4613610-105A	3120010753414	98897	...BUSHING, FLANGED O.S.	2	AR EA					ALT					
	.1	4611476-103A	1620001157415	98897	.POSITIONING COLLAR ASSY												

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	...3	4613609-103A	3120001159781	98897	...BUSHING, FLANGED	2	EA										
	...3	4613609-105A	3120010536145	98897	...BUSHING, FLANGED O.S.	2	AR EA					ALT					
	...3	4613338-103A	3120002565208	98897	...BUSHING, FLANGED	2	EA										
	...3	4613610-103A	3120001922079	98897	...BUSHING, FLANGED	2	EA										
	...3	4613610-105A	3120010753414	98897	...BUSHING, FLANGED O.S.	2	AR EA					ALT					
	...3	4611476-109A	N.S.L.	98897	...POSITIONING COLLAR	1											
	.1	4614321-101A	1620002516770	98897	.SENSOR MOUNT	1	EA										
	.1	AN502-416-8	5305001509519	88044	.SCREW, MACHINE	2	EA										
	.1	AN502-4.6-14	5305001509516	88044	.SCREW, MACHINE	1	EA										
	.1	NAS43D04-22	5365008023998	80205	.SPACER	1	EA										
	.1	MS21919WD6-10	5340005846556	96906	.CLAMP	1	EA										
	.1	179-50092	4720004777 82	79470	.HUSE ASSY EMG LOCK	1	EA										
	.1	4613661-101A	1620001355650	98897	.MOUNTING PLATE SEQ	1	EA										
	.1	NPS1306-1H	5306009164249	80205	.BOLT, SHEAR	2	EA										
	.1	NAS1304-1HW	5306006876357	80205	.BOLT MACHINE	2	EA										
	.1	AN960-416	5310001411795	88044	.WASHER	2	EA										
	.1	4612536-101A	1620001922020	98897	.TUBE BRACKET, POSIT COLLAR	1	EA										
	.1	4613337-101A	16200109790 66	98897	.SPACER PLATE	1	EA										
	.1	4613366-101A	1 [redacted]0002284716LE	98897	.SHAFT, ROTATION	2	EA										
	.1	4613378-101A	1620002349238	98897	.SPACER	2	EA										
	.1	4613377-101A	1620002349237	98897	.SHAFT, RETAINER FITTING	2	EA										
	.1	AN960PD816	5310001670751	88044	.WASHER, FLAT	2	EA										
	.1	4613376-101A	5306012179746	98897	.BOLT SHOULDERED	2	EA										
	.1	4613379-101A	1620002349240	98897	.PLATE, SHAFT RETAINER	2	EA										
	.1	AN960-616	5310010164871	88044	.WASHER, FLAT	2	EA										
	.1	H29649-6	5310001554962	15653	.NUT, SELF LOCKING	2	EA										
	.1	4612042-101A	1620003510220	98897	.BRACKET, PLUMBING	1	EA										
	.1	4612042-102A	1620001921994	98897	.BRACKET, PLUMBING	1	EA										
	.1	4614299-101A	1620010074209	98897	.BRACKET	1	EA										
	.1	4614299-102A	1620010074210	98897	.BRACKET	1	EA										
	.1	NAS1104-8	5306005790944	80205	.BOLT MACHINE	4	EA										
	.1	NAS1304-10	5306000526938	80205	.BOLT MACHINE	2	EA										
	.1	NAS1133V3	5305004206449	80205	.SCREW MACHINE	2	EA										
	.1	LS881-22	5310006262879	36659	.WASHER, FLAT	2	EA										
	.1	MS21042-3	5310008071467	96906	.NUT, SELF LOCKING	2	EA										
	.1	NAS603-7P	5305009952125	80205	.SCREW, MACHINE	4	EA										
	.1	RM52LHA4972-882	5310000625315	98897	.NUT CLIP	4	EA										
	.1	RMLHA4972-10-02	5310010731539	98897	.NUT CLIP	1	EA										
	.1	NAS6203-3	5306001752651	80205	.BOLT, MACHINE	1	EA										
	.1	4612538-111A	1620001162106	98897	.BRACKET, PIPING	1	EA										
	.1	4612535-109A	1620001164417	98897	.BRACKET, PIPING	1	EA										
	.1	4612365-101A	1620010999701	98897	.CLAMP, NYLON BLOCK	2	EA										
	.1	4612537-101A	1620001922026	98897	.NUT PLATE	2	EA										

STL=STEEL
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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	T4604104-109A	N.S.L.	98747	.TUBE ASSY	1											
	.1	NAS577-5A	5310008392017	80205	.BARREL NUT	4	EA										
	.1	4613710-101A	5365004375134	98897	.SPACER	4	EA										
	.1	NAS2805-14	5305002263434	80205	.SCREW, MACHINE	4	EA										
	.1	2-01590F0606	4730004595055	11328	.ELBOW, BULKHEAD 90 DEGREE	4	EA										
	.1	AN924-6D	5310006382605	88044	.NUT	4	EA										
	.1	2-03014F06	5310001816038	98897	.NUT	4	EA					INT					
	.1	4613701-101M	1620004711178	98897	.ROTATION MANIFOLD	1	EA										
	.1	4511441-101A	1620001157412	98897	.ROTATION MANIFOLD	1	EA					INT					
	.1	MS21902J4	4730007025377	96906	.UNION	2	EA										
	.1	MS28778-4	5330008052966	96906	.PACKING PREFORMED	2	EA					INT					
	.1	AS1009J100410	4730001993607	98897	.BULKHEAD TEE	1	EA					INT					
	.1	AN6289J10	4730005857485	88044	.NUT	2	EA										
	.1	MS28773-10	5330005506743	96906	.RETAINER PACKING	3	EA										
	.1	MS28778-10	5330002859842	96906	.PACKING, PREFORMED	2	EA										
	.1	AS1008J1008	4730002222357	98897	.ELBOW	1	EA										
	.1	118-00011	4730004427239	79470	.BOLT FLUID PASSAGE	1	EA										
	.1	118-00015	4730004636012	79470	.CLUSTER NUT	1	EA					SUB					
	.1	118-00013	4730004427240	79470	.CLUSTEER 90 DEGREES	1	EA										
	.1	211FR2T	5330004208236	72902	.RETAINER, PACKKING	4	EA										
	.1	211FR160A	5330004210026	72902	.PACKING, PREFORMED	2	EA										
	.1	92220-2	4820003407186	99240	.VALVE RESTRICTOR	1	EA										
	.1	4613708-101A	1620001994597	98897	."L" BRACKKET	2	EA										
	.1	NAS1305-15D	5306000780332	80205	.BOLT	1	EA										
	.1	NAS6205-15D	N.S.L.	80205	.BOLT	1						INT					
	.1	NAS1305-13D	5306007217526	80205	.BOLT	1	EA										
	.1	NAS6205-13D	N.S.L.	80205	.BOLT	1						INT					
	.1	NAS1305-12	5306009438202	80205	.BOLT	2	EA										
	.1	NAS1305-14	5306007208048	80205	.BOLT	2	EA										
	.1	4612539-101A	1650004558129LE	98897	.CROSSWIND POSIT MAN	1	EA										
	.1	AF33-657-15053	4820004159968	34199	.VALVE, RESTRICTOR	1	EA										
	.1	2C9204	4820004839348	34199	.VALVE RESTRICTOR	1	EA					INT					
	.1	MS28778-10	5330009316748	96906	.PACKING, PREFORMED	1	EA										
	.1	AN960-516	5310001670820	88044	.WASHER, FLAT	12	EA										
	.1	MS21042-5	5310008071469	96906	.NUT, SELF LOCKING	6	EA										
	.1	22266780	1650010486842	81873	.SERVO VALVE	1	EA										
	.1	MS24678-13	5305002070959	96906	.SCREW ALLEN HEAD (SERVO ATTACH)	4	EA										
	.1	MS21912-J4	4730007021100	96906	..BULKHEAD TEE	1	EA										
	.1	MS28778-4	5330008052966	96906	.PACKING PREFORMD	2	EA										
	.1	MS21902J4	4730007025377	96906	.UNION	1	EA										
	.1	MS28775-115	5330005797910	96906	..PACKING, PREFORMED	3	EA										
	.1	MS28775-115	5330011858702	96906	..PACKING, PREFORMED	3	EA					INT					
	.1	4511461-101A	1620001225854	98897	..CLUSTER ASSY	1	EA										

STL=STEEL
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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	AN9601216L	5310001670842	88044	.WASHER, FLAT	3	EA										
	.1	4612043-101B	1620002330758	98897	.BRACKET, UNKNEELING	1	EA										
	.1	4869151-115A	5340011601038	98897	.ANGLE BRACKET	1	EA										
	.1	NAS603-6P	5305000132796	80205	.SCREW, MACHINE	1	EA										
	.1	MS27240-1	5930009723314	96906	.SWITCH, UNKNEELING	1	EA										
	.1	4869142-109A	1620011161746	98897	.CONDUIT	1	EA										
	.1	MS21908-10J	4730008258543	96906	.ELBOW 90 DEGREES	1	EA										
	.1	MS21924J10	4730008271301	96906	.UNION, BULKHEAD	1	EA										
	.1	MS21924J8	4730005260692	96906	.UNION, BULKHEAD	3	EA										
	.1	2-01096F0604	4730000935519	11328	.BULKHEAD UNION	2	EA										
	.1	AN924-8D	5310002827835	88044	.NUT	12	EA										
	.1	2-01096F0806	4730002293010	11328	.UNION, BULKHEAD	2	EA										
	.1	2-01096F0604	4730000935519	11328	.UNION, BULKHEAD	2	EA										
	.1	2-01096F0606	4730002391144	11328	.,UNION, BULKHEAD	2	EA										
	.1	STSPB202JF080804	4730001443736	98897	.BULKHEAD TEE	2	EA										
	.1	T4604104-105A	N.S.L.	98747	.TUB ASSY	1											
	.1	T4604104-113A	N.S.L.	98747	.TUBE ASSY	1											
	.1	ER2833J06	4730004333206	50948	.ELBOW 90 DEGREES	2	EA										
	.1	T4604104-101A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-211A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604100-117A	N.S.L.	98747	.TUBE ASSY (IN FLIGHT BRAKE)	1											
	.1	T4604104-119A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604104-121A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604104-123A	N.S.L.	98747	.TUBE ASSY	1											
	.1	AN924-10	5310002827832	88044	.NUT	2	EA										
	.1	AN960-D1416	5310001872393	88044	.WASHER, FLAT	4	EA										
	.1	MS21924J10	4730008271301	96906	.BULKHEAD UNION	1	EA										
	.1	AN6289J4	4730004536189	88044	.NUT	4	EA										
	.1	MS28773-04	5330002466403	96906	.RETAINER, PACKING	17	EA										
	.1	AN960PD716	5310001670741	88044	.WASHER, FLAT	3	EA										
	.1	AN924-4D	5310001596339	88044	.NUT	8	EA										
	.1	4612505-101A	4710010374600	98897	.TUBE ASSY	1	EA										
	.1	4612504-101A	N.S.L.	98747	.TUBE ASSY	1											
	.1	MS21919WD6-4	5340002915323	96906	.CLAMP	2	EA										
	.1	NAS1103-2	5306006853605	80205	.BOLT MACHINE	1	EA										
	.1	LS5984S3M	5310009419413	98897	.WASHER, SPECIAL	1	EA										
	.1	MS21042-3	5310008071467	96906	.NUT SELF LOCKING	1	EA										
	.1	4612506-101A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604104-149A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-153A	N.S.L.	98747	.TUBE ASSY	1											
	.1	MS21912J4	4730007201100	96906	.TEE	1	EA										
	.1	AN960PD716	5310001670741	88044	.WASHER, FLAT	1	EA										
	.1	AN924-4D	5310001596339	88044	.NUT	1	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	T4604104-143A	N.S.L.	98747	.TUBE ASSY	1											
	.1	2-03014F08	5310001816040	11328	.NUT	2	EA										
	.1	STSP8315F0806	4730002293010	98897	.UNION	1	EA										
	.1	T4604104-105A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604104-113A	N.S.L.	98747	LG CC/W POSIT TUBE	1											
	.1	2-02269F060604	4730003369457	11328	.TEE	4	EA										
	.1	2-01096F0604	4730000935519	11328	.BULKHEAD UNION	2	EA										
	.1	T4604104-117A	N.S.L.	98747	.TUBE ASSY	1											
	.1	STSP8315F0606	4730002391144	98897	.BULKHEAD UNION	1	EA										
	.1	2-01590F0606	4730004595055	11328	.ELBOW BULKHEAD 90 DEGREES	4	EA										
	.1	MS21919WDG-6	5340005980146	96906	.CLAMP	6	EA										
	.1	NAS1133V2	5305004206456	80205	.SCREW, CLOSE TOL	1	EA										
	.1	2-01090F0606	4730004202805	11328	.UNION	1	EA										
	.1	MS2736960096	4720001859819	96906	.HOSE ASSY	1	EA										
	.1	MS21922-6	4730005547398	96906	.SLEEVE	1	EA										
	.1	2-01096F0404	4730001622864	11328	.BULKHEAD UNION	3	EA										
	.1	2-02269F040404	4730001769805	11328	.TEE	3	EA										
	.1	T4604101-155A	N.S.L.	98747	.TUBE ASSY	1											
	.1	2-01090F0404	4730006138557	11328	.UNION	1	EA										
	.1	2-01590F0404	4730005494656	11328	.ELBOW, TUBE	4	EA										
	.1	T4604101-215A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-161A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-201A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-213A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-151A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-159A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-179A	N.S.L.	98747	.TUBE ASSY	1											
	.1	T4604101-203A	N.S.L.	98747	.TUBE ASSY	1											
	.1	4613720-101A	5340004560135	98897	.TUBING BLOCK (3 LINE)	1	EA										
	.1	4613717-101A	1620001994598	98897	.TUBING BLOCK (2 LINE)	1	EA										
	.1	NAS1103-22	5306008342688	80205	.SCREW, MACHINE	1	EA										
	.1	NAS1103-15	5306008160111	80205	.SCREW, MACHINE	1	EA										
	.1	NAS1103-44	5306008160117	80205	.SCREW, MACHINE	1	EA										
	.1	NAS1103-52	5306001079199	80205	.SCREW, MACHINE	1	EA										
	.1	LS5987-10-56	N.S.L.	....*	.INSULATOR	2											
	.1	LS5987-10-64	5970009456701	98897	.INSULATOR	2	EA					SUB					
	.1	4612645-101F	4820001390380	98897	.SEQUENCE VALVE	1	EA										
	.1	NAS1304-22H	5306006897141	80205	.BOLT	3	EA										
	.1	4613725-101A	1620004643464	98897	.BRACKET (SEQUENCE VALVE)	1	EA										
	.1	118-00017	4730004427237	79470	.LONG #4 UNION	1	EA										
	.1	MS21924-J4	4730007201568	96906	.BULKHEAD UNION	2	EA										
	.1	179-50076	4720004562968	79470	.HOSE ASSY, PILOT INERLOCK	1	EA										
	.1	179-50080	4720004557380	79470	.HOSE ASSY	1	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

1757aA

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	179-50074	4720001162354	78286	.HOSE ASSY	1	EA										
	.1	179-50075	4720004562967	79470	.HOSE ASSY	1	EA										
	.1	4631003-101B	1620001790438	98897	.CROSSWIND CYL (R.E.)	1	EA										
	.1	4631003-103B	1620004427875	98897	.CROSSWIND CYL (CLEVIS)	1	EA										
	.1	4612433-101A	1620001177319	98897	.ANTI ROTATION BOLT ASSY	2	EA										
	..2	MS16625-1137	5365007541083	96906	..SNAP RING	2	EA										
	..2	4613618-101A	5340012471999	98897	..DISC (GREASE SEAL)	2	EA										
	..2	MS28775-017	5330006181920	96906	..PACKING, PREFORMED	2	EA										
	..2	MS28775-017	5330011902750	96906	..PACKING PREFORMED	2	EA					INT					
	..2	4613392-101A	1620002496046	98897	..PLUG, GREASE REATINER	2	EA										
	..2	MS15001-4	4730000504207	96906	..FITTING, LUBRICATION	2	EA										
	..2	4613617-101A	5310004563104	98897	..ANTI ROTATION WASHER	2	EA										
	..2	55LH7644-202	5310002440514	72962	..NUT	2	EA										
	.1	4611454-101D	1620001157413	98897	.NORMAL LOCK CYL	1	EA										
	.1	4614563-101A	16500113273371E	98897	.EMG LOCK CYL	1	EA										
	.1	NAS1104-130	5306006804225	80205	.BOLT	4	EA										
	.1	AN320-4	5310001768108	88044	.NUT	4	EA										
	.1	AN960-416	5310001411795	88044	.WASHER, FLAT	4	EA										
	.1	MS24665-153	5315001850037	96906	.COTTER PINT	5	EA										
	.1	4613561-101A	5315001321925	98897	.APEX SHAFT	1	EA										
	.1	4611633-101A	4730011385377	98897	.SPECIAL BOLT	1	EA										
	.1	4613771-101A	4730001324076	98897	.SPECIAL BOLT	1	EA										
	.1	4613766-101A	5315001218807	98897	.PIN	2	EA										
	.1	4613345-101A	5307004842354	98897	.TRANSDUCER MOUNT	2	EA										
	.1	4613767-101A	5315010867739	98897	.ANTI ROTATION PIN	1	EA										
	.1	4612660-101A	1620004777638	98897	.PLUG APEX SHAFT	1	EA										
	.1	4613949-101A	1620004643463	98897	.PLUG, APEX SHAFT	1	EA					INT					
	.1	NAS1291X8	5310010681323	80205	.NUT, SPECIAL	1	EA										
	.1	AN960-816	5310010407177	88044	.WASHER, FLAT	1	EA										
	.1	4613792-101A	5355004432673	88044	.POINTER	1	EA										
	.1	NAS1191-3P6	5305004826919	80205	.SCREW, MACHINE	2	EA										
	.1	AN960-10L	5310007670834	88044	.WASHER, FLAT	8	EA										
	.1	4612443-101A	1620011386758	98897	.PILOT, SEQUENCE VALVE	1	EA										
	.1	461436-101A	4710011311419	98897	.TUBE ASSY (LOCK MOD)	1	EA										
	.1	4614637-101A	4710011311418	98897	.TUBE ASSY (LOCK MOD)	1	EA										
	.1	4613487-101A	1620001357842	98897	.MOUNTING PLATE	1	EA										
	.1	4613487-102A	1620002284722	98897	.MOUNTING PLATE	1	EA										
	.1	4613967-101A	5360011331971	98897	.SPRING	1	EA										
	.1	4614634-101A	1620011315155	98897	.ACTUATOR LEVER	1	EA										
	.1	4613968-103A	5306011351628	98897	.BOLT, SPECIAL	2	EA										
	.1	MS2736960170	4720004022962	96906	.HOSE ASSY	1	EA										
	.1	MS2736960184	4720002510782	98441	.HOSE ASSY	1	EA										
	.1	MS2736960194	4720004513280	96906	.HOSE ASSY	2	EA										
	.1	MS2736960197															

STL=STEEL
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LD=LEAD

C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	MS28778-6	5330008045695	96906	.PACKING PREFORMED	10	EA										
	.1	NAS577-4A	5310008108956	80205	.BARREL NUT	2	EA										
	.1	4613790-101A	5365001132131	98897	.SPACER	2	EA										
	.1	R-5	5310000873155	43334	.WASHER, (SPECIAL WAVE)	2	EA										
	.1	AN960C616L	5310001834355	88044	.WASHER, FLAT	2	EA										
	.1	AN960C416L	5310002058924	88044	.WASHER, FLAT	4	EA										
	.1	NAS1104-18	5306005844993	80205	.BOLT	2	EA										
	.1	NAS1104-18	5306002867524	80205	.BOLT	2	EA					INT					
	.1	4614250-101A	1620001355663	98897	.BRACKET	2	EA										
	.1	420-75-625SH	4730007607696	98625	.CLAMP	4	EA										
	.1	4613085-107A	4730010065701	98897	.PAD	4	EA										
	.1	2690079	4810004899202	92003	.VALVE, LINEAR SHUTOFF	2	EA										
	.1	GM515200-1	1620001575763	22863	.LINEAR TRANSDUCER	2	EA										
	.1	NAS1303-6	5306006805285	80205	.BOLT	4	EA										
	.1	MS21902-6	4730002037491	96906	.UNION	8	EA										
	.1	2-01595F0404	4730001505183	11328	.ELBOW 90 DEGREES	4	EA										
	.1	4614252-101A	1620010868742	98897	.TUBE ASSY (HYD STEERING)	1	EA										
	.1	4614319-101A	4710010132078	98897	.TUBE4 ASSY (HYD STEERING)	1	EA										
	.1	4614318-101A	1620010868740	98897	.TUBE ASSY (C/W POSIT)	1	EA										
	.1	4614270-101A	4710010143899	98897	.TUBE ASSY (CC/W POSIT)	1	EA										
	.1	MS27372H0224200	4720000356603	96906	.HOSE ASSY	1	EA										
	.1	MS27373H0156190	4720001169295	96906	.HOSE ASSY	1	EA										
	.1	MS27374H0244045	4720001756256	96906	.HOSE ASSY	1	EA										
	.1	MS27372H0210200	4720001169289	96906	.HOSE ASSY	1	EA										
	.1	70943	1620002411587	98897	.SPLIT WASHER	2	EA										
	.1	4694432-103A	1620012051172	98897	.SPLIT WASHER	2	EA					INT					
	.1	4613565-101B	1620004884553	98897	.ROTATION COLLAR	1	EA										
	.1	8341244-01	5305011882381	98747	.SETSCREW	4	EA										
	.1	4613613-101A	1620001233796	98897	.CUP WASHER	1	EA										
	.1	4613970-101A	5365004620994	98897	.WASHER, SPACER RING	1	EA										
	.1	4613614-101A	5310004582848	98897	.ROUND NUT, (SPLINED TUBE)	1	EA										
	.1	4613424-105A	1620001233794	98897	.STAND PIPE	1	EA										
	.1	MS28778-12	5330002518839	96906	.PACKING PREFORMED	1	EA										
	.1	4612636-101A	1620001157427	98897	.LOCK RING ASSY	1	EA										
	..2	4613412-101A	1620001357841	98897	..LOCK COLLAR RING	1	EA										
	..2	4613569-101A	1620010751661	98897	..LOCK RING GUIDE	1	EA										
	..2	4613571-101A	5310004625224	98897	..ROUND NUT	1	EA										
	..2	4613683-101A	5315001353355	98897	..PIN	4	EA										
	.1	4613563-103A	1620005168457	98897	.LOCK COLLAR INSERT	1	EA										
	.1	4611447-101A	1620001157389	98897	.COLLAR ASSY LOCK ACTUATOR	1	EA										
	..2	4613609-103A	3120001159781	98897	..BUSHING, FLANGED	4	EA										
	..2	4613609-105A	3120010536145	98897	..BUSHING, FLANGED U.S.	4	AR	EA				ALT					
	.2	4611447-103A															

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	4614606-101A	5305004730666	98897	.SETSCREW, HEADLESS	4	EA										
	.1	4613608-101A	5330001309201	98897	.FELT WIPER (MECH)	1	EA										
	.1	4613420-101A	5310004422817	98897	.SEGMENT WASHER	2	EA										
	.1	4619074-101A	3120005426972	98897	.THRUST BEARING	1	EA										
	.1	4611453-101A	1620001132126	98897	.STOP PLATE ASSY	1	EA										
	..2	4611453-103A	N.S.L.	98897	..STOP PLATE	1											
	..2	4614605-101A	3120010546363	98897	..BUSHING REPAIR	1	AR EA										
	..2	4613575-103A	3120001313564	98897	..BUSHING, FLANGED	1	EA										
	..2	4613575-105A	3120010753422	98897	..BUSHING FLANGED O.S.	1	AR EA					ALT					
	.1	4611453-101B	1620004304375	98897	.STOP PLATE ASSY	1	EA					INT					
	..2	4611453-103B	N.S.L.	98897	..STOP PLATE	1											
	..2	4614605-101A	3120010546363	98897	..BUSHING REPAIR	1	EA										
	..2	4613575-103A	3120001313564	98897	..BUSHING FLANGED	1	EA										
	..2	4613575-105A	3120010753422	98897	..BUSHING FLANGED O.S.	1	AR EA					ALT					
	.1	4613391-101A	1620004649159	98897	.WEDGE	1	EA										
	.1	NAS1624-24	5305004600730	80205	.SCREW	1	EA										
	.1	4613769-101A	5365002800067	98897	.SHIM	2	EA										
	.1	4612471-101A	1620001132129	98897	.SHIM PLATE	1	EA										
	.1	4613768-101A	1620001324075	98897	.STOP PAD	1	EA										
	.1	4613768-103A	1620011692208	98897	.STOP PAD	1	EA					INT					
	.1	4613770-101A	5306001366199	98897	.BOLT	1	EA										
	.1	4613793-101A	5305001433407	98897	.SCREW, HEADLESS	4	EA										
	.1	4613793-103A	5305010782912	98897	.SCREW, HEADLESS	1	EA										
	.1	4613761-101A	1620001132130	98897	.COVER PLATE	1	EA										
	.1	MS19060-26	3110000311744	96906	.BALL BEARING	4	EA										
	.1	MS19060-26	3110000454493	96906	.BALL BEARING	4	EA					INT					
	.1	MS19060-26	3110005751861	96906	.BALL BEARING	4	EA					INT					
	.1	4613419-101A	5310004891417	98897	.STOP PLATE NUT	1	EA										
	.1	NAS1303-210	5306001503232	80205	.BOLT	1	EA										
	.1	NAS1303-14D	5306008068835	80205	.BOLT	1	EA										
	.1	MS17826-3	5310000664289	96906	.NUT, SELF LOCKING	2	EA										
	.1	MS24665-153	5315002341854	96906	.COTTER PIN	2	EA										
	.1	AN960PD10L	5310007716827	88044	.WASHER	4	EA										
	.1	MS24690	5330000797381	96906	.PACKING, PREFORMED	1	EA										
	.1	4614322-101B	1620010984553	98897	."Y" BLOCK (3 PART)	1	EA										
	.1	MS28775-012	5330005840265	96906	.PACKING, PREFORMED	4	EA										
	.1	NAS551-5H	4730006631393	80205	.BOLT, FLUID PASSAGE	1	EA										
	.1	LS4764-4	5330001715462	36559	.PACKING PREFORMED	1	EA										
	.1	G3714	6685002283784	34840	.GAGE, PRESSURE	1	EA										
	.1	MS28889-1	4820005356483	96906	.VALVE AIR	1	EA										
	.1	705617	5306001098923	99167	.SWITCH, PRESSURE	1	EA										
	.1	4614512-101A	1620001091100	98897	.PUSH ROD ASSY	1	EA										
	..2	MS35674-17	5315004511528	96906	..PIN	1	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	BFEFS-3	3120001288990	15860	.ROD END	1	EA										
	.1	ATM3-50	3120001288990	15860	.ROD END	1	EA					INT					
	.1	MS9359-1	5340005874173	80205	.LOCK	1	EA										
	.1	AN23-17	5306001511969	88044	.BOLT	1	EA										
	.1	AN320-3	5310002852177	88044	.NUT	1	EA										
	.1	4611478-109A	1620003238292	98897	.NORMAL ROTATION CYL	1	EA										
	.1	4611481-101C	1620002223887	98897	.EMG ROTATIONN CYL	1	EA										
	.1	MS21924J8	4730005260692	96906	.UNION	1	EA										
	.1	MS28778-8	5330012292234	96906	.PACKING, PREFORMED	2	EA										
	.1	9R2220-1	4820003407192	99240	.RESTRICTOR VALVE	1	EA										
	.1	SSLN7644-108	5310004600731	72962	.NUT	2	EA										
	.1	4613370-101A	5310004045071	98897	.SPACER	2	EA										
	.1	4613372-101A	5310004038303	98897	.KEYED WASHER	2	EA										
	.1	4613904-101A	5310004103428	98897	.SHIM	2	EA										
	.1	SSNE4717-162	5310002211405	72962	.NUT, SELF LOCKING	1	EA										
	.1	MS24665-378	5315008994118	96906	.COTTER PIN	1	EA										
	.1	4613646-103B	5315001760762	98897	.HEADLESS PIN	1	EA										
	.1	NAS1104-52	5306008273566	80205	.BOLT	1	EA										
	.1	MS21919WD6-8	5340002915347	96906	.CLAMP	10	EA										
	.1	4614515-101A	1620001236738	98897	.SYNCHRO TRANSMITTER	1	EA										
	.1	4613864-101A	5365001357882	98897	.SHIM	1	EA										
	.1	NAS1304-6H	5306008081319	80205	.BOLT	4	EA										
	.1	LS607-11	5365003071035	36659	.SPACER	1	EA										
	.1	AN960-10	5310007225943	88044	.WASHER	4	EA										
	.1	AN23-23	5306001512302	88044	.BOLT	1	EA										
	.1	LS590494M	5310009619414	98897	.WASHER	4	EA										
	.1	RT35C	5975010645592	88044	.WIRE TIE	10	EA										
	.1	GSB30AB4	5970000631495	26512	.SHRINK TUBING 1/2"	6	FT										
	.1	BACT63A58D	5970009143118	81205	.SHRINK TUBING 1"	6	FT										
	.1	M7928-1-13	5940001912708	81349	.TERMINAL LUG 18 GAGE	4	EA										
	.1	M7928-1-15	5940001912714	81349	.TERMINAL LUG 22 GA GND	1	EA										
	.1	M7928-1-22	5940001912722	81349	.TERMINAL LUG 20 GAGE	50	EA										
	.1	M7928-1-24	5940002419677	81349	.TERMINAL LUG 20 GA GND	10	EA										
	.1	M7928-1-31	5940010238575	81349	.TERMINAL LUG 18 GAGE	4	EA										
	.1	M7928-1-33	5940002419696	81349	.TERMINAL LUG 18 GA GND	1	EA										
	.1	BACT63D2	5970001461122	81205	.END CAP SHRINKABLE	12	EA										
	.1	GM1215797-75	5970002222017	10001	.UNSULATED TEFLON TAPE	1	ROLL										
	.1	2681-7	9330006903104	98841	.CHAFE GUARD 1/4"	1	FT										
	.1	MT-2077	9330006897776	09106	.CHAFE GUARD 3/8	1	FT										
	.1	2681-15	9330000776722	98441	.CHAFE GUARD 1/2"	1	FT										
	.1	MS17821-1-0	5975009846582	96906	.WIRE TIE	6	EA										
	.1	MS336/-2-2	5975006842525B	96906	.WIRE TIE	10	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LDN LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE K,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	MS21919WDG-8	5340007225878	96906	.CLAMP	10	EA										
	.1	NAS603-8P	5305008660937	80205	.SCREW	17	EA										
	.1	MS21042-3	5310008071467	96906	.NUT, SELF LOCKING	25	EA										
	.1	4611414-107A	1620004176249	98897	.INNER CYLINDER ASSY	1	EA										
	..2	4611414-109A	N.S.L.	98897	..INNER CYLINDER	1											
	..2	4813490-109A	1620002640758	98897	..SADDLE BUSHING	1	EA										
	..2	4613490-117A	3120010539968	98897	..SADDLE BUSHING O.S.	1	AR EA					ALT					
	..2	4613491-103A	3120001793975	98897	..BUSHING	1	EA										
	..2	4613491-105A	3120010539967	98897	..BUSHING O.S.	1	EA					ALT					
	...3	7926422-01	5310011018447LE	98747	...METERING TUBE BUSHING REPAIR	1	EA										
	...3	AS119	5330000976395	02289	...PACKING PREFORMED	1	EA										
	..2	4614604-101A	3120010536148	98897	..BUSHING, POSITIONER LUGS(RPR)	4	AR										
	.1	AN814-2L	5365005953911	88044	.PLUG	1	EA										
	.1	MS28778-2	5330008037208	96906	.PACKING, PREFORMED	1	EA										
	.1	202615L475	1620001189624	10989	.FILTER	1	EA										
	.1	NAS509-12	5310002989255	80205	.NUT	1	EA										
	.1	4613521-101A	5310004563095	98897	.LOCKWASHER	1	EA										
	.1	MS28774-364	5330000879975	96906	.RETAINER	2	EA										
	.1	AN6227-49	5330007202130	88044	.PACKING PREFORMED	1	EA					ALT					
	.1	MS28775-346	5330005793161	96906	.PACKING, PREFORMED	1	EA					INT					
	.1	4613520-101A	1620001233791	98897	.CUP WASHER	1	EA										
	.1	AN6227-23	5330001965385	88044	.PACKING PREFORMED	2	EA										
	.1	MS28775-218	5330005840263	96906	.PACKING, PREFORMED	2	EA					INT					
	.1	MS28774-218	5330005822150	96906	.RETAINER	2	EA										
	.1	4613519-101A	1620001233790	98897	.METERING TUBE BASE	1	EA										
	.1	MS28774-114	5330005763206	96906	.RETAINER	2	EA										
	.1	AN6227-12	5330006183385	88044	.PACKING, PREFORMED	1	EA										
	.1	MS28775-114	5330006[illegible]01	96906	.PACKING, PREFORMD	1	EA					INT					
	.1	4613390-101A	1620002284720	98897	.UPPER METERING TUBE	1	EA										
	.1	4613518-101A	1620001233787	98897	.LOWER METERING TUBE	1	EA										
	.1	4613495-101A	1620001522857	98897	.PISTON RING	1	EA										
	.1	4613513-101A	5[illegible]5001436231	98897	.LOCK PIN	1	EA										
	.1	4613512-101A	[illegible]5001219452	98897	.STOP RING	1	EA										
	.1	4613677-101A	5330001437175	98897	.SQUARE PACKING	1	EA										
	.1	4613515-101A	5310004625222	98897	.ROUND NUT	1	EA										
	.1	4612409-101A	1620001162100	98897	.STOP TUBE ASSY	1	EA										
	..2	4612409-103A	1620001214199	98897	..TUBE PISTON STOP	1	EA										
	..2	4615662-101A	5315001189447	98897	..LOCATING PIN	1	EA										
	.1	4612409-101B	1620001299168	98897	.STOP TUBE ASSY	1	EA					INT					
	..2	4612409-103A	1620001214199	98897	..TUBE PISTON STOP	1	EA										
	..2	4613662-101A	5315001189447	98897	..LOCATING PIN	1	EA										
	.1	4613516-101A	5310004563093	98897	.LOCKWASHER	1	EA										
09	.1	326FK2T	5330004541387	72962	.BACKUP RETAINER	4	EA										

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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	4653767-101A	5330004537539	98897	.FELT WIPER (ROUND)	6	FT										
	.1	744F8MTE160	5330010838865	72902	.KIT SEAL (1ST OVERSIZE)	2	AR EA					INT					
	.1	44C8MK2N	5330004475322	72902	.BACKUP RETAINER	4	EA										
	.1	44C8MR2T	5365004636154	72902	.BACKUP RETAINER	4	EA										
	.1	44C8MTE160A	5330004541380	72902	.PACKING PREFORMED	2	EA										
	.1	AN6230-8	5330000546866	88044	.PACKING, PREFORMED	2	EA										
	.1	MS28775-230	5330009824257	96906	.PREFORMED PACKING	2	EA					INT					
	.1	MS28774-230	5330005822143	96906	.RETAINER	4	EA										
	.1	4613510-101A	1620001164430	98897	.FLOATING PISTON	1	EA										
	.1	MS28778-4	5330008052966	96906	.PACKING, PREFORMED	1	EA										
	.1	MS28773-04	5330002466403	96906	.RETAINER	1	EA										
	.1	MS28778-4	5330008052966	96906	.PACKING, PREFORMED	1	EA					INT					
	.1	1-03076C4	4730001993608	24930	.LOCKING NUT	1	EA										
	.1	83714	6685002283784	34840	.GAGE PRESSURE	1	EA										
	.1	4653787-101A	N.S.L.	98897	.WARNING PLATE	2											
	.1	MS28889-1	4820005356483	96906	.VALVE, AIR (SCHRADER)	2	EA										
	.1	MS28778-5	5330008537491	96906	.PACKING, PREFORMED	1	EA										
	.1	MS28775-013	5330006843420	96906	.PACKING, PREFORMED	1	EA										
	.1	MS28774-013	5330008439726	96906	.RETAINER	1	EA										
	.1	4613522-101A	1620001164432	98897	."Y" (BULK) FITTING	1	EA										
	.1	81213122-01	1620011426670	98897	.FITTING GAGE & VALVE	1	EA					INT					
	.1	4613679-101A	4730001233798	98897	.BOLT	1	EA										
	.1	4612432-101A	1620001157393	98897	.SPLINED TUBE ASSY	1	EA										
	..2	4613413-101A	N.S.L.	98897	...TUBE SPLINED	1											
	..2	4612408-101A	4730001214199	98897	...RESTRICTOR CAP	1	EA										
	..2	8341160-01	5305011731729	98747	...SCREW	1	EA										
	.1	4613496-103A	1620001233782	98897	.SPLINED SLIDE RING	1	EA										
	.1	4613501-101A	5365005316329	98897	.LOCK RING	1	EA										
	.1	4614686-101A	1620011805778LE	98897	.KEY LOCK (GLAND NUT MOD)	2	EA										
	.1	4613686-101A	5306001262839	98897	.BOLT	4	EA										
	.1	4813437-105A	4730011819672	98897	.NUT, PACKING (MODIFIED)	1	EA										
	.1	4613438-103A	5365004092202	98897	.SHIM	1	EA										
	.1	4613436-101A	5365004560072	98897	.RING, BEARING RETAINER	1	EA										
	.1	4613703-101A	5365001260811	98897	.SPECIAL WASHER	1	EA										
	.1	351-45100-312A	3120011799553LE	72907	.NYLON SCRAPER	1	EA										
	.1	4653767-1099	5330004537539	98897	.FELT WIPER (MECHANICAL)	2	FT										
	.1	4694448-105A	3120011789028LE	98897	.LOWR BEARING (ONE PIECE)	1	EA										
	.1	745A2MT-987	5330004094686	72902	.PACKING, PREFORMED	3	EA										
	.1	745A2MT2N	5330004087215	72902	.RETAINER	6	EA										
	.1	7451FT60A	5330004094685	72902	.PACKING, PREFORMED	2	EA										
	.1	7451FT2P3	5330001481687	72902	.RETAINER	4	EA										
	.1	AN6227-78	5330002313236	88044	.PACKING, PREFORMED	1	EA										
99	.1	S12561-451	5330004541432	97820	.CHANNEL SEAL (SHAM BAM)	1	EA										

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

C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	4613508-101A	1620001227973	98897	.SNUBBER VALVE	1	EA										
	.1	4613507-101A	5365001227986LE	98897	.SNUBBER SPACER	1	EA										
	.1	4613509-101A	5365001233784	98897	.SHIM	1	EA										
	.1	4613504-101A	3120001321909	98897	.BEARING SLEEVE	1	EA										
	.1	4613502-101A	5365001227966	98897	.SHIM	1	EA										
	.1	4613503-101A	5310004617448	98897	.LOCK (TAB) WASHER	1	EA										
	.1	4613499-101A	1620001227964	98897	.RING, THREADED RETAINER	1	EA										
	.1	78863	N.S.L.	....*	.THRUST RING	1											
	.1	4694433-103A	1620001233783	98897	.THRUST RING	1	EA					INT					
	.1	LS35196-1	5330005657043	98897	.SEAL, PREFORMED	1	EA										
	.1	4611439-107B	1620003190461	98897	.ROLL PIN ASSY	1	EA										
	..2	MS15001-1	4730000504203	96906	..FITTING, LUBRICATION	3	EA										
	...3	4613544-103A	3120001313554	98897	...BUSHING	1	EA										
	...3	4613407-103A	3120001313527	98897	...BUSHING	4	EA										
	...3	N.P.L.	N.S.L.	98747	...BUSHING, 7-PORT VALVE LUG(RPR)	2	AR										
	...3	4611439-109B	N.S.L.	98897	...ROLL PIN	1											
	.1	4611439-113A	1620012079984	98897	.ROLL PIN ASSY	1	EA					INT					
	..2	MS15001-1	4730000504203	96906	..FITTING LUBRICATION	3	EA										
	...3	4613544-103A	3120001313554	98897	...BUSHING	1	EA										
	...3	4613407-103A	3120001313527	98897	...BUSHING	4	EA										
	...3	N.P.L.	N.S.L.	98747	...BUSHING,7-PORT VALVE LUG (RPR)	2	AR										
	...3	7729292-01	N.S.L.	....*	...INBOARD SPACER (1ST O.S.)	1	AR										
	4	7729292	3120010541204LE	84747	....INBOARD SPACER BLANK	2	EA										
	...3	7729292-03	N.S.L.	....*	...INBOARD SPACER (2ND O.S.)	2	AR					ALT					
	4	7729292	3120010541204LE	84747	....INBOARD SPACER BLANK	2	EA										
	...3	7729292-05	N.S.L.	....*	...INBOARD SPACER (3RD O.S.)	2	AR					ALT					
	4	7729292	3120010541204LE	84747	....INBOARD SPACER BLANK	2	EA										
	...3	7729292-07	N.S.L.	....*	...INBOARD SPACER (4TH O.S.)	2	AR					ALT					
	4	7729292	3120010541204LE	84747	....INBOARD SPACER BLANK	2	EA										
	...3	7729293-01	N.S.L.	....*	...OUTBOARD SPACER (1ST O.S.)	2	AR										
	4	7729293	3120010541205LE	84747	....OUTBOARD SPACER BLANK	2	EA										
	...3	7729293-03	N.S.L.	....*	...OUTBOARD SPACER (2ND O.S.)	2	AR					ALT					
	4	7729293	3120010541205LE	84747	....OUTBOARD SPACER BLANK	2	EA										
	...3	7729293-05	N.S.L.	....*	...OUTBOARD SPACER (3RD O.S.)	2	AR					ALT					
	4	7729293	3120010541205LE	84747	....OUTBOARD SPACER BLANK	2	EA										
	...3	7729293-07	N.S.L.	....*	...OUTBOARD SPACER (4TH O.S.)	2	AR					ALT					
	4	7729293	3120010541205LE	84747	....OUTBOARD SPACER BLANK	2	EA										
	...3	4611439-109B	N.S.L.	98897	...ROLL PIN		EA										
	.1	4613700-101A	3120002349545LE	98897	.THRUST WASHER	1	EA										
	.1	4612784-101A	5310004983198	98897	.THRUST WASHER	1	EA										
	.1	4613783-101A	5310004902792	98897	.LOCK (TAB) WASHER	1	EA										
	.1	4613782-101A	5310004970602	98897	.ROUND NUT	1	EA										
	.1	68485-6-020	5306004708728	80539	.BOLT	2	EA										

STL=STEEL
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C-5A MLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	4613492-101B	3120001357883	98897	.BUSHING	4	EA										
	.1	STS86001A08D024	5306001525509	98897	.BOLT, CLOSE TOL	2	EA										
	.1	68485-8-024	5306001525503	56878	.BOLT CLOSE TOL	2	EA					INT					
	.1	MS20002-C-8	5310001499116	96906	.WASHER	4	EA										
	.1	AN960-816	5310001670823	88044	.WASHER	4	EA										
	.1	MS17826-8	5310009618396	96906	.NUT	2	EA										
	.1	AN320-8	5310001768112	88044	.NUT	2	EA					INT					
	.1	AN320-6	5310001768110	88044	.NUT	2	EA										
	.1	MS24665-302	5315002341864	96906	.COTTER PIN	2	EA										
	.1	4614551-101B	1620010510374	98897	.ROLL POSITIONER	2	EA										
	.1	4613726-101A	3120001313568	98897	.BUSHING	4	EA										

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 5046B-MM1-DY-MA 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

SEQ STEP	CH D	S T	S L	W #R K	F A C	FF FA DC	A/R SUPPORT ELEMENT	REV	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A Y	PCT	C
0A031		S	N	JA EA 1			J 89017		.92	PERCENT ENGR 56.1	MACHINE LOCK COLLAR GUIDE	.20					
0001				JA 01		00			.92		PART NUMBER/NSN	.000	.000				0
0010										4G13569-101A	1620010751661						
0030				JA 01		15			.46		NICK AND BURR	.077	.005				20
0010	E					RLG-RS-N3			1.00	NICK & BURR MED STRUT PART		.06711					
0020	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001					
0035				JA 01		15			.05		MACHINE LOCK RING SURFACE	.218	.009				34
0010	E					RLA-SU-S3			1.00	SET UP SMALL MEDIUM LATHE		.07962					
0015	E					RLA-HP-C4			2.00	IRREG PART IN 4 JAW CHUCK	OCCURRANCED FOR 2 SIDES	.22097					
0020	E					RLA-FR-NG			2.00	FACE ROUGH 9 - 10 DIA. GRP 4	OCC FOR 12 INCH DIA	.04424					
0030	E					RLA-FF-NG			2.00	FACE FINISH 9 - 10 GROUP 4	OCC FOR 12 INCH DIA	.08910					
0040	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001					
0045				JA 01		00			1.00		HOLD FOR REASSY	.093	.000				46
0010	N								1.00		PLACE IN HOLDING AREA	.08300					
0020	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001					
9000				JA 01		15			.00		LABOR STANDARD HISTORY	000	.000				0
0010										27AUG85 UPDATED OCCURANCE FACTORS/RESTRUCTURED							
0011										LABOR STANDARD TO MATCH AFLC FORM 958							
0012										WORK PREVIOUSLY DONE ON OPER. B0090							
0013										<OLD STANDARD> 13.42							
0020										31DEC85 UPDATED OCC FACTORS <OLD STD> 9.35							
0900										N MONROE MANEAA 73357							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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1234567890123456 ELSE PUT IN END

OPS STEP	CH D	S T L	S K	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	ID URS	DLY PCT	A C
RA033		S	E	JA	EA	1	J 89037	.54	PERCENT ENGR 99.9	MACH C-5A MLG UPPER PLATE	3.68	1.99		
0001				JA	01		15	.00		PART NUMBER / NSN	.000	.000		0
0010									4G12423-101A	1620004182976				
0033				JA	01		15	.31		REPAIR SMALL SHAFT HOLE	.734	.262		7
0010	E						KMM-SU-V1	.34	S/U VERT MILL BORE SMAL FXTR	PRORATE 3 OPERATIONS	.50518	.197		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS,		.08531	.098		
0030	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	DIAL ALONG BASE	.07609	.087		
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	DIAL IN CENTER HOLE	.07609	.087		
0050	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	MOVE TO SML HOLE/CHK LOCATE	.07609	.087		
0060	E						RML-BB-AC	1.00	BORE HOLE 1 X 1 1/2 GROUP 2 ,		.23926	.275		
0070	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001	.011		
0035				JA	01		15	.39		REPAIR LARGE SHAFT HOLES	1.049	.471		13
0010	E						KMM-SU-V1	.34	S/U VERT MILL BORE SMAL FXTR	PRORATE 3 OPERATIONS	.50518	.197		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS,		.08531	.098		
0030	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	DIAL IN BASE	.07609	.087		
0040	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	DAIL IN CENTER HOLE	.07609	.087		
0050	E						RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	MOVE TO LRG HOLE/2 HOLES	.07609	.175		
0060	E						RML-BB-AC	2.00	BORE HOLE 1 X 1 1/2 GROUP 2	2 HOLES	.23926	.550		
0070	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001	.011		
0037				JA	01		15	.77		REPAIR BEARING BORE	.733	.649		18
0010	E						KMM-SU-V1	.34	S/U VERT MILL BORE SMAL FXTR	PRORATE 3 OPERATIONS	.50518	.197		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS,		.08531	.098		
0030	E						RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	DIAL IN CENTER HOLE	.07609	.087		
0040	E						RML-BB-GC	1.00	BORE HOLE 4 X 1 1/2 GROUP 2	BORE CENTER HOLE	.39012	.448		
0050	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001	.011		
0038				JA	01		15	.46		REMOVE INSERTS	.156	.083		2
0010	E						RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525	.158		
0020	E						KER-AS-DA	4.00	REMOVE SPRING HELICAL	4 INSERTS	.00209	.009		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001	.011		
0072				JA	01		15	.31		MACH SM. SHAFT HOLE BUSHING	.552	.197		5
0010	E						RLA-SU-S3	.33	SET UP SMALL MEDIUM LATHE	PRORATE 3 OPERATIONS	.49962	.189		
0020	E						RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK,		.01006	.011		
0030	E						KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250 ,		.06699	.077		
0040	E						KML-TA-CD	1.00	DIA 1.0 REMOVE .250 ADD INCH TURN O.D.		.00947	.010		
0050	E						RLA-DR-EC	1.00	DRILL HOLE 1/2-2 DIA 1 - 1.5,		.06744	.077		
0060	E						RLA-BO-BA	1.00	BORE HOLE 1/2 TO 1 DIA 1 DP	BORE BUSHING	.08663	.099		
0070	E						RLA-BO-BB	1.00	BORE HOLE 1/2 - 1 DIA ADD IN,		.01254	.014		
0080	E						RLA-FR-BA	1.00	FACE ROUGH 1/2 - 1 DIA GRP 1	FACE 1ST END	.01481	.017		
0090	E						RLA-FF-BA	1.00	FACE FINISH 1/2 - 1 GROUP 1 ,		.03023	.034		
0100	E						RLA-CO-BA	1.00	CUT OFF 1/2 - 1 DIA. GROUP 1,		.02742	.031		
0110	E						RLA-HP-C2	1.00	ADDITIONAL PART SCROLL CHUCK	TURN PART AROUND IN CHUCK	.00640	.007		
0120	E						RLA-FR-BA	1.00	FACE ROUGH 1/2 - 1 DIA GRP 1	FACE 2ND END	.01481	.017		
0130	E						RLA-FF-BA	1.00	FACE FINISH 1/2 - 1 GROUP 1 ,		.03023	.034		
0140	E						RJP-PW-R1	1.00	REM RPL PAPSWRK SIGN OFF DOC		.01001	.011		
0073				JA	01		15	1.00		INST SM.SHAFT HOLE BUSHING	.167	.193		5
0010	E						RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053		
0020	E						RBW-BU-B2	.50	REBUSH A SET OF 2 BOSSES	1 STRAIGHT BUSHING	.22231	.127		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001	.011		
				JA	01		15	.39		MACH LG. SHAFT HOLE BUSHING	.929	.417		11

	0010	E	RLA-SU-S3	.33	SET UP SMALL MEDIUM LATHE	PRORATE 3 ... ATIONS	.49962		.169	
	0020	E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023	
	0030	E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS		.06699		.154	
	0040	E	KML-TA-CD	2.00	DIA 1.0 REMOVE .250 ADD INCH 2 BUSHINGS		.00947		.021	
	0050	E	RLA-DR-EC	2.00	DRILL HOLE 1/2-2 DIA 1 - 1.5 2 BUSHINGS		.06744		.155	
	0060	E	RLA-BO-BA	2.00	BORE HOLE 1/2 TO 1 DIA 1 DP 2 BUSHINGS		.03663		.179	
	0070	E	RLA-BO-BB	2.00	BORE HOLE 1/2 - 1 DIA ADD IN 2 BUSHINGS		.01254		.028	
	0080	E	RLA-FR-BA	2.00	FACE ROUGH 1/2 - 1 DIA GRP 1 FACE 1ST [illegible] BUSHINGS		.01481		.034	
	0090	E	RLA-FF-BA	2.00	FACE FINISH 1/2 - 1 GROUP 1 2 BUSHINGS		.03023		.069	
	0100	E	RLA-CO-BA	2.00	CUT OFF 1/2 - 1 DIA. GROUP 1 2 BUSHINGS		.02762		.063	
	0110	E	RLA-HP-C2	2.00	ADDITIONAL PART SCROLL CHUCK TURN PART AROUND IN CHUCK		.00640		.014	
	0120	E	RLA-FR-BA	2.00	FACE ROUGH 1/2 - 1 DIA GRP 1 FACE 2ND [illegible] BUSHINGS		.01481		.034	
	0130	E	RLA-FF-BA	2.00	FACE FINISH 1/2 - 1 GROUP 1 ,		.03023		.069	
	0140	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0075		JA 01	15	1.00		INST LG. SH[illegible] HOLE BUSH	.278	.042	.321	9
	0010	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVE[illegible] ARTS	.18669		.053	
	0020	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES [illegible] & POLISH	.22231		.255	
	0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0076		JA 01	15	.77		MACH BEARING BORE BUSHING	.669	.077	.593	16
	0010	E	RLA-SU-S3	.33	SET UP SMALL MEDIUM LATHE	PRORATE 3 [illegible]ATIONS	.49962		.169	
	0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK,		.01006		.011	
	0030	E	KML-TA-GE	1.00	DIA 3.00-4.00 REM .251-.500 ,		.09425		.108	
	0040	E	KML-TA-GF	1.00	DIA 4.0 REM .500 ADD INCH	TURN O.D.	.01762		.020	
	0050	E	RLA-DR-EC	1.00	DRILL HOLE 1/2-2 DIA 1 - 1.5,		.06744		.077	
	0060	E	RLA-BO-GA	1.00	BORE HOLE 3 - 3 1/2 DIA 1 DP BORE BUSH[illegible]		.13261		.152	
	0070	E	RLA-BO-GB	1.00	BORE HOLE 3-3.5 DIA. ADD IN ,		.04189		.048	
	0080	E	RLA-FR-GA	1.00	FACE ROUGH 3 - 4 DIA. GRP 1	FACE 1ST END	.01545		.017	
	0090	E	RLA-FF-GA	1.00	FACE FINISH 3 - 4 GROUP 1 ,		.03150		.036	
	0100	E	RLA-CO-GA	1.00	CUT OFF 3 - 3 1/2 DIA. GRP 1,		.03007		.034	
	0110	E	RLA-HP-C2	1.00	ADDITIONAL PART SCROLL CHUCK TURN PART [illegible] IN CHUCK		.00640		.007	
	0120	E	RLA-FR-GA	1.00	FACE ROUGH 3 - 4 DIA. GRP 1	FACE 2ND [illegible]	.01545		.017	
	0130	E	RLA-FF-GA	1.00	FACE FINISH 3 - 4 GROUP 1 ,		.03150		.036	
	0140	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0077		JA 01	15	1.00		INST BEARI[illegible] BORE BUSHING	.167	.025	.193	5
	0010	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE O[illegible] ARTS	.18669		.053	
	0020	E	RBW-BU-B2	.50	REBUSH A SET OF 2 BOSSES	1 STRAI[illegible]SHING	.22231		.127	
	0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0078		JA 01	15	.69		INSTALL INS[illegible]	.431	.040	.308	8
	0010	E	RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS ,		.31093		.357	
	0020	E	RBW-TR-H1	4.00	INSTALL HELICOIL INSERT	4 INSERTS	.02763		.127	
	0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001		.011	
9000		JA 01	15	.00		LABOR STAND[illegible] HISTORY	.000	.000	.000	0
	0010				15OC785 UPDATED OCCURANCE FACTOR/RESTR[illegible]ED					
	0011				LABOR STD TO MATCH AFLC FORM [illegible]					
	0012				<OLD STD> .40					
	0020				22JAN86 UPDATED OCC FACTORS <OLD STD [illegible]					
	0900				NED MONROE MANEAA 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

[illegible]FSD NROP NR
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12[illegible] [illegible]90123456 ELSE PUT IN END

17575A CSA MLG 4G11020-107A RCC MNPRA 4S1-9 84013

OPER SU	STEP	T D	S L	S K	W #R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A C
RA012	S	E	JA	EA	1			J	89017	.13	PERCENT ENGR 99.9		MACH LOWER PLATE C-5A M	.61		.34			
0001			JA	01		00				.00			PART NUMBER/NSN	.000	.000	.000			0
0010											4G13558-101A		1620004212101						
0040			JA	01		15				.33			SHAFT HOLE REP (SMALL)	.734	.036	.279			11
0010	E					KMM-SU-V1				.34	S/U VERT MILL BORE SMAL FXTR		PRORATE 3 OPERATIONS	.50518		.197			
0020	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS,			.08531		.098			
0030	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		DIAL ALONG BASE	.07609		.087			
0040	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		DIAL IN CENTER HOLE	.07609		.087			
0050	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		MOVE TO SML HOLE/CHK LOCATE	.07609		.087			
0060	E					RML-BB-AC				1.00	BORE HOLE 1 X 1 1/2 GROUP 2 ,			.23926		.275			
0070	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011			
0050			JA	01		15				.33			SHAFT HOLE REP (LARGE)	1.049	.052	.398			15
0010	E					KMM-SU-V1				.34	S/U VERT MILL BORE SMAL FXTR		PRORATE 3 OPERATIONS	.50518					
0020	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS,			.08531		.098			
0030	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		DIAL IN BASE	.07609		.087			
0040	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		DAIL IN CENTER HOLE	.07609		.087			
0050	E					RML-AL-AC				2.00	ALIGN HOLE TO SPINDLE ROD		MOVE TO LRG HOLE/2 HOLES	.07609		.175			
0060	E					RML-BB-AC				2.00	BORE HOLE 1 X 1 1/2 GROUP 2		2 HOLES	.23926					
0070	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011			
0			JA	01		15				.33			BEARING BORE REP	.734	.036	.279			11
0010	E					KMM-SU-V1				.34	S/U VERT MILL BORE SMAL FXTR		PRORATE 3 OPERATIONS	.50518					
20	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS,			.08531					
30	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		DIAL ALONG BASE	.07609		.087			
0040	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		DIAL IN CENTER HOLE	.07609		.087			
0050	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD		MOVE TO SML HOLE/CHK LOCATE	.07609		.087			
0060	E					RML-BB-AC				1.00	BORE HOLE 1 X 1 1/2 GROUP 2 ,			.23926		.275			
0070	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011			
0065			JA	01		15				.05			REMOVE INSERTS	.156	.001	.007			0
0010	E					RBW-SU-G1				.50	S/U FOR BENCH WORK GENERAL		PRORATE 2 PARTS	.27525		.158			
0020	E					KER-AS-DA				4.00	REMOVE SPRING HELICAL		4 INSERTS	.00209		.009			
0030	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011			
0118			JA	01		15				.33			MACH SHAFT HOLE BUSH (SMAL	.211	.010	080			3
0010	E					RLA-SU-S3				.25	SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.14			
0020	E					RLA-HP-C1				1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011			
0030	E					KML-TA-CC				1.00	DIA .501-1.00 REM .033-.250			.06699		.077			
0040	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0120			JA	01		15				.33			INST SHAFT HOLE BUSH (SMALL)	.077	.004	.029			1
0010	E					RBW-BU-S1				.25	SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053			
0020	E					RBW-BU-A4				1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023			
0030	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0121			JA	01		15				.33			FINISH MACH SML HOLE BUSH	.640	.032	.243			9
0010	E					KMM-SU-V1				.25	S/U VERT MILL BORE SMAL FXTR		PRORATE OVER 4 PARTS	.50518		.145			
0020	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098			
0030	E					RML-AL-AB				1.00	ALIGN VERTICAL AXIS ROD			.12699		.146			
0040	E					RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087			
0050	E					RML-BA-CD				1.00	BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248			
0060	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
			JA	01		15				.33			MACH SHAFT HOLE BUSH (LRG)	.211	.010	.080			3
10	E					RLA-SU-S3				.25	SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1				1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011			
0030	E					KML-TA-CC				1.00	DIA .501-1.00 REM .033-.250			.06699		.077			
0040	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0130			JA	01		15				.33			INST SHAFT HOLE BUSH (LRG)	.211	.010	.080			3

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    0030 E          KML-TA-CC  1.00 DIA .501-1.00 REM .033-.250                          .06[illegible]      .077
    0040 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                         .01001              .011
         JA 01      15         .33                          FINISH MACH      E BUSH    .606    030       .230      9
      10 E          KMM-SU-V1  .25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER  S          .5051[illegible]    .145
     020 E          RML-HP-CA  1.00 HAND HANDLE NO WRAP 2 CLAMPS                         .08[illegible]      .098
    0030 E          RML-AL-AB  1.00 ALIGN VERTICAL AXIS ROD                            .12699              .146
    0040 E          RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                          .0760[illegible]    .087
    0050 E          KMM-BA-AC  1.00 BORE HOLE 1 X 1 1/2 GROUP 1 USE PROPER     TABLE   .18220              .209
    0060 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .0100[illegible]    .011
0138     JA 01      15         .67                          MACH BEARING   USH       .240    .024      .185      7
    0010 E          RLA-SU-S3  .25 SET UP SMALL MEDIUM LATHE   PRORATE OVER  ARTS     .4996[illegible]    .143
    0020 E          RLA-HP-C1  1.00 1ST PART IN-OUT SCROLL CHUCK                        .01006              .011
    0030 E          KML-TA-GC  1.00 DIA 3.00-4.00 REM .033-.250                        .0780C              .089
    0040 E          KML-TA-GD  1.00 DIA 4.0 REM .250 ADD INCH                          .01707              .019
    0050 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .0100[illegible]    .011
0140     JA 01      15         .67                          INST BEARI     USH       .077    .008      .060      2
    0010 E          RBW-BU-S1  .25 SET UP TO REBUSH BOSSES     PRORATE OVE     S      .1866[illegible]    .053
    0020 E          RBW-BU-A4  1.00 INSTALL ONE STRAIGHT BUSHING                       .02062              .023
    0030 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001              .011
0141 *   JA 01      15         .67                          FINISH MA      BORE BUS  .650    [illegible]5      .501     19
    0010 E          KMM-SU-V1  .25 S/U VERT MILL BORE SMAL FXTRPRORATE OV      S       .50[illegible]      .145
    0020 E          RML-HP-CA  1.00 HAND HANDLE NO WRAP 2 CLAMPS                        .085[illegible]     .098
    0030 E          RML-AL-AB  1.00 ALIGN VERTICAL AXIS ROD                            .1269[illegible]    .146
    0040 E          RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                          .07609              .087
    0050 E          KMM-BA-FC  1.00 BORE HOLE 3.5 X 1.5 GROUP 1 USE PROPER     TABLE   .22574              .259
    0060 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .0100[illegible]    .011
0145     JA 01      15         .33                          INSTALL INSE[illegible]   .431    .021      .164      6
    0010 E          RBW-SU-H1  1.00 SET UP TO INSTALL HELICOILS                        .31093              .357
    0020 E          RBW-TR-H1  4.00 INSTALL HELICOIL INSERT    4 INSERTS               .0[illegible]       .127
    0030 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001              .011
9000     JA 01      15         .00                          LABOR STA      ORY       .000    000       .000      0
    0010                       15OCT85 UPDATED OCCURANCE FACTOR/RESTRI[illegible]
    0011                               LABOR STD TO MATCH AFLC FORM 9[illegible]
    0012                               <OLD STD> .75
    0020                       30DEC85 UPDATE[illegible]C FACTORS <OLD STD>
    0900                               N MONR[illegible] HANEAA  73357
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INTERROGATE LABOR STANDARDS. INPUT

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CC PRD NROP NR
--X----X--->
34567890123456  ELSE PUT IN END
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	TH D	S T L	S K	W #R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB032		S	E	JA EA 3			J 85345	.67	PERCENT ENGR 99.9	GRND COLLAR LOCK RING C5	2.55		1.71		
0001				JA 01		00		1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4G13412-101A	1620001357841					
0070				JA 01		15		.63		GRIND FACE OF TEETH	.556	.053	.403		16
0010	E					RGR-SU-S1		.50	SET UP SURFACE GRINDER	PRORATE 2 PARTS	.04390		.025		
0020	E					KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		02308		.026		
0030	E					RLA-HP-C6		1.00		LOAD PART ON SURFACE GRINDER	.02466		.028		
0040	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E					KMG-OD-TA		1.00	GRIND .010 FROM 12 D X 1		.38100		.438		
0060	E					RLG-EI-C3		2.00	CHK FACE TO FACE I/S OR O/S	MIC 2 TIMES	.01427		.032		
0070	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0075				JA 01		15		.63		CHAMFER EDGES OF TEETH	.193	.018	.140		5
0010	E					RBW-SU-G1		.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
0020	E					RLG-RS-N4		1.00		CHAMFER EDGE OF TEETH	.04595		.052		
0030	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080				JA 01		15		.56		1ST GRIND SHOULDER	.919	.077	.592		23
0010	E					RGR-SU-C2		1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E					KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E					KMG-OD-TA		1.00	GRIND .010 FROM 12 D X 1		.38100		.438		
0070	E					RLG-EI-C3		2.00	CHK FACE TO FACE I/S OR O/S	MIC 2 TIMES	.01427		.032		
0080	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090				JA 01		15		.56		1ST GRIND MAJOR DIA	.919	.077	.592		23
0010	E					RGR-SU-C2		1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E					KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E					KMG-OD-TA		1.00	GRIND .010 FROM 12 D X 1		.38100		.438		
0070	E					RLG-EI-C3		2.00	CHK FACE TO FACE I/S OR O/S	MIC 2 TIMES	.01427		.032		
0080	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0204				JA 01		15		.63		FINISH GRIND MAJOR DIA	1.141	.108	.827		32
0010	E					RGR-SU-C2		1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E					KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E					KMG-OD-TF		1.00	GRIND .040 FROM 12 IN D X 1		.61901		.711		
0070	E					RTL-MM-M3		2.00	MIC O D FIRST MEASUREMENT	MIC 2 TIMES	.00616		.014		
0080	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000				JA 01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									11DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM						
0011									958/UPDATED OCC FACTOR/WORK PREVIOUSLY						
0012									DONE ON OPER A0210 <OLD STD> 2.49						
0900									N MONROE MANEA 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107n RCC MNFRA 4S1-93-3 84013

OP SEQ	STEP	T	D	K	L	#R	K	A C	FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION <---- STORED	DESCRIPTION ----> SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA032		E		N	JA	EA	1		J	88280	1.00	PERCENT ENGR 3.8	MACH COLLAR LOCK RING C5	.26		.26		
0001					JA	01		00			1.00		PART NUMBER/NSN	.000	.000	.000		0
	0010											4G13412-101A	1620001357841					
0315					JA	01		00			1.00		ASSY COLLAR	.260	.000	.260		100
	0010	N									1.00		ASSY COLLAR	.25000		.250		
	0020	E							RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
9000					JA	01		00			.00		LABOR STANDARD HISTORY	.000	.000	.000		0
	0010											9 JUNE 88 INITIAL INPUT MRPII						
	0900											NED MONROE MANEL 73255 MR BIG						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
<---><----><--->
1234567890123456 ELSE PUT IN END

L248

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

MLG BALL SCREW ASSY

BILL OF MATERIALS

746529

ROUTED ITEM	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNIT PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE (P,D,C)	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	0	4694034-101A	1620001486466	00293	BALLSCREW ASSY	1	EA										
	.1	B-15576-2R	N.S.L.	00293	.BALL NUT	1											
	.1	N.P.L.	N.S.L.		.SCREW ASSY	1											
	..2	66C33001-107ST	3120010731954	99747	..CROSS PIN BUSH D.S.	12	AR	EA									
	..2	B-15576-1	N.S.L.	00293	..SCREW	1											
	.1	B15376-12	1620010064606	00293	.ADAPTER	1	EA										
	.1	B562-1A	1620012944408	00293	.BALL BEARING	187	EA										
	.1	MS1759-2424	3110001006159	96906	.BALL BEARING	187	EA					INT					
	.1	BB562-1A05	N.S.L.	00293	.BALL BEARING (0.0005) O.S.	187	AR					ALT					
	.1	BB562-1A10	N.S.L.	00293	.BALL BEARING (0.001)O.S.	187	AR					ALT					
	.1	BB562-1A20	N.S.L.	00293	.BALL BEARING (0.002)O.S.	187	AR					ALT					
	.1	BB562-1A30	N.S.L.	00293	.BALL BEARING (0.003)O.S.	187	AR					ALT					
	.1	BB15576-7R	N.S.L.	00293	.SCRAPER	1											
	.1	B15576-14R	1620010064607	00293	.SCRAPER	1	EA										
	.1	B15576-9	5315010053596	00293	.DRIVE PIN (SCRAPER)	4	EA										
	.1	B15576-8	5330010049089	00293	.SEAL FELT	2	EA										
	.1	MS28775-240	5330006181683	96906	.PACKING, PREFORMED	1	EA										
	.1	AN6230-18	5330001943733	88044	.PACKING PREFORMED	1	EA					INT					
	.1	B15576-4R	1620010065359	00293	.DEFLECTOR (YOKE)	4	EA										
	.1	B15576-3R	1620010063304	00293	.TUBE, BALL RETURN	2	EA										
	.1	B15576-5R	1620010065357	00293	.TUBE, BALL RETURN	1	EA										
	.1	B15576-6	1620010065358	00293	.TUBE CLAMP	1	EA										
	.1	MS9368-12	5310006645279	96906	.HEX NUT	4	EA										
	.1	MS15001-4	4730006504207	96906	.FITTING, LUBRICATION	1	EA										
	.1	B15576-13R	1620010064608	00293	.DOG STOP	1	EA										
	[redacted]	B15576-10	5310010068370	00293	.HEX NUT	1	EA										
	.1	B15576-11	N.S.L.	00293	.NAME PLATE	1											
	.1	67C30171-03	N.S.L.	LOC MFG	.NAME PLATE DECAL	1						ALT					

FAMILY 7

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	601 FLO DAY
BENT	COOP	17467A		KC-135 NLG	TORSION LINK	1620-00-650-9335	5-72334-9	4A4-12-3	410
BENT	POLL	17474A	-G	T-38 NLG	STRUT ASSY L/H	1620-00-264-0744	7227217-10	4S1-75-73	45
BENT	POLL	17476A	-G	T-38 NLG	STRUT ASSY R/H	1620-00-279-5839	7227217-20	4S1-75-13	45
BENT	POLL	17478A	-G	T-38 NLG	STRUT ASSY	1620-00-299-0278	7227219-10	4S2-62-3	30
COOP	COOP	17494A	-G	F-15 NLG	ORIFICE TUBE	1620-00-308-4145	6a##450726-2001	4S2-73-3	60
COOP	COOP	17517A		F-15 NLG	ORIFICE TUBE	1620-00-348-6485	68A410726-1001	4A4-22-3	30
BENT	TOLM	17527A		A-7D NLG	STRUT ASSY	1620-01-006-3237	986100-509	4S1-90-3	30
DELE		17541A		F-111 NLG	BRACE	1620-00-948-8182	10 OCT 88	4A4-15-3	20
BENT	POLL	17546A		F-5/T-38	SIDE BRACE	1620-00-140-5241	6-40650-513	4SA6-11-3	30
BENT	POLL	17547A		F-5/T-38	SIDE BRACE	1620-00-140-5242	6-40650-514	4SA6-11-3	30
COOP	POLL	17565A	-G	C-141 NLG	STRUT ASSY	M 1620-01-020-4973	3610005-125	4S1-73-3	35
BENT	COOP	17567A	-G-J	KC-135 NLG	STRUT ASSY	M 1620-01-038-1912	7327025-50	4S2-30-3	37
JENS	POLL	17568A		F-5/T-38	SIDE BRACE TRUNNION	1620-00-007-1783	1440695-1	4SA6-11-3	
COOP	POLL	17574A	-G-J	C-141 NLG	CRANK ASSY	1620-00-397-7413	7430178-30	4S2-59-3	46
MONR	ANDE	17575A	-G	C-5 NLG	STRUT ASSY R/H AFT	M 1620-01-005-4191	4611020-107A	4S1-93-3	34
MONR	ANDE	17576A	-G	C-5 NLG	STRUT ASSY L/H AFT	M 1620-01-005-4192	4611020-105A	4S1-93-3	34
MONR	ANDE	17577A	-G	C-5 NLG	STRUT ASSY L/H FWD	M 1620-01-005-4193	4811020-101A	4S1-93-3	34
MONR	ANDE	17578A	-G	C-5A NLG	STRUT ASSY RH FWD	M 1620-01-005-4194	4611020-103A	4S1-93-3	34
BENT	TOLM	17595A	-G	A-7D NLG	STRUT ASSY	M 1620-00-837-2427	986100-505	4S1-90-3	30
JENS	COOP	17652A	-G	F-106 NLG	STRUT ASSY "A"	1620-00-569-5209	578600-501	4S2-40-3	
BENT	TOLM	17654A	-G	F-106 NLG	SIDE BRACE	1620-00-633-2008	578350-501	4S1-32-13	25
COOP	TOLM	17662A	-G	F-111 NLG	STRUT ASSY SHOCK	1620-01-066-8945	7327074-110	4S1-78-3	44
COOP	TOLM	17663A	-G	F-111 NLG	STRUT ASSY-SHOCK	1620-01-066-8946	7729961-10	4S1-78-3	44
COOP	TOLM	17664A		F-111 NLG	STRUT ASSY-SHOCK	1620-01-070-0632	7729961-30	4S1-78-3	44
COOP	TOLM	17677A		F-111 NLG	STAB. ROD	1620-00-422-1839	12L9593-701	4A4-19-3	15
BENT	TOLM	17681A		A-7D NLG	STEERING LINK ASSY	1620-00-168-5519	215-24041-6	4A4-27-3	10
BENT	TOLM	17685A	-G	F-106 NLG	STRUT ASSY "B"	1620-00-082-8821	634600-50	4S2-50-3	55
COOP	POLL	17686A		C-141 NLG	LINK ASSY	1620-00-281-0622	3611092-101	4S1-73-3	20
MONR	ANDE	17687A	-G	C-5A NLG	INNER CYLINDER	1620-01-000-5925	7926445	4S1-93-3	31
DELE		17693A		E-3A NLG	LOWER LINK	1620-01-007-4262	30 NOV 87	4A4-24-13	
DELE		17696A		E-3A NLG	TORSION LINK	1620-01-009-0087	30 NOV 87	4S1-107-3	
DELE		17702A		E-3A NLG	TORSION LINK	1620-01-010-6718	30 NOV 87	4A4-24-13	
DELE		17708A		E-3A NLG	DRAG STRUT	1620-01-016-4227	30 NOV 87	4S1-107-3	
DELE		17709A		E-3A NLG	TRUCK ASSY	1620-01-016-4228	30 NOV 87	4A4-25-3	
DELE		17711A		E-3A NLG	BEAM ASSY	1620-01-018-1681	30 NOV 87	4S1-105-3	
DELE		17754A		E-3A NLG	STRUT ASSY R/H	1620-01-009-8083	30 NOV 87	4S1-102-3	
BENT	COOP	17757A	-J	KC-135 NLG	BOLT TRUNNION	4730-00-758-6711LE	69-30734-1	4A4-12-24	20
DELE		17759A		F-15	BUNGEE ASSY	1620-00-333-7134	8 AUG 86	4A4-22-3	
DELE		17816A	-G	F-111 NLG	BRACE LOWER	1620-00-225-1854	10 OCT 88	4A4-18-3	25
DELE		17857A		E-3A NLG	TRUNNION L/H	1620-01-015-5021	30 NOV 87	4S1-107-3	
MART	SHEL	17874A		F-15	LOADER L/H 40 MM	1010-00-314-3246	7329956	11M2-52-62	10
MART	SHEL	17921A		F-16	DRUM ASSY	1005-01-044-6174	13201869	11M1-7-16-2	15
MART	SHEL	17945A			GRENADE LAUNCHER 40 MM	1010-00-179-6447	11838703	11M3-9-4-2	4
DELE		17952A		E-3A NLG	BRAKE SUPPORT COLLAR	1620-01-015-9813	30 NOV 87	4S1-107-3	
DELE		17953A		E-3A NLG	BRAKE EQUALIZER ROD	1620-01-015-9814	30 NOV 87	4S1-107-2	
DELE		17954A		E-3A NLG	BRAKE EQUALIZER ROD	1620-01-015-9815	30 NOV 87	4S1-107-3	
JENS	PRIC	17964A	-J	F-15 NLG	WHEEL	1630-01-071-6112	5004395	4M3-8-23	16
COOP	TOLM	18076A	-G-J	F-111 NLG	STAB ROD	3040-00-161-4085	12L10030-707	4A4-17-3	12
DELE		18077A			LINKER DELINKER M284-1	4925-00-420-2970	19 NOV 86	34Y36-1-1	
DELE		18097A			POD ADAP	1560-00-350-7821BF	20 NOV 86		

FAMILY 7
C-5 MLG

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
[redacted]	MKPRW	XKPRW	X	4N	6	.54	1.00	54
	*							54
	MNPC=	H6374	N	H2	6	.93	1.00	93
		HC305	N	HC	6	5.05	1.00	5.05
		HC363	N	H8	6	5.29	1.00	5.29
		HP306	N	3S	6	1.10	1.00	1.10
	*							12.37
	MNPCK	00100	N	YF	1	4.00	1.00	4.00
		XNPCK	X	YA	6	30.00	1.00	30.00
	*							34.00
	MNPGP	00010	N	YK	5	110.60	1.00	110.60
		PA020	N	YK	5	43.40	1.00	43.40
		PD058	N	YK	5	126.02	1.00	126.02
		PD374	E	YK	5	.02	1.00	2
		PM045	N	YK	5	.50	1.00	50
		PM058	N	YK	5	8.92	1.00	8.92
		PM088	E	YK	5	1.03	1.00	1.03
		PP001	E	3S	5	2.51	1.00	2.51
		PP005	E	3S	5	.54	1.00	54
		PP006	E	3S	5	.42	1.00	42
		PP009	E	3S	5	.40	1.00	40
		PP011	E	3S	5	.89	1.00	89
		PP013	E	3S	5	1.20	1.00	1.20
		PP014	E	3S	5	.85	1.00	85
		PP015	E	3S	5	1.22	1.00	1.22
		PP016	E	3S	5	.81	1.00	81
		PP017	E	3S	5	.54	1.00	54
		PP018	E	3S	5	1.61	1.00	1.61
		PP019	E	3S	5	.35	1.00	35
		PP020	E	3S	5	.40	1.00	40
		PP021	E	3S	5	.40	1.00	40
		PP024	E	3S	5	1.13	1.00	1.13
		PP025	E	3S	5	.52	1.00	52
		PP026	E	3S	5	.40	1.00	40
		PP034	E	3S	5	.54	2.00	1.08
		PP038	E	3S	5	.54	1.00	54
		PP048	E	3S	5	.54	1.00	54
		PP053	E	3S	5	.54	.58	31
		PP059	N	3S	5	.41	1.00	41
		PP060	E	3S	5	.40	1.00	40
		PP062	E	3S	5	.70	1.00	70
		PP082	E	3S	5	1.23	1.00	1.23
		PP091	E	3S	5	.54	1.00	54
		PP092	E	3S	5	.54	1.00	54
		PP093	E	3S	5	.54	1.00	54
		PS000	N	YK	5	.50	1.00	50
		PS001	N	YK	5	.25	1.00	25

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
17576A	MNPGP	PS014	N	YK	5	1.21	1.00	1.21
		PS015	N	YK	5	.26	1.00	26
		PS045	N	YH	5	2.00	1.00	2.00
		PS048	N	YK	5	.40	1.00	40
		PS059	N	YK	5	.55	1.00	55
		PS062	N	HB	5	.25	1.00	25
		PS028	N	YK	5	7.60	1.00	7.60
		XNPGP	X	3S	5	19.64	1.00	19.64
	*							349.17
	MNPGW	WC001	N	KI	5	16.41	1.00	16.41
		WE001	E	DI	5	.94	1.00	94
		WE002	N	DI	5	4.32	1.00	4.32
		WE005	N	DI	5	.28	1.00	28
		WE006	N	DI	5	.28	1.00	28
		WE007	E	DI	5	.42	1.00	42
		WE009	N	DI	5	.22	1.00	22
		WE011	N	DI	5	.18	1.00	18
		WE012	N	DI	5	.30	1.00	30
		WE013	E	DI	5	.49	1.00	49
		WE014	N	DI	5	.53	1.00	53
		WE015	E	DI	5	1.16	1.00	1.16
		WE016	N	DI	5	.37	1.00	37
		WE017	N	DI	5	.19	1.00	19
		WE018	E	DI	5	.69	1.00	69
		WE019	N	DI	5	.44	1.00	44
		WE020	N	DI	5	.19	2.00	38
		WE021	N	DI	5	.41	1.00	41
		WE024	N	DI	5	.19	1.00	19
		WE025	N	DI	5	.19	1.00	19
		WE026	N	DI	5	.27	1.00	27
		WE031	N	DI	5	.18	1.00	18
		WE032	N	DI	5	.28	1.00	28
		WE033	N	DI	5	.30	1.00	30
		WE034	N	DI	5	.17	2.00	34
		WE035	N	DI	5	.18	1.00	18
		WE036	N	DI	5	.18	1.00	18
		WE037	N	DI	5	.34	1.00	34
		WE038	N	DI	5	.19	1.00	19
		WE039	N	DI	5	.17	1.00	17
		WE040	N	DI	5	.27	1.00	27
		WE041	N	DI	5	.15	1.00	15
		WE043	N	DI	5	.26	1.00	26
		WE046	N	DI	5	.29	1.00	29
		WE047	N	DI	5	.27	1.00	27
		WE048	N	DI	5	.26	1.00	26
		WE049	N	DI	5	.16	1.00	16
		WE051	N	DI	5	.38	1.00	38
		WE052	N	DI	5	.25	1.00	25
		WE053	N	DI	5	.26	1.00	26
		WE055	N	DI	5	.16	1.00	16
		WE060	N	DI	5	.16	1.00	16

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
17573A	MNPGW	WE052	N	DI	5	.26	1.00	26
		WE01	N	DI	5	.30	1.00	30
		WE092	N	DI	5	.29	1.00	29
		WE093	N	DI	5	.30	1.00	30
		XNPGW	X	HB	5	6.06	1.00	6.06
	*							40.90
	MNPMG	XNPMG	X	JB	1	2.00	.10	20
	*							20
	MNPMN	MN062	N	JA	1	1.00	1.00	1.00
	*							1.00
	MNPNA	NA001	E	DB	2	4.52	1.00	4.52
		NA002	E	DB	2	1.95	1.00	1.95
		NA005	E	DB	2	.56	1.00	56
		NA006	E	DB	2	.53	1.00	53
		NA007	E	DB	2	1.60	1.00	1.60
		NA009	E	DB	2	.50	1.00	50
		NA011	E	DB	2	.10	.95	9
		NA012	E	DB	2	.33	.11	3
		NA013	E	DB	2	.22	1.00	22
		NA014	E	DB	2	.54	1.00	54
		NA015	E	DB	2	.55	1.00	55
		NA016	E	DB	2	.59	.69	40
		NA017	E	DB	2	.11	1.00	11
		NA018	E	DB	2	.90	1.00	90
		NA019	E	DB	2	.16	1.00	16
		NA020	E	DB	2	.16	2.00	32
		NA021	E	DB	2	.47	1.00	47
		NA024	E	DB	2	.20	2.00	40
		NA025	E	DB	2	.17	1.00	17
		NA026	E	DB	2	.78	1.00	78
		NA031	E	DB	2	.06	1.00	6
		NA032	E	DB	2	.11	1.00	11
		NA033	E	DB	2	.34	1.00	34
		NA034	E	DB	2	.17	2.00	34
		NA035	E	DB	2	.06	1.00	6
		NA036	E	DB	2	.09	1.00	9
		NA037	E	DB	2	.14	.63	8
		NA038	E	DB	2	.75	.07	5
		NA041	E	DB	2	.07	1.00	7
		NA043	E	DB	2	.15	1.00	15
		NA047	E	DB	2	.33	1.00	33
		NA048	E	DB	2	.07	1.00	7
		NA049	E	DB	2	.26	.05	1
		NA051	E	DB	2	.14	1.00	14
		NA052	E	DB	2	.34	1.00	34
		NA053	E	DB	2	.33	.16	5
		NA060	E	DB	2	.10	.63	6

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
17570A	MNPNA	NA042	E	JA	2	.19	1.00	19
		NA305	E	JA	2	.58	1.00	58
		NA353	E	JA	2	.05	1.00	5
		XNPNA	X	JA	2	7.33	1.00	7.38
	*							25.38
	MNPRA	RA000	E	JA	1	1.60	.25	40
		RA001	E	JA	1	33.65	.79	26.58
		RA002	E	JA	1	22.13	.67	14.82
		RA007	E	JA	1	.05	.25	1
		RA009	E	JA	1	5.33	.63	3.70
		RA012	E	JA	1	2.62	.13	34
		RA013	E	JA	1	6.79	.50	3.39
		RA014	E	JA	1	7.35	.67	4.92
		RA015	E	JA	1	46.96	.79	37.09
		RA016	E	JA	1	2.41	.58	1.39
		RA017	E	JA	1	.54	.67	36
		RA018	E	JA	1	7.34	.83	6.09
		RA021	E	JA	1	1.60	.54	86
		RA024	E	JA	1	.54	1.00	54
		RA025	E	JA	1	.54	.08	4
		RA026	E	JA	1	1.41	.63	88
		RA030	N	JA	1	3.55	.41	1.45
		RA031	N	JA	1	.20	.92	18
		RA032	N	JA	1	.26	1.00	26
		RA033	E	JA	1	3.69	.54	1.99
		RA034	E	JA	1	3.00	.06	18
		RA038	E	JA	1	4.70	.09	42
		RA041	E	JA	1	.87	.05	4
		RA043	E	JA	1	1.11	.09	9
		RA047	E	JA	1	.09	.13	1
		RA048	E	JA	1	3.08	1.00	3.08
		RA049	N	JA	1	.11	1.00	11
		RA051	E	JA	1	.54	.79	42
		RA059	N	JA	1	1.15	1.00	1.15
		RA091	N	JA	1	3.41	.15	51
		RA092	N	JA	1	3.41	.05	17
		RA093	N	JA	1	3.41	.15	51
	*							111.98
	MNPRB	RB001	E	JA	3	29.29	.79	23.13
		RB002	E	JA	3	23.19	.67	15.53
		RB005	E	JA	3	3.78	.17	64
		RB006	E	JA	3	4.89	.21	1.02
		RB007	E	JA	3	1.66	1.00	1.66
		RB014	E	JA	3	5.75	1.00	5.75
		RB015	E	JA	3	4.05	.20	81
		RB016	E	JA	3	7.95	.58	4.61
		RB017	E	JA	3	2.06	.17	35
		RB018	E	JA	3	8.31	.17	1.41
		RB019	E	JA	3	10.23	.05	51

PROD NBR	RCL	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
17576A	MNPRC	RB020	E	JA	3	1.78	1.00	1.78
		RB024	E	JA	3	3.36	.50	1.68
		RB025	E	JA	3	3.40	.29	1.00
		RB032	E	JA	3	2.55	.67	1.70
		RB034	E	JA	3	2.80	.41	1.14
		RB040	N	JA	3	.60	1.00	60
		RB051	E	JA	3	1.76	.79	1.59
		RB053	E	JA	3	1.28	.50	64
		XNPRC	X	JA	3	.03	1.00	3
	*							65.38
	MNPRC	RC001	N	UP	3	11.64	1.00	11.64
		RC002	N	UP	8	21.87	1.00	21.87
		RC005	E	UP	8	1.25	.71	88
		RC006	E	UP	8	1.33	.75	99
		RC007	E	UP	8	3.05	1.00	3.05
		RC009	N	UP	3	1.80	.63	1.13
		RC011	E	UP	8	.64	.21	13
		RC012	E	UP	8	.19	.38	7
		RC013	E	UP	8	2.34	.18	42
		RC014	N	UP	8	6.40	1.00	6.40
		RC015	E	UP	8	4.51	1.00	4.51
		RC016	E	UP	8	3.16	.63	1.99
		RC017	N	UP	8	1.16	.67	77
		RC018	E	UP	8	2.82	.84	2.36
		RC019	E	UP	8	2.50	.16	36
		RC020	N	UP	8	1.41	1.50	2.11
		RC021	E	UP	8	1.94	.79	1.53
		RC024	E	UP	8	.87	.85	73
		RC025	N	UP	8	1.47	.79	1.16
		RC026	E	UP	8	1.73	.67	1.15
		RC032	N	UP	8	2.18	1.00	2.18
		RC033	E	UP	8	.62	.54	33
		RC034	N	UP	8	3.15	.97	3.05
		RC035	E	UP	8	.66	1.00	66
		RC036	E	UP	8	1.28	.79	1.01
		RC037	E	UP	8	.69	1.63	1.12
		RC038	E	UP	8	.96	.50	48
		RC039	E	UP	8	.14	.21	2
		RC040	E	UP	8	.14	.05	
		RC043	E	UP	8	.41	.21	8
		RC046	E	UP	8	.17	.13	2
		RC047	E	UP	8	.75	.17	12
		RC048	E	UP	8	1.46	1.00	1.46
		RC049	E	UP	8	.56	.83	46
		RC051	N	UP	8	1.59	.63	1.00
		RC052	E	UP	8	.36	.16	5
		RC053	N	UP	8	2.41	.58	1.39
		RC060	E	UP	8	.64	.13	8
		RC062	E	UP	8	1.22	.54	65
		RC091	E	UP	8	.33	.50	19
		RC092	E	UP	8	.38	.50	19

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
17575A	MNPRC	RC093	S	UP	3	.33	.05	1
	*							77.80
	MNPSA	XNPSA	X	47	S	5.00	1.00	5.00
	*							5.00
	MNPWW	WF048	N	WF	9	1.14	1.00	1.14
		WH091	N	WL	A	.57	1.00	57
		WH092	N	WF	A	.57	1.00	57
		WH093	N	WF	A	.57	1.00	57
	*							2.85
*								726.57

21001N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 1 OF __ PAGES

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

7. R[redacted]UMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MAIN		4S-1-182 & DWG 4G11415 4S1-93-3 AND SUPPLEMENTS
13. SERIAL NUMBER	**14. NOUN**	
	OUTER CYLINDER	

17575A 6 7 8 9

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G11415-107A		NSN 1620004463776 S/N 17575A ~~17576A~~ ~~17577A~~ 17578A 72879A			
		****** UNIT COST: $59055.05 ****** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		~~FPI IAW MIL-STD-6866~~ FMPI IAW MIL-STD-1949 P/O N01561			
		STRIP CHROME IAW MIL-STD-871 ~~GRIND IAW MIL-STD-866~~			
		TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 ~~P/O N61891~~			
		CAD PLATE IAW MIL-STD-870 TYPE II CLASS II BRUSH PLATE IAW MIL-STD-865 ~~BAKE IAW 4S-1-182~~ MADI 74-12			
		BLAST IAW MIL-STD-1504 IVD IAW MIL-C-83488A ~~ALODINE IAW MIL-C-5541~~			
		******MAT'L 300M (280-300 KSI)****** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT ~~HAVE BEEN THOROUGHLY TRAINED AND ARE~~ FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) ~~AND T.O. SUPPLEMENTS REFERENCED. THE~~ APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. (CONTINUED)			

21. [redacted]NAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

IDA

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21001N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 2 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4011415-107A			
[redacted]	005 *REQD*	DISASSEMBLE/REMOVE ALL BUSHINGS *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 CL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ML01	
[redacted]	*REQD*	DEGREASE AFTER MAG		001 MNPRB 002 06 003 MU01	
8	020 *REQD*	CHECK CONCENTRICITY OF DIAMETER "C" TO DIAMETER "B". MAXIMUM 0.003 TIR. RECORD ACTUAL READING _____ ~~I.D. 7.724/7.727/7.729 WEAR~~ RECORD DIMENSION _____ *C/P MOVE		001 MNPRB 002 01 003 GI01 ~~005 X8745221~~ 006 X8745223	
8	025 *REQD*	CHECK CONCENTRICITY OF COLLAR AREA O.D. TO DIA "C" MAXIMUM 0.003 TIR. RECORD ACTUAL READING _____ ~~*C/P MOVE~~		001 MNPRB 002 01 003 GI01 ~~005 X8745221~~ 006 X8745223	
8	030 *REQD*	CHECK CONCENTRICITY OF UPPER BORE I.D. TO DIA "A" MAXIMUM .005 TIR RECORD ACTUAL READING _____ ~~*C/P MOVE~~		001 MNPRB 002 01 003 GI01 ~~005 X8745221~~ 006 X8745223	
8	035 *REQD*	CHECK CONCENTRICITY OF LOWER BORE I.D. TO DIA "A". MAXIMUM OF .005 TIR RECORD ACTUAL READING _____ ~~*C/P MOVE~~		001 MNPRB 002 01 003 GI01 ~~005 X8745221~~ 006 X8745223	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	E AND I INSPECTION ***NOTE*** IF AREA "C" HAS FLASH CHROME (.0007 FROM FACTORY) AND IS ~~WITHIN .006 TIR, INITIATE 150 FOR~~ USE AS IS. *CHECK & RECORD CONCENTRICITY BETWEEN UPPER & LOWER BORE ~~I.D. AREA "C" 7.724/7.727 WEAR 7.729~~ CYLINDER O.D. 12.496/12.499 WEAR 12.490 CYLINDER ID LOWER BORE ~~11.974/11.979 WEAR 11.992~~ CYLINDER ID UPPER BORE 11.746/11.756 WEAR 11.760 RECORD BASE METAL DIMENSION ~~POSITIONING LUG BUSHING I.D.~~ 1.624/1.626 WEAR 1.628 CROSSWIND LUG BUSHING FACE TO FACE 2.185/2.188 WEAR 2.183 ~~BASE METAL 2.210 MAX~~ RECORD BASE METAL DIMENSIONS LEFT _____ RIGHT _____ BALLSCREW HOLE BUSHING I.D. ~~3.249/3.251 WEAR 3.253~~ BASE METAL 4.100 MAX RECORD BASE METAL DIMENSIONS LEFT _____ RIGHT _____ ~~BALLSCREW CROSS PIN HOLE BUSHING I.D.~~ 1.600/1.602 WEAR 1.6035 BASE METAL 1.900 MAX RECORD BASE METAL DIMENSIONS LEFT _____ RIGHT _____ RETAINER RING GROVE ID 12.057/12.062 WEAR 12.064 ROTATION LUG BUSHING ID 1.937/1.938 WEAR 1.9395 BASE METAL UPPER LEFT 2.210 MAX RECORD BASE METAL DIMENSIONS _____ (CONTINUED)		001 MNPGW 002 04 003 EI01	

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		LOWER LEFT 2.280 MAX RECORD BASE METAL DIMENSIONS UPPER RIGHT 2.280 MAX RECORD BASE METAL DIMENSIONS LOWER RIGHT 2.210 MAX RECORD BASE METAL DIMENSIONS AREA C OVERALL LENGTH 3.860/3.845 MANIFOLD LUG BUSHING ID .323/.326 WEAR .329 BASE METAL .500 MAX UPPER END THRUST BEARING FROM TOP 2.660/2.670 WEAR 2.659 NOTE: A MINIMUM OF TWO FMPI'S REQUIRED ON THIS PART			
8	050	GRIND CHAMFER TO REMOVE CHROME BETWEEN FACE & AREA "C" .090 X 30 DEG *C/P MOVE		001 MNPRE 002 01 003 GP01 ~~005 XR745120~~	
26	052	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	053	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	054	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	055	GRIT BLAST UPPER BORE & DOME AREA TO REMOVE MINOR CORROSION & DAMAGE NOT EXCEEDING .005 IN DEPTH OR 15% TOTAL SURFACE AREA. *C/P MOVE		001 MNPRC 002 01 003 BL02	
[redacted]		LOCAL REWORK I.D. .030 DEPTH X 1.0 WIDTH X 3.0 LENGTH IAW FIG 5-48 *C/P MOVE		001 MNPGW 002 04 003 EI01	

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	065	STRIP CHROME FROM CYLINDER O.D. *C/P MOVE		001 MNPRC 002 02 003 SC02 005 X7432930	
26	070	STRIP CHROME FROM UPPER BORE I.D. *C/P MOVE		001 MNPRC 002 02 003 SC02 005 X7432930	
26	075	STRIP CHROME FROM LOWER BORE I.D. *C/P MOVE		001 MNPRC 002 02 003 SC02 005 X7432930	
26	080	STRIP CHROME FROM I.D. OF "C" AREA IF FACE IS NOT CHROME PLATED *C/P MOVE		001 MNPRC 002 02 003 SC02 005 X7432930	
8G	085	FIRST GRIND CYLINDER O.D. MIN O.D. 12.476 RECORD BASE METAL DIMENSIONS *C/P MOVE		001 MNPRB 002 03 003 GG02	
8	090	FIRST GRIND UPPER BORE I.D. MAX I.D. 11.770 MAINTAIN 0.005 TIR WITH DIA "A" RECORD TIR		001 MNPRB 002 01 003 GI01 005 X8745221	
		RECORD BASE METAL DIMENSIONS *C/P MOVE		006 X8745223	
8	100	FIRST GRIND LOWER BORE I.D. MAX I.D. 11.892 TO BE CONCENTRIC WITH DIA "A" MAXIMUM OF .005 TIR RECORD TIR RECORD BASE METAL DIMENSIONS		001 MNPRB 002 01 003 GI01 005 X8745221	
		*C/P MOVE		006 X8745223	
8	105	IF OPERATION .020 READING IS MORE THAN 0.003 OR DIA "C" DOESN'T MEET TECH ORDER REQUIREMENTS, FIRST GRIND (CONTINUED)		001 MNPRB 002 01 003 GP01 005 X8745180	

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		AREA "C" TO REMOVE CHROME MAX I.D. 7.739 MAINTAIN 0.003 TIR WITH UPPER BORE. THIS OPERATION WILL NOT BE ~~REQUIRED IF 150 HAS BEEN INITIATED~~ PER OPERATION 045. RECORD TIR. MAKE SURE ALL CHROME IS REMOVED FROM CHAMFER			
		********NOTE******** * IF I.D. DOES NOT EXCEED 7.729 * WITH A 32 RMS FINISH NO CHROME * IS REQUIRED.!!!!!!! **********			
		RECORD BASE METAL DIMENSION *C/P MOVE			
8G	110	HONE LOWER BORE TO REMOVE DEFECTS RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRB 002 03 003 HV04 ~~005 XB745187~~	
8G	113	LOCAL REWORK I.D. .030 DEPTH X 1.0 WIDTH X 3.0 LENGTH, IAW FIG 5-48 IF HONE DOES NOT CLEAN UP, IN LOWER BORE *C/P MOVE		001 MNPRB 002 03 003 BE01	
8G	115	HONE UPPER BORE TO REMOVE DEFECTS RECORD BASE METAL DIMENSIONS *C/P MOVE		001 MNPRB 002 03 003 HV04 ~~005 XB745187~~	
8G	118	LOCAL REWORK I.D. .030 DEPTH X 1.0 WIDTH X 3.0 LENGTH, IAW FIG 5-48 IF HONE DOES NOT CLEAN UP IN UPPER BORE *C/P MOVE		001 MNPRB 002 03 003 BE01	
69	120	**SECOND REPAIR AREA "C" ID BORE ID** MIN ID 7.844/7.984 MAINTAIN 0.003 TIR WITH UPPER BORE RECORD TIR		001 MNPRA 002 02 003 MH05 ~~005 XB633672~~	
		MAX ID 7.984 MIN WALL .607 RECORD BASE METAL DIMENSIONS *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
~~69~~	121	CHECK & RECORD DIMENSIONS ON ATTACHED SHEET (INITIAL)		001 MNPRA 002 02	
	REQD	*C/P MOVE		003 MH05	
				~~005 X8633672~~	
69	125	COLLAR AREA O.D. REPAIR MIN O.D 8.965 CONCENTRIC TO DIA "C" WITHIN .003 TIR RECORD TIR _____ RECORD BASE METAL DIMENSION _____ *C/P MOVE		001 MNPRA 002 02 003 MH05 ~~005 X8633672~~	
69	130	REPAIR COLLAR FACE. MACHINE TO 3.710 MIN. FOR BUSHING I.A.W. T.O. 4S1-93-3. RECORD REQD FLANGE THICKNESS		001 MNPRA 002 02 003 MH05 ~~005 X8633672~~	
		ON OPERATION 425. *C/P MOVE			
69	135	MACHINE SHOULDER OF THRUST BEARING AREA O.D. MIN WALL THK .700 MAINTAIN .380 RADIUS RECORD REQD WASHER THICKNESS ON		001 MNPRA 002 02 003 MH05 ~~005 X8633672~~	
		OPERATIONS 420 & 432 * C/P MOVE			
69	140	BALLSCREW HOLE REPAIR (RIGHT SIDE) MAX I.D. 4.100 RECORD CRITICAL DIMENSION _____ *C/P MOVE		001 MNPRA 002 02 003 MH05 ~~005 X8633672~~	
69	145	BALLSCREW HOLE REPAIR (LEFT SIDE) MAX I.D. 4.100 RECORD CRITICAL DIMENSION _____ *C/P MOVE		001 MNPRA 002 02 003 MH05 ~~005 X8633672~~	
69	150	BALLSCREW HOLE FACE REPAIR RIGHT SIDE MATERIAL REMOVAL .080/.150 RECORD REQD FLANGE THICKNESS ON OPERATION 475 _____		001 MNPRA 002 02 003 MH05 ~~005 X8633672~~	
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
69	155	BALLSCREW HOLE FACE REPAIR LEFT SIDE MATERIAL REMOVAL .080/.150 RECORD REQD FLANGE THICKNESS ON OPERATION 470 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	160	BALLSCREW CROSS PIN HOLE REPAIR (LEFT SIDE) MAX I.D. 1.900 RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	165	BALLSCREW CROSS PIN HOLE REPAIR (RIGHT SIDE) MAX I.D. 1.900 RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	170	CROSSWIND LUG HOLE REPAIR (LEFT SIDE) MAX I.D. 2.310 RECORD BASE METAL DIMENSION RECORD REQD FLANGE THICKNESS ON OPERATION 426 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	175	CROSSWIND LUG HOLE REPAIR (RIGHT SIDE) MAX I.D. 2.310 RECORD BASE METAL DIMENSION RECORD REQD FLANGE THICKNESS ON OPERATION 427 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	180	ROTATION LUG HOLE REPAIR (LEFT SET) MAX I.D. 2.210 RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	190	ROTATION LUG HOLE REPAIR (RIGT SET) MAX I.D. 2.210 RECORD BASE METAL DIMENSION (CONTINUED)		001 MNPRA 002 02 003 MH05 005 X8433672	

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
69	205	MANIFOLD LUG HOLE REPAIR (LEFT SIDE) MAX I.D. .500 *C/P MOVE		001 MN 002 02 003 BE	PRA 01
69	210	MANIFOLD LUG HOLE REPAIR (RIGHT SIDE) MAX I.D. .500 *C/P MOVE		001 MN 002 02 003 BE	PRA 01
[redacted]		TIME OUT ______ DATE OUT ______ *C/P MOVE * * * * * * * * N O T E * * * * * * * *	M	001 MN 002 06 003 TE	PNA 03
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
[redacted]		TIME OUT ______ DATE OUT ______ *C/P MOVE * * * * * * * * N O T E * * * * * * * *	M	001 MN 002 06 003 TE	PNA 03
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
[redacted]		TIME OUT ______ DATE OUT ______ *C/P MOVE * * * * * * * * N O T E * * * * * * * *	M	001 MN 002 06 003 TE	PNA 03
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
[redacted]		(IF MACHINED) TIME OUT ______ DATE OUT ______ (CONTINUED)	M	001 MN 002 06 003 TE	PNA 03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
[redacted]		TIME OUT ______ DATE OUT ______	M	001 MN 002 06 003 TE	PNA 03
		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
[redacted]		TIME OUT ______ DATE OUT ______	M	001 MN 002 06 003 TE	PNA 03
		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
[redacted]		TIME OUT ______ DATE OUT ______	M	001 MN 002 06 003 TE	PNA 03
		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
26B	250	BAKE 4 HRS AT 350 - 400F WITHIN 8 HRS OF ETCH DATE IN ______ TIME IN ______		001 MN 002 02 003 BK	PRC 01
		DATE OUT ______ TIME OUT ______ (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	257	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	260	SHOT PEEN GROUND SURFACE O D. INTENSITY OF .006/.010A *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	265	SHOT PEEN GROUND SURFACE LOWER BORE INTENSITY OF .006/.010A *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	270	SHOT PEEN REWORKED SURFACE COLLAR ID INTENSITY .006/.010A *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	275	SHOT PEEN GROUND SURFACE COLLAR FACE INTENSITY .006/.010A *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	280	SHOT PEEN REWORKED SURFACE UPPER BORE & DOME AREA. I.D. INTENSITY .006 TO .010A *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	285	SHOTPEEN ALL REWORKED AREAS INTENSITY .006/.010A *C/P MOVE		001 MNPRC 002 01 003 SP02	

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26 C	287	PREPARE CYLINDER O.D. FOR CHROME PLATE TYPE II CLASS III IAW MIL-STD-1501, MASK/FIXTURE/STC ~~MECHANIC SIGN OFF REQUIRED~~ *C/P MOVE		001 MNPRC 002 02 003 BE01 ~~005 X7402930~~	
26	288	PREPARE CYLINDER I.D. FOR CHROME PLATE. GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	290	CHROME PLATE CYLINDER O.D MIL-STD-1501 TYPE II CLASS 3 SUFFICIENT TO GRIND BACK TO 12.496/12.499 ~~(SEE PLATING DATA SHEET)~~ *NOTE: APPLY MIN AMOUNT OF CHROME DATE OUT_____TIME OUT_____ ~~MECHANIC SIGN OFF REQUIRED~~ *C/P MOVE		001 MNPRC 002 02 003 CP01 ~~005 X7432930~~ 003 CUC10	
263	300	BAKE 4 HRS AT 350 - 400F WITHIN 4 HRS OF CHROME DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
86	305	FINISH GRIND CYLINDER O.D. 12.496/12.499 32 RMS ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____*C/P MOVE		001 MNPRB 002 03 003 GG02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26B	307	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	309	PREPARE CYLINDER UPPER/LOWER BORES I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	310	PREPARE CYLINDER UPPER/LOWER BORE ID FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC. ~~MECHANIC SIGN OFF REQUIRED~~ *C/P MOVE		001 MNPRC 002 02 003 BE01 ~~005 X7A32502~~	
26	312	CHROME PLATE CYLINDER LOWER BORE I.D. TYPE II CLASS III SUFFICIENT TO GRIND TO 11.874/11.878 ~~(SEE PLATING DATA SHEET)~~ *NOTE: APPLY MIN AMOUNT OF CHROME DATE OUT _____ TIME OUT _____ ~~MECHANIC SIGN OFF REQUIRED~~ *C/P MOVE		001 MNPRC 002 02 003 CP01 ~~005 X7A32902~~ 008 CI010	
26	320	CHROME PLATE CYLINDER UPPER BORE I.D. TYPE II CLASS III SUFFICIENT TO GRIND TO 11.746/11.756 ~~(SEE PLATING DATA SHEET)~~ *NOTE: APPLY MIN AMOUNT OF CHROME DATE OUT _____ TIME OUT _____ (CONTINUED)		001 MNPRC 002 02 003 CP01 ~~005 X7A32902~~ 008 CI020	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE			
26B	325	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
8	330	FINISH GRIND CYLINDER UPPER BORE ID 11.746/11.756 32 RMS MAINTAIN 0.005 TIR WITH DIA "A" RECORD TIR		001 MNPRB 002 01 003 G101 005 X8745223	
		LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED		006 X8745223	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
8	335	FINISH GRIND CYLINDER LOWER BORE FINISH SIZE I.D. 11.874/11.878 32 RMS TO BE CONCENTRIC WITH DIA "A" WITHIN .005 TIR RECORD TIR		001 MNPRB 002 01 003 G101 005 X8745223	
		LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED		006 X8745223	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
8G	340	HONE LOWER BORE TO REMOVE DEFECTS LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 (CONTINUED)		001 MNPRB 002 03 003 HV04 005 X8745197	

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
8G	345	HONE UPPER BORE TO REMOVE DEFECTS LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 *C/P MOVE		001 MNPRB 002 03 003 HV04 005 X8745107	
26	346	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	347	PREPARE AREA "C" I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	348	PREPARE AREA "C" I.D. FOR CHROME PLATE TYPE II CLASS I MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED		001 MNPRC 002 02 003 BE01 005 X7851933	
26	350	CHROME PLATE AREA "C" I.D. TYPE II CLASS I SUFFICIENT TO GRIND TO 7.724/7.727 (NOTE: APPLY MIN AMOUNT OF CHROME		001 MNPRC 002 02 003 CP01 005 X7851933	
		(SEE PLATING DATA SHEET) DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED		008 CI030	
		*C/P MOVE			
26B	355	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	360	FINISH GRIND AREA "C" I.D. FINISH SIZE ID 7.724/7.727 32 RMS MAINTAIN 0.003 TIR WITH UPPER BORE RECORD TIR _____ RECORD WEAR .2in IF REWORK LIMITS ARE EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE		001 MNPRB 002 01 003 GP01	
26B	365	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	372	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		LATED AREAS *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	
26	378	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	380	CAD PLATE (SEE PLATING DATA SHEET) TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	385	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	395	IRIDITE CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE		001 MNPNA	
		*C/P MOVE ACCOMPLISHED PRIOR TO USING IVD OPTION.	M	002 06 003 ML04	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26	396	IVD PLATE (INITIATED BY PLATING) **NOTE** OPERATION 385 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION.		001 MNPRC 002 03 003 IV01	
26	400	ALODINE IVD AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]		MACHINE AREA "C" BUSHING P/N 4G14598-101A *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	410	AREA "C" I.D. BUSHING INSTALLATION P/N 4G14598-101A INSTALL PER 4S1-93-3 AND APPLICABLE SUPPLEMENTS (CONTINUED)		001 MNPRA 002 02 003 BE01	

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13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.004-.008 FIT *C/P MOVE			
69	415	CUT OFF AREA "C" BUSHING & CHAMFER 30 DEG. X .090 *C/P MOVE		001 MNPRA 002 02 003 MH05 ~~005 XB~~	
69	418	MACHINE UPPER END THRUST BEARING P/N 4013612-101A *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	419	UPPER END THRUST BEARING INSTALLATION P/N 4013612-101A. INSTALL WITH ~~MIL-C-16173D SEALING COMPOUND~~ RECORD REQD WASHER THICKNESS_____ REF OP 135 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	420	MACHINE UPPER END COLLAR BEARING *C/P MOVE P/N 4013611-103A OR ~~P/N 4014587-101A~~		001 MNPRA 002 02 003 LE02	
69	421	UPPER END COLLAR BEARING INSTALLATION P/N 4013611-103A OR P/N 4013597-101A PRESS FIT .0024-.0044 ~~INSTALL WITH SEALING~~ COMPOUND OR AA PER MIL-S-22463D RECORD REQD FLANGE THICKNESS_____ REF OP 130 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	422	MACHINE CROSSWIND LUG HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4013675-103A		001 MNPRA 002 02 003 LE02	
69	423	INSTALL CROSSWIND LUG HOLES (LEFT SIDE) P/N 4013675-103A RECORD REQD FLANGE THICKNESS (CONTINUED)		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		(UPPER) REF OP170 NOTE: FOR FLANGE THICKNESS OF LOWER BUSHING, MAINTAIN DIMENSION OF OVERALL 2.185/2.188 .0009-.0024 FIT.			
69	424	MACHINE CROSSWIND LUG HOLE BUSHINGS (LEFT SIDE) FINISH SIZE 1.624/1.626 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X84 22672	
69	426	MACHINE CROSSWIND LUG HOLE BUSHINGS (RIGHT SIDE) P/N 4613675-103A		001 MNPRA 002 02 003 LE02	
69	427	INSTALL CROSSWIND LUG HOLES (RIGHT SIDE) BUSHING 4613675-103A RECORD REQD FLANGE THICKNESS (UPPER) REF OP 175 NOTE: FOR FLANGE THICKNESS OF LOWER BUSHING, MAINTAIN DIMENSION OF OVERALL 2.185/2.188 .0009-.0024 FIT.		001 MNPRA 002 02 003 RE01	
69	428	MACHINE CROSSWIND LUG HOLE BUSHINGS (RIGHT SIDE) FINISH SIZE 1.624/1.626 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS (CONTINUED)		001 MNPRA 002 02 003 MH05 005 X84 22672	

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
B	430	FINISH GRIND AREA "C" BUSHING I.D. 7.724/7.727 16RMS. MAINTAIN 0.003 TIR WITH UPPER BORE. RECORD TIR _____		001 MNPRB 002 01 003 CP01	
		~~RECORD FINISH SIZE _____~~		~~005 XQ745100~~	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING ~~REWORK LIMITS _____ *C/P MOVE~~			
69	431	COLLAR O.D. BUSHING FINISH O.D. 9.440/9.445 OVERALL DIM 3.845/3.860		001 MNPRA 002 02 003 MH05	
		~~FOR FLANGED BUSHING 32 RMS TO BE~~		~~005 XQ~~	
		CONCENTRIC WITH DIA "C" WITHIN .003 TIR RECORD TIR _____ *C/P MOVE			
69	432	UPPER END THRUST BEARING FINAL MACHINE. RECORD REQD WASHER THICKNESS _____ REF OP 135		001 MNPRA 002 02 003 MH05	
		~~FINISH DISTANCE FROM TOP OF THRUST~~		~~005 XQ~~	
		WASHER TO FACE OF AREA "C" 2.660/2.670 32 RMS. RECORD WEAR DIM IF REWORK LIMITS ARE ~~EXCEEDED _____~~			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
69	433 *REQD*	CHECK & RECORD THE FOLLOWING DIMENSIONS: 1. COLLAR FACE TO TOP OF THRUST ~~WASHER 2.660/2.670~~		001 MNPRA 002 02 003 MH05	
		~~005 XQ~~		~~005 XQ~~	
		RECORD ACTUAL _____ 2. COLLAR FACE TO AREA "C" (CONTINUED)			

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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERPENDICULAR WITHIN .0005 INCH PER INCH (.004 MAX TIR). RECORD ACTUAL			
		3. TOP OF CROSSWIND BUSHINGS TO TOP OF THRUST WASHER 1.964/1.984 RECORD ACTUAL (LEFT) RECORD ACTUAL (RIGHT)			
		*C/P MOVE			
8	435	IF REWORKED CHECK CONCENTRICITY OF DIAMETER "C" TO DIAMETER "B". MAXIMUM 0.003 TIR. RECORD ACTUAL READING		001 MNPRB 002 01 003 GI01 005 X8745221	
		I.D. 7.724/7.727/7.729 WEAR *C/P MOVE		006 X8745223	
8	440	IF O.D. OR UPPER BORE WAS REWORKED CHECK CONCENTRICITY OF UPPER BORE I.D. TO DIA "A" MAXIMUM .005 TIR RECORD ACTUAL READING		001 MNPRB 002 01 003 GI01 005 X8745221	
		*C/P MOVE		006 X8745223	
8	445	IF O.D.OR LOWER BORE WAS REWORKED CHECK CONCENTRICITY OF LOWER BORE I.D. TO DIA "A" MAXIMUM OF .005 TIR RECORD ACTUAL READING		001 MNPRB 002 01 003 GI01 005 X8745221	
		*C/P MOVE		006 X8745223	
69	469	MACHINE BALL SCREW HOLE (LEFT SIDE) BUSHING *C/P MOVE P/N 4G13588-103A		001 MNPRA 002 02 003 LE02	

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13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	470	BALLSCREW HOLE (LEFT SIDE) BUSHING INSTALLATION P/N 4G13588-103A IF FACE WAS WORKED ~~BUSHING MUST HAVE FLANGE~~ IAW 4S1-93-3. RECORD REQD FLANGE THICKNESS_____REF OP 155 .0018/.0033 FIT.		001 MNPRA 002 02 003 BE01	
69	471	MACHINE BALLSCREW HOLE BUSHING (LEFT SIDE) FINISH SIZE 3.749/3.751 125 RMS ~~RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED~~_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE		001 MNPRA 002 02 003 MH05 ~~005 X8432672~~	
69	474	MACHINE BALLSCREW HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4G13588-103A		001 MNPRA 002 02 003 LE02	
69	475	BALLSCREW HOLE (RIGHT SIDE) BUSHING INSTALLATION P/N 4G13588-103A IF FACE WAS ~~WORKED, BUSHING MUST HAVE FLANGE IAW~~ 4S1-93-3. RECORD REQD FLANGE THICKNESS_____ REF OP 150 ~~.0018-.0032 FIT~~ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	476	MACHINE BALLSCREW HOLE BUSHING (RIGHT SIDE) FINISH SIZE 3.749/3.751 ~~125 RMS~~ RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ REWORK LIMITS_____ (CONTINUED)		001 MNPRA 002 02 003 MH05 ~~005 X8432672~~	

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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
69	478	MACHINE BALLSCREW CROSS PIN HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4013591-103A ~~P/N 4013672-103A~~		001 MNPRA 002 02 003 LE02	
69	480	INSTALL BALLSCREW CROSS PIN HOLES BUSHINGS (LEFT SIDE) P/N 4013591-103A P/N 4013672-103A ~~FINISH SIZE 1.600/1.602~~		001 MNPRA 002 02 003 BE01	
		INSTALL IAW 451-93-3 125 RMS .0009-.0024 FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	484	MACHINE BALLSCREW CROSS PIN HOLE BUSHINGS (RIGHT SIDE) *C/P MOVE P/N 4013591-103A ~~P/N 4013672-103A~~		001 MNPRA 002 02 003 LE02	
69	485	INSTALL BALLSCREW CROSS PIN HOLES BUSHINGS (RIGHT SIDE) P/N 4013591-103A P/N 4013672-103A ~~SIZE 1.600/1.602 125 RMS~~		001 MNPRA 002 02 003 BE01	
		.0009-.0024 FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		~~RECORD REASON & CAUSE FOR EXCEEDING~~ REWORK LIMITS *C/P MOVE			
69	488	MACHINE ROTATION LUG HOLE BUSHINGS (LEFT UPPER) *C/P MOVE P/N 4013385-103A (CONTINUED)		001 MNPRA 002 02 003 LE02	

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 4G13382-103A			
69	500	INSTALL ROTATION LUG HOLES (LEFT UPPER) BUSHINGS P/N 4G13385-103A P/N 4G13382-103A ~~.001-.0025 FIT~~		001 MNPRA 002 02 003 BE01	
69	502	MACHINE ROTATION LUG HOLE BUSHINGS (LEFT UPPER) FINISH SIZE 1.937/ 1.9385 125 RMS ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED..... RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS.....*C/P MOVE		001 MNPRA 002 02 003 MH05 ~~005 X8K32672~~	
69	504	MACHINE ROTATION LUG HOLE BUSHINGS (LEFT LOWER) *C/P MOVE P/N 4G13385-103A ~~P/N 4G13382-103A~~		001 MNPRA 002 02 003 LE02	
69	505	INSTALL ROTATION LUG HOLES (LEFT LOWER) BUSHINGS P/N 4G13385-103A P/N 4G13382-103A ~~.001-.0025 FIT~~		001 MNPRA 002 02 003 BE01	
69	507	MACHINE ROTATION LUG HOLE BUSHING (LEFT LOWER) FINISH SIZE 1.937/ ~~1.~~9385 125 RMS ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED..... RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS.....*C/P MOVE		001 MNPRA 002 02 003 MH04 ~~005 X8K32672~~	
69	509	MACHINE ROTATION LUG HOLE BUSHINGS (RIGHT UPPER) *C/P MOVE P/N 4G13385-103A ~~P/N 4G13382-103A~~		001 MNPRA 002 02 003 LE02	
69	510	INSTALL ROTATION LUG HOLES (RIGHT UPPER BUSHINGS P/N 4G13385-103A P/N 4G13382-103A (CONTINUED)		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21001N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 26 OF ___ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.001-.0025 FIT			
69	512	MACHINE ROTATION LUG HOLE BUSHING (RIGHT UPPER) FINISH SIZE 1.937/ 1.9385 125 RMS		001 MNPRA 002 02 003 MH05	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE		005 X8[illegible]	
69	514	MACHINE ROTATION LUG HOLE BUSHINGS (RIGHT LOWER) *C/P MOVE P/N 4G13385-103A P/N 4G13382-103A		001 MNPRA 002 02 003 LE02	
69	515	INSTALL ROTATION LUG HOLES (RIGHT SIDE) BUSHINGS P/N 4G13385-103A P/N 4G13382-103A .001-.0025 FIT		001 MNPRA 002 02 003 BE01	
69	516	MACHINE ROTATION LUG HOLE BUSHINGS (RIGHT LOWER) FINISH SIZE 1.937/ 1.9385 125 RMS		001 MNPRA 002 02 003 MH05	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE		005 X8[illegible]	
69	519	MACHINE MANIFOLD LUG HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4G13673-103A		001 MNPRA 002 02 003 LE02	
69	520	MANIFOLD LUG HOLES (LEFT SIDE) BUSHINGS P/N 4G13673-103A FINISH I.D. .323/.326 125 RMS .0004-.0019 FIT		001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21001N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 27 OF 27 PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		REWORK LIMITS _____ *C/P MOVE			
69	524	MACHINE MANIFOLD LUG HOLE BUSHINGS (RIGHT SIDE) *C/P MOVE P/N 4G13673-103A		001 MNPRA 002 02 003 LE02	
69	525	MANIFOLD LUG HOLES (RIGHT SIDE) BUSHINGS P/N 4G13673-103A FINISH I.D. .323/.326 125 RMS .009"-.0019" FIT		001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
[redacted]	540	DEGREASE & SEAL BUSHING FLANGES *C/P MOVE		001 MNPGP 002 01 003 BE01	
[redacted]	545	PAINT & DECAL AS REQUIRED IAW 4S-1-182 AND 4S1-93-3 *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	550 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS *55		001 MNPGP 002 01 003 MU06	
[redacted]	555 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21002N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89107 | PAGE 1 OF __ PAGES

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

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

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		AF DWG 7926446 4S-1-182 4S1-93-3 AND SUPPLEMENTS
13. SERIAL NUMBER	**14 NOUN**	
	INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G1141	4-107A	NSN 1620004176249 C/N 74626A 17576A 17577A			
		17578A 17575A 17687A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949 P/O N01541			
		BAKE IAW 4S-1-182 MAOI 74-12			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		CHROME PLATE IAW MIL-STD-1501 P/O N61891 & P/O N41331		"D"	
		GRIT BLAST IAW MIL-STD-1504			
		CAD PLATE IAW MIL-STD-870 TYPE II CLASS II			
		BRUSH NICKLE PLATE IAW MIL-STD-865			
		FPI IAW MIL-STD-6866			
		STRIP CHROME IAW MIL-STD-871			
		IVD PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		*****300 M 280,000-300,000 KSI*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 2 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP			
	001	4G11414-107A 7926445 7926446			
34C5	005 *REQD*	DISASSEMBLE/REMOVE BUSHINGS *C/P MOVE		001 MNPGP 002 01 003 SL03	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
34B	011 *REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 3 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE	M	001 MNPGW 002 05 003 ML01	
	REQD				
34E	030 *REQD*	E AND I CYLINDER O.D. 10.994-10.997 WEAR 10.992 CYLINDER I.D. (STD) 10.176-10.181			
		WEAR 10.186 (1ST O/S) 10.190-10.195 WEAR 10.200 (2ND O/S) 10.205-10.210			
		WEAR 10.215 LARGE ATTACH BUSHING I.D. 10.008-10.014 WEAR 10.018 RECORD BASE METAL DIM. _____			
		SMALL ATTACH BUSHING I.D. 6.008-6.014 WEAR 6.018 RECORD BASE METAL DIM. _____ SMALL LUG OVERALL THICKNESS 1.75 MIN			
		POSITIONER LUG I.D. .6245-.6280 WEAR .640 RETAINER GROOVE I.D. 10.575-10.583			
		WEAR 10.585 METERING PIN BUSHING 4.494-4.496 WEAR 4.500			
		BASE METAL 4.674-4.724 RECORD BASE METAL DIM. _____ I.D. SPLINES 10.285-10.290			
		MAX. 10.295 **********NOTE********** CYLINDERS WITH MORE THAN .003 OF CHROME ON THE I.D. DIAMETER			
		(.0015 PER SIDE) WILL REQUIRE STRIP. NOTE: A MINIMUM OF TWO FMPI (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 4 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		OPERATIONS REQUIRED ON THIS PART. *C/P MOVE			
34E	040	HAND POLISH CYL ID TO REMOVE DEFECTS STD. 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215		001 MNPGW 002 04 003 EI01	
		16RMS 25.500 FROM TOP OF CYL 4-12RMS 25.500/38.000 FROM TOP OF CYLINDER IF NO REWORK IS REQUIRED RECORD DIMENSION_____			
		*C/P MOVE			
26	044	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	046	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	048	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	050	LARGE ATTACH LUG HOLE REPAIR MAXIMUM SIZE 10.470 RECORD BASE METAL DIMENSION_____ *C/P MOVE		001 MNPRA 002 02 003 MH05	
69	060	SMALL ATTACH LUG HOLE REPAIR MAXIMUM SIZE 6.480 RECORD BASE METAL DIMENSION_____ *C/P MOVE		001 MNPRA 002 02 003 MH05	
69	070	MACHINE SMALL ATTACH FACE TO REMOVE CORROSION 1.75 MIN LUG THICKNESS *C/P MOVE		001 MNPRA 002 02 003 MH05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89107 | PAGE 5 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
29	080	POSITIONER LUG REPAIR MAXIMUM SIZE .750 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	090	SECOND REPAIR METERING PIN HOLE MACHINE FOR BUSHING IAW T.O 4S1-93-3 4.674 MIN. 4.724 MAX. CONCENTRIC TO DIA A WITHIN .003 TIR RECORD TIR		001 MNPRA 002 02 003 MH05	
		RECORD BASE METAL DIMENSION_____ *C/P MOVE			
26	095	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	100	STRIP CHROME FROM CYLINDER O.D. REVERSE CURRENT METHOD ONLY *C/P MOVE		001 MNPRC 002 02 003 SC02	
26	110	STRIP CHROME FROM CYLINDER I.D. REVERSE CURRENT METHOD ONLY & RETURN TO E & I (STATION 34E) FOR CONDITION CHECK OF I.D. *C/P MOVE		001 MNPRC 002 02 003 SC02	
34E	120	CONDITION CHECK & MIC CYL I.D. STD. 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215		001 MNPGW 002 04 003 EI01	
		RECORD DIMENSION_____ *C/P MOVE			
86	130	FIRST GRIND CYLINDER OD FOR CHROME MIN OD 10.982 TO BE CONCENTRIC TO DIA. A WITHIN .003 TIR RECORD TIR RECORD BASE METAL DIMENSION		001 MNPRB 002 03 003 GG02 005 X8745207	
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 6 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8G	140	FIRST GRIND CYLINDER OD UPPER BRG SURFACE MIN DIA 10.975 TO BE CONCENTRIC TO I.D. WITHIN .003 TIR RECORD TIR_____		001 MNPRB 002 03 003 GB02 005 X8745207	
		RECORD BASE METAL DIMENSION_____ *C/P MOVE			
8G	150	HONE I.D. AS REQUIRED TO CLEAN-UP 10.176-10.181-10.184 STANDARD 10.188-10.198 1ST OVERSIZE 10.203-10.213 2ND OVERSIZE		001 MNPRB 002 03 003 HV04 005 X8745197	
		32 RMS 25.0-38.0 FROM OPEN END 32 RMS ABOVE SEAL AREA RECORD FINAL DIMENSION_____ ***NOTE: SEAL AREA MUST BE DEFECT			
		FREE-LOCAL REWORK ABOVE & BELOW SEAL AREA *C/P MOVE			
8	160	GRIND I.D. AS REQUIRED TO CLEAN-UP 10.176-10.181-10.184 STANDARD 10.188-10.198 1ST OVERSIZE 10.203-10.213 2ND OVERSIZE		001 MNPRB 002 01 003 GI01 005 X8745225	
		32 RMS 25.0-38.0 FROM OPEN END 32 RMS ABOVE SEAL AREA RECORD FINAL DIMENSION_____ ***NOTE: SEAL AREA MUST BE DEFECT		006 X8745227	
		FREE-LOCAL REWORK ABOVE & BELOW SEAL AREA *C/P MOVE			
		[redacted] REWORKED AREAS AS NECESSARY. DATE OUT_____TIME OUT_____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | DATE 89107 | PAGE 7 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * * * * * * * * * * * * * *			
26B	180	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
8G	190	POLISH I.D. TO REMOVE BURN INDICATION RECORD BASE METAL DIMENSION_____ *C/P MOVE		001 MNPRB 002 03 003 BE01	
[redacted]		CH I.D. AFTER HONE DATE OUT_____TIME OUT_____ *C/P MOVE * * * * * * * * N O T E * * * * * * * *	M	001 MNPNA 002 06 003 TB03	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26B	210	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT. *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 8 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	225	VAPOR DEGREASE *C/P MOVE		001 MN 002 03 003 DG	PRC 01
26	230	SHOT PEEN GROUND SURFACE CYL O.D. .008-.012 A2 *C/P MOVE		001 MN 002 01 003 SP	PRC 02
26	240	SHOT PEEN GROUND SURFACE CYL UPPER END O.D. .008-.012 A2 *C/P MOVE		001 MN 002 01 003 SP	PRC 02
26	250	SHOT PEEN CYL I.D. .008-.012 A2 *C/P MOVE		001 MN 002 01 003 SP	PRC 02
26	260	SHOT PEEN REWORKED SURFACE METERING PIN BORE .008-.012 A2 *C/P MOVE		001 MN 002 01 003 SP	PRC 02
26	270	SHOT PEEN ALL OTHER REWORKED AREAS .008-.012 A2 *C/P MOVE		001 MN 002 01 003 SP	PRC 02
26	280	PREPARE CYLINDER O.D./UPPER O.D. FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED--------- *C/P MOVE		001 MN 002 02 003 BE 005 XR	PRC 01 412360
26	290	BLAST CYL OD USING 80 - 180 GRIT ALUM OXIDE OR GARNET *C/P MOVE		001 MN 002 01 003 BL	PRC 02
26	300	BLAST-CYL UPPER O.D. USING 80-180 GRIT ALUM OXIDE OR GARNET *C/P MOVE		001 MN 002 01 003 BL	PRC 02

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

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21002N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89107

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	310	VAPOR DEGREASE/HAND CLEAN O.D. AREAS FOR CHROME PLATE *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	320	CHROME PLATE CYLINDER O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 10.994/10.997		001 MNPRC 002 02 003 CR01 005 X8412360	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED--------> *C/P MOVE		008 CQ010	
26	330	CHROME PLATE UPPER END O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 10.998/10.990		001 MNPRC 002 02 003 CR01 005 X8412360	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED--------> *C/P MOVE		008 CQ020	
26B	340	BAKE 4 HRS AT 350-400F.WITHIN 4HRS OF CHROME DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	345	RE-SHOTPEEN CYLINDER I.D. IF REQUIRED .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
8G	350	HONE CYLINDER I.D. AFTER SHOTPEEN STANDARD 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215		001 MNPRB 002 03 003 HV04 005 X8745187	
		10 RMS 25.5-38.0 FROM OPEN END 16 RMS ABOVE SEAL AREA IF MORE THAN .0024 MATERIAL WAS (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 10 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		REMOVED FROM THE I.D.(SEE OPERATION 120 OR 160 FOR READING) OR I.D. DOES NOT CLEAN-UP, CYLINDER MUST BE RE-SHOTPEENED & RE-HONED ON AN OVERLAY			
		RECORD RMS IN SEAL AREA_____ RECORD RMS ABOVE SEAL AREA_____ RECORD FINAL DIMENSION_____ *C/P MOVE			
26	355	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG02	
26	358	PREPARE I.D. FOR CHROME PLATE IAW P/O N41321, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED--------->		001 MNPRC 002 02 003 BB01 005 X7831900	
26	360	CHROME PLATE I.D. .0004/.0007 RECORD MEASURED THICKNESS_____ DATE OUT_____TIME OUT_____		001 MNPRC 002 02 003 CP01 005 X7831900	
		MECHANIC SIGN OFF REQUIRED---------> *C/P MOVE		008 CI010	
26B	370	BAKE 4 HRS AT 350 TO 400 F WITHIN 4 HRS OF CHROME DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
8G	380	REIDENTIFY IAW DWG 7926446 STAMP -30 (1ST O/S) -50 (2ND O/S) RECORD ACTUAL DIMENSIONS_____ *C/P MOVE		001 MNPRB 002 03 003 BB01	
8G	390	FINISH GRIND CYLINDER O.D. 10.994/ 10.997 16RMS TO BE CONCENTRIC TO I.D. WITHIN (CONTINUED)		001 MNPRB 002 03 003 GG02 005 X8745207	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002 **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 1 OF ___ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.003 TIR RECORD TIR_____ RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING			
		REWORK LIMITS_____ *C/P MOVE			
8G	400	FINISH GRIND UPPER END O.D. FINISH DIA 10.988/10.990 16RMS TO BE CONCENTRIC TO I.D. WITHIN .003 TIR RECORD TIR_____		001 MACHINE 002 GR 003 GRIND 005 VISUAL	
		*C/P MOVE			
8G	410	VISUAL INSPECT CYL I.D. AFTER CHROME FOR DEFECTS & RMS. 12 RMS IN SEAL AREA 24 RMS ABOVE SEAL AREA. RECORD RMS IN SEAL AREA_____		001 MACHINE 002 GR 003 BENCH	
		RECORD RMS ABOVE SEAL AREA_____ IF DEFECTIVE INITIATE OPERATION 420 *C/P MOVE			
8G	420	HONE CYLINDER I.D. STANDARD 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215		001 MACHINE 002 GR 003 HONE 005 VISUAL	
		12 RMS 25.5-38.0 FROM OPEN END 24 RMS ABOVE SEAL AREA RECORD RMS IN SEAL AREA_____ RECORD RMS ABOVE SEAL AREA_____			
		RECORD FINAL DIMENSION_____ *C/P MOVE			
26B	430	BAKE 4 HRS AT 350 TO 400F DATE IN_____ TIME IN:_____ DATE OUT_____ TIME OUT_____ (CONTINUED)		001 MANUAL 002 GR 003 BENCH	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	2100
		B	D	

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDT OPERATION IS COMPLETED*	M	001 MNPW 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT. *			
26	445	VAPOR DEGREASE *C/P MOVE		001 MNPW 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDT OPERATION IS COMPLETED*	M	001 MNPW 002 06 003 ZS01	
		HERE, TAKE PRODUCTION COUNT. *			
26	455	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPW 002 03 003 BP01	
26	460	CAD PLATE O.D. TIME OUT_____ DATE OUT_____ *C/P MOVE		001 MNPW 002 03 003 CP01	
26P	470	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN_____ TIME IN_____		001 MNPW 002 03 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

21002N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89107 | PAGE 13 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	490	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 03 003 IR01	
[redacted]		OMPLISH PRIOR TO IVD OPTION *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT *			
26	501	IVD PLATE (INITIATED BY PLATING) **NOTE** IF CHROME REWORK WAS DONE OPERATION 470 MUST BE ACCOMPLISHED PRIOR TO IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	502	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	509	MACHINE METERING PIN HOLE BUSHING *C/P MOVE P/N 7926422-01		001 MNPRA 002 03 003 LE03	
69	510	METERING PIN HOLE INSTALL BUSHING P/N 7926422-01 & PACKING P/N ARP568-047 IAW T.O. 4S1-93-3. ALLOW SUFFICIENT MATERIAL		001 MNPRA 002 03 003 BE01	
		ON ID TO GRIND TO 4.494/4.496. .004-.006 SHRINK FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
8	520	FINISH GRIND METERING PIN BUSHING ID 4.494/4.496 32 RMS TO BE CONCENTIC TO DIA A WITHIN (CONTINUED)		001 MNPRB 002 01 003 GR01 005 XR745180	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMEN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

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

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

13. SERIAL NUMBER	14. NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.003 TIR RECORD TIR_____ RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING			
		REWORK LIMITS_____ RECORD CRITICAL DEMENSION_____ *C/P MOVE			
26BP	530	BRUSH PLATE ID OF METERING PIN HOLE BUSHING USING NICKEL TUNGSTEN OR NICKEL COBALT *C/P MOVE		001 MNPRC 002 02 003 BP01	
34C5	535	PRESSURE CHECK INNER CYL IAW TEST PROCEDURES IN T.O. 4S1-93-3 RECORD LEAKAGE 1ST HOUR RECORD LEAKAGE 4TH HOUR		001 MNPGP 002 01 003 PA07 004 PA0001	
69	538	MACHINE LARGE ATTACH BEARING *C/P MOVE P/N 4G13490-109A		001 MNPRA 002 02 003 LE03	
69	540	LARGE ATTACH BEARING INSTALLATION P/N 4G13490-109A .004-.006 FIT RECORD WEAR DIM IF REWORK LIMITS ARE		001 MNPRA 002 02 003 BE01	
		EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
69	542	MACHINE LARGE ATTACH BEARING FINISH SIZE 10.008/10.014 *C/P MOVE		001 MNPRA 002 02 003 MH05	
69	548	MACHINE SMALL ATTACH BEARING *C/P MOVE P/N 4G13491-103A		001 MNPRA 002 02 003 LE03	
69	550	SMALL ATTACH BEARING INSTALLATION P/N 4G13491-103A FINISH SIZE 6.008/6.014 .001-.003 FIT (CONTINUED)		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
69	551	MACHINE SMALL ATTACH BEARING FINISH SIZE 6.008/6.014 *C/P MOVE		001 MNPRA 002 02 003 MH05	
69	559	MACHINE POSITIONER LUG BUSHING *C/P MOVE P/N 4G14604-101A		001 MNPRA 002 02 003 LB02	
69	560	POSITIONER LUG BUSHING INSTALLATION INSTALL IAW 4S1-93-3. FINISH SIZE .6245/.628 P/N4G14604-101A .0005-.001 PRESS FIT		001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
34A	570	DEGREASE *C/P MOVE		001 MNPGP 002 06 003 ML01	
34P	600	PAINT IAW 4S-1-182 & 4S1-93-3 DECAL AS REQUIRED *C/P MOVE		001 MNPGP 002 09 003 WB03	
34 C5	610 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 ML06	
34 C5	620 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 ML06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

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

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

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

17575A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
					6
		1620001164434 17576A			7
					8

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	148

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

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

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

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

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

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
			09027	3

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]					
[redacted]					
9	060	FIRST GRIND CHART FOR CHROME MINIMUM			
		GRIND SIZE O.D. 3.1925		002 02	
[redacted]		MOVE		002 02 1	
				001 [illegible]	
		TIME OUT _____ PIECE OUT _____	M	002 02	
		MOVE MOVE		003 [illegible]	
		* * * * * * * * * * * * * * * * * * * *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A [illegible] PRODUCTION CONT [illegible]	C	
		B	D	[illegible] 150

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1 DATE	PAGE__OF__PAGES

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

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

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

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

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	230	FINISH GRIND SHAFT CHROME SURFACE			

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

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

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

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

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

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

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1 DATE	PAGE__OF__PAGES

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

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

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

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

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

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21006N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89037 | PAGE 1 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		4S-1-182 AND SUPPLEMENTS 451-93-3
13. SERIAL NUMBER	**14 NOUN**	
	LOWER DRAG SHAFT	

17575A
6
7
8

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
P/N 4G1353[illegible]9-101A		NSN 1620001164435 C/N 17575A **17576A** ~~17577A~~ 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949 ~~P/O N01561~~			
		STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 ~~SHOT PEEN IAW MIL-S-13165~~			
		CHROME PLATE IAW MIL-STD-1501 TYPE II CLASS III P/O N61891 CAD PLATE IAW MIL-STD-870 ~~FPI IAW MIL-STD-6866~~			
		BAKE IAW 4S-1-182 MAOI 74-12 IVD PLATE IAW MIL-C-83488A ~~ALODINE IAW MIL-C-5541~~			
		300 M 280,000-300,000 KSI ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT ~~HAVE BEEN THOROUGHLY TRAINED AND ARE~~ FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND ~~T.O. SUPPLEMENTS REFERENCED IN BLOCK~~ 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH ~~THIS DOCUMENT.~~ COMPONENTS WILL BE THOUROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

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21006N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	LOWER DRAG SHAFT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4013539-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]		E AND I INSPECTION		001 MNPGW	
				002 04	
	REQD	SHAFT OD 4.4965/4.4975 WEAR 4.4955		003 EI01	
		~~NOTE: A MINIMUM OF TWO FMPI'S~~ ARE REQUIRED ON THIS PART. *C/P MOVE			
26	035	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	040	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	045	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	050	STRIP CHROME FROM SHAFT *C/P MOVE		001 MNPRC 002 02 003 SC02	
8	060	FIRST GRIND SHAFT FOR CHROME MINIMUM GRIND SIZE O.D. 4.4815 *C/P MOVE		001 MNPRB 002 02 003 GE01	
[redacted]			M	001 MNPNA 002 06 003 TE03	
		TIME OUT_____DATE OUT_____ *C/P MOVE			
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	080	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH		001 MNPRC 002 02 003 BK01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 4 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	LOWER DRAG SHAFT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____			
[redacted]		*C/P MOVE		001 MNPNA	
		* * * * * * * * N O T E * * * * * * * * * IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
26 E	095	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26 E	100	SHOTPEEN SHAFT FOR CHROME INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26 E	103	PREPARE SHAFT FOR CHROME PLATE MASK/FIXTURE/ETC *C/P MOVE MECHANIC SIGN OFF REQUIRED--------->		001 MNPRC 002 02 003 BE01	
26 E	107	PREPARE SHAFT FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 E	110	CHROME PLATE SHAFT SUFFICIENT TO GRIND BACK TO 4.4965/4.4975 . DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED---------> *C/P MOVE		001 MNPRC 002 02 003 CP01 004 CQ010	
26E	120	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21006N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER DRAG SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20 "Q"
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
8	130	FINISH GRIND SHAFT FINISH DIAMETER O.D. 4.4965/4.4975 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE		001 MNPRB 002 02 003 GE01	
26B	140	BAKE 4 HRS AT 350F TO 400F DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	155	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 6 OF __ PAGES

2 J G ORDER NO	3 QUANTITY	4 PRODUCTION SEC RCC	5 DATE SCHED	6 DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	**14 NOUN**	
	LOWER DRAG SHAFT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	165	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	170	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
263	180	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD. DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	185	CHROMATE CONVERSION COATING (IRIDITE) *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	191	IVD PLATE (INITIATED BY PLATING) NOTE**OPERATION 180 MUST BE ACCOMPLISHED PRIOR TO IVD OPTION IF CHROME PLATE WAS DONE *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	192	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	160

AFLC FORM 958 NOV. 81 PREVIOUS EDITION WILL BE USED

21006N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89037

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER DRAG SHAFT

15. DISPATCH STATION	16. PERF R C %	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]	193	DEGREASE & PREPAINT *C/P MOVE		001 MNPGP 002 09 003 PP01	
[redacted]	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	16

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE	PAGE 1 OF __ PAGES
89037	

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

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-99-3 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
CSA MAIN		74644A 17575A

13 SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4013413-101A		NSN C/N N.S.L. 74644A 17575A ~~17576A~~ 17577A 17578A			
		******** UNIT COST: $10,815.00***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-I-6868 P/O N01561 GRIND IAW MIL-STD-868 ~~SHOT PEEN IAW MIL-S-13165~~ CAD PLATE IAW MIL-STD-870 NICKEL PLATE IAW MIL-STD-868 P/O N62541 ~~PHOSPHATE TREATMENT IAW TOD-P-16232~~ P/O N73061 DRY FILM LUBE IAW MIL-L-46010 TEMPER ETCH IAW MIL-STD-867 ~~BAKE IAW 4S-1-182~~ IAW MAOI-74-12 BLAST IAW MIL-STD-1504			
		~~*****MAT'L: 300M (280/300 KSI)*****~~			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT ~~HAVE BEEN THOROUGHLY TRAINED AND ARE~~ FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	162

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037 | PAGE 2 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* COMPONENTS WILL BE THOUROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4612432-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	[redacted] *REQD*	DEGREASE ONLY *C/P MOVE		001 MNPGW 002 02 003 DG02	
[redacted]	[redacted] *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	[redacted] *REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 3 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ML04	
8	025 *REQD*	CHECK SEAL GROOVE O.D. BEARING AREA O.D. FOR CONCENTRICITY. TO BE WITHIN .004 TIR RECORD READING _____ *C/P MOVE		001 MNPRB 002 03 003 GE05	
8	026 *REQD*	CHECK BEARING AREA O.D. TO SPLINES ACROSS .3840 PINS FOR CONCENTRICITY IAW DRWG 4613413 TO BE WITHIN .006 TIR. RECORD READING _____ *C/P MOVE		001 MNPRB 002 03 003 GE05	
[redacted]	*REQD*	E & I INSPECTION NOTE: IF CONCENTRICITY CHECK (025) EXCEEDS .004 TIR - ROUTE FOR REPAIR. NOTE: IF CONCENTRICITY CHECK (026) EXCEEDS .006 TIR - NOTIFY PLANNING FOR DISPOSITION. SPLINE O.D. 7.735/7.740 ACROSS 0.4800 ROLL PINS SERVICE LIMIT 7.728 SPLINE O.D. 8.988/8.994 ACROSS 0.3840 ROLL PINS SERVICE LIMIT 8.980 SEAL GROOVE O.D. 7.244/7.247 WEAR 7.242 RECORD BASE METAL DIMENSION _____ SEAL GROOVE WIDTH .579/.589/.750 BEARING SURFACE OD 7.720/7.722/7.718 (CONTINUED)		001 MNPGW 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 4 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		RECORD BASE METAL DIM. *C/P MOVE*			
26	035	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	040	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	045	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	050	RECENTER ENDS *C/P MOVE		001 MNPRA 002 02 003 LE07	
69	060	NICK AND BURR REPAIR AS NECESSARY *C/P MOVE		001 MNPRA 002 02 003 BE01	
8	070	FIRST GRIND SEAL GROOVE MIN DIAMETER O.D. 7.220, MAX WIDTH .750. MAINTAIN CONCENTRICITIES. ~~RECORD BASE METAL DIMENSION~~ *C/P MOVE		001 MNPRB 002 03 003 GE05	
[redacted]		TIME OUT_____DATE OUT_____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	

21007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 5 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * * * * * * * * * * * * * *			
26B	090	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
		* * * * * * * * * * * * * * * * * * * *			
26	103	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	105	GRIT BLAST SPLINES TO REMOVE MINOR CORROSION/RIDGES NOT EXCEEDING .010 DEPTH *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	107	SHOT PEEN SPLINES THAT HAVE BEEN GRIT BLASTED. SHOT PEEN .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	110	SHOT PEEN SEAL AREA AFTER NICK AND BURR .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	112	SHOT PEEN SEAL GROOVE .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 6 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	120	PREPARE SEAL GROOVE FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	125	PREPARE SEAL GROOVE FOR NICKEL PLATE, MASK/FIXTURE/ETC.		001 MNPRC 002 03 003 BE01 005 X7732159	
26	130	SULPHAMATE NICKEL PLATE SEAL GROOVE TYPE II SUFFICIENT TO GRIND BACK TO 7.244/7.247 WIDTH .579/.750		001 MNPRC 002 03 003 NP01 005 X7732159	
		TIME OUT_____ DATE OUT_____ *C/P MOVE		008 NO010	
26B	140	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF NICKLE PLATE DATE IN:_____ TIME IN:_____		001 MNPRC 002 02 003 BK01	
		DATE OUT:_____ TIME OUT:_____ *C/P MOVE			
8	160	FINISH GRIND SEAL GROOVE FINISHED DIAMETER OD 7.244/7.247. WIDTH OF GROOVE .579/.750. MAINTAIN CONCENTRICITY OF .004 TO BEARING AREA O.D. 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ RECORD CRITICAL DIMENSION_____ *C/P MOVE		001 MNPRB 002 03 003 GE05	
8	170	CHAMFER EDGES OF SEAL GROOVE .040-.050 X 43-47DEGREES IF NOT PREVIOUSLY ACCOMPLISHED *C/P MOVE		001 MNPRB 002 03 003 GE05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 7 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26B	189	BAKE 4 HRS AT 350/400 F TIME IN_____DATE IN_____		001 MNPRC 002 02 003 BK01	
		TIME OUT_____DATE OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	193	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	197	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	200	CAD PLATE UPPER END AND UPPER END THREADS AND SEAL GROOVE FACES IF IF NICKLE PLATE IS NOT PRESENT TYPE II CLASS II		001 MNPRC 002 03 003 CA01	
		TIME OUT_____DATE OUT_____ *C/P MOVE			
26B	210	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD DATE IN:_____TIME IN:_____		001 MNPRC 002 02 003 BK01	
		DATE OUT:_____TIME OUT:_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 8 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26B	217	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26M	218	PRIOR TO PHOSPHATE, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	220	PHOSPHATE TREATMENT TYPE "M" ALL EXTERIOR SURFACES EXCEPT THREADS & SEAL GROOVE. *C/P MOVE		001 MNPRC 002 03 003 PH01	
26B	230	BAKE FOR 8 HRS AT 210F TO 225F DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK02	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	240	DRY FILM LUBE EXTERIOR PHOSPHATED AREA ONLY *C/P MOVE		001 MNPRC 002 03 003 EL01	
26B	250	BAKE FOR ONE HOUR AT 400F IAW MIL-L-46010 DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK02	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21007N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89037 | PAGE 9 OF 9 PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	270	CHROMATE CONVERSION COATING (IRIDITE) *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]	280 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	290 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	
		721			
		install			
		end cap			
		OCC RCC 1.00			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21009N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO
	4S-1-182 ~~4S1-99-2~~ AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		
13. SERIAL NUMBER	**14 NOUN**	
	UPPER SIDE BRACE ARM	

17575A 6 7 8

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20.
P/N 4011436-107A		NSN 1620001157388 C/N 17575A **17576A** ~~17577A~~ 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504 ~~FMPI IAW MIL-STD-1949~~ P/O N01561			
		SHOT PEEN IAW MIL-S-13165 CAD PLATE IAW MIL-STD-870 ~~BAKE IAW 4S-1-182~~ MAOI 74-12			
		TEMPER ETCH IAW MIL-STD-867 ALODINE IAW MIL-C-5541 ~~IVD PLATE IAW MIL-C-83488A~~			
		****MAT'L STEEL 280-300 KSI 300M**** ****COST = $4235.36**** ALL PERSONNEL INVOLVED IN THE WORK ~~PROCESSES SPECIFIED IN THIS DOCUMENT~~ HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN ~~THE BASIC TECHNICAL ORDER (T.O.) AND~~ T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE APPLICABLE T.O.'S AND SUPPLEMENTS ~~WILL ALWAYS BE USED IN CONJUNCTION~~ WITH THIS DOCUMENT. * COMPONENTS WILL BE THOUROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR ~~MOVES BETWEEN OPERATIONS/DISPATCH~~ STATIONS. WARNING MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-164

21009N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 2 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	UPPER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4611436-107A			
[redacted]	005 *REQD*	DISASSEMBLE/REMOVE ALL BUSHINGS 100% REQUIRED DUE TO CORROSION.		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21009N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 | PAGE 3 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	UPPER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E AND I INSPECTION.		001 MNPGW 002 04	
	REQD	BASE LUG ID 3.1995/3.2025/3.2045 WEAR FACE TO FACE 8.243/8.247/8.249 WEAR APEX LUG ID 2.9995/3.0025/3.0045 WEAR FACE TO FACE 6.212/6.215/6.217 WEAR OVERALL 9.475/9.465/9.463 WEAR *NOTE: A MINIMUM OF 2 FMPI OPERATIONS MUST BE ACCOMPLISHED. *C/P MOVE		003 EI01	
[redacted]		NICK AND BURR REPAIR. *C/P MOVE			
26	022	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	024	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	026	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	030	BASE LUG HOLE REPAIR. LINE BORE MAX ID FOR SPARE BUSH 3.488 MAX ID FOR SPECIAL BUSH 3.570 -.694 MIN. WALL *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X8633673	
69	035	BASE LUG FACE REPAIR MIN 1.41 *C/P MOVE		001 MNPRA 002 03 003 MH04 004 X8633673	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—646-163

21009N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 4 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	UPPER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
69	040	APEX LUG HOLE REPAIR LINE BORE MAX ID FOR SPACER BUSH 3.289 MAX ID FOR SPECIAL BUSH 3.370 .6515 MIN. WALL *C/P MOVE		001 MNPRA 002 03 003 MH04 005 XR33673	
69	045	APEX LUG FACE REPAIR MIN 1.33 *C/P MOVE		001 MNPRA 002 03 003 MH04 005 XR33673	
		[redacted]ALL REWORKED AREAS TIME OUT ____ DATE OUT ____ *C/P MOVE * * * * * * * N O T E * * * * * * *	M	001 MNPNA 002 06 003 TE03	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
26B	047	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH TIME IN ____ DATE IN ____ TIME OUT ____ DATE OUT ____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
		[redacted] *C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	049	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	050	SHOT PEEN ALL REWORKED AREAS .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	

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AFLC FORM 956 NOV 80 PREVIOUS EDITION WILL BE USED

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	16

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21009N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89040 PAGE 5 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	UPPER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	051	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	052	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	053	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD PLATE. DATE IN: _____ TIME IN: _____	M	001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	054	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	056	IVD PLATE(INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	057	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IV01	
69	078	**MACHINE BASE LUG BUSHING** P/N 4013533-103A		001 MNPRA 002 02 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	175

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21009N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 6 OF 6 PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	UPPER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	080	BASE LUG BUSHING INSTALLATION. BRUSH CAD & INSTALL WITH MIL-C-16173D. FINISHED BUSHING DIA. ~~ID 3.1995/3.2025~~		001 MNPRA 002 02 003 BE01	
		FACE TO FACE FLANGED BUSHING 8.243/8.247. OVERALL EACH LUG 1.490/1.505 63RMS ~~*C/P MOVE~~			
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
69	088	MACHINE APEX LUG BUSHING *P/N 4G13534-103A*		001 MNPRA 002 02 003 LE02	
69	090	APEX LUG BUSHING INSTALLATION. BRUSH CAD AND INSTALL WITH MIL-C-16173D. ~~FINISH BUSH DIA ID 2.9995/3.0025~~		001 MNPRA 002 02 003 BE01	
		FACE TO FACE INSIDE 6.212/6.215 OVERALL EACH LUG 1.605/1.640 63RMS *C/P MOVE			
		~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
[redacted]	095	PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	100 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	110 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATUPE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	

AFLC FORM 958 NOV 80 PREVIOUS EDITION MAY BE USED

21011N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89037 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 ~~4S1-99-3 & SUPPLEMENTS~~	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MLG		17575A 6

13 SERIAL NUMBER	14 NOUN
	HEADLESS PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G1364	6-103B	NSN 5315001760762 C/N 17575A *17576A* ~~17577A~~ 17578A			7 8
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BAKE IAW 4S-1-182 ~~MANOI 74-12~~			
		FMPI IAW MIL-STD-1949 P/O NO1561			
		CAD PLATE IAW MIL-STD-870 ~~TP II CL II~~			
		IVD PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541			
		~~***MAT'L 300 M 220,000-300,000PSI***~~ ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE ~~FAMILIAR WITH ALL PERTINENT SAFETY~~ PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC~~ABLE T.O.'S AND SUPPLEMENTS WILL~~ ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY ~~CLEANED AND PROTECTED (C/P MOVE)~~ FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. ~~**********"W A R N I N G"**********~~ MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21011N
		B	D	177

AFLC FORM 958 NOV 80 — PREVIOUS EDITION WILL BE USED

21011N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 2 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	HEADLESS PIN

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G13646-103B			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4HRS AT 350-400F DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNPGW 002 03 003 BK03	
[redacted]	*REQD*	*C/P MOVE		001 MNPNA 002 05 003 MS03	
[redacted]		E & I CHECK PIN O.D. 1.372/1.373/1.3712 SERVICE		001 MNPCW 002 04 003 EI01	
26	032	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21011N
		B	D	

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AFLC FORM 468 NOV 80 PREVIOUS EDITION WILL BE USED

21011N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 3 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	HEADLESS PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	034	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	036	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	038	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	040	CAD PLATE ALL AREAS NOT CHROME PLATED. TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	050	BAKE 23 HRS AT 350-400F WITHIN 4HRS OF CAD. DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	060	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	065	IVD PLATE(INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21011N
		B	D	

AFLC FORM 958 NOV 80

21011N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOU
	HEADLESS PIN

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	066	ALODINE IVD PLATED AREAS *C/PMOVE		001 MNPRC 002 03 003 TA01	
[redacted]	067	DEGREASE & PRE-PAINT *C/P MOVE		001 MNPGP 002 09 003 PP01	
[redacted]	068	PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	070 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	080 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21011N
		B	D	180

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21012N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89037 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3 & SUPPLEMENTS ~~4S-1-182~~	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C-5A MLG		

13 SERIAL NUMBER	14 NOUN
	LOWER PLATE

17575A 6 7 8

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
P/N 4613553-101A		NSN 1620004212101 C/N 17575A 17576A ~~17577A~~ 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		~~SHOTPEEN I A W MIL-S-13165~~			
		F.P.I. I A W MIL-STD-6866 ANODIZE I A W MIL-A-8625 ALODINE I A W MIL-C-5541 ~~STRIP I A W MIL-STD-871~~			
		MAT'L 7075-T73 A L U M I N U M			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY ~~PRACTICES AND HAZARDS CONTAINED IN~~ THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ~~ALWAYS BE USED IN CONJUNCTION WITH~~ THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR ~~MOVES BETWEEN OPERATIONS/DISPATCH~~ STATIONS.			
		**********"W A R N I N G"********** ~~MANY OF THE FOLLOWING REPAIR~~ PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21012N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21012N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 2 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER PLATE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4613558-101A			
34C5	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
340	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 AC02	
348	009 *REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
34E	018 *REQD*	E & I BEARING BORE I.D 3.3465/3.3475/3.348 SHAFT HOLES I.D: SMALL .7490-.7505		001 MNPGW 002 04 003 EI01	
		LARGE .8120-.8135 *C/P MOVE			
34E	019	NICK & BURR REPAIR *C/P MOVE		001 MNPGW 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21012N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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21012N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037

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

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

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

13. SERIAL NUMBER	14. NOUN
	LOWER PLATE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	040	SHAFT HOLE REPAIR (SMALL) OVERSIZE SMALL HOLE AS REQUIRED TO CLEAN UP .8305/.950 *C/P MOVE		001 MNPRA 002 04 003 MV02	
69	050	SHAFT HOLE REPAIR (LARGE) OVERSIZE LARGE HOLES AS REQUIRED TO CLEAN UP .8935/.950 *C/P MOVE		001 MNPRA 002 04 003 MV02	
69	060	BEARING BORE REPAIR OVERSIZE BEARING BORE AS REQUIRED TO CLEAN UP 3.650 MAX *C/P MOVE		001 MNPRA 002 04 003 MV02	
69	065	REMOVE INSERTS P/N MS124738 (4EA) & P/N 124736(4EA) ONLY IF ANODIZE STRIP IS REQUIRED. *C/P MOVE		001 MNPRA 002 02 003 BE01	
26	070	STRIP ANODIZE *C/P MOVE		001 MNPRC 002 03 003 AN04	
26A	080	FPI *C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZA02	
26	090	SHOTPEEN REWORKED AREAS .008-.010 A *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	100	ANODIZE TYPE II *C/P MOVE		001 MNPRC 002 03 003 AS03	
26	110	ALODINE *C/P MOVE		001 MNPRC 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER PLATE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	118	MACHINE SHAFT HOLE BUSHING (SMALL) FROM 7075 T6 OR 6061 T6 ALUM		001 MNPRA 002 02 003 LE02	
69	120	INSTALL SHAFT HOLE REPAIR (SMALL) BUSHING. INSTALL WITH MIL-C-16173D COMPOUND .0003-.001 PRESS FIT. *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	121	MACHINE SHAFT HOLE BUSHING (SMALL) FINISH I.D. .7490/.7505		001 MNPRA 002 04 003 MV02 005 XB052122	
69	128	MACHINE SHAFT HOLE BUSHING (LARGE) FROM 7075-T6 OR 6061 T6 ALUM		001 MNPRA 002 02 003 LE02	
69	130	INSTALL SHAFT HOLE REPAIR (LARGE) BUSHING INSTALL WITH MIL-C-16173 PRESS FIT .0003/.001 .8120-.8135 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	132	MACHINE SHAFT HOLE BUSHING (LARGE) FINISH I.D. .8120/8135		001 MNPRA 002 04 003 MV02 005 XB052123	
69	138	MACHINE BEARING BORE BUSHING FROM 7076-T6 OR 6061-T6 ALUM		001 MNPRA 002 02 003 LE02	
69	140	INSTALL BEARING BORE REPAIR BUSHING INSTALL WITH MIL-C-16173 COMPOUND .0003-.001 PRESS FIT		001 MNPRA 002 02 003 BE01	

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

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

21012N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER PLATE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	141	MACHINE BEARING BORE BUSHING FINISH I.D. 3.3465/3.3475 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 04 003 MV02 005 XB052120	
69	145	INSTALL INSERTS (4 EA) *C/P MOVE P/N MS124736 P/N MS124738		001 MNPRA 002 02 003 BE01	
34C5	150	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
34C5	160	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 ~~4S1-93-2~~ AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		17575A 6

13. SERIAL NUMBER	14 NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4611436-101A		NSN 1620001157387 C/N 17575A **17576A** * ~~17577A~~ 17578A		7 8	
		******* UNIT COST: $4890.00 ******* GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ~~FMPI~~ ~~IAW~~ ~~MIL-STD-1949~~ P/O N01561 SHOT PEEN IAW MIL-S-13165 CAD PLATE IAW MIL-STD-870 ~~PAKE~~ ~~IAW~~ ~~4S-1-182~~ MAOI 74-12 TEMPER ETCH IAW MIL-STD-867 BLAST IAW MIL-STD-1504 ~~IVD PLATE~~ ~~IAW~~ ~~MIL-C-83488A~~ ALODINE IAW MIL-C-5541 *****MAT'L 300 M 280-300 KSI***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOUROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4011435-101A			
[redacted]	005 *REQD*	DISASSEMBLE/REMOVE BUSHINGS 100% REQUIRED DUE TO CORROSION		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21013N
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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

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

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

13. SERIAL NUMBER	14. NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E AND I INSPECTION		001 MNPGW 002 04 003 EI01	
	REQD	BASE LUG BUSHINGS I.D. 4.499/4.502 ~~WEAR 4.504~~ FACE TO FACE 8.243/8.249/8.251 WEAR APEX LUG BUSHINGS I.D. 2.9995/3.0025 WEAR 3.0045			
		FACE TO FACE 2.626/2.630 NOTE: A MINIMUM OF TWO FMPI OPERATIONS REQUIRED ON THIS PART. ~~*C/P MOVE~~			
[redacted]		NICK AND BURR REPAIR *C/P MOVE			
26	050	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	053	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	057	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	070	BASE LUG HOLE REPAIR O/S TO CLEANUP 125 RMS MAX ID FOR SPARE BUSH 4.807 MAX ID FOR SPECIAL BUSH 4.940 - .800 MIN. WALL *C/P MOVE		001 MNPRA 002 02 003 MH04 ~~005 X9633674~~	
69	075	BASE LUG FACE REPAIR MACH LUG FACE AS NECESSARY TO CLEAN UP 1.27 MINIMUM 125RMS (CONTINUED)		001 MNPRA 002 02 003 MH04 005 X9633674	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
69	080	APEX LUG HOLE REPAIR OVERSIZE TO CLEANUP 125 RMS .76 MIN WALL *C/P MOVE		001 MNPRA 002 02 003 MH04 005 X8633674	
69	085	APEX LUG FACE REPAIR MACH LUG FACES AS NECESSARY TO CLEAN UP 1.36 MINIMUM 125RMS *C/P MOVE		001 MNPRA 002 02 003 MH04 005 X8633674	
[redacted]		TIME OUT _____ DATE OUT _____ C/P MOVE * * * * * * * * N O T E * * * * * * * *	M	001 MNPNA 002 06 003 TE03	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *			
26B	087	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	089	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
26	090	SHOT PEEN ALL REWORKED AREAS INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	091	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	092	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	093	BAKE 23 HOURS AT 350 TO 400F WITHIN 4 HOURS OF CAD PLATE DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	094	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	100	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	110	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

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

13. SERIAL NUMBER	14 NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "O"
69	138	MACHINE BASE LUG BUSHING P/N 4013536-103A		001 MNPRA 002 02 003 LE02	
69	140	BASE LUG BUSHING INSTALLATION BRUSH CAD AND INSTALL WITH MIL-C-16173D ID 4.499/4.502 ~~FACE TO FACE FOR FLANGED BUSH~~ 8.243/8.249 OVERALL EACH LUG 1.501/1.490 63RMS RECORD WEAR DIM IF REWORK LIMITS ARE ~~EXCEEDED~~ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	148	MACHINE APEX LUG BUSHING P/N 4013535-103A		001 MNPRA 002 02 003 LE02	
69	150	APEX LUG BUSHING INSTALLATION BRUSH CAD & INSTALL MIL-C-16173D FINISH BUSH ID 2.9995/3.0025 ~~OVERALL FOR FLANGED BUSH 6.298/6.302~~ OVERALL EACH LUG 1.770/1.802 FACE TO FACE 2.630/2.626 63RMS RECORD WEAR DIM IF REWORK LIMITS ARE ~~EXCEEDED~~ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 BE01	
[redacted]	155	PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	160 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER SIDE BRACE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]	1/0 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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1 DATE	PAGE 1 OF [redacted] PAGES
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		4S-1-182 1C-5A-3 4S1-93-3 & SUPPLEMENTS
13 SERIAL NUMBER	**14 NOUN**	
	YOKE	

17575A

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	"Q"
P/N 4G1143[illegible]0-113B		NSN 1620001753939 C/N 17575A **17576A** ~~17577A~~ 17578A			
		****** UNIT COST: $44029.41********** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		~~FPI IAW MIL-STD-6866~~			
		STRIP ANODIZE IAW MIL-STD-871			
		SHOT PEEN IAW MIL-S-13165			
		ANODIZE IAW MIL-A-8625			
		~~ALODINE IAW MIL-C-5541~~			
		BLAST IAW MIL-STD-1504			
		********MATL: ALUMINUM 7075-T6****** ~~**********(H.T. T73)**********~~			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT ~~HAVE BEEN THOROUGHLY TRAINED AND ARE~~ FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND ~~T.O. SUPPLEMENTS REFERENCED.~~ THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. ~~COMPONENTS WILL BE THOUROUGHLY~~ CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. ~~NOTE: TO DISTINGUISH RIGHT & LEFT~~ FACE SIDE BRACE LUGS WITH YOKE UPRIGHT ****WARNING**** (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SHOP
DISPATCH	FUNCTIONAL CODE	A	C	21015N
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21015N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 2 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS ~~WHICH ARE POTENTIALLY DANGEROUS TO~~ PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. ~~*REQD* (MANDATORY REQUIREMENT) IN~~ COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4611430-113B			
[redacted]	005 *REQD*	DISASSEMBLE -- NOTE: REMOVE ALL BALLSCREW BUSHINGS, UPPER AND LOWER DRAG SHAFT BUSHING, AND ~~OBVIOUSLY WORN OR DAMAGED BUSHINGS.~~ NOTE: THESE BUSHINGS MUST BE RE-MOVED DUE TO BASE METAL CORROSION *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	DEGREASE YOKE/CLEAN YOKE *C/P MOVE		001 MNPGW 002 02 003 DE02	
[redacted]	*REQD*	DIMENSIONAL CHECK/DETERMINE CENTER LINE SERVICABILITY 12.513-12.524 SERVICE LIMIT 12.527 RECORD DIMENSION *C/P MOVE		001 MNPGW 002 04 003 EI01	
69	008	REMOVE CENTER BORE LINER IF REQUIRED AND BUSHINGS ~~THAT CANNOT~~ BE REMOVED IN C5 AREA *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8622667	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21015N
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21015N **WORK CONTROL DOCUMENT (MEDS)**

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

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

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

13. SERIAL NUMBER	14. NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		BLAST TO REMOVE SEALANT FROM CENTERBORE AND YOKE COMPLETE *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]		CHECK/MIC CENTER BORE BASE METAL 12.750-12.754 & DETERMINE BUSHING REMOVAL REQUIREMENTS. NOTE: IF CENTER BORE REQUIRES HONING, ALL BUSHINGS MUST BE REMOVED *C/P MOVE		001 MNPGW 002 04 003 EI01	
[redacted]	011	REMOVE BUSHINGS AS INDICATED AND SCRAPE OFF REMAINING SEALANT FROM EDGES. *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	012	REMOVE INSERTS FROM CHAIN COVER HOLES IF REQUIRED. *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]		BLAST YOKE AS REQUIRED NOTE: IF CENTER LINER WAS NOT REMOVED, MASK TO PREVENT DAMAGE. *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]		STRIP ANODIZE IF REQ'D *C/P MOVE		001 MNPGW 002 03 003 AN03	
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
[redacted]	*REQD*	E AND I INSPECTION CENTER MOUNTING HOLE SLEEVE I.D. 12.513/12.524 WEAR 12.522		001 MNPGW 002 04 003 EI01	
		RECORD BASE METAL DIMENSION_____ BALL SCREW BUSHINGS I.D. 3.756/3.759 WEAR 3.761 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21015N
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BASE METAL 4.100 MAX I.D. RECORD BASE METAL DIMENSION_____ LEFT_____ RIGHT_____			
		UPPER SIDE BRACE BUSHINGS I.D. 3.199/3.202 WEAR 3.204 BASE METAL 3.570 MAX I.D. RECORD BASE METAL DIMENSION_____			
		LOWER SIDE BRACE BUSHINGS I.D. 4.499/4.502 WEAR 4.504 BASE METAL 4.870 MAS I.D. RECORD BASE METAL DIMENSION_____			
		TRUNNION END BUSHINGS I.D. 6.6245/6.6275 WEAR 6.629 BASE METAL 6.993 MAX I.D. RECORD BASE METAL DIMENSION RIGHT_____LEFT_____			
		TRUNNION CROSS HOLE BUSHINGS I.D. 2.253/2.255 WEAR 2.257 BASE METAL 2.540 MAX I.D. RECORD BASE METAL DIMENSION RIGHT_____LEFT_____			
		RETAINER BOLT BUSHINGS I.D. .3745/.3725 WEAR .3785 BASE METAL .625 MAX I.D. *C/P MOVE			
69	035	NICK AND BURR REPAIR AS NECESSARY *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	037	REPAIR DAMAGED THREADS IN CHAIN COVER HOLES AS INDICATED_____ NOTE: HOLES ARE NUMBERED 1-6 STARTING IN UPPER L/H HOLE AND GOING COUNTER CLOCKWISE. *C/P MOVE		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	040	REPAIR CRACK IN CHAIN COVER HOLES AS INDICATED_____ IAW IC-5A-3 SECTION 5 *C/P MOVE		001 MNPRA 002 02 003 BE01	
[redacted]		O INSURE REMOVAL OF CRACK IF NECESSARY. *C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
8	050	HONE I.D. OF CENTER BORE TO TRUE UP 12.750/12.754 RECORD DIM_____ *C/P MOVE		001 MNPRB 002 01 003 HV03	
69	055	MACHINE BALLSCREW FACE (LEFT SIDE) TO REMOVE DAMAGE OR CORROSION IAW FIGURE 5-49. *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8633667	
69	060	MACHINE BALLSCREW FACE (RIGHT SIDE) TO REMOVE DAMAGE OR CORROSION IAW FIGURE 5-49. *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8633667	
69	070	BALLSCREW HOLE (LEFT SIDE) REPAIR MACHINE HOLE TO CLEANUP, DO NOT EXCEED MAX I.D. 4.100 RECORD BASE METAL DIMENSION_____ *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8633667	
69	080	BALL SCREW HOLE (RIGHT SIDE) REPAIR MACHINE HOLE TO CLEANUP NOT TO EXCEED MAX I.D. 4.100 RECORD BASE METAL DIMENSION_____ *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8633667	
69	090	UPPER SIDE BRACE HOLE REPAIR O/S HOLE TO CLEANUP, NOT TO EXCEED 3.570 MAX ID MIN LUG WALL OF (CONTINUED)		001 MNPRA 002 02 003 BE01	

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. P	20. Q
		1.1113 RECORD BASE METAL DIMENSION..... *C/P MOVE			
69	100	LOWER SIDE BRACE HOLE REPAIR O/S HOLE TO CLEANUP, NOT TO EXCEED 4.870 MAX ID MIN LUG WALL OF ~~1.8313~~		001 MNPRA 002 02 003 BE01	
		RECORD BASE METAL DIMENSION..... *C/P MOVE			
69	110	TRUNNION END HOLE (LEFT SIDE) HOLE REPAIR. MACHINE HOLE TO CLEANUP, NOT TO EXCEED I.D. 6.993 MAINTAIN ~~EXISTING RADIUS~~		001 MNPRA 002 02 003 MH05 ~~005 X8623667~~	
		RECORD BASE METAL DIMENSION..... *C/P MOVE			
69	120	TRUNNION END HOLE (RIGHT SIDE) REPAIR. MAINTAIN HOLE TO CLEANUP, NOT TO EXCEED I.D. 6.993 MAINTAIN ~~EXISTING RADIUS~~		001 MNPRA 002 02 003 MH05 ~~005 X8623667~~	
		RECORD BASE METAL DIMENSION..... *C/P MOVE			
69	130	TRUNNION CROSS PIN HOLE (LEFT SIDE) REPAIR. O/S HOLES IN LINE TO CLEANUP, NOT TO EXCEED I.D. 2.560 ~~RECORD BASE METAL DIMENSION.....~~		001 MNPRA 002 02 003 BE01	
		*C/P MOVE			
69	140	TRUNNION CROSS PIN HOLE (RIGHT SIDE) O/S HOLES IN LINE TO CLEANUP NOT TO EXCEED I.D. 2.560. (CONTINUED)		001 MNPRA 002 02 003 BE01	

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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20 "Q"
		RECORD BASE METAL DIMENSION *C/P MOVE			
69	150	RETAINER BOLT HOLE (LEFT SIDE) REPAIR. LINE REAM AND ROLL BURNISH TO CLEANUP, NOT TO EXCEED I.D. .625 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8[illegible]	
69	160	RETAINER BOLT HOLE (RIGHT SIDE) REPAIR. LINE REAM AND ROLL BURNISH TO CLEANUP, NOT TO EXCEED I.D. .625 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8[illegible]	
69	165	BALLSCREW SPROCKET BORE ____ SIDE REPAIR. MACHINE BORE TO CLEAN-UP 9.350 MAX I.D. .800/.825 LENGTH *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8[illegible]	
26	180	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	190	SHOTPEEN YOKE COMPLETE INTENSITY OF .010/.014 A INCLUDING ALL HOLES AND LUGS OVER 2 INCHES *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	200	SHOTPEEN REDWRKED AREAS. INTENSITY OF .010/.014 A *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	205	SHOTPEEN I.D. OF CENTER BORE IF REWORKED INTENSITY .010/.014A *C/P MOVE		001 MNPRC 002 01 003 SP01	
26	210	POLISH LUG HOLES THAT HAVE BEEN SHOTPEENED. LIGHTLY POLISH TO REMOVE SHOTPEEN ROUGHNESS, DO NOT REMOVE MORE THAN .002 MATERIAL.		001 MNPRC 002 03 003 BE01	
		*C/P MOVE			

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
8	215	HONE I.D. OF CENTER BORE AFTER SHOTPEEN 12.750/12.754 64 RMS. RECORD DIM. _____ *C/P MOVE		001 MNPRB 002 01 003 HV03	
26	220	ANODIZE YOKE COMPLETE. TYPE II *C/P MOVE		001 MNPRC 002 03 003 AS03	
26	222	ALODINE REWORKED LOCAL AREAS *C/P MOVE		001 MNPRC 002 03 003 IA01	
69	225	INSTALL INSERT IN REPAIRED HOLES P/N MS21208-F4-20 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	230	CENTER MOUNTING HOLE SLEEVE INSTALLATION (SUB ZERO SHRINKING). USE SLEEVE P/N 469449-101A INSTALL WITH		001 MNPRA 002 02 003 BE01	
		PR1431G TPI, P/S 870C-12 OR PR-4400 C-12. SWAG THE UPPER END OF SLEEVE WITH SWAGING TOOL P/N 12560237 .013-.014 PRESS FIT			
		I.D. DIMENSION 12.511/12.524 RECORD I.D. DIMENSION _____ *C/P MOVE			
69	238	MACHINE BALLSCREW HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4G19063-107A		001 MNPRA 002 02 003 LE02	
69	240	BALLSCREW HOLE BUSHING (LEFT SIDE) INSTALLATION. P/N 4G19063-107A .0015 PRESS FIT INSTALL WITH MIL-C-14173D, GRADE 2		001 MNPRA 002 02 003 BE01	
		AMD 2 FINISH BUSHING ID 3.756/3.759 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)			

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

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EXCEEDED..... RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS..... ~~*C/P MOVE~~			
69	248	MACHINE BALLSCREW HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4619063-107A		001 MNPRA 002 02 003 LE02	
69	250	BALLSCREW HOLE BUSHING (RIGHT SIDE) INSTALLATION. P/N 4619063-107A .0015/.0035 PRESS FIT ~~INSTALL WITH MIL-C-16173D GRADE 2~~ AMD 2 FINISH BUSHING ID 3.756/3.759 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED..... ~~RECORD REASON & CAUSE FOR EXCEEDING~~ REWORK LIMITS..... *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	259	MACHINE UPPER SIDE BRACE HOLE BUSHING *C/P MOVE P/N 4613592-103A (6 EA) ~~P/N 4613649-105A (2 EA)~~		001 MNPRA 002 02 003 LE02	
69	260	UPPER SIDE BRACE HOLE BUSHING INSTALLATION. USE BUSHING P/N 4613592-103A (6 EA) AND BUSHING ~~P/N 4613649-105A (2 EA)~~ .0015/.0035 PRESS FIT INSTALL WITH MIL-C-16173D, GRADE 2, AMD 2 FINISH BUSHING ID 3.199/3.202 ~~OVERALL 2.740/2.746 FACE TO FACE~~ 1.506/1.509 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED..... ~~RECORD REASON & CAUSE FOR EXCEEDING~~ REWORK LIMITS..... *C/P MOVE		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
69	269	MACHINE LOWER SIDE BRACE HOLE BUSHING *C/P MOVE P/N 4613593-103A (6 EA) ~~P/N 4613650-105A (2 EA)~~		001 MNPRA 002 02 003 LE02	
69	270	LOWER SIDE BRACE HOLE BUSHING INSTALLATION. USE BUSHING P/N 4613593-103A (6 EA) AND BUSHING P/N ~~4613650-105A (2 EA)~~ .0015/.0035 PRESS FIT. FINISH BUSHING I.D. 4.499/4.502 125 RMS INSTALL BUSHINGS WITH MIL-C-16173D, ~~GRADE 2 AMD 2~~ FACE TO FACE 1.506/1.509 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	278	MACHINE TRUNNION END HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4613595-103A		001 MNPRA 002 02 003 LE02	
69	280	TRUNNION END HOLE (LEFT SIDE) BUSH INSTALLATION. P/N 4613595-103A MACHINE FOR A .0025/.0055 PRESS FIT ~~INSTALL WITH MIL-C-16173D, GRADE 2~~ AMD 2. MAINTAIN BUSHING FLANGE THICKNESS OF .200 MAX FINISH BUSH ID 6.6245/6.6275 125 RMS ~~OVERALL 74.394/74.460~~ CHAMFER CROSS BOLT HOLES 35 TO 40 DEG X .040 RECORD OVERALL DIM_____ ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ (CONTINUED)		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
69	288	MACHINE TURNNION END HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4G13595-103A		001 MNPRA 002 02 003 LE02	
69	290	TRUNNION END HOLE (RIGHT SIDE) BUSH P/N 4G13595-103A MACHINE FOR A .0025/.0055 PRESS FIT. INSTALL WITH ~~MIL-C-16173D GRADE 2, AMD 2.~~ MAINTAIN BUSH FLANGE THICKNESS OF .200 MAX FINISH BUSHING I.D. 6.6245/6.6275 125 RMS ~~OVERALL 74.394/74.440~~ CHAMFER CROSS BOLT HOLES 35 TO 40 DEG X .040 RECORD OVERALL DIMENSION OF TRUNNION BUSHING RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	295 *REQD*	IF NOT PREVIOUSLY ACCOMPLISHED, MIC AND RECORD OVERALL DIM. OF TRUNNION BUSHINGS *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	298	MACHINE TRUNNION CROSS PIN HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4G13597-103A		001 MNPRA 002 02 003 LE02	
69	300	TRUNNION CROSS PIN HOLE (LEFT SIDE) BUSHING INSTALLATION. USE BUSHING P/N 4G13597-103A .0025/.0055 (CONTINUED)		001 MNPRA 002 02 003 BE01	

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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRESS FIT INSTALL WITH MIL-C-16173D, GRADE 2 AMD 2 FINISH BUSHING I.D. 2.253/2.255 OVERALL 10.750/10.760 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
69	308	MACHINE TRUNNION CROSS PIN HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4G13597-103A		001 MNPRA 002 02 003 LE02	
69	310	TRUNNION CROSS PIN HOLE (RT SIDE) BUSHING INSTALLATION. USE BUSH P/N 4G13597-103A .0025/.0055 PRESS FIT INSTALL WITH MIL-C-16173D GRADE 2, AMD 2 FINISH BUSHING I.D. 2.253/2.255 OVERALL 10.750/10.760 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	318	MACHINE RETAINER BOLT HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4G13729-103A		001 MNPRA 002 02 003 LE02	
69	320	RETAINER BOLT HOLE (LEFT SIDE) BUSHING INSTALLATION. BUSHING P/N 4G13729-103A .001/.002 PRESS FIT. INSTALL WITH MIL-C-16173D, GRADE 2, AMD 2. FINISH BUSHING I.D. .3745/.3775 RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	YOKE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
69	324	MACHINE RETAINER BOLT HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4013729-103A		001 MNPRA 002 02 003 LE02	
69	325	RETAINER BOLT HOLE (RT SIDE) BUSHING INSTALLATION. P/N 4013729-103A .001/.002 PRESS FIT INSTALL WITH MIL-C-14173D, GRADE 2 AMD 2 FINISH BUSHING ID .3745/.3775 125 RMS PRODUCTION COUNT BO110		001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
69	326	MACHINE BALLSCREW SPROCKET SLEEVE FROM 6061-T6 OR EQUAL LENGTH .795/.800 PRESS FIT .005/.009 *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	327	INSTALL BALLSCREW SPROCKET SLEEVE I.D. 9.251/9.2535 64 RMS BRUSH ALODINE AFTER FINAL MACHINE *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	329	MANUFACTURE REPAIR MEMBER #5 IAW T.O 1C-5A-3 SEC 5 FIG 5-17 *C/P MOVE*		001 MNPRA 002 02 003 LE02	
69	330	INSTALL REPAIR MEMBERS 1,2,3,4,5, & 6 IAW T.O. 1C-5A-3 SEC 5 FIG 5-17 *C/P MOVE*		001 MNPRA 002 02 003 BE01	

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	YOKE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]	331	DEGREASE & SEAL BUSHINGS *C/P MOVE		001 MNPSP 002 01 003 BE01	
[redacted]	333	PRE-PAINT *C/P MOVE		001 MNPSP 002 09 003 PP01	
[redacted]	335 *RECD*	PAINT & DECAL NOTE: SEE OPERATIONS 280, 290 OR 295 AND STENCIL ACTUAL DIMENSION. *C/P MOVE		001 MNPSP 002 09 003 WB03	
[redacted]	340 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPSP 002 01 003 MU06	
[redacted]	350 *RECD*	FINAL PRODUCT VISAUL INSPECTION *C/P MOVE		001 MNPSP 002 01 003 MU06	

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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 4S1-9[illegible]-3 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MLG		17575A 6

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20. "Q"
		P/N 4611476-107A NSN 1620005581485 C/N 17575A 4611476-101B 1620001157415 17576A ~~17577A~~ 17578A			7 8
		****** UNIT COST: $9145.37 ******** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		~~BLAST~~ ~~IAW MIL-STD-1504~~			
		FMPI IAW MIL-STD-1949 P/O N01561			
		STRIP CHROME IAW MIL-STD-871			
		~~GRIND IAW MIL-STD-[illegible]~~			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-[illegible]5			
		FPI IAW MIL-STD-[illegible]			
		~~CAD PLATE IAW MIL-STD-[illegible]~~			
		CHROME PLATE IAW MIL-STD-150[illegible] TP II CL III P/O N61891			
		BAKE IAW 4S-1-182 ~~MANOI 74-12~~			
		IVD PLATE IAW MIL-C-8048[illegible]			
		ALODINE IAW MIL-C-5541			
		******* 300M 280/300 KSI ********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE ~~FAMILIAR WITH ALL PERTINENT SAFETY~~ PRACTICES AND HAZARDS CONTAINED IN BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE ~~APPLICABLE T.O.'S AND SUPPLEMENTS~~ WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL THOUROUGHLY (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21016N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 2 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4011476-107A 4011476-101B			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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

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

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

13. SERIAL NUMBER	14. NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECTION COLLAR I.D. 9.4542/9.4562		001 MNPGW 002 04 003 EI01	
		COLLAR THICKNESS 3.055 MINIMUM POSITIONER LUG BUSHING I.D. ~~2.249/2.2514 WEAR 2.2529~~ FACE TO FACE I.D. 2.875/2.879 WEAR 2.8805 CLEVIS LUG BUSHINGS (R&L) I.D. ~~.249/.251 WEAR .2525~~ FACE TO FACE I.D. .341/.348 WEAR .3495 ~~BASE METAL REWORK SIZES AS FOLLOWS:~~ POSITIONER LUG HOLE MAX I.D. 2.550 ~~OR MIN WALL OF .500~~ CLEVIS LUG HOLES MAX I.D. .412 OR MIN LUG WALL OF .120 ~~**********N O T E**********~~ INSURE ALL TEETH HAVE BEEN CHAMFERED IF NOT, ROUTE FOR OPERATIONS 090 AND /OR 095 *C/P MOVE			
[redacted]		LOCAL REWORK COLLAR FACE MAX. DEPTH OF 0.060 X 0.75 IN. SQ. PER 90 DEGREE QUADRANT. ~~*C/P MOVE~~			
[redacted]		REMOVE BUSHINGS *C/P MOVE		001 MNPGW 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
		B	D	

21016N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	047	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	050	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	052	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	055 *REGO*	REMOVE PINS P/N 4G13312-101A *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	060	POSITIONER LUG HOLE REPAIR. LINE BORE OR HONE TO CLEANUP NOT TO EXCEED ID 2.550 OR MIN LUG WALL THICKNESS OF .500 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	070	CLEVIS LUG HOLE (LEFT SIDE) REPAIR LINE REAM HOLES TO CLEANUP, NOT TO EXCEED ID .412 OR LUG WALL OF .120 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	080	CLEVIS LUG HOLE (RIGHT SIDE) REPAIR LINE REAM HOLES TO CLEANUP, NOT TO EXCEED ID .412 OR LUG WALL OF .148 *C/P MOVE		001 MNPRA 002 02 003 BE01	
8	090	MACHINE TOP OF ALL SMALL TEETH .015/.020 BELOW THE TOP OF THE TWO LARGE TEETH AND CHAMFER EDGES OF SMALL TEETH 45 (+OR- 5 DEG) BY .010 TO .060 MAINTAIN 3.055 MINIMUM OVERALL DIMENSION AS MEASURED FROM TOP OF LARGE TEETH TO CHROMED FACE.		001 MNPRB 002 02 003 GJ02	
8	095	CHAMFER BOTH EDGES OF THE TWO LARGE TEETH 15 (+OR- 5 DEG) BY .125 - .150 *C/P MOVE		001 MNPRB 002 02 003 BE01	

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

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21016N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 PAGE 5 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20 "Q"
26	090	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	100	STRIP CHROME FROM COLLAR FACE *C/P MOVE		001 MNPRC 002 02 003 SC02	
26	110	STRIP CHROME FROM COLLAR INSIDE *C/P MOVE		001 MNPRC 002 02 003 SC02	
8	120	FIRST GRIND COLLAR FACE. CLEANUP FOR CHROME, NOT TO EXCEED MIN THICKNESS OF 3.050 FROM DATUM PLANE A *C/P MOVE		001 MNPRS 002 01 003 GI04 005 [illegible]	
8	130	FIRST GRIND COLLAR INSIDE. CLEANUP FOR CHROME OR TO REMOVE OLD CHROME, NOT TO EXCEED I.D. 9.472 *C/P MOVE		001 MNPRS 002 01 003 GI04 005 [illegible]	
[redacted]		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	150	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH *C/P MOVE DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
		B	D	211

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21016N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 | PAGE 6 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		HERE, TAKE PRODUCTION COUNT *			
26	165	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DK01	
26	170	SHOT PEEN COLLAR FACE FOR CHROME INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	180	SHOT PEEN COLLAR [illegible] FOR CHROME INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	190	SHOT PEEN ROWOPTION AREAS INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNP[illegible] 002 01 003 S[illegible]	
26	192	PREPARE COLLAR FACE FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	197	PREPARE COLLAR FACE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED------->		001 MNPRC 002 02 003 BE01 ~~004 XTE2214~~	
26	200	CHROME PLATE COLLAR FACE SUFFICIENT TO GRIND BACK TO 3.065/3.075 FROM DATUM PLANE A		001 MNPRC 002 02 003 CP01 ~~004 XTE2214~~	
		DATE OUT ..... TIME OUT ..... MECHANIC SIGN OFF REQUIRED-------> *C/P MOVE		008 CO010	
26B	202	BAKE 4 HRS AT 350F - 400F WITHIN 4 HRS OF CHROME		001 MNPRC 002 02 003 BK01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
		B	D	212

21016N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 7 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ ~~*C/P MOVE~~			
20	204	PREPARE COLLAR I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 SLD2	
16	206	PREPARE COLLAR INSIDE FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 BE01 ~~005 X2E32142~~	
20	210	CHROME PLATE COLLAR INSIDE SUFFICIENT TO GRIND BACK TO 9.4542/9.4562		001 MNPRC 002 02 003 CI01 ~~005 X2E32142~~	
		~~DATE OUT _____ TIME OUT _____~~ MECHANIC SIGN OFF REQUIRED---------- ~~*C/P MOVE~~		005 CI01	
~~20~~	~~220~~	~~GRIND I.D. TO SIZE TO 4005" WITHIN 4 MILS OF CHROME *C/P MOVE~~ ~~DATE IN _____ TIME IN _____~~		001 MNPRG 002 02 003 BP01	
		DATE OUT: _____ TIME OUT: _____			
8	230	FINISH GRIND COLLAR, FACE FINISHED THICKNESS TO BE 3.005/3.007 FROM DATUM PLANE A. MAINTAIN ~~PARALLELISM & STRAIGHTNESS .03MM~~ *C/P MOVE		001 MNFRB 002 01 003 GT04 ~~005 X9245164~~	
8	240	FINISH GRIND COLLAR INSIDE, FINISHED DIA ID 9.4542/9.4562 MAINTAIN STRAIGHTNESS & CONCENTRICITIES (CONTINUED)		001 MNPRB 002 01 003 GT04 ~~005 X9245164~~	

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20 "O"
		63RMS *C/P MOVE			
24B	250	BAKE 4 HRS AT 350F TO 400F DATE IN: ..... TIME IN:		001 MNPRC 002 02 003 BK01	
		DATE OUT: ..... TIME OUT: ..... *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE *PRODUCTION COUNT *	M	001 MNPNA 002 02 003 ND01	
26	265	VAPOR DEGREASE *C/P MOVE		001 MNPNA 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 04 003 ZL01	
26	275	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	280	CAD PLATE TYPE II CLASS II TIME OUT: ..... DATE OUT		001 MNPRC 002 03 003 CA01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
268	290	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD PLATE DATE IN: TIME IN:		001 MNPRC 002 02 003 BK01	
		DATE OUT: TIME OUT: *C/P MOVE			
26	295	(IRIDITE) CHROMATE CONVERSION COATING		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PORUCTION COUNT *	K	001 MNPNA 002 06 003 ML04	
26	301	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 290 MUST BE DONE PRIOR TO IVD OPTION *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	302	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IA01	
69	303	MACHINE AND FACE PINS .290/.295 FROM FACE OF SMALL LUGS I.A.W. DWG 4611476 *C/P MOVE (CONTINUED)		001 MNPRA 002 02 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
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21016N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 10 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 4G13313-101A			
69	305	INSTALL PINS I.A.W. T.O. *C/P MOVE *REQD* P/N 4G13313-101A		001 MNPRA 002 02 003 BE01	
69	308	MACHINE POSITIONER LUG BUSHING *C/P MOVE P/N 4G13610-103A		001 MNPRA 002 02 003 LE02	
69	310	POSITIONER LUG BUSHING INSTALLATION USE BUSHING P/N4G13610-103A PRESS FIT .001/.003. USE SEALING COMPOUND MIL-C-16173D. FINISH BUSHING DIA ID 2.249/2.2514. FACE TO FACE INSIDE 2.675/2.879. 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	318	MACHINE CLEVIS LUG HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4G13338-103A P/N 4G13609-103A		001 MNPRA 002 02 003 LE02	
69	320	CLEVIS LUG HOLE (LEFT SIDE) BUSHING INSTALLATION USE BUSHING P/N4G13339-103A & P/N 4G13609-103A PRESS FIT .0005/.002. USE SEALING COMPOUND MIL-C-16173D. FINISH BUSHING DIA ID .249/.2514. FACE TO FACE INSIDE .341/.348. 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING (CONTINUED)		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	POSITIONING COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		REWORK LIMITS *C/P MOVE			
69	328	MACHINE CLEVIS LUG HOLE BUSHINGS (RIGHT SIDE) *C/P MOVE P/N 4613338-103A ~~P/N 4613609-103A~~		001 MNPRA 002 02 003 LE02	
69	330	CLEVIS LUG HOLE (RIGHT SIDE) BUSHING INSTALLATION USE BUSHINGS P/N4613338-103A & P/N4613609-103A ~~PRESS FIT~~		001 MNPRA 002 02 003 BE01	
		.0005/.002, USE SEALING COMPOUND MIL-C-161730 FINISH DIA I.D. .249/.2514 FACE TO FACE INSIDE ~~.241/.242 63RMS~~			
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING ~~REWORK LIMITS~~			
		*C/P MOVE			
[redacted]	335	PAINT IAW 4S1-93-3 & 4S-1-180 *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	340 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 FA05	
[redacted]	350 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 FA05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO
	4S-1-182 4S1-99-2 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		17575A

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4613561	1-101A	NSN 5315001321925 C/N 17575A 17576A ~~17577A~~ 17578A			
		******* UNIT COST: $367.65 ******* GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		~~ALODINE~~ IAW ~~MIL-C-5541~~			
		FMPI IAW MIL-STD-1949 P/O N01561			
		BAKE IAW 4S-1-182 ~~MANT 74-12~~			
		GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-6[illegible] SHOT PEEN IAW MIL-S-13165 ~~CAD PLATE~~ ~~IAW MIL-STD-870~~			
		CHROME PLATE IAW MIL-STD-1501 TP II CL III P/O M61891			
		FPI IAW MIL-STD-6866 ~~IVD PLATE~~ ~~IAW MIL-C-83456~~			
		STRIP CHROME IAW MIL-STD 871 ***MAT/L: 300M 280,000-300,000 KSI ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOUROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21017N
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		WARNING ~~MANY OF THE FOLLOWING REPAIR~~ PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO ~~PERSONNEL. ADEQUATE SAFEGUARDS AND~~ PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. ~~*REQD* (MANDATORY REQUIREMENT) IN~~ COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4613561-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPOP 002 01 003 SB03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	AKE 4 HRS AT 350-400F DATE IN ____ TIME IN ____		001 MNPGW 002 03 003 BK03	
		DATE OUT ____ TIME OUT ____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/T MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECTION SHAFT OD 2.2465/2.2485 WEAR 2.2455 NOTE: A MINIMUM OF TWO FMPI'S ~~ARE REQUIRED ON THIS ITEM~~ *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	035	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	040	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	045	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	050	STRIP CHROME FROM SHAFT *C/P MOVE		001 MNPRC 002 02 003 SC02	
69	055	RECENTER IF REQUIRED *C/P MOVE		001 MNPRA 002 02 003 LE09	
8	060	FIRST GRIND SHAFT MINIMUM GRIND SIZE O.D. 2.2335 63RMS MAINTAIN EXISTING RADIUS. *C/P MOVE		001 MNPRB 002 02 003 GE01	
[redacted]		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26P	080	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	095	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	100	SHOT PEEN SHAFT INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	103	PREPARE SHAFT FOR CHROME PLATE MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	107	PREPARE SHAFT FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	110	CHROME PLATE SHAFT SUFFICIENT TO GRIND BACK TO 2.2465/2.2485 .		001 MNPRC 002 02 003 CP01 004 CP010	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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21017N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 5 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED ----------> *C/P MOVE			
26B	120	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME PLATE. ~~DATE IN: _____ TIME IN: _____~~ DATE OUT: _____ TIME OUT: _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
8	130	FINISH GRIND SHAFT FINISHED DIAMETER O.D. 2.2465/2.2485, MAINTAIN EXISTING RADIUS 63 RMS ~~RECORD WEAR TIM IF REWORK LIMITS ARE~~ EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE		001 MNPRB 002 02 003 GE01	
26	140	BAKE 4 HRS AT 350F TO 400F DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNG 002 06 003 ML04	
26	155	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	
26	165	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	170	CAD PLATE SHAFT TYPE II CLASS II TIME OUT:..... DATE OUT..... *C/P MOVE		001 MNPRC 002 03 003 C[illegible]01	
26B	180	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD PLATE DATE IN:..... TIME IN:..... DATE OUT:..... TIME OUT:..... *C/P MOVE		001 MNPRC 002 02 003 BK01	
26	190	(IRIDITE) CHROMATE CONVERSION *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS04	
26	201	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 180 MUST (CONTINUED)		001 MNPRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		BE DONE PRIOR TO IVD OPTION. *C/P MOVE			
26	202	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	205	PAINT IAW 4S1-93-3 & 4S-1-162 *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	210 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	230 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 ~~4S1-93-3 AND SUPPLEMENTS~~	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		17575A

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
P/N 461144B-107A		NSN 1620001157390 C/N 17575A 17576A ~~17577A~~ 17578A			
		******* UNIT COST: $5308.00 ******* GOVERNING DIRECTIVES: AFLCR 66-51 MANO1 86-3			
		~~ALODINE~~ ~~IAW MIL-C-5541~~ FMPI IAW MIL-STD-1949 P/O A01561			
		STRIP CHROME IAW MIL-STD-871 ~~GRIND IAW MIL-STD-866~~			
		TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 ~~TYPE II CLASS 1(1) P-C-A01581~~			
		CAD PLATE IAW MIL-STD-870 FPI IAW MIL-STD-6866 BAKE IAW 4S-1-182 ~~MAO1 74-12~~			
		IVD PLATE IAW MIL-C-83468A MAT'L 300 M 280,000 300,000 KSI ALL PERSONNEL INVOLVED IN THE WORK ~~PROCESSES SPECIFIED IN THIS DOCUMENT~~ HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN ~~THE BASIC TECHNICAL ORDER (T.O.) AND~~ T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION ~~WITH THIS DOCUMENT.~~ *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		STATIONS. WARNING ~~MANY OF THE FOLLOWING REPAIR~~ PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO ~~PERSONNEL. ADEQUATE SAFEGUARDS AND~~ PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. ~~*REQD* (MANDATORY REQUIREMENT) IN~~ COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	401144-107A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPOP 002 01 003 SUB 1	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPOW 002 02 003 SU 01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPOW 002 02 003 BL 01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPOW 002 03 003 BK 03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "O"
[redacted]		*C/P MOVE	M	001 MNPNA 002 05 003 ML04	
	REQD				
[redacted]		E AND I INSPECTION		001 MNPGW 002 04 003 EI01	
	REQD	ARM SHAFT O.D. 6.622/6.624 ~~WEAR 6.621~~			
		CROSS PIN HOLE ID. 2.253/2.255 WEAR 2.257 SMALL ARM BUSHING I.D. 1.351/1.353 ~~WEAR 1.3545~~			
		LARGE ARM BUSHING I.D. 2.251/2.253 WEAR 2.2545			
		FACE TO FACE 1.503/1.505 RIG PIN HOLE .500/.505 *C/P MAX NOTE: A MINIMUM OF TWO FACES ~~ARE REQUIRED ON THIS ITEM~~			
[redacted]		REMOVE BUSHINGS *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	045	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	050	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	055	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	060	CROSS PIN HOLE REPAIR MAX HOLE SIZE I.D. 2.465/2.445 (CONTINUED)		001 MNPRA 002 02 003 MH04 005 XB633668	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. P	20 Q
		MAX COUNTER BORE SIZE I.D. 2.820 *C/P MOVE			
69	065	REPAIR RIG PIN HOLE BY BORING HOLE TO [illegible] *C/P MOVE		001 MNPRG 002 0 003 MC*	
69	070	SMALL ARM HOLE REPAIR MAX I.D. 1.750 *C/P MOVE		001 MNPRG 002 02 003 MC*	
69	080	LARGE ARM HOLE REPAIR MAX I.D. 2.650 *C/P MOVE		001 MNPRG 002 [illegible] 003 MC*	
36	085	MAJOR DISPOSAL *C/P MOVE		001 MNPRG 002 [illegible] 003 [illegible]	
36	090	STRIP CHROME FROM ARM SHAFT *C/P MOVE		001 MNPRG 002 02 003 [illegible]	
BG	100	FIRST GRIND ARM SHAFT MIN SIZE O.D. 6.610 *C/P MOVE		001 MNPRG 002 03 003 [illegible]	
[redacted]		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNPRG 002 04 003 [illegible]	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	120	BAKE 3 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH (CONTINUED)		001 MNPRG 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		DATE IN:_____TIME IN:_____ DATE OUT:_____TIME OUT:_____			
		[redacted] *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST MDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	131	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	132	SHOT PEEN CROSS PIN HOLE .006-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	134	SHOT PEEN SMALL ARM HOLE .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	136	SHOT PEEN LARGE ARM HOLE .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	137	SHOT PEEN ARM SHAFT *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	138	PREPARE ARM SHAFT FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	139	PREPARE ARM SHAFT FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	140 ✓	CHROME PLATE ARM SHAFT SUFFICIENT TO GRIND BACK TO 6.622/6.624 (APPLY MINIMUM AMOUNT OF CHROME)		001 MN 002 02 003 CP 008 FG	PRC 01 010
		DATE OUT ________ TIME OUT ________ MECHANIC SIGN OFF REQUIRED---------- *C/P MOVE			
26B	150	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME DATE IN: ________ TIME IN: ________		001 MN 002 02 003 BK	PRC 01
		DATE OUT: ________ TIME OUT: ________ *C/P MOVE			
86	160	FINISH GRIND ARM SHAFT 63 RMS FINISH SIZE O.D. 6.622/6.624 RECORD WEAR O/S IF REWORK LIMITS ARE		001 MN 002 03 003 GG	PRP 01
		EXCEEDED ________ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS ________ *C/P MOVE			
26B	170	BAKE 4 HRS AT 350F TO 400F DATE IN: ________ TIME IN: ________		001 MN 002 02 003 BK	PRC 01
		DATE OUT: ________ TIME OUT: ________ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MN 002 06 003 ML	NA 04
		* * * * * * * * * * * * * * * * * *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
26	185	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	
26	195	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED		001 MNPRC 002 01 003 BL02	
26	200	CADMium PLATE TYPE II CLASS II TIME OUT: ____ DATE OUT ____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	210	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD DATE IN: ____ TIME IN: ____		001 MNPRC 002 02 003 BK01	
		DATE OUT: ____ TIME OUT: ____ *C/P MOVE			
26	215	(IRIDITE)CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	222	IVD PLATE(INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 210 MUST BE DONE PRIOR TO IVD OPTION. *C/P MOVE		001 MNPRC 002 02 003 IVD1	
26	224	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 THD1	
69	228	MACHINE LARGE ARM HOLE BUSHINGS *C/P MOVE P/N 4013530-105A		001 MNPRA 002 02 003 LED2	
69	230	LARGE ARM HOLE BUSHING INSTALLATION P/N 4013530-105A FACE TO FACE 1.532/1.535		001 MNPRA 002 02 003 BED1	
69	232	MACHINE LARGE ARM HOLE BUSHINGS FINISH ID 2.251/2.253 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 M C4 005 XB13268	
69	238	MACHINE SMALL ARM HOLE BUSHING *C/P MOVE P/N 4013529-103A		001 MNPRA 002 02 003 LED2	
69	240	SMALL ARM HOLE BUSHING INSTALLATION P/N 4013529-103A FACE TO FACE 1.532/1.535 *C/P MOVE		001 MNPRA 002 02 003 BED1	
69	242	MACHINE SMALL ARM HOLE BUSHING FINISH ID 1.351/1.353 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)		001 MNPRA 002 02 003 MHD4 005 XB13268	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21018N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 9 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	248	MACHINE CROSS BOLT HOLE BUSHING MANUFACTURE IAW 4S1-93-3 *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	249	CROSS BOLT HOLE BUSHING INSTALLATION INSTALL IN ACCORDANCE WITH 4S1-93-3 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	250	MACHINE CROSS BOLT HOLE BUSHING FINISH ID 2.253/2.255 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED		001 MNPRA 002 02 003 MH04	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	251	MACHINE RIG PIN BUSHING HEAT TREAT 180-200KSI *C/P MOVE P/N 66C33001-03ST02		001 MNPRA 002 02 003 LE02	
69	252	INSTALL RIG PIN BUSHING P/N 66C33001-03ST02 .0005-.001 PRESS FIT *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	253	MACHINE RIG PIN BUSHING FINISH ID .500/.505 *C/P MOVE		001 MNPRA 002 02 003 MH04	
[redacted]	255	DEGREASE & PRE-PAINT *C/P MOVE		001 MNPGP 002 09 003 PP01	
[redacted]	260	PAINT IAW 43-1-182 & 4S1-95-3 *C/P MOVE		001 MNPGP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	232

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21018N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 PAGE 10 OF 10 PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	RETRACT ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20 "Q"
[redacted]	270 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95B		001 MNFQP 002 01 003 MUDe	
[redacted]	280 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MJF-4P 002 01 003 MUDe	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89061 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-102 451 93 3 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		17575A 72852A

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4612400-101A		NSN 1620001162099 C/N 17575A 17576A ~~17577A~~ 17578A 72852A	7 8		
		GOVERNING DIRECTIVES: AFLCR 66-61 MANOI 66-3			
		FMPI IAW MIL-STD-1949 ~~P/O NO1561~~			
		BAKE IAW 4S-1-102 MAOI 74-12			
		STRIP CHROME IAW MIL-STD-871			
		~~GRIND IAW MIL-STD-865~~			
		TEMPER ETCH IAW MIL STD-867			
		SHOTPEEN IAW MIL-S-13165			
		CAD PLATE IAW MIL-STD-870			
		~~CHROME PLATE IAW MIL-STD-150~~			
		TP II CL II P/O N01561			
		FPI IAW MIL-STD 6866			
		IVD PLATE IAW MIL-C-83488A			
		~~ALODINE IAW MIL-C-5541~~			
		MAT'L: 300M 280,000-300,000 KSI			
		COST: $1199.25			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.)			
		AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION			
		WITH THIS DOCUMENT.			
		* COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED FOR MOVES			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89061 | PAGE 2 OF ___ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		(C/P MOVE) BETWEEN OPERATIONS AND DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	*0134 101A			
[redacted]	005	DISASSEMBLE *C/P MOVE		001 MNPGW 002 01 003 SD03	
[redacted]		CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 CL01	
[redacted]		BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89061

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECTION PIN OD 6.623/6.624 WEAR 6.6225		001 MNPGW 002 04 003 EI01	
		CROSS BOLT HOLE ID 2.563/2.565 PIN ID 5.873/5.880 WEAR 5.882 ~~NOTE: A MINIMUM OF TWO FMPI'S~~ ARE REQUIRED ON THIS PART. *C/P MOVE			
[redacted]		REMOVE BUSHINGS		001 MNPGW 002 04 003 EI01	
[redacted]		CROSS BOLT HOLES REPAIR (FOR DEFECT REMOVAL) NICK & BURR HOLES IAW FIG 5-20 *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	044	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	046	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	048	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	050	STRIP CHROME FROM OUTSIDE *C/P MOVE		001 MNPRC 002 02 003 SC02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

21019N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89061 | PAGE 4 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	060	STRIP CHROME FROM INSIDE *C/P MOVE		001 MNPRC 002 02 003 SC02	
8	070	FIRST GRIND O.D. MIN REWORK 6.609. MAINTAIN CONCENTRICITIES 125 RMS *C/P MOVE		001 MNPRB 002 02 003 GE01	
8	080	FIRST GRIND I.D. MAX REWORK 5.893. MAINTAIN CONCENTRICITIES IAW FIG 5-20 125 RMS *C/P MOVE		001 MNPRB 002 02 003 GI05	
8	085	POLISH I.D. MAX REWORK 5.893. MAINTAIN CONCENTRICITIES IAW FIG 5-20 125 RMS		001 MNPRB 002 02 003 BE01	
[redacted]		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNPNA 002 06 003 IE02	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26B	100	BAKE 4 HOURS AT 350 TO 400F WITHIN 8 HRS OF ETCH DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89061 | PAGE 5 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	115	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	120	SHOT PEEN PIN REWORKED AREAS INTENSITY OF .006/.012 * C/P MOVE		001 MNPRC 002 01 003 SP02	
26	123	PREPARE PIN OUTSIDE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED---------- *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	127	PREPARE PIN O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
2[illegible]	130	CHROME PLATE PIN OUTSIDE SUFFICIENT TO GRIND BACK TO O.D. 6.623/6.624		001 MNPRC 002 02 003 CP01 ~~004 CD610~~	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED---------- *C/P MOVE			
2&3	131	BAKE 4 HRS AT 350 TO 400F WITH 4 HRS OF CHROME ~~DATE IN: _____ TIME IN: _____~~ DATE OUT: _____ TIME OUT: _____ * C/P MOVE		001 MNPRC 002 02 003 BK01	
8	132	**FINISH GRIND PIN O.D.** 6.623/6.624. MAINTAIN CONCENTRICITIES 63 RMS ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ (CONTINUED)		001 MNPRB 002 02 003 GE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	238

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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21019N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89061 | PAGE 6 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26B	133	BAKE 4 HRS AT 350 TO 400F DATE IN:---------TIME IN---------		001 MNPRC 002 02 003 BK01	
		DATE OUT:---------TIME OUT:_____ *C/P MOVE			
26	135	PREPARE PIN I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 IL02	
26	137	PREPARE PIN INSIDE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED---------> *C/P MOVE		001 MNPRC 002 02 003 BE01 005 [illegible]	
26	140 ✓	CHROME PLATE PIN INSIDE SUFFICIENT TO GRIND BACK TO I.D. 5.875		001 MNPRC 002 02 003 CP01 005 [illegible]	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED--------> *C/P MOVE		008 CI010	
26B	150	BAKE 4 HOURS AT 350 TO 400F WITH 4 HRS OF CHROME DATE IN:_____TIME IN:_____		001 MNPRC 002 02 003 BK01	
		DATE OUT:_____TIME OUT:_____ * C/P MOVE			
8	170	FINISH GRIND PIN I.D. 5.878/5.880 MAINTAIN CONCENTRICITIES. 63 RMS (CONTINUED)		001 MNPRB 002 02 003 GI05 005 X8P45162	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89061 | PAGE 2 OF ___ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 "Q"
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
26B	180	BAKE 4 HRS AT 350 TO 400F DATE IN:--------TIME IN-------- DATE OUT:--------TIME OUT:-------- *C/P MOVE		001 MNPRL 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * *	M	001 MNPRL 002 02 003 BK01	
26	195	VAPOR DEGREASE *C/P MOVE		001 MNPRO 002 02 003 INSP1	
[redacted]		* C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * *	M	001 MNPRL 002 02 003 BK01	
26	205	PRIOR TO CAD IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRO 002 01 003 BL02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89061 | PAGE 8 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 Q
26	210	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ * C/P MOVE		001 MNPRC 002 03 003 TA01	
262	220	BAKE 24 HOURS AT 350 TO 400F WITHIN 4 HRS OF CAD DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 SP01	
		DATE OUT: _____ TIME OUT: _____ * C/P MOVE			
26	230	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 03 003 IT01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * *	M	001 MNPRC 002 03 003 MO0	
26	240	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 240 MUST BE DONE PRIOR TO (UN OPTION) *C/P MOVE		001 MNPRC 002 03 003 TA01	
26	241	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRL 002 03 003 TA01	
[redacted]	242	PAINT IAW 4S-1-182 & 4S1-93-3 *C/P MOVE		001 MNPOP 002 03 003 WE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	241

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21019N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89061 | PAGE 2 OF 2 PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]	245	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPDP 002 01 003 FA05	
[redacted]	250	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPDP 002 01 003 FA05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	242

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21020N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89035 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 ~~4S1-99-3~~ AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		

13 SERIAL NUMBER	14 NOUN
	ANTI-ROTATION BOLT

17575A 6 7 8

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4612433-101A		NSN 1620001177319 C/N 17575A 17576A ~~17577A~~ 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		FMPI IAW MIL-STD-1949 ~~P/O N01561~~			
		BAKE IAW 4S-1-182 MAOI 74-12			
		GRIND IAW MIL-STD-866			
		~~TEMPER ETCH IAW MIL-STD-867~~			
		SHOT PEEN IAW MIL-S-13165			
		CAD PLATE IAW MIL-STD-870			
		CHROME PLATE IAW MIL-STD-1501 ~~TP II CL III P/O N61821~~			
		FPI IAW MIL-STD-6866			
		STRIP CHROME IAW MIL-STD 871			
		IVD PLATE IAW MIL-C-83488A			
		~~ALODINE IAW MIL-C-5541~~			
		MAT'L 300M 280,000-300,000 KSI			
		COST: $205.09			
		~~ALL PERSONNEL INVOLVED IN THE WORK~~ PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY ~~PRACTICES AND HAZARDS CONTAINED IN~~ THE BASIC TECHNICAL ORDER (T.O._ AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE ~~APPLICABLE T.O.'S AND SUPPLEMENTS~~ WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOUROUGHLY (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	243

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

21020N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 2 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	ANTI-ROTATION BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF ~~EQUIPMENT, PROCESSES & CHEMICALS~~ WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO ~~PRECLUDE INJURIES.~~ *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4012433-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21020N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 3 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	ANTI-ROTATION BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECTION BOLT SHANK O.D. 1.622/1.623 WEAR 1.621 *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	025	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	030	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	035	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	040	STRIP CHROME FROM BOLT SHANK *C/P MOVE		001 MNPRC 002 02 003 SC02	
8	050	FIRST GRIND BOLT SHANK. MIN GRIND SIZE OD 1.609. MAINTAIN EXISTING RADIUS 63 RMS *C/P MOVE		001 MNPRR 002 01 003 GE00	
[redacted]		*C/P MOVE TIME OUT_____DATE OUT_____	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	070	BAKE 4 HOURS AT 350 TO 400F WITHIN 8 HRS OF ETCH *C/P MOVE (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21020N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 4 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	ANTI-ROTATION BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE IN:_____TIME IN:_____ DATE OUT:_____TIME OUT:_____			
[redacted]		*C/P MOVE * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	085	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	090	SHOT PEEN BOLT SHANK INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	093	PREPARE BOLT SHANK FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	097	PREPARE BOLT SHANK FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	100	CHROME PLATE BOLT SHANK SUFFICIENT TO GRIND BACK TO O.D. 1.622/1.623		001 MNPRC 002 02 003 CP01 003 CP010	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE			
26B	110	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE *C/P MOVE (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21020N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89035 | PAGE 5 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	ANTI-ROTATION BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____			
8	120	FINISH GRIND BOLT SHANK. FINISHED DIA OD 1.622/1.623. MAINTAIN EXISTING RADIUS 63 RMS *C/P MOVE		001 MNPRB 002 01 003 GE00	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
26B	130	BAKE 4 HOUR AT 350 TO 400F *C/P MOVE DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	145	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

21020N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 6 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	ANTI-ROTATION BOLT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	155	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	160	CAD PLATE TYPE II CLASS II TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	170	BAKE 24 HRS AT 350 - 400F WITHIN 4 HRS OF CAD PLATE *C/P MOVE DATE IN:_____TIME IN:_____		001 MNPRC 002 02 003 BK01	
		DATE OUT:_____TIME OUT:_____			
26	180	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* WERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	191	IVD PLATE OPTION (INITIATED BY PLATING) IF CHROME REWORK WAS ACCOMPLISHED, OPERATION 170 MUST BE DONE PRIOR TO IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	192	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21020N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	ANTI-ROTATION BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20. "Q"
[redacted]	195	PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21024N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89035 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO
	4S-1-182 ~~4S1-99-3 AND SUPPLEMENTS~~	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		

13 SERIAL NUMBER	14 NOUN
	TRUNNION CROSS BOLT

17575A 6 7 8

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "O"
P/N 4013347-101A		NSN 5306004541547 C/N 17575A 17576A ~~17577A~~ 17578A			
		******* UNIT COST: $238.00 ******* GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		~~IVD PLATE IAW MIL-C-83402A~~			
		FMPI IAW MIL-STD-1949 P/O N01561			
		ALODINE IAW MIL-C-5541			
		~~STRIP CHROME IAW MIL-STD-87~~			
		GRIND IAW MIL-STD-8~~6~~			
		TEMPER ETCH IAW MIL-STD-6~~4~~7			
		SHOT PEEN IAW MIL-S-1316~~5~~			
		~~CAD PLATE IAW MIL-STD-87~~			
		CHROME PLATE IAW MIL-STD-150~~1~~ TYPE II CLASS III P/O N61891			
		FPI IAW MIL-STD-686~~A~~			
		~~BAKE IAW 4S-1-182~~ MAOI 74-12			
		******* 300 M 280/300 KSI *******			
		~~ALL PERSONNEL INVOLVED IN THE WORK~~ PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PPERTINENT SAFETY ~~PRACTICES AND HAZARDS CONTAINED IN~~ THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE ~~T.O.'S AND SUPPLEMENTS WILL ALWAYS~~ BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOUROUGHLY (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	250

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21024N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 2 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	**14 NOUN**	
	TRUNNION CROSS BOLT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		CLEANED & PTOTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 14 IS EQUIVALENT TO DELTA STAMP.			
	001	4013247-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	251

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21024N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 3 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	TRUNNION CROSS BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
	REQD				
[redacted]		E AND I INSPECTION BOLT SHANK O.D. 2.249/2.250 WEAR 2.249 *C/P MOVE		001 MNPGW 002 04 003 EI01	
	REQD				
26	035	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	040	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	045	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	050	STRIP CHROME *C/P MOVE		001 MNPRC 002 02 003 SC02	
69	055	RECENTER IF NECESSARY *C/P MOVE		001 MNPRA 002 02 003 LE03	
8	060	FIRST GRIND BOLT SHANK MINIMUM GRIND SIZE O.D. 2.2350 63 RMS *C/P MOVE		001 MNPRP 002 01 003 GE00	
[redacted]		TIME OUT _____ DATE OUT _____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21024N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 4 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	TRUNNION CROSS BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * * * * * * * * * * * *			
26B	080	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN:_____ TIME IN:_____		001 MNPRC 002 02 003 BK01	
		DATE OUT:_____ TIME OUT:_____ *C/P MOVE			
[redacted]		* * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *C/P MOVE	M	001 MNPNA 002 06 003 NL04	
26	095	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	100	SHOT PEEN BOLT INTENSITY .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	103	PREPARE BOLT SHANK FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 BE01	
26	107	PREPARE FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	110	CHROME PLATE BOLT SHANK SUFFICIENT TO GRIND BACK TO 2.249/2.250 (CONTINUED)		001 MNPRC 002 02 003 CP01 003 CP010	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21024N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 5 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	TRUNNION CROSS BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "O"
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED ——————> *C/P MOVE			
26B	120	BAKE 4 HOURS AT 350 TO 400F WITHIN 4 HRS OF CHROME DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
8	130	FINISH GRIND BOLT SHANK. FINISH DIAMETER O.D. 2.249/2.250. 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED		001 MNPRC 002 01 003 SE00	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
26B	140	BAKE 4 HOURS AT 350 TO 400F DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26 F	155	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21024N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	TRUNNION CROSS BOLT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20 "Q"
[redacted]		*C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		003 ZS01	
		* * * * * * * * * * * * * * * * * *			
26	165	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	170	CAD PLATE TYPE II CLASS II TIME OUT: _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26	180	BAKE 23 HOURS AT 350 TO 400F WITHIN 4 HRS OF CAD PLATE DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	190	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUN *		003 ML04	
		* * * * * * * * * * * * * * * * * *			
26	201	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME REWORK WAS ACCOMPLISHED, OPERATION 180 MUST		001 MNPRC 002 03 003 IV01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	

21024N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 7 OF 7 PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BE DONE PRIOR TO IVD OPTION. *C/P MOVE			
26	202	ALODINE IVD PLATED AREASY (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	205 *REQD*	DEGREASE & PRE-PAINT *C/P MOVE		001 MNPGP 002 09 003 PP01	
[redacted]	206 *REQD*	PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	210 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS PSS		001 MNPGP 002 01 003 MU06	
[redacted]	220 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21025N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 4S1-99-3 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
CSA MAIN		17575A

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4013537-101A		NSN 1620001164433 C/N 17575A 17576A ~~17577A~~ 17578A		6 7 8	
		COST: $250.29 GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		~~SUB PLATE~~ IAW ~~MIL-C-83488A~~			
		FMPI IAW MIL-STD-1949 P/O N01561			
		ALODINE IAW MIL-C-5541			
		~~STRIP CHROME~~ IAW ~~MIL-STD-871~~			
		GRIND IAW MIL-STD-865			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		~~CAD PLATE~~ IAW ~~MIL-STD-870~~			
		CHROME PLATE IAW MIL-STD-1501 TP II CL III P/O N61891			
		FPI IAW MIL-STD-6866			
		~~BAKE~~ IAW ~~4S-1-182~~ MAOI 74-12			
		MAT'L: 300M STEEL (280/300 KSI)			
		~~ALL PERSONNEL INVOLVED IN THE WORK~~ PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY ~~PRACTICES AND HAZARDS CONTAINED IN~~ THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE ~~APPLICABLE T.O.'S AND SUPPLEMENTS~~ WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOUROUGHLY (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21025N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21025N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 2 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DOTA STAMP.			
	001	4013537-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21025N
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21025N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 3 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECTION BOLT SIZE O.D. 2.9985/2.999 WEAR 2.998 ~~*NOTE: A MINIMUM OF 2 FMPI~~ OPERATIONS MUST BE ACCOMPLISHED. *C/P MOVE		001 MNPQW 002 04 003 EI01	
26	025	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	030	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	035	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	040	STRIP CHROME FROM OUTER DIAMETER *C/P MOVE		001 MNPRC 002 02 003 SC02	
69	045	RECENTER IF NECESSARY *C/P MOVE		001 MNPRA 002 02 003 LE03	
8	050	FIRST GRIND BOLT SHANK MIN DIA O.D. 2.9835 MAINTAIN EXISTING RADIUS 63 RMS *C/P MOVE		001 MNPRB 002 01 003 GE00	
[redacted]		*C/P MOVE TIME OUT _____ DATE OUT _____ * * * * * * * * N O T E * * * * * * * * (CONTINUED)	M	001 MNPNA 002 06 003 TE03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21025N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 4 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	070	BAKE 4 HOURS AT 350 TO 400F WITHIN 8 HRS OF ETCH ~~DATE IN: _____ TIME IN: _____~~ DATE OUT: _____ TIME OUT: _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* ~~HERE, TAKE PRODUCTION COUNT~~ *	M	001 MNPNA 002 06 003 ML04	
26	085	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	090	SHOTPEEN INTENSITY OF .008/.12 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	093	PREPARE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		001 MNPRC 002 02 003 BE01	
26	097	PREPARE FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	100	CHROME PLATE SUFFICIENT TO GRIND BACK TO 2.9985/2.999 .		001 MNPRC 002 02 003 CP01 004 CQ01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21025N
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21025N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____ TIME OUT_____ MECHANIC SIGN OFF REQUIRED---------> *C/P MOVE			
26B	110	BAKE 4 HOURS AT 350 TO 400F WITHIN 4 HRS OF CHROME ~~DATE IN:_____ TIME IN:_____~~ DATE OUT:_____ TIME OUT:_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
8	120	FINISH GRIND BOLT SHANK. FINISH DIAMETER O.D. 2.9985/2.999 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE ~~EXCEEDED~~ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE		001 MNPRB 002 01 003 GE00	
26B	130	BAKE 4 HOURS AT 350 TO 400F DATE IN:_____ TIME IN:_____ DATE OUT:_____ TIME OUT:_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	145	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21025N
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21025N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 6 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ZS01	
26	155	PRIOR TO CAD/IVD, GRIT BLAST ALL AREASE TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	160	CAD PLATE TYPE II CLASS II TIME OUT: _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	170	BAKE 23 HOURS AT 350 TO 400F WITHIN 4 HRS OF CAD DATE IN: _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	180	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	191	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME REWORK WAS ACCOMPLISHED, OPERATION 170 MUST (CONTINUED)		001 MNPRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21025N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 7 OF 7 PAGES

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

7. PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BE DONE PRIOR TO IVD OPTION. *C/P MOVE			
26	192	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	193 *REQD*	DEGREASE & PRE-PAINT *C/P MOVE		001 MNPGP 002 09 003 PP01	
[redacted]	195 *REQD*	PAINT IAW 4S-1-182 & 451-93-3 *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21025N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21026N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89035 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 4S1-99-2 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MAIN		17575A

13 SERIAL NUMBER	14 NOUN
	COLLAR LOCK COLLAR

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
P/N 4G1144-7-101A		NSN 1620001157389 C/N 17575A 17576A ~~17577A~~ 17578A		6 7 8	
		*****COST: $3622.35***** GOVERNING DIRECTIVES: AFLCR 64-51 MANOI 66-3			
		~~ALODINE~~ IAW ~~MIL-C-5541~~			
		FMPI IAW MIL-STD-1949 F/O N01561			
		STRIP CAD IAW MIL-STD-871			
		~~CAD PLATE~~ IAW ~~MIL-STD-870~~			
		IVD PLATE IAW MIL-C-83488A			
		TEMPER ETCH IAW MIL-STD-867			
		BLAST IAW MIL-STD-1504			
		~~BAKE~~ IAW ~~4S-1-182~~ MAOI 74-13			
		MAT'L: 300M STEEL (280/300 KSI)*			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * ~~COMPONENTS WILL BE THOROUGHLY~~			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21026N
		B	D	264

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21026N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4011447-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPSP 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	GLASS BEAD BLAST TO REMOVE CORROSION *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21026N
		B	D	

21026N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 3 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	COLLAR LOCK COLLAR

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MN *NA 002 05 003 MS03	
[redacted]	*REQD*	E AND E INSPECTION ~~ATTACHING LUG BUSHINGS I.D.~~ .249/.251 WEAR .2525 FACE TO FACE INSIDE .344/.348		001 MN PGW 002 04 003 EI01	
		ATTACHING LUGS BASE METAL, MAX REWORK I.D. .500 *C/P MOVE			
26	043	VAPOR DEGREASE *C/P MOVE		001 MN PRC 002 03 003 DG01	
26	045	STRIP CAD *C/P MOVE		001 MN PRC 002 02 003 CS01	
26	047	STRIP RUST *C/P MOVE		001 MN PRC 002 02 003 CS02	
69	050	NICK AND BURR *C/P MOVE		001 MN PRA 002 02 003 BE01	
69	052	ATTACHING LUG HOLE (LEFT SIDE) REPAIR. LINE REAM TO CLEANUP, NOT TO EXCEED ID .500 MAINTAIN ~~EXISTING HOLE LOCATIONS.~~ *C/P MOVE		001 MN PRA 002 02 003 BE01	

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21026N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 4 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	054	ATTACHING LUG HOLE (RIGHT SIDE) REPAIR. LINE REAM TO CLEANUP, NOT TO EXCEED ID .500 MAINTAIN EXISTING HOLE LOCATIONS. *C/P MOVE		001 MNPRA 002 02 003 BE01	
[redacted]		DATE OUT ____ TIME OUT ____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
265	057	BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH DATE IN ____ TIME IN ____		001 MNPRL 002 02 003 BK01	
		DATE OUT ____ TIME OUT ____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	060	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	070	SHOT PEEN REWORKED AREA'S INTENSITY OF .005/.010 A2 SHOT SIZE 110 *C/P MOVE		001 MNPRC 002 01 003 SP02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21026N
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21026N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 5 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	**14 NOUN**	
	COLLAR LOCK COLLAR	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	080	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	090	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	100	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	110	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *	M	001 MNPRA 002 06 003 ML01	
26	121	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	122	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	128	MACHINE ATTACHING LUG (LEFT SIDE) BUSHING *C/P MOVE P/N 4613609-103A		001 MNPRA 002 02 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21026N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 6 OF 6 PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	COLLAR LOCK COLLAR

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
69	130	ATTACHING LUG (LEFT SIDE) BUSHING INSTALLATION. PRESS FIT .0004/.002. ~~BRUSH CAD AND INSTALL WITH~~ MIL-C-16173D, GRADE 2, AMD 2 FINISH BUSHING DIA ID .249/.251 FACE TO FACE INSIDE .344/.348 ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ ~~*C/P MOVE~~		001 MNPRA 002 02 003 BE01	
69	138	MACHINE ATTACHING LUG (RIGHT SIDE) BUSHING *C/P MOVE P/N 4013809-103A		001 MNPRA 002 02 003 LE02	
69	140	ATTACHING LUG (RIGHT SIDE) BUSHING INSTALLATION. PRESS FIT .0004/.0012 BRUSH ~~CAD AND INSTALL WITH MIL-C-16173D,~~ GRADE 2, AMD 2 FINISH BUSHING DIA ID .249/.251 FACE TO FACE INSIDE .344/.348 ~~RECORD WEAR DIM IF REWORK LIMITS ARE~~ EXCEEDED _____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ ~~*C/P MOVE~~		001 MNPRA 002 02 003 LE01	
[redacted]	145 *REQD*	PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	150 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
[redacted]	160 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21026N
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AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (MED)

1. DATE	2. JOB ORDER NO	3. QUANTITY	PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
	21030N			89035	1

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
	4S-1-182 4S1-93-3 AND SUPPLEMENTS	17575A 6

13. SERIAL NUMBER	14. NOUN
L5A MLG	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		LOCK RING			7
P/N		NSN C/N			
4012636-101A		1620001157427 17575A [redacted] 17577A 17578A			8
		COST: $7975.25			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-2			
		MAT'L 300M (280-300 KSI)			
		ALL PERSONNEL INVOLVED IN THE WORK			
		PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN			
		THE BASIC TECHNICAL ORDER (T.O.)			
		AND T.O. SUPPLEMENTS REFERENCED IN			
		BLOCK 8 OF THIS AFLC FORM 958. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS			
		WILL ALWAYS BE USED IN CONJUNCTION			
		WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED [illegible]			
		MOVES BETWEEN OPERATIONS [illegible]			
		STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF			
		EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO →			
		PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES.			

21. FINAL DESTINATION *REQ	22. (MANUFACTURING ORGANIZATION) CONTAINED ON SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	
	A 16 IS EQUIVALENT TO DELTA (CONTINUED)	
	B	D
		21020N 270

WORK CONTROL DOCUMENT

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21030N			89035	2 2

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. ASSY MLG LOCK RING WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP.			
	001	4012636-101A			
	005A	Disassembly			
69		MATCH UP		001 MNPRA	
		ROUTES COMPONENTS		002 02	
				003 BEC1	
		NEW SERVICEABLE — REWORKED 958 — NO REWORK			
		LOCK COLLAR GUIDE 21031N COLLAR LOCK RING			
		21032N LOCK RING NUT 21049N			
69		[illegible] COMPONENT		001 MNPRA	
		PARTS		002 02	
		*C/P MOVE		003 BEC1	
69	030	ASSEMBLE COMPONENT PARTS REQUIRED		001 MNPRA	
		OF LOCK RING ASSY PER T.O. [illegible]		002 02	
		*		003 BEC1	
		**********N O T E**********			
		INSURE TORQUE VALUE OF 800 +/- 100			
		INCH POUNDS HAS BEEN MET. GREASE			
		PARTS PRIOR TO ASSEMBLY USING			
		MIL-G-81322 OR EQUAL. *C/P MOVE			
	040	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMNET FOR COMPLETENESS & ACCURACY		002 01	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 MU06	
	050	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	

21. FINAL DESTINATION *C/P MOVE	COORDINATION/INITIATING RCC SIGNATURE/DATE		22 DOCUMENT/SN
DISPATCH *REQD* FUNCTIONAL CODE	A	C	003 MU06
	B	D	21030N

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[redacted] PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21031N			89035	1

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
	4S-1-182 4S1-93-3 AND SUPPLEMENTS	17575A

13. SERIAL NUMBER	14 NOUN
CSA MLG	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20.
		LOCK COLLAR			6
P/N		NSN C/N			7
4613569-101A		1620010751661 17575A 17576A 17577A 17578A			8
		******** UNIT COST: $960.00********			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANUI 66-3 FPI IAW MIL-STD-6866			
		********NAT'L BERYLIUM COPPER******** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN BASIC TECHNICAL ORDERS (T.O.'S) AND			
		T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P NO.) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF			
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	A (CONTINUED)	C	23. DOCUMENT/SN
		B	D	21031N 272

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WORK CONTROL DOCUMENT (MEDS)

1. DATE [redacted] PAGE 1 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21031N			89035	2

7. [redacted] NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		LOCK COLLAR			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	46135AY-101A			
3405	005	DISASSEMBLE *C/P MOVE		001 MNPOP	
	REQD			002 01 003 SD02	
[redacted]	007	CHEM CLEAN *C/P MOVE		001 MNPCN	
	REQD			002 02 003 ML04	
34Z	015	FPI *C/P MOVE		001 MNPNA	
	REQD		M	002 05 003 ZY05	
345	020	E&I INSPECTION		001 MNPSP	
	REQD	VISUAL INSPECT IAW 4S1-93-3 **********WARNING********** SURFACE IS BERYLLIUM-COPPER		002 01 003 ZY05	
		*C/P MOVE			
[redacted]		[redacted] CRACKS,		001 MNPRA	
		REWORK DAMAGED THREADS T.O. 4S1-93-3 125RMS		002 02 003 BE01	
[redacted]		[redacted] KING		001 MNPRA	
		SURFACE .430 MINIMUM C/P *MOVE		002 02 003 LE06	
34Z	040	FPI		001 MNPNA	

21. [redacted] INAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. REMOVE/INSTALL/MOVE (CONTINUED)	C	23. DOCUMENT/SN 002 03 003 ZY05
			D	21031N

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (MEDS)

1. DATE

PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21031N			89035	3 3

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * * N O T E * * * * * * * *			
		IF LAST RCC OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		-	
69	045	HOLD FOR REASSEMBLY PURPOSES *		001 MNPPA	
	READY	*C/P MOVE		002 02 003 BE01	
20 69	250	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPQP	
	READY	DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS RCC		002 01 003 ***	
8 69	250	FINAL PRODUCT WEIGHT INTO DEPOT		001 MNPQ	
	READY	*C/P MOVE		002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21031N

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WORK CONTROL DOCUMENT (MEDS)

1 DATE | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21032N			89035	1

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
	4S-1-182 4S1-73-3 AND SUPPLEMENTS	17575A 6

13. SERIAL NUMBER	14 NOUN
SA MLG	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LOCK			T
P/N		NSN C/N			8
4011241?-101A		1620001357841 17575A 17576A 17577A 17578A			
		******* UNIT COST: $992.16 *******			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949 P/O N61641			
		STRIP CHROme IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165			
		CHROME PLATE IAW MIL-STD-1501 TP II CL III P/O N61891 DRY FILM LUBE IAW MIL-L-46010 PHOSPHATE TREATMENT IAW DOD-P-16232 P/O N73061			
		FPI IAW MIL-STD-6866 BAKE IAW 4S-1-182 MAOI 74-12			
		*****MAT'L 300M (280/300 KSI)***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.)			
		AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			

21. FINAL DESTINATION* DISPATCH	FUNCTIONAL CODE	COMPONENTS COORDINATION/SIGNATURE/DATE		23. DOCUMENT/SN
		CLEANED & PROTECTED (C/P REMOVE) FOR (CONTINUED)		
		B	D	21032N 825

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WORK CONTROL DOCUMENT (WCD)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21032N			89035	2

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LOWER CASTING			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G13412-101A			
24C5	005	DISASSEMBLE *C/P MOVE		001 MNPGP	
	REQD			002 01 003 SD03	
24C	007	CHEM CLEAN *C/P MOVE		001 MNPGW	
	REQD			002 03 003 SL01	
34B	009	BLAST CLEAN *C/P MOVE		001 MNPGW	
	REQD			002 03 003 BL01	
34B	011	BAKE 4 HRS AT 350-400F		001 MNPGW	
	REQD	DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____		002 03 003 BK03	

21. FINAL DESTINATION *C/P MOVE		COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21032N

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WORK CONTROL DOCUMENT (MEDS)

[redacted] DATE [redacted] PAGE [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21032N			89035	3

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LOWER			
34M	013	FMPI *C/P MOVE		001 MNPNA	
	REQD		M	002 05 003 MS03	
34E	018	E & I INSPECTION		001 MNPGW	
	REQD	CHROMED DIA 11.801/11.799 WEAR11.797 CHECK ROTATIONAL FREE PLAY OF SPLINE MAX 0 TO 15 DEGREES		002 04 003 EI01	
34E	019	VISUAL INSPECT SURFACE DAMAGE *C/P MOVE NICK & BURR; IF SPLINES ARE		001 MNPGW	
		REWORKED RECHECK ROTATIONAL FREE PLAY *C/P MOVE		002 04 003 EI01	
26	050	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
26	060	STRIP CHROME FROM MAJOR O.D.		002 03 003 DG01 001 MNPRC	
26	065	*C/P MOVE STRIP CHROME FROM SHOULDER AREA		002 02 003 SC02 001 MNPRC	
[redacted]	070	*C/P MOVE GRI[redacted]E		002 02 003 SC02 001 MNPRB	
		CORROSION ON FACE OF TEETH=MIN. OVERALL DIM. OF 1.84 WITH 63RMS FIN. *C/P MOVE		002 03 003 GR01	
[redacted]		[redacted] OF TEETH 0.020-		001 MNPRB	
		0.040 X 45 + OR [redacted] *C/P MOVE		002 03 003 BE01 001 MNPRB	
[redacted]		[redacted] T TO DIA		[redacted]	
21. FINAL DESTINATION		11.80[redacted]11.7[redacted] COORDINATION/INITIATING OFFICE SIGNATURE/DATE		[redacted] DOCUMENTATION	
DISPATCH	FUNCTIONAL CODE	TO EXCEED MIN. DIM. OF .875 AS (CONTINUED)		003 BE05 005 X8745272	
		B	D		

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[redacted] MONITOR CONTROL DOCUMENT [redacted] | DATE [redacted] | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21032N			89035	4

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LOWER END			
		MEASURED FROM FACE TO SHOULDER.			
		DIA A & B PERPENDICULAR WITHIN .001 INCH PER INCH *C/P MOVE			
		[redacted]		001 MNPRB	
		MIN. O.D. 11.783 DIA A & B PERPENDICULAR WITHIN .001 INCH PER INCH *C/P MOVE		002 03 003 GEC5 005 X8745172	
26	100	TEMPER ETCH REWORKED AREAS OF TEETH		001 MNPNA	
		TIME OUT_____DATE OUT_____ *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	002 06 003 TEC3	
		HERE, TAKE PRODUCTION COUNT *			
26	110	TEMPER ETCH MAJ. DIA.		001 MNPNA	
		TIME OUT_____DATE OUT_____ *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	002 06 003 TEC3	
		HERE, TAKE PRODUCTION COUNT *			
26	120	TEMPER ETCH SMOOTH COLLAR		001 MNPNA	
		TIME OUT_____DATE OUT_____ *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	002 06 003 TEC3	
		HERE, TAKE PRODUCTION COUNT *			
26B	130	BAKE 4 HRS AT 350 TO 400 F WITHIN 8		001 MNPRC	
		HRS OF ETCH DATE IN:_____TIME IN:_____		002 02 003 BKC4	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	DATE OUT: COORDINATION/ROUTING/RCC SIGNATURE/DATE		23. DOCUMENT/SER
		A MOVE	C	
		B	D	21032N 228

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[redacted] WORK CONTROL DOCUMENT (MED9) | 1. DATE | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21032N			89035	5

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. COLLAR LOWER TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
9A	140	FMPI *C/P MOVE		001 MNPNA	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *		002 06 003 MLQ4	
24	142	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
24	145	GRIT BLAST SPLINES TO REMOVE CORROSION/RIDGES NOT EXCEEDING .010 DEPTH. *C/P MOVE		002 03 003 DG01 001 MNPRC 002 01 003 BL02	
26	150	SHOT PEEN GROUND FACES OF TEETH .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	160	SHOT PEEN MAJ. DIA. .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	170	SHOT PEEN SHOULDER AREA OF MAJ. DIA		001 MNPRC	
26	175	SHOT PEEN SPLINES AFTER GRIT BLAST .008-.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	176	PREPARE MAJOR DIA FOR CHROME		001 MNPRC	
26	178	PLATE, GRIT BLAST *C/P MOVE PREPARE MAJOR DIA FOR CHROME		002 01 003 BL04 001 MNPRC	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. MASK CODE/INSPECTION/TESTING RCC SIGNATURE/DATE		23. DOCUMENTATION
		MECHANIC SIGN OFF REQUIRED---------->		003 BEQ1 005 X8120918
		B	D	21032N

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[redacted] WORK CONTROL DOCUMENT [redacted] PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21032N			89035	6

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LOWER TORQUE			
26	180	CHROME PLATE MAJOR DIA SUFFICIENT		001 MNPRC	
		TO GRIND BACK TO 11.801		002 02	
				003 CP01	
		DATE OUT_____TIME OUT_____		005 X8120918	
		MECHANIC SIGN OFF REQUIRED----------		002 00010	
		*C/P MOVE			
26B	200	BAKE 23 HRS AT 350-400F WITHIN 4 HRS		001 MNPRC	
		OF CHROME		002 02	
		DATE IN:_____TIME IN:_____		003 BK01	
		DATE OUT:_____TIME OUT:_____			
		*C/P MOVE			
[redacted]				001 MNPRB	
		O.D. 11.801/11.799 CHROME RUN OUT		002 03	
		ALLOWED 63 RMS SEE FIG 5-32		003 GE05	
		DIA A & B PERPENDICULAR WITHIN .001		005 X8745172	
		INCH PER INCH			
		RECORD WEAR DIM IF REWORK LIMITS ARE			
		EXCEEDED_____			
		RECORD REASON & CAUSE FOR EXCEEDING			
		REWORK LIMITS			
		*C/P MOVE			
26B	210	BAKE 4 HRS AT 350-400F		001 MNPRC	
				002 02	
		DATE IN:_____TIME IN:_____		003 BK01	
		DATE OUT_____TIME OUT_____			
		*C/P MOVE			
8A	220	FMPI *C/P MOVE		001 MNPRA	

21. FINAL DESTINATION		22. * COORDINATION/INITIATING RCC SIGNATURE/DATE *	002 DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	LAST NDI OPERATION IS COMPLETED * (CONTINUED)	003 ML04
			21032N 200

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WORK CONTROL DOCUMENT (MEDS)

1. DATE	PAGE

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21032N			89035	7

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

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

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LOWER HERE, TAKE PRODUCTION COUNT *			
24	225	* * * * * * * * * * * * * * * * * * * VAPOR DEGREASE *C/P MOVE		001 MNPRC	
24A	230	FPI *C/P MOVE		002 03 003 DG01 001 MNPNA	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ZS01	
25	270	PREPARE FOR PHOSPHATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
25	280	PHOSPHATE TREATMENT FINISH TYPE M *C/P MOVE		001 MNPRC 002 03 003 PH01	
26B	290	BAKE 3 HRS AT [illegible]-250°		001 MNPRC 002 02 003 BK02	
		DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE			
26	300	DRY FILM LUBE ON SHOULDER ADJACENT TO 11.801 DIA. MAX THICKNESS .001 *C/P MOVE		001 MNPRC 002 03 003 EL01	
26B	310	BAKE 1 HR AT 400 DEGREES F (CONTINUED)		001 MNPRC 002 DOCUMENTION 003 BK02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE	
DISPATCH	FUNCTIONAL CODE	IN_____TIME IN_____	
		a	b

21032N

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[redacted] WORK CONTROL DOCUMENT (REDS) [redacted] PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21032N			89035	8 8

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLLAR LO[redacted]			
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
[redacted]				001 MNPRA	
		*C/P MOVE		002 02	
	REQD			003 BE01	
34 05	320	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
	REQD	OF ALL PRECEDING OPERATIONS THIS 95[redacted]		003 MU06	
34 05	320	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
		*C/P MOVE		002 01	
	REQD			003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SER
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21032N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-168

[redacted] DOCUMENT (MED[redacted] | DATE [redacted] | PAGE [redacted] OF [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21033N			89035	1

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
	4S-1-182/4S1-93-3 & SUPPLEMENTS	17575A

13. SERIAL NUMBER	14 NOUN
C5A MLG	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "D"
		UPPER PLA[redacted]			6
P/N		NSN C/N			7
4G12423-101A		1620004182976 17575A 17576A 17577A 17578A			8
		****COST: $195.34****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 SHOTPEEN I A W MIL-S-13165 F.P.I. I A W MIL-STD-6866			
		ANODIZE I A W MIL-A-8625 ALODINE I A W MIL-C-5541 STRIP I A W MIL-STD-871 **MAT'L 7075-T73 A L U M I N U M**			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS [redacted]			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY			
		CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"**********			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	PERSONNEL, CONFIGURATION, IDENTIFICATION, INSPECTION/DATE	23. DOCUMENT/SER
		PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)	
			21033N 2 [redacted]

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985—461-163

[illegible] CONTROL DOCUMENT (MEDS) | DATE | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21033N			89035	2

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		UPPER PLA[illegible]			
		PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4812493-101A			
3405	005	DISASSEMBLE *C/P MOVE		001 MNP	GP
	REQD			002 01 003 SDQ	3
34E	007	CHEM CLEAN *C/P MOVE		001 MNP	GW
	REQD			002 03 003 ACQ	2
349	009	BLAST CLEAN *C/P MOVE		001 MNP	GW
	REQD			002 03 003 BLQ	7
[redacted]		*C/P MOVE		001 MNP	NA
	REQD			002 05 003 ZYQ	5
34E	018	E & I		001 MNP	GW
	REQD	BEARING BORE I.D. 3.3465-3.3475-3.348 SHAFT HOLES I.D. SMALL .7490-7505/LARGE .8120-.8135 *C/P MOVE		002 04 003 EIQ	1
34E	019	NICK & BURR REPAIR *C/P MOVE		001 MNP	GW
				002 04 003 EIQ	1
[redacted]				001 MNP	R[illegible]
		SMALL HOLE [illegible] [illegible]505 #.950 *C/P MOVE		002 [illegible] 003 MV02 005 X8852123	

21. FINAL DESTINATION		COORDINATION/INITIATING RCC SIGNATURE/DATE		DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	B	D	21033N

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (WCD)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ/RCC	5. DATE SCHED	6. DATE COMPLETED
21033N			89035	3

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

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

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		UPPER PLA[illegible]			
[illegible]		[illegible] REPAIR (LARGE) OVERSIZE		001 MNPRA	
		LARGE HOLE AS REQUIRED TO CLEAN UP .8935/.950 *C/P MOVE		002 04 003 MV02 005 X8852123	
[illegible]		[illegible] REPAIR OVERSIZE BEARING		001 MNPRA	
		BORE AS REQUIRED TO CLEAN UP 3.650 MAX *C/P MOVE		002 04 003 MV02 005 X8852123	
26	030	REMOVE INSERTS (4EA) P/N MS124738		001 MNPRA	
		ONLY IF ANODIZE STRIP IS REQUIRED *C/P MOVE		002 02 003 BE01	
26	040	STRIP ANODIZE		001 MNPRC	
		*C/P MOVE		002 03 003 AN04	
26A	045	FPI *C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * * *	M	002 06 003 ZA02	
26	050	SHOTPEEN REWORKED AREAS		001 MNPRC	
		.008-.010 A *C/P MOVE		002 01 003 SP01	
26	060	ANODIZE TYPE II		001 MNPRC	
		*C/P MOVE		002 03 003 AS03	
26	070	ALODINE		001 MNPRC	
		*C/P MOVE		002 03 003 IA01	
[illegible]		[illegible] QUAST HOLE BUSHING (SMALL)		001 MNPRA	

21. FINAL DESTINATION MFG FROM 70	[illegible]	[illegible] SIGNATURE/DATE	002 DOCUMENT/SN

DISPATCH	FUNCTIONAL CODE	A	B	C	D
					21033N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (LCD)

PAGE [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21033N			89035	4 4

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

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

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		UPPER PLATE			
69	073	INSTALL SHAFT HOLE (SMALL) BUSHING		001 MNPRA	
		WITH MIL-C-16173D COMPOUND.0003-.001 PRESS FIT .7490-.7505 ID *C/P MOVE		002 02 003 BEQ1	
69	074	MACHINE SHAFT HOLE BUSHING (LARGE)		001 MNPRA	
		MFG FROM 7075-T6/6061-T6 ALUM		002 02 003 LEQ2	
69	075	INSTALL SHAFT HOLE (LARGE) BUSHING		001 MNPRA	
		WITH MIL-C-16173D COMPOUND.0003-.001 PRESS FIT .8120-.8135 ID *C/P MOVE		002 02 003 BEQ1	
69	076	MACHINE BEARING BORE BUSHING		001 MNPRA	
		FROM 7076-T6/6061-T6 ALUM		002 02 003 LEQ6	
69	077	INSTALL BEARING BORE BUSHING		001 MNPRA	
		WITH MIL-C-16173 COMPOUND .0003-.001 PRESS FIT 3.3465-3.3475 ID RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED		002 02 003 BEQ1	
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
69	078	INSTALL INSERTS (4EA)		001 MNPRA	
		*C/P MOVE P/N MS124738		002 02 003 BEQ1	
34C5	080	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
	REQD	DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		002 01 003 MUQ67	
34C5	090	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
	REQD	*C/P MOVE		002 01 003 MUQ[redacted]	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	B
		B	D	[redacted]

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

[redacted] ORDER CONTROL DOCUMENT [redacted] 1 DATE [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21034N			89050	1

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
	4S-1-182 4S1-93-3 AND SUPPLEMENTS	17575A 6 7 8

13. SERIAL NUMBER	14 NOUN
C-5A MLG	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ANCHOR SHACKLE			
P/N		NSN C/N			
4G13366-101A		1620002284716LE 17575A 17576A 17577A 17578A			
		*****COST: $299.98*****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		IVD PLATE IAW MIL-C-83488A FMPI IAW MIL-STD-1949			
		P/O N01561 STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-865 TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165 FPI IAW MIL-STD-6866 CAD PLATE IAW MIL-STD-870 CHROME PLATE IAW MIL-STD-1501			
		P/O N01871 BAKE IAW 4S-1-182 MADI 74-12 ALODINE IAW MIL-C-5541			
		MAT'L 4330 M [illegible] OR 300M 260,000-280,000 KSI ALL PERSONNEL INVOLVED IN THE WORK			
		PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE APPLICABLE T.O.'S AND SUPPLEMENTS			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	WILL ALWAYS BE ENTERED IN THIS BLOCK (CONTINUED)	SIGNATURE/INITIALS/STAMP/DATE	22. DOCUMENT NO
				21034N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

		*COMPONENTS WILL BE THOROUGHLY
		CLEANED & PROTECTED (C/P MOVE FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.
		REQ'D (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.
	001	4013366-101A
[redacted]	010	DISASSEMBLE *C/P MOVE

WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21034N			89050	3

7. P[redacted]UMBER	8 TECH DATA	9. ITEM SERIAL NO.

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

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

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

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1. DATE

PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21034N			89050	4

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

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

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		ANCHOR SHANK			
24	055	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 06	
				003 DG01	
24	060	STRIP CHROME FROM LARGE AND/OR		001 MNPR06	
		SMALL JOURNALS. *NOTE* IF ONE JOURNAL IS DEFECTIVE, BOTH JOURNALS MUST BE REWORKED. *C/P MOVE		002 02 003 SC02	
24	070	STRIP CHROME FROM TAPERED AREA O.D.		001 MNPRC	
		IF NOT PREVIOUSLY ACCOMPLISHED *C/P MOVE		002 02 003 SC02	
8	080	GRIND LARGE JOURNAL TO CLEAN-UP 1.921 MINIMUM *C/P MOVE		001 MNPR08 002 02 003 GE01	
8	090	GRIND SMALL JOURNAL TO CLEAN-UP 1.0577 MINIMUM *C/P MOVE		001 MNPR08 002 02 003 GE01	
		[redacted]		001 MNPRC	
		*C/P MOVE TIME OUT_____ DATE OUT_____ * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	002 06 003 TE03	
		HERE, TAKE PRODUCTION COUNT *			
26B	110	BAKE 4 HRS AT 375-400F WITHIN 8 HRS		001 MNPRC	
		OF ETCH. DATE IN_____ TIME IN_____		002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	DATE OUT_____ TIME OUT_____ (CONTINUED)		
		B	D	21034N

[redacted] OF TECHNICAL DOCUMENT [redacted] DATE [redacted] PAGE [redacted] OF [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21034N			89050	5

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ANCHOR SH[redacted]			
		*C/P MOVE			
		[redacted] RADIUS OF TAPERED AREA		001 MNPNA	
		IS CRITICAL.	M	002 06	
		*C/P MOVE		003 ML04	
		* * * * * * * N O T E * * * * * * *			
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * *			
26 [redacted]	125	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 DG01	
26 [redacted]	130	SHOTPEEN LARGE JOURNAL .008-.012 A2		001 MNPRC	
		*C/P MOVE		002 01	
				003 SP02	
26 [redacted]	131	SHOTPEEN SMALL JOURNAL .008-.012 A2		001 MNPRC	
		*C/P MOVE		002 01	
				003 SP02	
[redacted]	132	SHOTPEEN TAPERED AREA U.U. .008-		001 MNPRC	
		.010".		002 01	
	REOD	*C/P MOVE		003 SP02	
26 [redacted]	133	PREPARE JOURNALS FOR CHROME PLATE,		001 MNPRC	
		MASK/FIXTURE/ETC *C/P MOVE		002 02	
				003 BE01	
26 [redacted]	137	PREPARE JOURNALS FOR CHROME PLATE,		001 MNPRC	
		GRIT BLAST *C/P MOVE		002 01	
				003 BL04	
26 [redacted]	140	CHROME PLATE LARGE JOURNAL		001 MNPRC	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	TYPE OF CLASSIFICATION INITIATING RCC SIGNATURE/DATE		22 DOCUMENT/SER
		F[redacted]FICIENT TO GRIND BACK (CONTINUED)	TO 1.936	003 CP01 008 CD010
		B	D	21034N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

TIME OUT DATE OUT

*C/P MOVE

CHROME PLATE SMALL JOURNAL

TYPE II CLASS III

TIME OUT DATE OUT

*C/P MOVE

BAKE 4 HRS AT 375-400F

WITHIN 4 HRS OF CHROME

DATE IN TIME IN

DATE OUT TIME OUT

*C/P MOVE

[redacted]

1.935/1.936. 63 RMS FINISH OR
BETTER. CHROME MAY SHADE OUT
.080 MAX FROM EDGES.

RECORD WEAR DIM IF REWORK LIMITS ARE

EXCEEDED

RECORD REASON & CAUSE FOR EXCEEDING

REWORK LIMITS

*C/P MOVE

[redacted] WORK CONTROL DOCUMENT [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21034N	[redacted]		89050	7

7. P[redacted] NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ANCHOR SH[redacted]			
		[redacted]		001 MNPRB	
		OF JOURNALS.		002 02	
		*C/P MOVE		003 9E01	
26[redacted]	190	BAKE 4 HRS AT 375-400F		001 MNPRC	
		*C/P MOVE		002 02	
		DATE IN_____TIME OUT_____		003 BK01	
		DATE OUT_____TIME OUT_____			
[redacted]		[redacted]US OF TAPERED AREA IS		001 MNPRA	
		CRITICAL *C/P MOVE	R	002 02	
		* * * * * * * * N O T E * * * * * * * *		003 ML04	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * * * *			
[redacted]	205	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 02	
				003 BK01	
[redacted]		*C/P MOVE		001 MNPRA	
		* * * * * * * * N O T E * * * * * * * *	R	002 02	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		003 2S01	
		* * * * * * * * * * * * * * * * * * * *			
26[redacted]	215	PRIOR TO CAD/IVD, GRIT BLAST ALL		001 MNPRC	
		AREAS TO BE CAD/IVD PLATED		002 01	
		*C/P MOVE		003 BL04	
26[redacted]	220	CAD PLATE ALL AREAS NOT CHROMED		001 MNPRC	

21. [redacted]NAL DESTINATION DISPATCH	FUNCTIONAL CLASS CODE	22. INCLUDING TOOLING COORDINATION/INITIATING ECC SIGNATURE/DATE		23. DOCUMENT/SN
		A (CONTINUED)	C	003 CA01
		B	D	21034N

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT/MEDIA

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21034N			89050	8.

7. P[redacted]UMBER	8 TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ANCHOR SHOWN			
		TIME OUT DATE OUT			
		*C/P MOVE			
26[redacted]	230	BAKE 23 HRS AT 375-400F		001 MNPRC	
		WITHIN 4 HRS OF CAD.		002 02	
		DATE IN TIME IN		003 BK01	
		DATE OUT TIME OUT			
[redacted]	240	*C/P MOVE			
		CHROMATE CONVERSION COATING		001 MN[illegible]	
		INITIATED *C/P MOVE		002 02	
				003 IR01	
[redacted]		RADIUS OF TAPERED AREA IS		001 MNPNA	
		CRITICAL. SUBSTITUTE MAT'L CAN	M	002 06	
		BE 300M (280-300KSI)		003 ML04	
		*C/P MOVE			
		* * * * * * * * N O T E * * * * * * * *			
		** LAST MFG OPERATION IS COMPLETED**			
		MFG. FAB PRODUCTION COUNT			
[redacted]	251	* * * * * * * * * * * * * * * * * * * *		[illegible]	
		[illegible] INITIATED BY PLATING			
		*NOTE IF FINGER PLATE REWORK WAS		[illegible]	
		ACCOMPLISHED, OPERATION 230 MUST		002 02	
		DONE PRIOR TO IVD OPTION.		003 IV01	
		*C/P MOVE			
26[redacted]	252	ALODINE IVD PLATED AREAS		001 MNPRC	
		(INITIATED BY PLATING)		002 03	
		*C/P MOVE		003 TA01	
[redacted]		*C/P MOVE		001 MNPRA	

21. [redacted]NAL DESTINATION I.A.W	22.TO 4[illegible] ORIGINATION/INITIATING RCC SIGNATURE/DATE	002 DOCUMENT/SN
DISPATCH / FUNCTIONAL CODE	L 83859-8-12 / C	003 LE02
	B / D	21034N

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT (MEDS)

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21034N			89050	9 9

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ANCHOR SH[redacted]			
		[redacted]		001 MNPRA	
		AND FINISH I.D. IAW TO 451-93-3		002 02	
		125 RMS *C/P MOVE		003 BEQ1	
		[redacted]		001 MNPRA	
		*C/P MOVE		002 02	
				003 BEQ1	
[redacted]	275	PRIMER PAINT I.D. & PAINT TAPERED		001 MNPGP	
		AREA.		002 09	
	REQD	*C/P MOVE		003 WB03	
2305	280	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
	REQD	OF ALL PRECEDING OPERATIONS 1-IS 95[redacted]		003 MU06	
[redacted]	290	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
		*C/P MOVE		002 01	
	REQD			003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21034N 294

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-183

21035N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 1 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 4S1-99-3 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MLG		
13 SERIAL NUMBER	**14 NOUN**	
	COLLAR LOCK INSERT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
P/N 4G13563-103A		NSN 1620005168457 C/N 17575A **17576A** 17577A 17578A			
		****COST: $1335.01***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 IVD PLATE IAW MIL-C-83488A			
		FMPI IAW MIL-STD-1949 P/O N01561 TEMPER ETCH IAW MIL-STD-867 CAD PLATE IAW MIL-STD-870			
		4S-1-182 BAKE IAW 4S-1-182 MAOI 74-12 ALODINE IAW MIL-C-5541			
		**MAT'L 300M 280,000-300,000 KSI ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEENOPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21035N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 2 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	COLLAR LOCK INSERT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECUATIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA			
		STAMP.			
	001	4013563-103A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		M	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		M	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		M	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____			
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	K	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21035N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 3 OF __ PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	COLLAR LOCK INSERT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	E & I CHECK ALL AREAS FOR DAMAGE AND CORROSION. REMOVE MINOR NICKS AND DEFECTS. *C/P MOVE			
[redacted]		[redacted]LL REWORKED AREAS TIME OUT_____DATE OUT_____ *C/P MOVE	M	K	
		* * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	060	BAKE 4 HRS AT 350-400F WITHIN 8 HRS DATE IN_____TIME IN_____			
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	K	
		* * * * * * * * * * * * * * * * * * * *			
26	072	VAPOR DEGREASE *C/P MOVE			
26	074	STRIP CAD *C/P MOVE			
26	076	STRIP RUST *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	

FLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21069N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89043 | PAGE 1 OF __ PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
1652A		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
4G94034-101A		

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MLG	1620001486466	1603-2-80-3 4S-1-182 AND SUPPLEMENTS
13 SERIAL NUMBER	**14 NOUN**	
	BALL SCREW ASSY.	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK			
		PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION			
		WITH THIS DOCUMENT. *COMPONENTS WILLBE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH			
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN			
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G94034-101A			
34C5	010	*MATCH-UP* ----------ROUTED COMPONENTS---------- NEW/SERVICEABLE REWORK NO REWORK (CONTINUED)		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21069N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21069N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89043 | PAGE 2 OF ___ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BALLSCREW 21065N BALL NUT			
		21066N DOG STOP 21067N HEX NUT			
		21068N			
34C5	015 *REQD*	INSURE BALL NUT AND BALLSCREW ARE A MATCHED SET		001 MNPGP 002 01 003 MU06	
34C5	020 *REQD*	PRE ASSEMBLY INSPECTION INSPECT ALL COMPONENTS FOR GENERAL CONDITION * NOTE: * BALL BEARINGS WILL BE		001 MNPGP 002 01 003 LA02	
		REPLACED 100% AT EACH OVERHAUL. REPLACEMENT BALLS MUST HAVE A DIAMETER EQUAL TO OR GREATER THAN THE DIAMETER OF BALLS REMOVED AT			
		DISASSY.			
34C5	025 *REQD*	INSTALL FELT SEALS IN SCRAPERS AND INSTALL A NEW "O" RING ON THE SCRAPER WITH THE "O" RING GROOVE. INSTALL 4 EA SCRAPER DRIVE PINS IN		001 MNPGP 002 01 003 LA02 004 PA0003	
		BORE OF BALLNUT			
34C5	030 *REQD*	ASSEMBLE - NOTE: BALLS MUST BE EQUAL TO OR GREATER THAN BALLS REMOVED AT DISASSEMBLY - ALSO, BALLS MUST BE (CONTINUED)	M	001 MNPGP 002 01 003 LA02 004 PA0003	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
ATCH	FUNCTIONAL CODE	A	C	21069N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21069N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 |

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		THE SAME SIZE. (DO NOT MIX SIZES) AND REPLACED 100%			
34C5	035 *REQD*	INSTALL SELECTED BALLS IN COUNTER BORE HOLES ONE CIRCUIT AT A TIME, BY DROPING IN SEVERAL BALLS AT A TIME AND ROTATING THE SCREW WHILE		001 MNPGP 002 01 003 LA02 004 PA0003	
		HOLDING NUT STATIONARY TO MAKE ROOM FOR MORE BALLS. * * * * * * *N O T E * * * * * * * * * EACH OF THE TWO OUTER CIRCUITS OF			
		2 2/3 TURNS HOLD FROM 55 TO 57 BALLS. THE CENTER CIRCUIT OF 3-2/3 HOLDS 74 TO 76 BALLS			
34C5	040 *REQD*	WHEN CIRCUIT IS FULL INSTALL REMAINDER OF BALLS IN RETURN TUBES FILL BOTH ENDS WITH GREASE TO KEEP BALLS FROM FALLING OUT.		001 MNPGP 002 01 003 LA02 004 PA0003	
		OF THE NUT.			
34C5A	045 *REQD*	INSERT SHORT TUBES INTO TUBE HOLES OF FILLED CIRCUITS AND PRESS OR TAP GENTLY TO SEAL ENDS OF TUBS IN BOTTOM OF TUBE HOLES IN BALL NUT.		001 MNPGP 002 01 003 LA02 004 PA0003	
		HOLD IN PLACE WITH TAPE.			
34C5A	050 *REQD*	LOAD THE COUNTER BORE OF THE CENTER CIRCUIT AND FILL THE LONG TUBE AND GENTLY PRESS INTO BALLNUT. REMOVE TAPE AND HEXNUTS AND POSITION CLAMP		001 MNPGP 002 01 003 LA02 004 PA0003	
		OVER TUBES AND SECURE HEXNUTS.			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21069N
		B	D	

21069N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 | PAGE 4 OF ___ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34C5	055 *REQD*	USING A DIAL INDICATIOR, CHECK BACK LASH APPLY AN AXIAL FORCE OF APPROX 50 LBS. SET DIAL INDICATOR ON FACE OF BALLNUT AND ZERO THE SUM OF READING MUST NOT EXCEED 0.040		001 MNPGP 002 01 003 LA02 004 PA0003	
34C5	060 *REQD*	SAFETY WIRE THE HEXNUTS SECURING THE DEFLECTOR YOKES. APPLY SEALER AROUND BALL RETURN TUBES WITH PR-1422 AF OR EQUIVALENT AND ALLOW TO CORE 24 HOURS.		001 MNPGP 002 01 003 LA02 004 PA0003	
34C5	065 *REQD*	INSTALL A NEW 90 DEGREE ZERK AND FILL BALLNUT WITH GREASE (81322) UNTIL A SMALL AMOUT COMES OUT THE BOTTOM OF BALLNUT.		001 MNPGP 002 01 003 LA02 004 PA0003	
34C5	070 *REQD*	FUNCTIONAL TEST ROTATE BALLNUT BY HAND THROUGH ONE FULL STROKE IN BOTH DIRECTIONS. THE UNIT SHOULD OPERATE SMOOTHLY WITH NO KNOCKS OR CLICKS HEARD OR FELT.		001 MNPGP 002 01 003 LA02 004 PA0003	
34C5	075 *REQD*	APPLY A THIN COAT OF GREASE MIL-6-81322 TO ENTIRE LENGTH OF SCREW. APPLY A COAT OF EMRALON AMS - 3136 NO 310 OR EQUIVALENT TO THE TOP 7.5 INS OF SCREW.		001 MNPGP 002 01 003 LA02 004 PA0003	
34C5	080 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.		001 MNPGP 002 [illegible] 00[illegible]	

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

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21069N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043 PAGE [redacted]

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

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

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

13. SERIAL NUMBER	14 NOUN
	BALL SCREW ASSY.

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
3405	085	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 LA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21069N
		B	D	

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21088N **WORK CONTROL DOCUMENT (MEDS)** [redacted] 89043 [redacted] PAGE__OF__PAGES

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C-5A MLO		AF DWG 7926445 451-93-3 451-182

13. SERIAL NUMBER	14. NOUN
	PISTON SUB-ASSY

17687
17575
6
7
8

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
P/N 7926445		NSN 1620010805925 C/N 17687A 17575A [redacted] 17577A 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANUI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		********** A N D ********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT [redacted]			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	7926445			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21088N
		B	D	

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
[redacted]		

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

13. SERIAL NUMBER	14 NOUN
	PISTON [redacted]

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	010	* *MATCH - DP* *		001 MNP	
				002 01	
		NEW/SERVICEABLE REWORKED NO REWORK		003 MU06	
		INNER CYL			
		21002N			
		FLOATING PISTON			
		2104?N			
		PISTON CARRIER			
		21052N			
		PISTON STOP TUBE			
		2104?N			
		METERING TUBE BASE			
		21058N			
		GAUGE			
		2105?N			
[redacted]	015	PREASSEMBLY CLEANING; INSPECT ALL		001 MNP	
		CAVITIES AND PASSAGES FOR		002 01	
	REQD	CLEANLINESS AND SCRATCHES OK TO		003 PA07	
		ASSEMBLE/OR CLOSE			
[redacted]	020	ASSEMBLE TOGETHER ALL PARTS REQUIRED		001 MNP	
		TO BUILD THE HIGH PRESSURE PISTON		002 01	
	REQD	ASSY AND INSTALL INTO INNER CYL		003 PA07	
[redacted]	025	POUR APPROX 1 PT LIGHT OIL INTO		001 MNP	
		LOWER CHAMBER. PLACE BYPASS* INTO		002 01	
	REQD	TEST FIXTURE AN SECURE.		003 PA07	
				004 PA0001	
[redacted]	030	CHARGE PISTON SUBASSY WITH 2100 PSI		001 MNP	
		AND TEST IAW 421-93-2 PARA 6-6 PAGE		002 01	
	REQD	6-10		003 PA07	
				004 PA0001	
[redacted]	035	RECORD LEAKAGE;		001 MNP GP	
		1ST HOUR_____ 2ND HOUR_____		002 01	
	REQD			003 PA07	
		3RD HOUR 4TH HOUR		004 PA0001	
[redacted]	040	UPON COMPLETION OF TEST, DRAIN OFF		001 MNP GP	
		NITROGEN AND SAFETY WIRE AS REQUIRED		002 01	
	REQD	*C/P MOVE		003 PA07	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
[redacted]ATCH	FUNCTIONAL CODE	A	C	21088N
		B	D	

16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED
045 *REQD*	CLEAN, MASK AND PAINT IAW 481-102 AND SUPPLEMENTS
050 *REQD*	DECAL AS REQUIRED *C/P MOVE
055 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95
060 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE

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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
652A		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
4G94034-101A	16G3-2-80-3 4S1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C5A MLG	1620001486466	

13. SERIAL NUMBER	14. NOUN
	BALLSCREW DISASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	4G94034-101A			
34C5	015 *REQD*	CUT SAFETY WIRE AND REMOVE HEX NUT AND DOG STOP FROM END OF BALLSCREW		001 MNPGP 002 01 003 SD03	
34C5	020 *REQD*	ROTATE BALLNUT OFF THE ~~END~~ OF THE BALLSCREW AND REMOVE ~~ALL THE~~ BALL BEARING FROM I.D. ~~OF BALLNUT~~		001 MNPGP 002 01 003 SD03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	2109BN
		B	D	

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34C5	025 *REQD*	REMOVE GREASE FROM BALL BEARINGS AND RECORD THE SIZE OF THE BALLS FOR REFERENCE UPON REASSEMBLY OF BALL-SCREW.		001 MNPGP 002 01 003 SD03	
34C5	030 *REQD*	CLEAN SEALANT FROM RETURN TUBES AND TUBE STRAP, CUT SAFETY WIRE AND REMOVE HEX NUT HOLDING DEFLECTOR YOKES. REMOVE SCRAPERS AND DRIVE PINS AND RETURN TUBES.		001 MNPGP 002 01 003 SD03	
34C5	035 *REQD*	SCRAPE SEALANT FROM BALLNUT TO REMOVE AS MUCH AS POSSIBLE. REMOVE ZERK FITTING AND REMOVE "O" RING AND DISCARD.		001 MNPGP 002 01 003 SD03	
34C5	040 *REQD*	REMOVE EXCESS GREASE FROM BALLNUT AND ATTACH WORK CONTROL DOCUMENTS & ROUTE.		001 MNPGP 002 01 003 SD03	
34C5	045 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 SD03	
34C5	050 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 SD03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21098N
		B	D	

21089N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89043 | PAGE 1 OF [redacted] PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3 4S1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A		

13. SERIAL NUMBER	14. NOUN
	MLG STRUT-DISASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
4G11020-107A		1620010054191 17575A			
4G11020-105A		1620010054192 17576A			
4G11020-101A		1620010054193 17577A			
4G11020-103A		1620010054194 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
		YOKE SERIAL NUMBER. _____ OUTER SERIAL NUMBER. _____ (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21089N
		B	D	

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21089N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 | PAGE 2 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	MLG STRUT DISASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		INNER CYL SERIAL NUMBER_____ SPLINED TUBE SERIAL NO._____			
		ROLL PIN SERIAL NUMBER_____			
	001	4G11020-107A 4G11020-105A 4G11020-101A 4G11020-103A			
34C5	005 *REQD*	OPEN SHIPPING CRATE AND REMOVE TIE DOWN STRAPS FROM CRADDLES. REMOVE APEX PIN, SIDE BRACE ARMS AND ATTACHING HARDWARE FROM STRUT.		001 MNPGP 002 01 003 CC22	
		ATTACH WORK CONTROL DOCUMENT AND ROUTE.			
34C5	010 *REQD*	WITH A STRAP HOLD THE INNER CYL IN COLLAPSED POSITION. ATTACH LIFTING SLING THROUGH THE ROLL PIN AND LIFT STRUT TO THE VERTICLE POSITION UP		001 MNPGP 002 01 003 CC22	
		SIDE DOWN.			
34C5	015 *REQD*	REMOVE "Y" BLOCK AND DRAIN HYDRAULIC FLUID FROM UPPER CHAMBER INTO A WASTE OIL DRUM. REMOVE TRUNNION PIN AND RETRACT ARM ASSY. DISASSEMBLE		001 MNPGP 002 01 003 CC22	
		RETRACT ARM. ~~ATTACH WCD AND ROUTE~~			
34C5	020 *REQD*	ROLL STRUT INTO UPRIGHT POSITION AND MOVE INTO DISASSEMBLY STAND. BE SURE LOWER CHAMBER HAS NO AIR IN (CONTINUED)		001 MNPGP 002 01 003 SD03 004 PM5573	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21089N
		B	D	

21089N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043 | PAGE 3 OF [redacted] PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	MLG STRUT DISASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IT. (REMOVE ROLL POSITIONERS, CLEAN AND TAG COND "F".			
34C5	025 *REQD*	REMOVE ROLL PIN AND ATTACHING PARTS. REMOVE FLUID TRANSFER HOUSING., ATTACH WCD'S AND ROUTE. REMOVE STAND PIPE, FLEX HOSE, AND JUNCTION BOX.		001 MNPGP 002 01 003 SD03 004 PM5573	
34C5	030 *REQD*	REMOVE ALL HYD LINES AND TUBING FROM THE KNEELING SYSTEM. REMOVE THE HYD MOTOR, HYD BRAKE AND GEAR BOX. DRAIN HYD FLUID CLEAN AND CAP. TAG COND "F".		001 MNPGP 002 01 003 SD03 004 PM5573	
34C5	035 *REQD*	REMOVE CHAIN COVER, KNEELING CHAINS, GEAR DRIVE HOUSING. DISASSEMBLE THE GEAR DRIVE HOUSING. ATTACH WCD'S AND ROUTE.		001 MNPGP 002 01 003 SD03 004 PM5573	
34C5	040 *REQD*	REMOVE NORM & ENG ROTATION CYLS. DRAIN, CAP AND CLEAN. TAG COND "F". REMOVE ALL HYD TUBING AND FLEX HOSES TO CROSS WIND CYLS. CLEAN TUBING AND HOSES AND STORE FOR REUSE. * * * * * * * * N O T E * * * * * * * * * ON COMPONENTS BEING STORED FOR REUSE VISUALLY INSPECT FOR ~~CLEANLINESS AND SERVICEABI~~LITY BEFORE STORING		001 MNPGP 002 01 003 SD03 004 PM5573	
34C5	045 *REQD*	DISCONNECT ELECT WIRES AT ELECT JUNCTION BOX. REMOVE LINEAR SHUTOFF VALVES FROM BRACKETS. DRAIN, CAP, (CONTINUED)		001 MNPGP 002 01 003 SD03 004 PM5573	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21089N
		B	D	

		* * * * * * * N O T E * * * * * * * USE CARE IN REMOVING ELECT. WIRING HARNESS TO AVOID DAMAGE. ELECT WIRING HARNESS SHOULD BE REUSED. * * * * * * * * * * * * * * * * * *
34C5	050 *REQD*	REMOVE AND CLEAN ID'S OF CROSS WIND APEX BOLT AND ANTI ROTATION BOLTS. ATTACH WCD'S AND ROUTE. REMOVE AND DRAIN, CAP AND CLEAN CROSS WIND CYLS, NORM & EMG LOCK CYLS TAG F CONDITION.
34C5	055 *REQD*	REMOVE ALL HYD TUBING AND FLEX LINE IN SEQUENCE, ALL HYD FITTINGS AND VALVES. CLEAN ~~AND~~ STORE FOR REUSE. REMOVE ELECT. WIRING HARNESS, SYNCHRO TRANS. ATTACH WCD'S & ROUTE
34C5	060 *REQD*	REMOVE ROTATION SHAFTS, BRACKETS AN COVERS, BALLSCREW CROSS PINS. REMOV ELECT. INSERT, CROSS WIND AND ROTATION MANIFOLDS, DRAIN, CAP ~~AND~~ CLEAN. TAG COND "F".

[redacted] WORK CONTROL DOCUMENT (MEDS) [redacted] PAGE ___ OF ___ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		AND POSITIONING COLLAR. ATTACH ~~WORK~~ CONTROL DOCUMENTS AND ROUTE.			
34C5	070 *REQD*	UNSCREW PACKING NUT FROM OUTER CYL DROP THE SPLINED TUBE INTO THE INNER CYL I.D. PLACE INNER CYL IN HOLDING CART AND SEPARATE THE INNER CYL FROM		001 MNPGP 002 01 003 SD03 004 PM5573	
		THE OUTER CYL. MOVE FROM UNDER STAND			
34C5 [redacted]	075 *REQD*	REMOVE OUTER CYL FROM YOKE, AND PLACE IN A "V" CART. ~~REMOVE ALL BUSHINGS.~~ REMOVE BALLSCREWS FROM YOKE AND ~~DISASSEMBLE. ATTACH WCD'S AND ROUTE~~		001 MNPGP 002 01 003 SD03 004 PM5573	
34C5	080 *REQD*	REMOVE AND DISASSEMBLE SPLINED TUBE. DISASSEMBLE HIGH PRESSURE PISTON ASSEMBLY FROM INNER CYL. REMOVE YOKE ASSY. FROM STAND, CLEAN EXCESS		001 MNPGP 002 01 003 SD03 004 PM5573	
		GREASE FROM TRUNNIONS. ~~ATTACH~~ WCD'S AND ROUTE.			
34C5	085 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.		001 MNPGP 002 01 003 SD03	
34C5	090 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 SD03	
[redacted]					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21089N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

OPER STEP	TECH D	S L	S K	W #R	F A	PF C	A/R DC	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY FCT	A C
RA009	S	E	JA	EA	1		J	88337		.63	PERCENT ENGR 99.9	REP CEA UPPERSIDE BRACE ARM	10.04		6.32		
0001			JA	01			00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010											4G11436-107A	1620001157388					
0030			JA	01			1E			1.00		MACH REP BASE LUGS	1.937	.291	2.228		22
0010	E						RML	-BU-V3		.50	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.596		
0015	E						RML	--P-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0020	E						RML	-AL-CA		1.00	ALIEN HORIZ AXIS MAG BASE		.05917		.068		
0030	E						RML	-AL-CB		1.00	ALIEN VERTICAL AXIS MAG BASE		.12281		.142		
0040	E						RML	-AL-CC		1.00	ALIEN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E						RML	-BD-FB		2.00	BORE HOLE 3.5 X 1 GROUP 4 2 LUGS		.52431		1.208		
0060	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0035			JA	01			1E			1.00		BASE LUG FACE REPAIR	1.404	.211	1.615		16
0010	E						KMM	-BU-V1		.50	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 2 PARTS		.50518		.290		
0020	E						RML	--P-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.13531		.098		
0030	E						RML	-AL-AB		1.00	ALIEN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML	-AL-AC		1.00	ALIEN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						RML	-BD-FA		2.00	BORE HOLE 4.5 X 1/2 GROUP 4 2 LUGS		.42654		.981		
0060	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0040			JA	01			1E			1.00		MACH REP APEX LUGS	1.882	.282	2.165		22
0010	E						RML	-BU-V3		.50	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.596		
0015	E						RML	--P-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0020	E						RML	-AL-CA		1.00	ALIEN HORIZ AXIS MAG BASE		.05917		.068		
0030	E						RML	-AL-CC		1.00	ALIEN HOLE TO SPINDLE CLAMP		.06585		.079		
0040	E						RML	-AL-CC		1.00	ALIEN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E						RML	-BD-FB		2.00	BORE HOLE 3.5 X 1 GROUP 4 2 LUGS		.52431		1.208		
0060	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045			JA	01			1E			1.00		APEX LUG FACE REP	1.881	.282	2.164		22
0010	E						RML	-BU-V3		.50	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.596		
0015	E						RML	--P-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0017	E						RML	-AL-AB		1.00	ALIEN VERTICAL AXIS ROD		.12699		.146		
0020	E						RML	-AL-CC		1.00	ALIEN HOLE TO SPINDLE MAG BS		.07261		.083		
0030	E						RML	-BD-FB		2.00	BORE HOLE 3.5 X 1 GROUP 4		.52431		1.208		
0040	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0078			JA	01			1E			1.00		MACHINE BASE LUG BUSHING	.629	.094	.723		7
0010	E						RLA	-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.287		
0020	E						RLA	--P-C1		4.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.046		
0030	E						KML	-TA-EC		4.00	DIA 3.00-4.00 REM .033-.250		.07800		.355		
0040	E						KML	-TA-ED		1.00	DIA 4.0 REM .250 ADD INCH		.01707		.019		
0050	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01			1E			1.00		INST BASE LUG BUSHING	.206	.031	.237		2
0010	E						RBW	-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
0020	E						RBW	-BU-A1		2.00	INSTALL SET FLANGED BUSHINGS4 BUSHINGS		.05133		.116		
0070	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0088			JA	01			1E			1.00		MACHINE APEX LUG BUSHING	.606	.091	.697		7
0010	E						RLA	-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.287		
0020	E						RLA	--P-C1		4.00	1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.044		
0030	E						KML	-TA-EC		4.00	DIA 1.50-2.00 REM .033-.250		.06659		.308		
0040	E						KML	-TA-ED		4.00	DIA 2.0 REMOVE .250 ADD INCH		.00947		.043		
0050	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01			1E			1.00		INSTALL APEX BUSHING	.185	.028	.214		2
0010	E						RBW	-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
0020	E						RBW	-BU-A4		4.00	INSTALL ONE STRAIGHT BUSHING	4 BUSHINGS	.02062		.094		
0030	E						RJP	-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		

```
7000   JA 01  00        .00          LABOR STANDARD HISTORY          .000  .000  .000   0
  0010                  9 JL  18 INITIAL INPUT MAPII
  0020                  17 APR 89 BUSHING REMOVAL INCREASED TO 100%
  0030                        <OLD STD> 3.70
  0900                  NED MONROE        MANEL      73255    MR 313
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TO INTERROGATE LABOR STANDARDS, INPUT

```
 RCC PRD NROP MR
<---><----><-->
1234567890123456  ELSE PUT IN END
```

OPER SUB STEP	TECH D	S L	S K	#R C	A DC	F FA	PF SUPPORT ELEMENT	A/R REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	STD TIME	STD HOURS	DLY	POT	A C
RA013		B	E	JA	EA	1	J 89018	.50	PERCENT ENGR 99.9	C-5A LOWER SIDE BRACE	11.86		5.93			
0001				JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0	
0010									4G11435-101A	1620001157387						
0070				JA	01	15		1.00		BASE LUG REPAIR	2.043	.307	2.350		20	
0010	E					RML	-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE	1.03687		.596			
0020	E					RML	-HP-AC	.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE	.12195		.070			
0030	E					RML	-AL-CA	.50	ALIGN -HORIZ AXIS MAG BASE	PRORATE	.05917		.034			
0035	E					RML	-AL-C3	.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE	.12351		.071			
0040	E					RML	-AL-CC	.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE	.07261		.041			
0050	E					RML	-BD-J3	2.00	BORE HOLE 3 X 1 GROUP 4	2 HOLES	.66525		1.533			
0060	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0075				JA	01	15		1.00		BASE LUG FACE REPAIR	2.139	.331	2.469		21	
0010	E					RML	-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE	1.03687		.596			
0015	E					RML	-HP-AC	.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE	.12195		.070			
0020	E					RML	-AL-CA	.50	ALIGN HORIZ AXIS MAG BASE	PRORATE	.05917		.034			
0030	E					RML	-AL-C3	.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE	.12351		.071			
0040	E					RML	-AL-CC	.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE	.07261		.041			
0050	E					KMM	-MV-AE	64.00	TRAVERSE 1 INCH-MILLING MACH	8 INCH/2 PASSES/4 FACES	.02222		1.633			
0060	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0080				JA	01	15		1.00		APEX REPAIR	1.785	.269	2.054		17	
0010	E					RML	-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE/2 OPERATIONS	1.03687		.596			
0020	E					RML	-HP-AC	.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE 2 OPER.	.12195		.070			
0030	E					RML	-AL-CA	.50	ALIGN HORIZ AXIS MAG BASE	PRORATE 2 OPER.	.05917		.034			
0040	E					RML	-AL-C3	.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE 2 OPER.	.12351		.071			
0050	E					RML	-AL-CC	.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE 2 OPER.	.07261		.041			
0060	E					RML	-BD-F3	2.00	BORE HOLE 3.5 X 1 GROUP 4	2 HOLES	.82421		1.933			
0070	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0085				JA	01	15		1.00		APEX FACE REPAIR	1.783	.268	2.051		17	
0010	E					RML	-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE 2 OPER	1.03687		.596			
0020	E					RML	-HP-AC	.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE	.12195		.070			
0030	E					RML	-AL-CA	.50	ALIGN HORIZ AXIS MAG BASE		.05917		.034			
0040	E					RML	-AL-C3	.50	ALIGN VERTICAL AXIS MAG BASE		.12351		.071			
0050	E					RML	-AL-CC	.50	ALIGN HOLE TO SPINDLE MAG BS		.07261		.041			
0060	E					KMM	-MV-AE	48.00	TRAVERSE 1 INCH-MILLING MACH	6 INCHES/2 CUTS/4 FACES	.02222		1.226			
0070	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0138				JA	01	15		1.00		MACHINE BASE LUG BUSHING	.727	.109	.836		7	
0010	E					RLA	-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.287			
0020	E					RLA	-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.046			
0030	E					KML	-TA-HC	4.00	DIA 4.00-5.00 REM .030-.250		.08497		.390			
0040	E					KML	-TA-HD	4.00	DIA 5.0 REM .250 ADD INCH		.02185		.100			
0050	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0140				JA	01	15		1.00		INSTL BASE LUG BUSH	.580	.087	.667		5	
0010	E					RBW	-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107			
0020	E					RBW	-BU-B1	2.00	REBUSH A SET OF 2 BOSSES	4 BUSHINGS	.29305		.548			
0030	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0148				JA	01	15		1.00		MACHINE APEX LUG BUSHING	.680	.102	.782		7	
0010	E					RLA	-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.287			
0020	E					RLA	-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.046			
0030	E					KML	-TA-BC	4.00	DIA 3.00-4.00 REM .030-.250		.07900		.358			
0040	E					KML	-TA-BD	4.00	DIA 4.0 REM .250 ADD INCH		.01707		.078			
0050	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0				JA	01	15		1.00		INSTALL APEX LUG BUSHINGS	.580	.087	.667		5	
0010	E					RBW	-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107			

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     0020 E          RBW-BU-31  2.00 REBUILD A SET OF 2 BOSSES   4 BUSHINGS          .23835        .548
     0030 E          RJP-PW-R1  1.00 REMOVE PAPRWRK SIGN OFF DOC                     .01001        .011
 9000        JA 01   15          .00                          LABOR STANDARD HISTORY .000  .000  .000        0
     0010                          27AUG85 UPDATED OCCURANCE FACTORS/RESTRUCTURED
     0011                                  LABOR STANDARD TO MATCH AFLC FORM 958
     0012                                  WORK PREVIOLSLY DONE ON OPER. 80090
     0013                                  <OLD STANDARD> 13.42
     0020                          21DEC85 UPDATED OCC FACTORS <OLD STD> 9.55
     0030                          17APR89 BUSHING REMOVAL INCREASED TO 100%
     0040                                  <OLD STD> 6.39
     0900                                  N MONROE  MANEAA  73357
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TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD WROP NR
<---><----><--->
12345678901234567  ELSE PUT IN END
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17575A C5A MLG 4G11020-107A RCC MMPRA 4S1-93-3 84013

STEP	TH	S T	S K	W R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
0015	S	E	JA	EA	1		J	88292		.79	PERCENT ENGR 99.9	C5A YOKE	47.21		37.30			
0001			JA	01			00			.00		PART NUMBER/NSN	.000	.000	.000		0	
0010											4G11430-113B	1620001753939						
0008			JA	01			15			.58		REMOVE CENTER BUSHING	13.736	1.195	9.162		19	
0010	E						RML	SU	V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0020	E						RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181			
0030	E						RML	AL	CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0040	E						RML	BC	LM	6.00	BORE HOLE 6 X 6 GROUP 3	OCC FOR SIZE MINUS FINISH CT	2.07875		14.343			
0050	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0035			JA	01			15			.85		NICK AND BURR LARGE PART	.166	.021	.162		0	
0010	E						RLG	RS	N2	1.00	NICK & BURR LGE STRUT PARTS		.15614		.179			
0020	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0037			JA	01			15			.05		REP CHAIN COVER HOLES	.470	.004	.027		0	
0010	E						RBW	SU	G1	1.00	S/U FOR BENCH WORK GENERAL	.	.27525		.316			
0015	E						RBW	TR	H3	3.00	REMOVE / REPLACE HELICOIL	OCC FOR 50% REPLACMENT	.05849		.201			
0020	E						BTL	TD	03	6.00	TAP/DIE CUT W/FGR TO 6IN HDL6 HOLES		.00102		.007			
0030	E						BTL	TD	04	6.00	TAP/DIE REM W/FGR TO 6IN HDL6 HOLES		.00063		.004			
0040	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC.		.01001		.011			
0040			JA	01			15			.25		REMOVE CRACKED LUGS	1.278	.048	.368		1	
0010	E						RML	SU	V3	.25	S/U VERT MIL BORE FXTR HOISTPRORATE OVER 4 PARTS		1.03687		.298			
0020	E						RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181			
0030	E						RML	AL	AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146			
0040	E						RML	AL	AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087			
0050	E						KNM	BA	BG	3.00	BORE HOLE 1.5 X 3.5 GROUP 1		.21626		.746			
0060	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0055			JA	01			15			.16		BALLSCREW SPROCKET BORE	1.763	.042	.324		1	
0010	E						RML	SU	V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0020	E						RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP.		.15776		.181			
0030	E						RML	AL	CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0040	E						RML	AL	CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0050	E						RML	AL	CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0060	E						RML	BA	LD	1.00	BORE HOLE 6 X 2 GROUP 1		.30344		.348			
0070	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0060			JA	01			15			.16		BALLSCREW SPROCKET BORE	1.763	.042	.324		1	
0010	E						RML	SU	V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0020	E						RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP.		.15776		.181			
0030	E						RML	AL	CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0040	E						RML	AL	CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0050	E						RML	AL	CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0060	E						RML	BA	LD	1.00	BORE HOLE 6 X 2 GROUP 1		.30344		.348			
0070	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0070			JA	01			15			.05		O/S BALLSCREW HOLE/LEFT	1.709	.013	.098		0	
0010	E						RML	SU	V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192			
0015	E						RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP.		.15776		.181			
0020	E						RML	AL	CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0030	E						RML	AL	CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
0040	E						RML	AL	CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083			
0050	E						RML	BA	HC	1.00	BORE HOLE 4.5 X 1.5 GROUP 1		.24925		.286			
0060	E						RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0080			JA	01			15			.10		O/S BALLSCREW HOLE/RIGHT	1.284	.019	.148		0	
0010	E						RML	SU	V3	.59	S/U VERT MIL BORE FXTR HOIST		1.03687		.703			
0015	E						RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,		.15776		.181			
0020	E						RML	AL	CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068			
0030	E						RML	AL	CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142			
													.07261		.083			

0050	E		RML-BA-HC	1.00	BORE HOLE 4.5 X 1.5 GROUP 1			.24925		.286	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0090		JA 01	15	1.00		OVERSIZE HOLE WITH REAMER		.349	.052	.402	1
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND			.06831		.078	
0030	E		RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES		.07337		.253	
0040	E		RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0100		JA 01	15	1.00		OVERSIZE HOLE WITH REAMER		.349	.052	.402	1
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND			.06831		.078	
0030	E		RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES		.07337		.253	
0040	E		RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0110		JA 01	15	.05		O/S TRUNNION HOLE/LEFT		2.564	.019	.147	0
0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST			1.03687		1.192	
0015	E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,			.15776		.181	
0020	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE			.05917		.068	
0030	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE			.12351		.142	
0040	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0050	E		RML-BA-LM	2.00	BORE HOLE 6 X 6 GROUP 1	OCC FOR 7 IN X 8 IN.		.55232		1.270	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0120		JA 01	15	.10		O/S TRUNNION HOLE/LEFT		2.106	.032	.242	1
0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST			1.03687		1.192	
0015	E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,			.15776		.181	
0020	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE			.05917		.068	
0030	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE			.12351		.142	
0040	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0050	E		RML-BA-LM	1.17	BORE HOLE 6 X 6 GROUP 1	OCC FOR 7 IN X 8 IN.		.55232		.743	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0130		JA 01	15	.05		O/S CROSSPIN HOLE/LEFT		.366	.003	.021	0
0010	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0020	E		RBW-BU-R2	2.00	REAM WITH LEMPCO REAMER	8 PASSES		.07337		.168	
0030	E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0040	E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D			.00333		.007	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0140		JA 01	15	.10		O/S CROSSPIN HOLE/RIGHT		.769	.012	.089	0
0010	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0020	E		RBW-SU-G1	2.00	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.633	
0030	E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0040	E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D			.00333		.007	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0150		JA 01	15	.05		O/S RETAINER HOLES/LEFT		.601	.005	.035	0
0010	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0020	E		RBW-BU-R2	4.00	REAM WITH LEMPCO REAMER	4 PASSES		.07337		.337	
0030	E		RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES			.10435		.120	
0040	E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I DEXTRA POLISH			.00333		.007	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0160		JA 01	15	.05		O/S RETAINER HOLES/RIGHT		.607	.005	.035	0
0010	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0020	E		RBW-BU-R2	4.00	REAM WITH LEMPCO REAMER	4 PASSES		.07337		.337	
0030	E		RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES			.10435		.120	
0040	E		RBW-BU-P1	4.00	BUTTERFLY POLISH BUSHING I DEXTRA POLISH			.00333		.015	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
		JA 01	15	.05		BALLSCREW SPROCKET BORE		1.835	.014	.106	0
10	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST			1.03687		1.192	
0020	E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,			.15776		.181	
0030	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE			.05917		.068	
0040	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE			.12351		.142	
0050	E		RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.167	
0060	E		RML-BA-LD	1.00	BORE HOLE 6 X 2 GROUP 1			.30344		.348	
										.011	

0225		JA 01	15	.90		INSTALL INSERTS	.486	.066	.504	1
0010	E		RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS ,		.31093		.357	
0020	E		RBW-TR-H1	6.00	INSTALL HELICOIL INSERT	6 HOLES	.02763		.190	
30	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001		.011	
0		JA 01	15	.69		INSTL CENTER BUSH	.355	.037	.282	1
0010	E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES		.22231		.255	
0020	E		RLG-UP-01	1.00	UNPACK-OPEN ANY CONTAINER		.04101		.047	
0030	E		RBW-BU-A4	3.00	INSTALL ONE STRAIGHT BUSHINGOCC FOR LRG SIZE		.02062		.071	
0040	E		KNF-SP-01	1.00	STAKE PART-FIRST LOCATION		.00241		.002	
0050	E		KNF-SP-02	11.00	STAKE PART EA ADDL LOCATION		.00163		.020	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0238		JA 01	15	1.00		INST BALLSCREW BUSH/LEFT	.589	.088	.678	1
0010	E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	OCC FOR 2 OPERATIONS	.49962		.287	
0020	E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028	
0030	E		KML-TC-HA	.25	DIA 4.00-5.00 REM (.033	OCC FOR LENGTH/FLANGE	.14789		.042	
0040	E		KML-TC-HA	1.00	DIA 4.00-5.00 REM (.033	O.D.	.14789		.170	
0050	E		RLA-FF-LE	1.00	FACE FINISH 7 - 8 GROUP 3		.05888		.067	
0060	E		RLA-FF-LF	3.00	FACE FINISH 7-8 ADD 1/8 INCHOCC FOR 3/8 EXTRA TRAVEL		.02059		.071	
0090	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0240		JA 01	15	1.00		INST BALLSCREW BUSH/LEFT	.030	.005	.035	0
0080	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0090	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0248		JA 01	15	1.00		INST BALLSCREW BUSH/RGHT	.589	.088	.678	1
0010	E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	OCC FOR 2 OPERATIONS	.49962		.287	
0020	E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028	
0030	E		KML-TC-HA	.25	DIA 4.00-5.00 REM (.033	OCC FOR LENGTH/FLANGE	.14789		.042	
0040	E		KML-TC-HA	1.00	DIA 4.00-5.00 REM (.033	O.D	.14789		.170	
0050	E		RLA-FF-LE	1.00	FACE FINISH 7 - 8 GROUP 3		.05888		.067	
60	E		RLA-FF-LF	3.00	FACE FINISH 7-8 ADD 1/8 INCHOCC FOR 3/8 EXTRA TRAVEL		.02059		.071	
70	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0250		JA 01	15	1.00		INST BALLSCREW BUSH/RGHT	.123	.019	.143	0
0070	E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE 2 OPERATIONS	.18669		.107	
0080	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0090	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0259		JA 01	15	1.00		INST UPPER SIDE BRACE BUSH	7.342	1.101	8.444	18
0001					BRACE ARM BUSHINGS/BEA					
0002					2 STRAIGHT & 6 FLANGED					
0010	E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E		KML-TC-HA	8.00	DIA 4.00-5.00 REM (.033	FLANGE	.14789		1.360	
0030	E		KML-TC-GA	8.00	DIA 3.00-4.00 REM (.033	OD	.12496		1.149	
0040	E		RLA-FF-JE	1.50	FACE FINISH 5 - 6 GROUP 3		.05098		.087	
0050	E		RLA-BO-HE	8.00	BORE HOLE 3 1/2 - 4 DIA 1 DP		.44809		4.122	
0060	E		RLA-CO-HE	8.00	CUT OFF 3 1/2 - 4 DIA. GRP 3		.06645		.611	
0070	E		RLA-FR-JE	6.00	FACE ROUGH 5 - 6 DIA. GRP 3		.02519		.173	
0080	E		RLA-FF-JE	6.00	FACE FINISH 5 - 6 GROUP 3		.05098		.351	
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0260		JA 01	15	1.00		INST UPPER SIDE BRACE BUSH	1.150	.173	1.323	3
0001					BRACE ARM BUSHINGS/BEA					
0002					2 STRAIGHT & 6 FLANGED					
0090	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0100	E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES	4 SETS OF 2 BUSHINGS	.23835		1.096	
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0269		JA 01	15	1.00		INST LOWER SIDE BRACE BUSH	8.742	1.311	10.054	21
0001					BRACE ARM BUSHINGS/BEA					
72					2 STRAIGHT & 6 FLANGED					
10	E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E		KML-TC-JA	8.00	DIA 5.00-6.00 REM (.033	FLANGE	.17036		1.567	
0030	E		KML-TC-HA	8.00	DIA 4.00-5.00 REM (.033	OD	.14789		1.360	
0040	E		RLA-FF-LE	1.50	FACE FINISH 7 - 8 GROUP 3		.05888		.101	
0050	E		RLA-BO-JE	8.00	BORE HOLE 4 - 4 1/2 DIA 1 DP		.56243		5.174	
0060	E		RLA-CO-JE	8.00	CUT OFF 4 - 4 1/2 DIA. GRP 3		.07135		.456	

0080 E		RLA-FF-LE	6.00	FACE FINISH 7 - 8 GROUP 3			.05888		.406	
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0	JA 01	15	1.00		INST LOWER SIDE BRACE BUSH		1.150	.173	1.323	3
001				BRACE ARM BUSHINGS/BEA						
J02				2 STRAIGHT & 6 FLANGED						
0090 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0100 E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES	4 SETS OF 2		.23835		1.096	
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0278	JA 01	15	1.00		INST TRUN END HOLE BUSH/LEFT		1.757	.264	2.021	4
0010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	OCC FOR 2 OPERATIONS		.49962		.287	
0020 E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS			.02466		.028	
0030 E		KML-TC-JC	1.00	DIA 5.00-6.00 REM .033-.250			.24985		.287	
0040 E		KML-TC-JD	8.00	DIA 6.0 REM .250 ADD INCH	OCC FOR EXTRA LENGTH		.13553		1.246	
0050 E		RLA-FR-NE	1.00	FACE ROUGH 9 - 10 DIA. GRP 3			.03320		.038	
0060 E		RLA-FR-NF	1.00	FACE ROUGH 9 - 10 ADD 1/8 IN			.01300		.014	
0070 E		RLA-FF-NE	1.00	FACE FINISH 9 - 10 GROUP 3			.06699		.077	
0080 E		RLA-FF-NF	1.00	FACE FINISH 9-10 ADD 1/8 IN.			.02600		.029	
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0280	JA 01	15	1.00		INST TRUN END HOLE BUSH/LEFT		.123	.019	.143	0
0090 E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE 2 OPERATIONS		.18669		.107	
0100 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0288	JA 01	15	1.00		INST TRUN END HOLE BUSH R.S.		1.757	.264	2.021	4
0010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 OPERATIONS		.49962		.287	
0020 E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS			.02466		.028	
0030 E		KML-TC-JC	1.00	DIA 5.00-6.00 REM .033-.250			.24985		.287	
0040 E		KML-TC-JD	8.00	DIA 6.0 REM .250 ADD INCH	OCC FOR EXTRA LENGTH		.13553		1.246	
0050 E		RLA-FR-NE	1.00	FACE ROUGH 9 - 10 DIA. GRP 3			.03320		.038	
060 E		RLA-FR-NF	1.00	FACE ROUGH 9 - 10 ADD 1/8 IN			.01300		.014	
70 E		RLA-FF-NE	1.00	FACE FINISH 9 - 10 GROUP 3			.06699		.077	
0080 E		RLA-FF-NF	1.00	FACE FINISH 9-10 ADD 1/8 IN.			.02600		.029	
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0290	JA 01	15	1.00		INST TRUN END HOLE BUSH R.S.		.123	.019	.143	0
0090 E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE 2 OPERATIONS		.18669		.107	
0100 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0295	JA 01	15	1.00		CHECK TRUN BUSH/FACE TO FACE		.097	.015	.112	0
0010 E		RJP-TC-A1	1.00	TOOL TO & FROM SHOP CRIB			.06735		.077	
0020 E		RLG-EI-C3	1.00	CHK FACE TO FACE I/S OR O/S			.01427		.016	
0030 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION			.00601		.006	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0298	JA 01	15	1.00		INST L.S. CROSS PIN BUSH		.921	.138	1.060	2
0010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 OPERATIONS		.49962		.287	
0020 E		RLA-HP-C6	2.00	LOAD&UNLOAD SML PART-CENTERS	2 BUSHINGS		.02466		.056	
0030 E		KML-TC-FA	2.00	DIA 2.00-3.00 REM (.033	FLANGE/2 BUSHINGS		.10296		.236	
0040 E		KML-TC-FA	2.00	DIA 2.00-3.00 REM (.033	O.D./2 BUSHINGS		.10296		.236	
0050 E		KML-TC-FB	2.00	DIA 3.0 REM .033 ADD INCH	2 BUSHINGS		.04117		.094	
0060 E		RLA-FR-FE	2.00	FACE ROUGH 2.5 - 3 DIA GRP 3			.01957		.045	
0070 E		RLA-FF-FE	2.00	FACE FINISH 2.5 - 3 GROUP 3			.03974		.091	
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0300	JA 01	15	1.00		INST L.S. CROSS PIN BUSH		.921	.138	1.060	2
0010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 OPERATIONS		.49962		.287	
0020 E		RLA-HP-C6	2.00	LOAD&UNLOAD SML PART-CENTERS	2 BUSHINGS		.02466		.056	
0030 E		KML-TC-FA	2.00	DIA 2.00-3.00 REM (.033	FLANGE/2 BUSHINGS		.10296		.236	
40 E		KML-TC-FA	2.00	DIA 2.00-3.00 REM (.033	O.D./2 BUSHINGS		.10296		.236	
50 E		KML-TC-FB	2.00	DIA 3.0 REM .033 ADD INCH	2 BUSHINGS		.04117		.094	
0060 E		RLA-FR-FE	2.00	FACE ROUGH 2.5 - 3 DIA GRP 3			.01957		.045	
0070 E		RLA-FF-FE	2.00	FACE FINISH 2.5 - 3 GROUP 3			.03974		.091	
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0303	JA 01	15	1.00		INST R.S. CROSS PIN BUSH		1.171	.176	1.348	3
0010 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
							.02466		.056	

0030	E		KML-TC-FA	2.00	DIA 2.00-3.00 REM (.033	FLANGE/2 BUSHINGS		.10296		.236	
0040	E		KML-TC-FA	2.00	DIA 2.00-3.00 REM (.033	O.D./2 BUSHINGS		.10296		.236	
0050	E		KML-TC-FB	2.00	DIA 3.0 REM .033 ADD INCH			.04117		.094	
0060	E		RLA-FR-FE	2.00	FACE ROUGH 2.5 - 3 DIA GRP 3			.01957		.045	
0070	E		RLA-FF-FE	2.00	FACE FINISH 2.5 - 3 GROUP 3			.03974		.091	
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0310		JA 01	15	1.00		INST R.S. CROSS PIN BUSH		.435	065	.500	1
0080	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0090	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0318		JA 01	15	1.00		INST L.S. RET BUSH/2 EA		.844	.127	.971	2
0010	E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
0020	E		RLA-HP-C6	2.00	LOAD&UNLOAD SML PART-CENTERS			.02466		.056	
0030	E		KML-TC-BA	2.00	DIA .251-.500 REM (.033	FLANGE		.05538		.127	
0040	E		KML-TC-BA	2.00	DIA .251-.500 REM (.033	O.D.		.05538		.127	
0050	E		RLA-FF-BE	2.00	FACE FINISH 1/2 - 1 GROUP 3			.03184		.073	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0320		JA 01	15	1.00		INST L.S. RET BUSH/2 EA		.435	.065	.500	1
0060	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0070	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0324		JA 01	15	1.00		INST R.S. RET BUSH/2 EA		.844	.127	.971	2
0010	E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
0020	E		RLA-HP-C6	2.00	LOAD&UNLOAD SML PART-CENTERS			.02466		.056	
0030	E		KML-TC-BA	2.00	DIA .251-.500 REM (.033			.05538		.127	
0040	E		KML-TC-BA	2.00	DIA .251-.500 REM (.033			.05538		.127	
0050	E		RLA-FF-BE	2.00	FACE FINISH 1/2 - 1 GROUP 3			.03184		.073	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
		JA 01	15	1.00		INST R.S. RET BUSH/2 EA		.435	.065	.500	1
0060	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0070	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0326		JA 01	15	.05		MFR/INST SPROCKET SLEEVE		1.155	.009	.066	0
0010	E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	,		.49962		.574	
0020	E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	LOAD/MACHINE/REVERSE/MACHINE		.01006		.023	
0030	E		RLA-BO-MA	1.40	BORE HOLE 5 1/2 - 6 DIA 1 DP	OCCURRANCE FOR LRG DIAMETER		.27549		.443	
0040	E		KML-TA-JA	1.40	DIA 5.0-6.0 REM (.033	OCCURR FOR LRG DIAMETER		.07105		.114	
0050	E		RLA-FR-NA	2.00	FACE ROUGH 9 - 10 DIA. GRP 1	TWO ENDS		.01783		.041	
0060	E		RLA-FF-NA	2.00	FACE FINISH 9 - 10 GROUP 1	TWO ENDS		.03627		.083	
0070	E		RLA-CO-MA	1.00	CUT OFF 5 1/2 - 6 DIA. GRP 1,			.03269		.037	
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
0327		JA 01	15	.05		MFR/INST SPROCKET SLEEVE		.217	.002	.012	0
0080	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	,		.18669		.214	
0090	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING,			.02062		.023	
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
0329		JA 01	15	.25		MANUFACTURE REP MEMBER #5		.726	.027	.209	0
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCHULL CHUCK			.01006		.011	
0030	E		KML-TD-CC	3.00	DIA .501-1.00 REM .033-.250			.10898		.375	
0040	E		KML-CD-P1	3.00	CENTER DRILL			.01519		.052	
0050	E		RLA-DR-NB	3.00	DRILL HOLE 1/8-1/4 DIA X 1			.05541		.191	
0060	E		GTL-TH-A1	3.00	TAP HOLE TO 0.25 IN THRD DIA			.0142?		.049	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0330		JA 01	15	.25		INST MEMBER 1-6		.079	.003	.023	0
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-A2	1.00	INSTALL SET STRAIGHT BUSHING	NO POLISH AVERAGED 2 REP		.02299		.026	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
9000		JA 01	15	.00		LABOR STANDARD HISTORY		.000	.000	.000	0
0010					12JUL85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM						
0011					958/UPDATED OCC FACTORS/WORK PREVIOUSLY						
0012					DONE ON OPER B0110 <OLD STD> 42.13						
					24JAN86 UPDATED OCC FACTORS/ADDED SUB OPER 0165						

0021
0900

AND 0327 <OLD STD> 36.90
N MONROE MANEAA 73357

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR
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1234567890123456 ELSE PU: IN END

17575A C5A MLG 4G11020-107A RCC MMPRA 4S1-93-3 84013

TECH STEP	S T D	S K L	W R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
4016	S	E	JA	EA	1	J 89026	.58	PERCENT ENGR 99.9	MACH POSITIONING COLLAR C5AM	2.40		1.39		
0001			JA	01	00		.00		PART NUMBER / NSN	.000	.000	.000		0
0010								4G11476-107A	1620005581485					
0020								4G11476-101B	1620001157415					
0055			JA	01	15		.07		REMOVE PINS	.236	.002	.019		1
0010	E				RBW-SU-G1		.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
0020	E				RSG-JP-03		1.00	PREP HAND DRILL FOR USE		.00861		.009		
0030	E				GTL-SE-A1		3.00	DRILL & EASYOUT SCR TO .25IN	3 PINS	.02540		.087		
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01427		.016		
0060			JA	01	15		.07		O/S POSITIONER LUG HOLE	.620	.007	.050		2
0010	E				RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
0020	E				RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST	HAND	.06831		.078		
0030	E				RBW-BU-R2		6.00	REAM WITH LEMPCO REAMER	3 PASSES 2 LUGS	.07337		.506		
0040	E				RBW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBURR 2 LUGS	.00423		.009		
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01	15		.05		O/S CLEVIS LUG HOLE L/S	.620	.005	.036		1
0010	E				RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
0020	E				RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST	HAND	.06831		.078		
0030	E				RBW-BU-R2		6.00	REAM WITH LEMPCO REAMER	3 PASSES 2 LUGS	.07337		.506		
0040	E				RBW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBURR 2 LUGS	.00423		.009		
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15		.05		O/S CLEVIS LUG HOLE R/S	.620	.005	.036		1
0	E				RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
020	E				RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST	HAND	.06831		.078		
0030	E				RBW-BU-R2		6.00	REAM WITH LEMPCO REAMER	3 PASSES 2 LUGS	.07337		.506		
0040	E				RBW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBURR 2 LUGS	.00423		.009		
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0303			JA	01	15		.14		MACH & FACE PINS	1.301	.027	.210		9
0010	E				RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE	,	.49962		.574		
0020	E				RHL-HP-CA		3.00	HAND HANDLE NO WRAP 2 CLAMPS	3 PINS	.08531		.294		
0030	E				KHL-TD-BA		3.00	DIA .251-.500 (.033	FLANGE/3 PINS	.06193		.213		
0040	E				KHL-TD-BA		3.00	DIA .251-.500 (.033	O.D./3 PINS	.06193		.213		
0050	E				RLA-FR-EG		3.00	FACE ROUGH 2 - 2.5 DIA GRP 4	3 PINS	.02116		.073		
0060	E				RLA-FF-BG		3.00	FACE FINISH 1/2 - 1 GROUP 4	3 PINS TO LENGTH	.03356		.115		
0070	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0305			JA	01	15		.14		INSTALL PINS	.210	.004	.034		1
0010	E				RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW-BU-A1		3.00	INSTALL SET FLANGED BUSHINGS	INSTALL 3 PINS	.05133		.177		
0030	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0308			JA	01	15		1.00		MACH POSITIONER LUG BUSHING	.297	.045	.342		14
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E				KHL-TA-FC		2.00	DIA 2.00-3.00 REM .033-.250		.07104		.163		
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0310			JA	01	15		1.00		INSTALL POSITIONER LUG BUSH	.295	.044	.339		14
0010	E				RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
030	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15		1.00		MACH CLEVIS LUG BUSH L/S	.289	.043	.332		14
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E				KHL-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0320			JA	01	15		1.00		INST CLEVIS LUG BUSHING L/S	.295	.044	.339		14
0010	E				RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		

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    0020 E          RBW-BU-B1  1.00 REBUSH A SET OF 2 BOSSES     INCLUDES REAM & POLISH          .23835          .274
    0030 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
 0328       JA 01   15         1.00                             MACH CLEVIS LUG BUSH R/S        .289   .043     .332      14
    0010 E          RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE   PRORATE OVER 4 PARTS            .49962          .143
    0020 E          RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS                      .01006          .023
    0030 E          KML-TA-CC  2.00 DIA .501-1.00 REM .033-.250  2 BUSHINGS                      .06699          .154
    0040 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
 0330       JA 01   15         1.00                             INST CLEVIS LUG BUSH R/S        .295   .044     .339      14
    0010 E          RBW-BU-S1   .25 SET UP TO REBUSH BOSSES     PRORATE OVER 4 PARTS            .18669          .053
    0020 E          RBW-BU-B1  1.00 REBUSH A SET OF 2 BOSSES     INCLUDES REAM & POLISH         .23835          .274
    0030 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
 9000       JA 01   15          .00                             LABOR STANDARD HISTORY          .000   .000     .000       0
    0010                           27AUG85 NEW OPERATION/WORK PREVIOUSLY DONE ON
    0011                                   OPER B0060 <OLD STD> 3.58
    0020                           31DEC85 UPDATED OCC FACTORS <OLD STD> 3.10
    0900                                   N MONROE  MANEAA  73357


TO INTERROGATE LABOR STANDARDS, INPUT

 RCC PRD NROP NR
<---X----X--->
1234567890123456  ELSE PUT IN END
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                LABOR STANDARD  OPERATION RESOURCE STANDARD AND METHOD ANALYSIS   02/15/89    A-E046B-MM1-DY-M45  PAGE  0001
     17575A     CSA MLG  4G11020-107A                    RCC MNPRA              4S1-93-3              84013
TECH S S   W F PF A/R REV
     T K  #R A FA SUPPORT   OCC <-------------------- DESCRIPTION ------------------> BASE    PFD     STD            A
STEP D L   K C DC ELEMENT  FACT          STORED                  SUPPLEMENTAL       HOURS   TIME    HOURS    DLY PCT C
-------------------------------------------------------------------------------------------------------------------------
RA017   S  E JA EA 1    J 88334   .67 PERCENT ENGR 99.9          REP APEX SHAFT C-5A   .54             .36
  0001      JA 01   00            .00                           PART NUMBER/NSN       .000   .000     .000       0
    0010                             4G13561-101A          5315001321925
  0055      JA 01   15           1.00                           RECENTER PIN--60--    .472   .071     .543     100
    0010 E          RLA-SU-S3    .50 SET UP SMALL MEDIUM LATHE  PRORATE 2 PARTS      .49962           .287
    0020 E          RLA-HP-C3   2.00 CHUCK SYMET PART IN 4 JAW  BOTH SIDES          .09095           .209
    0030 E          KML-CD-P1   2.00 CENTER DRILL                                   .01519           .034
    0050 E          RJP-PW-R1   1.00 REM RPL PAPRWRK SIGN OFF DOC                   .01001           .011
  9000      JA 01   00            .00                           LABOR STANDARD HISTORY .000   .000     .000       0
    0010                             9 JUNE 88  INITIAL  INPUT MRPII
    0900                             NED MONROE        MANEL       73255     MR BIG


** INTERROGATE LABOR STANDARDS. INPUT

 RCC PRD MROP NR
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1234567890123456  ELSE PUT IN END
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S STEP	H S S T K D L	W F PF A/R REV #R A FA K C DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION <STORED>	DESCRIPTION <SUPPLEMENTAL>	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
9018	S E	JA EA 1	J 89017	.83	PERCENT ENGR 99.8	MACH RETRACT ARM C-5A	7.33		6.09		
0001		JA 01 00		.83		PART NUMBER/NSN	.000	.000	.000		0
0010					4G11448-107A	1620001157390					
0060		JA 01 15		.10		O/S CROSS PIN HOLES	2.344	.035	.270		4
0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOISTLUCAS BORING MILL		1.03687		1.192		
0020	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E		RML-BD-DB	1.00	BORE HOLE 2.5 X 1 GROUP 4		.44325		.509		
0060	N			1.00		ROTATE PART 180 DEGREE	.08300		.095		
0070	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0080	E		RML-BD-DB	1.00	BORE HOLE 2.5 X 1 GROUP 4		.44325		.509		
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0065		JA 01 15		.80		O/S RIG PIN HOLE	1.067	.128	.982		13
0010	E		RML-SU-V2	.50	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 2 PARTS		.80167		.460		
0020	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E		RML-BD-AD	1.00	BORE HOLE 1 X 2 GROUP 4		.40093		.461		
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070		JA 01 15		.10		O/S SMALL ATTACH HOLE	1.616	.024	.186		3
0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E		RML-BD-CA	1.00	BORE HOLE 2 X 1/2 GROUP 4		.31398		.361		
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080		JA 01 15		.20		O/S LARGE ATTACH HOLE	1.688	.051	.388		5
0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E		RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E		RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0050	E		RML-BD-DA	1.00	BORE HOLE 2.5 X 1/2 GROUP 4		.33548		.385		
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0228		JA 01 15		1.00		TURN BUSHING GROUP 1/BRONZE	.216	.032	.248		3
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E		KML-TA-FC	1.00	DIA 2.00-3.00 REM .033-.250		.07104		.081		
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0230		JA 01 15		1.00		INST SET FLANGED BUSHINGS	.108	.016	.124		2
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.059		
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0232		JA 01 15		1.00		O/S HOLE ON MILL/MED PART	.831	.125	.957		13
0010	E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS		.80167		.230		
0020	E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E		KMH-BC-DA	1.00	BORE HOLE 2.5 X 1/2 GROUP 3 USE PROPER ELEMENT/TABLE		.26060		.299		
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0238		JA 01 15		1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		5
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030	E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		

826

0240	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.108	.016	.124	2
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00		O/S HOLE ON MILL/MED PART	.805	.121	.927	13
0010 E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KMM-BC-BA	1.00	BORE HOLE 1.5 X 1/2 GROUP 3	USE PROPER ELEMENT/TABLE	.23467		.269	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0248	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.297	.045	.342	5
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030 E		KML-TA-FC	2.00	DIA 2.00-3.00 REM .033-.250		.07104		.163	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0249	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.108	.016	.124	2
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0250	JA 01	15	1.00		O/S HOLE ON MILL/MED PART	.787	.118	.906	12
0010 E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.248	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0251	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	5
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030 E		KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0252	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.108	.016	.124	2
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0253	JA 01	15	1.00		O/S HOLE ON MILL/MED PART	.845	.127	.972	13
0010 E		RML-SU-V2	.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KMM-BC-AC	1.00	BORE HOLE 1 X 1 1/2 GROUP 3	USE PROPER ELEMENT/TABLE	.27420		.315	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 00	15	.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010				27AUG85 UPDATE OCCURANCE FACTORS/RESTRUCTURED					
0011				LABOR STANDARD TO MATRCH AFLC FORM 958					
0012				WORK PREVIOUSLY DONE ON OPERATION B0020					
0013				<OLD STD> 5.12					
0020				16JAN86 UPDATED OCC FACTORS <OLD STD> 2.84					
0900				N. MONROE MANEAM 73357					

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	CH S T D	S K L	W R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
A021	S	E	JA	EA	1	J 88335	1.00	PERCENT ENGR 99.9	C5A TRUN CROSS BOLT	.54		.54		
0001			JA	02	00		1.00		PART NUMBER/NSN	.000	.000	.000		0
0010								4G13347-101A	5306004541547					
0055			JA	01	15		1.00		RECENTER PIN--60--	.472	.071	.543		100
0010	E				RLA-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287		
0020	E				RLA-HP-C3		2.00	CHUCK SYMET PART IN 4 JAW	BOTH SIDES	.09095		.209		
0030	E				KML-CD-P1		2.00	CENTER DRILL		.01519		.034		
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010								9 JUNE 88 INITIAL INPUT MRPII						
0900								NED MONROE MANEL 73255 MR BIG						

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

TECH STEP	S T	S K	W R	F A	PF DC	A/R ELEMENT	REV SUPPORT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
RA025	S	E	JA	EA	1		J 88335	.08	PERCENT ENGR 99.9	C5A APEX BOLT	.54		.04			
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0	
0010									4G13537-101A	1620001164433						
0045			JA	01		15		1.00		RECENTER PIN--60--	.472	.071	.543		100	
0010	E					RLA-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287			
0020	E					RLA-HP-C3		2.00	CHUCK SYMET PART IN 4 JAW	BOTH SIDES	.09095		.209			
0030	E					KML-CD-P1		2.00	CENTER DRILL		.01519		.034			
0050	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
9000			JA	01		00		.00		LABOR STANDARD HISTORY	.000	.000	.000		0	
0010									9 JUNE 88 INITIAL INPUT MRPII							
0900									NED MONROE MANEL 73255 MR BIG							

TO INTERROGATE LABOR STANDARDS. INPUT

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          17575A    CSA MLS  4611020-107A                     RCC MNPRA             4S1-93-3              84013
OPER   TECH S S    # F PF A/R REV
  JOB       T K   #R A FA SUPPORT   OCC <-------------------- DESCRIPTION -------------------->  BASE    PFD    STD          4
    STEP D L   K C OC ELEMENT  FACT              STORED                   SUPPLEMENTAL          HOURS   TIME   HOURS    DLY PCT C
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RA026    S  E JA EA 1    J 88173   .63 PERCENT ENGR 99.9          COLLAR LOCK COLLAR C-5A       1.44           .91
  0001      JA 01   00            .00                             PART NUMBER/NSN               .000   .000   .000          0
     0010                              4611447-101A          1620001157389
  0050      JA 01   15            1.00                            NICK & BURR                   .055   .008   .064          4
     0010 E          RLG-RB-N4    1.00 NICK & BURR SMALL STRUT PART                             .04595         .052
     0030 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  0052      JA 01   15            .05                             O/S ATT LUG LEFT SIDE         .349   .003   .020          1
     0010 E          RBW-BU-B1    .25 SET UP TO REBUSH BOSSES     PRORATE OVER 4 PARTS          .19669         .050
     0020 E          RLG-HP-V7    1.00 OBJ IN/OUT STP VISE--1ST HAND                            .06831         .078
     0030 E          RBW-BU-R2    3.00 REAM WITH LEMPCO REAMER    3 PASSES                      .07337         .253
     0040 E          RBW-DB-A1    1.00 DEBUR HOLE/CUTOUT BOTH SIDES                             .00423         .004
     0050 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  0054      JA 01   15            .05                             O/S ATT LUG RIGHT SIDE        .349   .003   .020          1
     0010 E          RBW-BU-B1    .25 SET UP TO REBUSH BOSSES     PRORATE OVER 4 PARTS          .19669         .050
     0020 E          RLG-HP-V7    1.00 OBJ IN/OUT STP VISE--1ST HAND                            .06831         .078
     0030 E          RBW-BU-R2    3.00 REAM WITH LEMPCO REAMER    3 PASSES                      .07337         .253
     0040 E          RBW-DB-A1    1.00 DEBUR HOLE/CUTOUT BOTH SIDES                             .00423         .004
     0050 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  0128      JA 01   15            1.00                            MACH ATT LUG BUSH LS          .289   .043   .332         23
     0010 E          RLA-SU-S3    .25 SET UP SMALL MEDIUM LATHE   PRORATE OVER 4 PARTS          .49962         .143
     0020 E          RLA-HP-C1    2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS                  .01006         .023
     0030 E          KML-TA-CC    2.00 DIA .501-1.00 REM .033-.250  2 BUSHINGS                  .06699         .154
     0040 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  0130      JA 01   15            1.00                            INSTL ATT LUG LS              .295   .044   .339         23
     0010 E          RBW-BU-B1    .25 SET UP TO REBUSH BOSSES     PRORATE OVER 4 PARTS          .19669         .050
     0020 E          RBW-BU-B1    1.00 REBUSH A SET OF 2 BOSSES   INCLUDES REAM & POLISH        .23835         .274
     0030 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  0138      JA 01   15            1.00                            MACH ATT LUG RS               .289   .043   .332         23
     0010 E          RLA-SU-S3    .25 SET UP SMALL MEDIUM LATHE   PRORATE OVER 4 PARTS          .49962         .143
     0020 E          RLA-HP-C1    2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS                  .01006         .023
     0030 E          KML-TA-CC    2.00 DIA .501-1.00 REM .033-.250  2 BUSHINGS                  .06699         .154
     0040 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  0140      JA 01   15            1.00                            INSTL ATT LUG RS              .295   .044   .339         23
     0010 E          RBW-BU-S1    .25 SET UP TO REBUSH BOSSES     PRORATE OVER 4 PARTS          .19669         .050
     0020 E          RBW-BU-B1    1.00 REBUSH A SET OF 2 BOSSES   INCLUDES REAM & POLISH        .23835         .274
     0030 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001         .011
  9000      JA 01   00            .01                             LABOR STANDARD HISTORY        .000   .000   .000          0
     0001                              INITIAL INPUT
     0900                              KIM VINCENT, MANEL, 73952


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17575A CSA MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	TCH	S	S	W	F	PF	A/R	REV	T	K	#R	A	FA	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RA030		E		N	JA	EA	1		J		89026				.41	PERCENT ENGR 6.0	MACH LOCK RING ASSY	3.54		1.45		
0001					JA	01			00						.00		PART NUMBER / NSN	.000	.000	.000		0
0010																4G12636-101A	1620001157427					
0010					JA	01			00						.37		MATCH UP	1.793	.000	.664		19
0010		E												RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL		.27525		.137		
0020		N													1.00		MATCH COMPONENT PARTS	1.50800		1.508		
0030		E												RLG-RS-N4	3.00	NICK & BURR SMALL STRUT PARTS MATCHING PARTS		.04595		.137		
0040		E												RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0025					JA	01			00						.37		PREASSY CLEANING	3.147	.000	1.165		33
0010		E												RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL		.27525		.137		
0020		N													3.00		CLEAN ALL PARTS	1.00000		3.000		
0030		E												RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0030					JA	01			00						.37		ASSEMBLE COMPONENT PARTS	4.646	.000	1.719		48
0010		E												RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL		.27525		.137		
0020		N													3.00		ASSEMBLE 3 PARTS	1.33300		3.999		
0030		N													1.00		DRILL NEW HOLES	.50000		.500		
0040		E												RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
9000					JA	01			15						.01		LABOR STD HISTORY	.000	.000	.000		0
0010																23JUN83 OCC FACTOR CHG AVG 3 STUDIES						
0020																PREVIOUS STD HRS 0.54						

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 04/17/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A FCC MNPRA 4G1-PO-3 84010

OPER TECH S S W F FF A/R REV STEP	T K #R A FA D L K C DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL		BASE HOURS	PFD TIME	STD HOURS	DLY FCT	A C
RA034 S E	JA EA 1	J 83062	.06	PERCENT ENGR 99.9	ANCHOR SHAFT	C-5A	2.99		.17		
0001	JA 01 00		.00		PART NUMBER/NSN		.000	.000	.000	0	
0010				4G13366-101A	1620002284716LE						
0040	JA 01 15		.68		O/S PIN -OLE	-040-	1.027	.105	.804	27	
0010 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE			.49962		.574		
0020 E		RLA--F-C4	2.00	IRREG PART IN 4 JAW CHUCK	OCC-BOTH ENDS		.22097		.515		
0030 E		RLA-HM-T2	1.00	INSTALL & ADJUST TOOL KCK BAR			.02972		.034		
0040 E		RLA-HM-F1	1.00	CHANGE FEED			.00326		.003		
0050 E		RLA-HM-S1	1.00	CHANGE SPEED ONE LEVER			.00154		.001		
0060 E		RLA-TA-CA	1.00	DIA.501-1.00 REMOVE (.030			.04177		.048		
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0050	JA 01 15		.68		O/S THREADED HOLE	-050-	.243	.025	.190	6	
0010 E		RBW-SU-S1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS		.27525		.156		
0020 E		RBD-JP-C0	1.00	PREP HAND DRILL FOR USE			.00861		.009		
0030 E		BPE-TP-D8	1.00	DRILL HOLE WITH HAND DRILL			.00650		.007		
0040 E		RLM-ZF-D1	5.00	REMOVE ZERK FITTING	OCC-DIFFICULT REMOVAL		.01197		.068		
0050 E		RWE-NB-04	1.00	PROC TIME NCK BUR SMALL PART			.02100		.024		
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0259	JA 01 15		.83		INST PIN HOLE BUSH	-260-	.724	.090	.692	20	
0010 E		RLA-SU-S3	.75	SET UP SMALL MEDIUM LATHE			.49962		430		
0020 E		KML-TD-BA	1.00	DIA .251-.500 (.033	FLANGE		.06193		.071		
0030 E		KML-TD-BA	1.00	DIA .251-.500 (.033	OD		.06193		.071		
0040 E		RLA-FF-BG	1.00	FACE FINISH 1/2 - 1 GROUP 4			.03356		.038		
0050 E		RLA-BO-AG	1.00	BORE HOLE (1/2 DIA 1 IN DP			.10123		.116		
0060 E		RLA-CO-AG	1.00	CUT OFF (1/2 DIA. GROUP 4			.03108		.035		
0070 E		RLA-FR-BG	1.00	FACE ROUGH 1/2 - 1 DIA GRP 4			.01648		.019		
0080 E		RLA-FF-BG	1.00	FACE FINISH 1/2 - 1 GROUP 4			.03356		.038		
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0260	JA 01 15		.83		INST PIN HOLE BUSH	-260-	.328	.041	.314	10	
0090 E		RBW-BU-S1	.75	SET UP TO REBUSH BOSSES			.18669		.161		
0100 E		RBW-BU-B1	.75	REBUSH A SET OF 2 BOSSES			.23835		.205		
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0270	JA 01 15		.83		INSTALL INSERT	-270-	1.043	.130	.996	33	
0010 E		RLA-SU-S3	.75	SET UP SMALL MEDIUM LATHE			.49962		.430		
0020 E		KML-TD-BA	1.00	DIA .251-.500 (.033	FLANGE		.06193		.071		
0030 E		KML-TD-BA	1.00	DIA .251-.500 (.033	OD		.06193		.071		
0040 E		RLA-FF-BG	1.00	FACE FINISH 1/2 - 1 GROUP 4			.03356		.038		
0050 E		RLA-BO-AG	1.00	BORE HOLE (1/2 DIA 1 IN DP			.10123		.116		
0060 E		RLA-CO-AG	1.00	CUT OFF (1/2 DIA. GROUP 4			.03108		.035		
0070 E		RLA-FR-BG	1.00	FACE ROUGH 1/2 - 1 DIA GRP 4			.01648		.019		
0080 E		RLA-FF-BG	1.00	FACE FINISH 1/2 - 1 GROUP 4			.03356		.038		
0090 E		RBW-SU-S1	.75	SET UP TO REBUSH BOSSES			.18669		.161		
0100 E		RBW-BU-B1	.75	REBUSH A SET OF 2 BOSSES			.23835		.205		
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0120				F.COLLINS TECHN MANEPA							
9000	JA 01 15		.01		LABOR STD HISTORY		.000	.000	.000	0	
0010				23JUN83 CHG OCC FACTORS							
0020				PREVIOUS STD HRS .08 3/3/83							

TO INTERROGATE LABOR STANDARDS, INPUT

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/16/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

CH STEP	S T	S K	W R	F A	PF C	A/R DC	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION <---- STORED	DESCRIPTION ----> SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
AC33	S	E	JA	EA	1		J	89018	.09	PERCENT ENGR 99.9	C-5A ROUND NUT	4.70		.42			
0001			JA	01		00			.00		PART NUMBER/NSN	.000	.000	.000		0	
0010										4G13782-101A	5310004970602						
0040			JA	01		15			.68		MACH NEW SLOTS	3.285	.335	2.569		55	
0010	E					KMM-SU-V1			.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145			
0020	E					RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098			
0030	E					RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146			
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087			
0050	E					RML-BD-AC			8.00	BORE HOLE 1 X 1 1/2 GROUP 4USE PROPER ELEMENT/TABLE		.35762		3.290			
0060	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0045			JA	01		15			1.00		MACH REPAIR OLD SLOTS	1.855	.278	2.133		45	
0010	E					KMM-SU-V1			.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145			
0020	E					RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098			
0030	E					RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146			
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087			
0050	E					RML-BD-AC			4.00	BORE HOLE 1 X 1 1/2 GROUP 4USE PROPER ELEMENT/TABLE		.35762		1.645			
0060	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
9000			JA	01		15			.01		LABOR STD HISTORY	.000	.000	.000		0	
0010										23JUN83 OCC FACTOR CHG AVG 3 STUDIES							
0020										PREVIOUS STD HRS 0.01							

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/16/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	TECH T	S D	S L	W K	F #R	PF A	A/R FA	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION <STORED>	DESCRIPTION <SUPPLEMENTAL>	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA041	S	E	JA	EA	1		J	88337	.05	PERCENT ENGR 99.9	C5A THRUST BEARING	.87		.04		
0001			JA	01	00				.05		PART NUMBER/NSN	.000	.000	.000		0
0010										4G19074-101A	3120005426972					
0025			JA	01	15				1.00		MACH TO REQ'D THICKNESS--10-	.757	.114	.871		100
0010		E				RLA-SU-S3			1.00	SET UP SMALL MEDIUM LATHE		.49962		.574		
0020		E				RLA-HP-C1			2.00	1ST PART IN-OUT SCROLL CHUCKMACHINE 2 SIDES		.01006		.023		
0030		E				RLA-FR-LG			2.00	FACE ROUGH 7 - 8 DIA. GRP 4 OCC FOR 11 IN DIA		.03779		.086		
0040		E				RLA-FF-LG			2.00	FACE FINISH 7 - 8 GROUP 4 OCC FOR 11 IN DIA		.07619		.175		
0050		E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	00				.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010										9 JUNE 88 INITIAL INPUT MRPII						
0900										NED MONROE MANEL 73255 MR BIG						

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD NROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/16/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	TCH T	S K	S L	W #R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
A043		S	E	JA EA 1		J	88319	.09	PERCENT ENGR 99.9	MACH PISTON STOP TUBE C-5A	1.10		.09		
0001				JA 00	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4G12409-101B	1620001299168					
0079				JA 01	15			1.00		TURN BUSHING GROUP 4/STEEL	.747	.112	.860		77
0010	E				RLA-SU-S3			1.00	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.574		
0020	E				RLA-HP-C1			2.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.023		
0030	E				KML-TD-CC			2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080				JA 01	15			1.00		INST STRAIGHT BUSH NO POLISH	.217	.033	.250		23
0010	E				RBW-BU-S1			1.00	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.214		
0020	E				RBW-BU-A4			1.00	INSTALL ONE STRAIGHT BUSHING		[illegible]		.023		
0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000				JA 01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									9 JUNE 88 INITIAL INPUT MRPII						
0900									MED MONROE	MANEL 73255 MR BIG					

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17575A C5A MLG 4611020-107A RCC MNPRA 4S1-93-3 84013

STEP	TECH D	S T L	S K K	W #R C	F A DC	PF FA	A/R SUPPORT ELEMENT	REV	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RA048	S	E	JA	EA	1		J 88334		1.00	PERCENT ENGR 99.9	C5A FLUID TRS HOUSING	3.07		3.07		
0001			JA	01		00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010										4612583-103A	1620001157419					
0055			JA	01		15			.20		NICK AND BURR SMALL PART	.055	.002	.013		0
0010	E						RLG-RS-N4		1.00	NICK & BURR SMALL STRUT PART		.04595		.052		
0030	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01		15			.40		O/S HOLE ON MILL/SMALL PART	.604	.036	.278		9
0010	E						KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						RML-BA-AA		1.00	BORE HOLE 1 X 1/2 GROUP 1	USE PROPER ELEMENT/TABLE	.17936		.206		
0060	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0065			JA	01		15			.40		O/S HOLE ON MILL/SMALL PART	.604	.036	.278		9
0010	E						KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						RML-BA-AA		1.00	BORE HOLE 1 X 1/2 GROUP 1	USE PROPER ELEMENT/TABLE	.17936		.206		
0060	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01		15			.30		O/S HOLE ON MILL/SMALL PART	.640	.029	.221		7
0010	E						KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
20	E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						RML-BA-CD		1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.248		
0060	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0075			JA	01		15			.20		O/S HOLE ON MILL/SMALL PART	.480	.014	.110		4
0010	E						KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						KML-TA-CA		1.00	DIA .501-1.00 REM (.033	KMLTACA	.05535		.063		
0060	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01		15			.30		O/S HOLE ON MILL/SMALL PART	.640	.029	.221		7
0010	E						KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E						RML-BA-CD		1.00	BORE HOLE 2 X 2 GROUP 1	FLAME SPRAY	.21626		.248		
0060	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0124			JA	01		15			.40		TURN BUSHING GROUP 1/BRONZE	.289	.017	.133		4
0010	E						RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E						KML-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0125			JA	01		15			.40		INST/REAM SET STRAIGHT BUSH	.167	.010	.077		3
0010	E						RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
20	E						RBW-BU-B2		.50	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.127		
0030	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0129			JA	01		15			.40		TURN BUSHING GROUP 1/BRONZE	.289	.017	.133		4
0010	E						RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E						KML-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		

0130	JA 01	15	.40		INST/REAM SET STRAIGHT BUSH	.278	.017	.128	4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.255	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	.10		REPLACE LEE PLUGS-113 & 115-	.508	.008	.058	2
0010 E		RDR-SU-R1	.50	S/U TO O/S BOSSES RAD DRILL	2 AREAS	.56378		.324	
0020 E		RLA-DR-CB	2.00	DRILL HOLE 1/8-1/4 DIA. X 1	REMOVE PLUGS	.04660		.107	
0030 E		RDR-SU-S1	1.00	CHANGE TOOL IN RADIAL DRILL		.00722		.008	
0040 E		RLA-DR-CB	2.00	DRILL HOLE 1/8-1/4 DIA. X 1	O/S PLUG HOLES	.04660		.107	
0050 E		RBW-BU-A2	1.00	INSTALL SET STRAIGHT BUSHING	OR LEE PLUGS	.02299		.026	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0145	JA 01	15	.20		INST SET FLANGED BUSHINGS	.082	.002	.019	1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.029	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0150	JA 01	15	.25		INSTALL HELICOILS --125--	.293	.011	.084	3
0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		GLM-AS-AA	2.00	INSTALL HELICAL SPRING	2EA	.00432		.009	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0900				LARRY CLARK-TECHN-MANEAA					
0155	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.082	.012	.095	3
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.029	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0158	JA 01	15	.20		TURN BUSHING GROUP 4/STEEL	.611	.018	.141	5
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.046	
0030 E		KML-TD-CC	4.00	DIA .501-1.00 REM .033-.250		.10898		.501	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00		INST/REAM SET STRAIGHT BUSH	.945	.142	1.088	35
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B2	4.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		1.022	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	00	.00		LABOR STANDRD HISTORY	.000	.000	.000	0
0900				8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 04/17/89 A-E0468-MM1-DY-M45 PAGE 0001

17575A CER MLG 4811020-107A RCC MNFRA 481-9C-C 8401C

OPER SUF	STEP	TECH D	S L	W K	F R	PF C	A/R A	REV FA	SUPPORT DOC ELEMENT	FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE -OLRS	PFD TIME	STD HOURS	A DLY PCT C
0001		S	E	JA	EA	1		J 89012	.79	PERCENT ENGR 99.9		MACH C-EA M BALLSCREW PIN	.54		.42	
	0001			JA	01	00			.00			PART NUMBER/NEN	.000	.000	.000	0
	0010									4812605-107A		5015001481779				
	0040			JA	01	1E			1.00			RECENTER PIN--60--	.472	.071	.540	100
	0010	E					RLA	-SU-B3	.50	SET UP SMALL MEDIUM LATHE		PRORATE 2 PARTS	.49982		.337	
	0020	E					RLA	-HP-2C	2.00	CHUCK SYMET PART IN 4 JAW		BOTH SIDES	.09095		.219	
	0030	E					VML	-DJ-P1	2.00	CENTER DRILL			.01519		.024	
	0050	E					RJP	-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
	9900			JA	01	00			.00			LABOR STANDARD HISTORY	.000	.000	.000	0
	0010									9 JUNE 88	INITIAL	INPUT MRPII				
	0900									NED MONROE		MANEL 70255 MR 378				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR
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17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	D	T	S L	K	W R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A C
A091	S	N	JA	EA	1				J	88351	.15	PERCENT ENGR 59.2	MACH SWIVEL FITTING(STEPPED)	3.41		.51			
0001			JA	01				00			1.00		PART NUMBER/NSN	.000	.000	.000			0
0010												4G12586-101A	1620001157398						
0040			JA	01				15			.72		END HOLE REPAIR	.211	.023	.176			5
0010	E								RLA	SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E								RLA	HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011			
0030	E								KML	TA-CC	1.00	DIA .501-1.00 REM .033-.250		.06699		.077			
0040	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0045			JA	01				00			.87		REPAIR THREADED END	.271	.000	.236			7
0010	E								RLA	SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.249			
0020	E								KML	CO-DD	1.00	CUT OFF 1.5-2 DIA ADD 1/8 INCUT OFF END		.00418		.004			
0030	E								KML	FF-DH	1.00	FACE FINISH 1.5 TO 2 ADD 1/8		.00743		.007			
0040	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010			
0050			JA	01				15			.87		DRILL HOLES IN FITTING	.297	.039	.298			9
0010	E								RLA	SU-S3	.25	SET UP SMALL MEDIUM LATHE		.49962		.143			
0020	E								KML	CD-P1	3.00	CENTER DRILL	DRILL 3 HOLES	.01519		.052			
0030	E								RLA	DR-CA	3.00	DRILL HOLE 1/8-1/4 DIA (1/2		.03903		.134			
0040	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0060			JA	01				00			.87		MFG A STUD (INSERT)	1.634	.000	1.422			42
0010	E								RLA	SU-S3	.25	SET UP SMALL MEDIUM LATHE		.49962		.124			
0020	N										1.00		MANUFACTURE STUD	.66700		.667			
0030	N										1.00		THREAD STUD BOTH ENDS	.83300		.833			
[illegible]	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010			
[illegible]			JA	01				15			1.00		MACH END HOLE BUSHINGS	.373	.056	.429			13
0010	E								RLA	SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E								RLA	HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023			
0030	E								KML	TD-CC	2.00	DIA .501-1.00 REM .033-.250		.10898		.250			
0040	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0090			JA	01				15			1.00		INST END HOLE BUSHINGS	.295	.044	.339			10
0010	E								RBW	BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020	E								RBW	BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274			
0030	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0095			JA	01				15			.87		INSTALL INSERT	.348	.045	.349			10
0010	E								RBW	SU-H1	1.00	SET UP TO INSTALL HELICOILS		.31093		.357			
0020	E								RBW	TR-H1	1.00	INSTALL HELICOIL INSERT		.02763		.031			
0030	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0100			JA	01				00			1.00		CHASE THREADED END	.161	.000	.162			5
0010	E								RBW	SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.137			
0020	E								GTL	TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.014			
0030	E								RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010			
9000			JA	01				15			.01		LABOR STD HISTORY	.000	.000	.000			0
0010												23JUN83 OCC FACTOR CHG AVG 3 STUDIES							
0020												PREVIOUS STD HRS 0.43							

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/16/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	TECH T	S D	S K	W #R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA092		S	N	JA	EA	1		J	88351	.05	PERCENT ENGR 59.2	MACH SWIVEL FITTING (LARGE)	3.41		.17		
0001				JA	01		00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010											4612584-101A	1620001157396					
0040				JA	01		15			.72		END HOLE REPAIR	.211	.023	.176		5
0010	E						RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA-HP-C1			1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E						KML-TA-CC			1.00	DIA .501-1.00 REM .033-.250		.06699		.077		
0040	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045				JA	01		00			.87		REPAIR THREADED END	.271	.000	.236		7
0010	E						RLA-SU-S3			.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.249		
0020	E						KML-CO-DD			1.00	CUT OFF 1.5-2 DIA ADD 1/8 INCUT OFF END		.00418		.004		
0030	E						KML-FF-DH			1.00	FACE FINISH 1.5 TO 2 ADD 1/8		.00743		.007		
0040	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0050				JA	01		15			.87		DRILL HOLES IN FITTING	.297	.039	.298		9
0010	E						RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE		.49962		.143		
0020	E						KML-CD-P1			3.00	CENTER DRILL	DRILL 3 HOLES	.01519		.052		
0030	E						RLA-DR-CA			3.00	DRILL HOLE 1/8-1/4 DIA (1/2		.03903		.134		
0040	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060				JA	01		00			.87		MFG A STUD (INSERT)	1.634	.000	1.422		42
0010	E						RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE		.49962		.124		
0020	N									1.00		MANUFACTURE STUD	.66700		.667		
0030	N									1.00		THREAD STUD BOTH ENDS	.83300		.833		
0040	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0070				JA	01		15			1.00		MACH END HOLE BUSHINGS	.373	.056	.429		13
0010	E						RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA-HP-C1			2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E						KML-TD-CC			2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090				JA	01		15			1.00		INST END HOLE BUSHINGS	.295	.044	.339		10
0010	E						RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E						RBW-BU-B1			1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0095				JA	01		15			.87		INSTALL INSERT	.348	.045	.349		10
0010	E						RBW-SU-H1			1.00	SET UP TO INSTALL HELICOILS		.31093		.357		
0020	E						RBW-TR-H1			1.00	INSTALL HELICOIL INSERT		.02763		.031		
0030	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100				JA	01		00			1.00		CHASE THREADED END	.161	.000	.162		5
0010	E						RBW-SU-G1			.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.137		
0020	E						GTL-TH-A1			1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.014		
0030	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
9000				JA	01		15			1.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0900											C. W. RIGBY MANEL-1 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

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17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	CH	S	T	S K	W R	F A	PF C	A/R FA DC	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
3A093		S	N	JA	EA	1		J	88351	.15	PERCENT ENGR 59.2	MACH SWIVEL FITTING (INT)	3.41		.51		
0001				JA	01		00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4G12585-101A		1620001157397						
0040				JA	01		15			.72		END HOLE REPAIR	.211	.023	.176		5
0010	E						RLA	SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA	HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E						KML	TA-CC		1.00	DIA .501-1.00 REM .033-.250		.06699		.077		
0040	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045				JA	01		00			.87		REPAIR THREADED END	.271	.000	.236		7
0010	E						RLA	SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.249		
0020	E						KML	CD-DD		1.00	CUT OFF 1.5-2 DIA ADD 1/8	INCUT OFF END	.00418		.004		
0030	E						KML	FF-DH		1.00	FACE FINISH 1.5 TO 2 ADD 1/8		.00743		.007		
0040	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0050				JA	01		15			.87		DRILL HOLES IN FITTING	.297	.039	.298		9
0010	E						RLA	SU-S3		.25	SET UP SMALL MEDIUM LATHE		.49962		.143		
0020	E						KML	CD-P1		3.00	CENTER DRILL	DRILL 3 HOLES	.01519		.052		
0030	E						RLA	DR-CA		3.00	DRILL HOLE 1/8-1/4 DIA (1/2		.03903		.134		
0040	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060				JA	01		00			.87		MFG A STUD (INSERT)	1.634	.000	1.422		42
0010	E						RLA	SU-S3		.25	SET UP SMALL MEDIUM LATHE		.49962		.124		
0020	N									1.00		MANUFACTURE STUD	.66700		.667		
30	N									1.00		*THREAD STUD BOTH ENDS*	.83300		.833		
40	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0085				JA	01		15			1.00		MACH END HOLE BUSHINGS	.373	.056	.429		13
0010	E						RLA	SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA	HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E						KML	TD-CC		2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090				JA	01		15			1.00		INST END HOLE BUSHINGS	.295	.044	.339		10
0010	E						RBW	BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E						RBW	BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0095				JA	01		15			.87		INSTALL INSERT	.348	.045	.349		10
0010	E						RBW	SU-H1		1.00	SET UP TO INSTALL HELICOILS		.31093		.357		
0020	E						RBW	TR-H1		1.00	INSTALL HELICOIL INSERT		.02763		.031		
0030	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100				JA	01		00			1.00		CHASE THREADED END	.161	.000	.162		5
0010	E						RBW	SU-G1		.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.137		
0020	E						GTL	TH-A1		1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.014		
0030	E						RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
9000				JA	01		15			.01		LABOR STD HISTORY	.000	.000	.000		0
0010											23JUN83 OCC FACTOR CHG AVG 3 STUDIES						
0020											PREVIOUS STD HRS 0.43						

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17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

STEP	TCH	S T	S K	W #R	F A	PF FA	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL		BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
A059	E	N	JA	EA	1	J	84316	1.00	PERCENT ENGR .0	REPAIR GUAGE P/N 3714	411	1.15		1.15	
0001			JA	00	00			.00		PART NUMBER/NSN		.000	.000	.000	0
0010									G3714	6685002283784					
0020									4G94407-101A						
0020			JA	01	15			1.00		REMOVE LENS		.500	.075	.575	50
0010	N							1.00		REMOVE LENS		.50000		.575	
0050			JA	01	15			1.00		INSTALL LENS		.500	.075	.575	50
0010	N							1.00		INSTALL LENS		.50000		.575	
9000			JA	01	00			.00		LABOR STANDARD HISTORY		.000	.000	.000	0
0010									9 JUNE 88 INITIAL INPUT MRPII						
0990									NED MONROE MANEL 73255 MR BIG						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E044B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MMPRB 4S1-93-3 84013

STEP	T D	S S K L	W R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A C
3B001	S E	JA	EA	3	J	87092	.79	PERCENT ENGR 98.0	GRIND OUTER CYLINDER 502	29.28		23.13			
0001		JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000			0
0010								4G11415-107A	1620004463776						
0020		JA	01		15		1.00		CK AREA C TO DIA B	1.180	.177	1.357			5
0010	E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE OVER 4 OPERATION	1.53372		.440			
0020	E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRO RATE 4 OPER	.09095		.026			
0030	E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS	.22097		.063			
0040	E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS	.36081		.103			
0050	E					KMG-GW-LK	4.00		LOCATE INDICATOR/4 TIMES	.06761		.311			
0060	E					KMM-SU-A1	4.00	DIAL ONE AXIS LONG OR CROSS	4 PLACES	.03892		.179			
0070	E					RJP-PW-C1	32.00	WRITE CRITICAL DIMENSION	32 READINGS	.00601		.221			
0080	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0025		JA	01		15		1.00		CK DIA C TO COLLAR AREA	.716	.107	.824			3
0010	E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE/4 OPERATIONS	1.53372		.440			
0020	E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRO RATE 4 OPER	.09095		.026			
0030	E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS	.22097		.063			
0040	E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS	.36081		.103			
0050	E					KMG-GW-LK	1.00		LOCATE INDICATOR	.06761		.077			
0060	E					KMM-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS	1 PLACE	.03892		.044			
0070	E					RJP-PW-C1	8.00	WRITE CRITICAL DIMENSION	8 READINGS	.00601		.055			
0080	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
		JA	01		15		1.00		CHK UPPER BORE TO DIA A	1.025	.154	1.179			4
.0	E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE/4 OPERATIONS	1.53372		.440			
0020	E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRO RATE 4 OPER	.09095		.026			
0030	E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS	.22097		.063			
0040	E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS	.36081		.103			
0050	E					KMG-GW-LK	3.00		LOCATE IDICATOR/3 PLACES	.06761		.233			
0060	E					KMM-SU-A1	3.00	DIAL ONE AXIS LONG OR CROSS	3 PLACES	.03892		.134			
0070	E					RJP-PW-C1	24.00	WRITE CRITICAL DIMENSION	24 READINGS	.00601		.165			
0080	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0035		JA	01		15		1.00		CHK LOWER BORE TO DIA A	1.025	.154	1.179			4
0010	E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE/4 OPERATIONS	1.53372		.440			
0020	E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRO RATE 4 OPER	.09095		.026			
0030	E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS	.22097		.063			
0040	E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS	.36081		.103			
0050	E					KMG-GW-LK	3.00		LOCATE INDICATOR/3 PLACES	.06761		.233			
0060	E					KMM-SU-A1	3.00	DIAL ONE AXIS LONG OR CROSS	3 PLACES	.03892		.134			
0070	E					RJP-PW-C1	24.00	WRITE CRITICAL DIMENSION	24 READINGS	.00601		.165			
0080	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0050		JA	01		15		.11		GRIND CHAMFER AREA C	2.044	.034	.259			1
0010	E					RGR-SU-P1	1.00	SET UP PLANETARY GRINDER		.82175		.945			
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181			
0030	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087			
0040	E					RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.06265		.072			
0050	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146			
0060	E					KMG-DW-NW	.50	DRESS OR FORM NEW WHEEL	PRORATE 2 PARTS	.06761		.038			
0070	E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
30	E					KMG-OD-OE	1.00	GRIND .010 8DIA X 3 LONG		.68818		.791			
5	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,		.01001		.011			
0085		JA	01		15		.32		1ST GRIND O.D.	9.497	.456	3.495			12
0010	E					RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218			
0020	E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW	LOAD CENTER & DIAL IN	.09095		.104			
0030	E					RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRNDR	OCC DUE TO EXTREME SIZE	.16231		.373			
0040	E					RGR-GE-S2	650.00	GR STEEL OD (OCC FACT L X D)	52.0 X 12.5	.01093		8.170			
0050	E					RGR-GE-D2	12.50	DWELL (GAP GRINDER STEEL OD)	12.5 DIA	.01014		.145			

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0060	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ,			.02632		.030		
0070	E		RGR-WD-G2	3.00	WHEEL DRESS GAP GRINDER	OCC DUE TO EXTREME SIZE		.08334		.287		
0080	E		RGR-HM-C5	1.50	HANDLE & MEAS LENGTH 24 - 36	OCC FOR 52 INCH LENGTH		.11700		.201		
0090	E		RLG-RS-F4	78.00	FILE/GRIND & POL NICK/BURR	OCC FOR 37.5 IN CIRCUMFERENC		.00415		.372		
0092					UPPER & LOWER END OF CYL							
0095	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0100	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION ,			.00601		.006		
0090		JA 01	15	.16		1ST GRIND UPPER BORE		10.741	.258	1.977		7
0010	E		RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER			1.53372		1.763		
0020	E		RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTR	LOAD PART INTERNAL GRINDER		.30830		.709		
0022					OCC FOR EXTREME SIZE OF PART							
0030	E		RML-AL-AC	4.00	ALIGN HOLE TO SPINDLE ROD	OCC FOR EXTREME SIZE		.07609		.350		
0040	E		KMG-ID-TE	5.33	GRIND OUT .010 12 ID X 3	OCC FOR 005 TO 007 MATERIAL		1.46961		9.007		
0042					REMOVAL 32 INCH LONG 32/3 X .5=5.33							
0050	E		KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	OCC FOR EXTREME SIZE		.02458		.084		
0060	E		RTL-SU-G1	3.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME LENGTH &		.08248		.284		
0062					DIA 32 INCHES LONG X 12 INCHES							
0070	E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36	USE BORE GAGE TO CHECK PART		.11700		.134		
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0085	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION ,			.00601		.006		
0100		JA 01	15	.05		1ST GRIND LOWER BORE		3.718	.028	.214		1
0010	E		RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER			1.53372		1.763		
0020	E		RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTR	LOAD LARGE PART INT GRINDER		.30830		.709		
0022					OCC FOR EXTREME SIZE OF PART							
0030	E		RML-AL-AC	4.00	ALIGN HOLE TO SPINDLE ROD	OCC FOR EXTREME SIZE		.07609		.350		
0040	E		KMG-ID-TB	1.67	GRIND OUT .010 12.0 ID X 1.0	OCC FOR 005 TO 007 MATERIAL		.56064		1.076		
0042					REMOVAL 10 INCH LONG 10/3 X .5=1.67							
0050	E		KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	OCC FOR EXTREME SIZE		.02458		.056		
0060	E		RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME SIZE		.08248		.189		
0070	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12	USE BORE GAGE TO CHECK I.D.		.09717		.111		
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0085	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION ,			.00601		.006		
0105		JA 01	15	.16		1ST GRIND COLLAR I.D.		3.675	.088	.676		2
0010	E		RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER			1.53372		1.763		
0020	E		RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRNDR	OCC DUE TO EXTREME SIZE		.16231		.373		
0030	E		RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	OCC FOR EXTREME SIZE		.07609		.175		
0040	E		KMG-ID-QD	2.00	GRIND OUT .010 8.0 ID X 2.0	4 INCHES LONG		.67681		1.556		
0042					4.0 X 7.80							
0050	E		KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	1 TO SQ WHEEL 1 FOR FINISH		.02458		.056		
0060	E		RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME SIZE		.08248		.189		
0070	E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	USE BORE GAGE TO CHECK I.D.		.08102		.093		
0075	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0080	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION ,			.00601		.006		
0110		JA 01	15	.11		HONE LOWER BORE		3.394	.056	.429		1
0010	E		RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER			.00623		.007		
0020	E		RHO-HP-L1	2.00	LOAD UNLOAD HONE WITH HOIST	OCC FOR EXTREME SIZE		.17802		.409		
0030	N			1.00		HONE ID		3.00000		3.450		
0032					FINISH & SIZE NO SUPPORT ELEMENTS AVAILABLE							
0034					AT THIS TIME							
0035	E		RLG-EI-C7	3.00		MIKE ID THREE TIMES		.00534		.018		
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0050	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION ,			.00601		.006		
0113		JA 01	15	.11		LOCAL POLISH OD		.540	.009	.068		0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS		.27525		.079		
0020	E		RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE			.08248		.094		
0030	E		RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES			.00481		.005		
0040	E		ZPO-BP-C4	1.00	BUTTERFLY POLISH V/LRG CYL			.30517		.350		
0050	E		ZIT-VI-B4	1.00	VISUAL INSP V/LRG CYL I.D.			.07328		.084		
0060	E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006		
0115		JA 01	15	.05		HONE UPPER BORE		3.394	.025	.195		1
0010	E		RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER			.00623		.007		
0020	E		RHO-HP-L1	2.00	LOAD UNLOAD HONE WITH HOIST	OCC FOR EXTREME SIZE		.17802		.409		

0030	N		1.00		HONE ID	3.00000		3.450			
0032				FINISH & SIZE NO SUPPORT ELEMENTS AVAILABLE							
0034				AT THIS TIME							
[illegible]	E	RLG-EI-C7	3.00		MIKE ID THREE TIMES	.00534		.018			
[illegible]	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0050	E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0118	JA 01	15	.11		LOCAL POLISH ID	.540	.009	.068		0	
0010	E	RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079			
0020	E	RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE		.08248		.094			
0030	E	RTL-MM-M1	1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.005			
0040	E	ZPO-BP-C4	1.00	BUTTERFLY POLISH V/LRG CYL		.30517		.350			
0050	E	ZIT-VI-B4	1.00	VISUAL INSP V/LRG CYL I.D.		.07328		.084			
0060	E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006			
0305	JA 01	15	.32		FINISH GRIND O.D.	16.884	.810	6.214		21	
0010	E	RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218			
0020	E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW	LOAD CENTER & DIAL IN	.09095		.104			
0030	E	RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRNDR	OCC DUE TO EXTREME SIZE	.16231		.373			
0040	E	RGR-GE-C26	50.00	GR CHROM OD (OCC FACT L X D)	52.0 X 12.5	.02189		16.362			
0050	E	RGR-GE-D3	12.50	DWELL (GAP GRINDER CHROM OD)	12.5 DIA	.02029		.291			
0060	E	RGR-MM-T2	3.00	ADJUST TAPER - GAP GRINDER	OCC DUE TO EXTREME SIZE	.02632		.090			
0070	E	RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER	OCC DUE TO EXTREME SIZE	.08334		.383			
0080	E	RGR-MM-C5	1.50	HANDLE & MEAS LENGTH 24 - 36	OCC FOR 52 INCH LENGTH	.11700		.201			
0090	E	RLG-RS-F4	78.00	FILE/GRIND & POL NICK/BURR	OCC FOR 37.5 IN CIRCUMFERENC	.00415		.372			
0092				UPPER & LOWER END OF CYL							
0095	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0100	E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0330	JA 01	15	.11		FINISH GRIND UPPER BORE	17.508	.289	2.215		8	
0010	E	RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763			
[illegible]	E	RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTR	LOAD INTERNAL OCC FOR SIZE	.30830		.709			
[illegible]	E	RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE AXIS	OCC FOR EXTREME SIZE	.07609		.175			
0040	E	KMG-ID-TK	5.33	GRIND OUT .040 12 ID X 3	OCC FOR 015 TO 020 MATERIAL	2.78772		17.087			
0042				REMOVAL 32 INCH LONG 32/3 X .5=5.33							
0050	E	KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	1 TO SQ WHEEL 1 FOR FINISH	.02458		.056			
0060	E	RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME SIZE OF BORE	.08248		.189			
0070	E	RGR-MM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36	USE BORE GAGE TO CHECK I.D.	.11700		.134			
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0085	E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0335	JA 01	15	.21		FINISH GRIND LOWER BORE	7.486	.236	1.808		6	
0010	E	RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763			
0020	E	RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTR	LOAD PART IN INT GRINDER	.30830		.709			
0022					OCC FOR EXTREME SIZE						
0030	E	RML-AL-AC	4.00	ALIGN HOLE TO SPINDLE AXIS	OCC FOR EXTREME SIZE	.07609		.350			
0040	E	KMG-ID-TK	1.67	GRIND OUT .040 12 ID X 3	OCC FOR 015 TO 025 MATERIAL	2.78772		5.353			
0042				REMOVAL 10 INCH LONG 10/3 X .5=1.67							
0050	E	KMG-DW-ID	4.00	DRESS INTERNAL WHEEL	1 TO SQ WHEEL 2 FOR ROUGH	.02458		.113			
0052				GRIND &	1 FOR FINISH						
0060	E	RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME SIZE	.08248		.189			
0070	E	RGR-MM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12	USE DIAL BORE GAGE CHECK PT	.09717		.111			
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0085	E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0340	JA 01	15	.05		HONE LOWER BORE	.628	.005	.036		0	
0010	E	RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER		.00623		.007			
0020	E	RHO-HP-L1	2.00	LOAD UNLOAD HONE WITH HOIST	OCC FOR EXTREME SIZE	.17802		.409			
0030	N		.08		HONE UPPER & LOWER BORE FOR	3.00000		.276			
[illegible]				FINISH & SIZE NO SUPPORT ELEMENTS AVIALABLE AT							
[illegible]				THIS TIME							
0035	E	RLG-EI-C7	3.00		MIKE ID THREE TIMES	.00534		.018			
0040	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0345	JA 01	15	.05		HONE UPPER BORE	.628	.005	.036		0	
0010	E	RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER		.00623		.007			
0020	E	RHO-HP-L1	2.00	LOAD UNLOAD HONE WITH HOIST	OCC FOR EXTREME SIZE	.17802		.409			
0030	N		.08		HONE UPPER & LOWER BORE FOR	3.00000		.276			

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0032                    FINISH & SIZE NO SUPPORT ELEMENTS AVIALABLE  AT
0034                    THIS TIME
0035 E      RLG-EI-C7  3.00                          MIKE ID THREE TIMES          .00534          .018
   ) E      RJP-PW-R1  1.00 MEN RPL PAPRWRK SIGN OFF DOC                          .01001          .011
     JA 01  15          .37                          FINISH GRIND COLLAR I.D.    3.846   .213   1.637    6
0010 E      RGR-SU-P1  1.00 SET UP PLANETARY GRINDER                             .82175          .945
0020 E      RGR-HP-L4  2.00 LOAD LARGE PART GAP GR FIXTRLOAD PART IN PLANETARY   .30830          .709
0022                                 OCC FOR EXTREME SIZE
0030 E      RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                            .07609          .087
0040 E      KMG-ID-QJ  1.50 GRIND OUT .040  8 ID X 2    4 INCHES LONG OCC FOR  020  1.37361        2.369
0042                                 TO 025 MTL REMOVAL
0050 E      KMG-DW-ID  4.00 DRESS INTERNAL WHEEL       1 TO SQ WHEEL TO PART 2 FOR  .02458         .113
0052                                 ROUGH & 1 FOR FINISH GRIND
0060 E      RTL-SU-G1  1.00 SET UP A DIAL BORE GAGE                              .08248          .094
0070 E      RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5 USE DIAL BORE GAGE CHECK I.D  .08102     .093
0090 E      RJP-PW-R1  1.00 MEN RPL PAPRWRK SIGN OFF DOC                          .01001          .011
0430     JA 01  15          .53                          FINISH GRIND COLLAR BUSHING  2.795  .222   1.704    6
0010 E      RGR-SU-P1  1.00 SET UP PLANETARY GRINDER                             .82175          .945
0020 E      RGR-HP-L2  2.00 LOAD EXTRA LRG PRT GAP GRNDRLOAD PART IN PLANETARY  OCC  .16231      .373
0022                                 FOR EXTREME SIZE
0030 E      RML-AL-CC  1.00 ALIGN HOLE TO SPINDLE MAG BS                         .07261          .083
0040 E      KMG-ID-QD  2.00 GRIND OUT .010 8.0 ID X 2.0 OCC FOR 4 INCH LENGTH    .67681         1.556
0042                                 4.0 X 7.8
0050 E      KMG-DW-ID  2.00 DRESS INTERNAL WHEEL       1 TO SQ WHEEL TO PART 1 FOR  .02458         .056
0052                                 FINISH
0060 E      RTL-SU-G1  1.00 SET UP A DIAL BORE GAGE                              .08248          .094
0070 E      RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5 USE   BORE GAGE CHECK I.D.  .08102        .093
0090 E      RJP-PW-R1  1.00 MEN RPL PAPRWRK SIGN OFF DOC                          .01001          .011
     JA 01  15          1.00                         CK AREA C TO DIA B          1.180  .177   1.357    5
   ) E      RGR-SU-I2   .25 SET UP LRG INTERNAL GRINDER PRORATE OVER 4 OPERATION  1.53372         .440
0020 E      RLA-HP-C3   .25 CHUCK SYMET PART IN 4 JAW   PRO RATE 4 OPER          .09095          .026
0030 E      RLA-HP-C4   .25 IRREG PART IN 4 JAW CHUCK   PRORATE/4 OPERATIONS     .22097          .063
0040 E      RGR-HP-L3   .25 LOAD EX LRG PRT GAP GR FIXT PRORATE/4 OPERATIONS     .36081          .103
0050 E      KMG-GW-LK  4.00                          LOCATE INDICATOR/4 TIMES    .06761          .311
0060 E      KMM-SU-A1  4.00 DIAL ONE AXIS LONG OR CROSS 4 PLACES                 .03892          .179
0070 E      RJP-PW-C1 32.00 WRITE CRITICAL DIMENSION   32 READINGS              .00601          .221
0080 E      RJP-PW-R1  1.00 MEN RPL PAPRWRK SIGN OFF DOC                          .01001          .011
0440     JA 01  15          1.00                         CHK UPRER BORE TO DIA A     1.025  .154   1.179    4
0010 E      RGR-SU-I2   .25 SET UP LRG INTERNAL GRINDER PRORATE/4 OPERATIONS     1.53372         .440
0020 E      RLA-HP-C3   .25 CHUCK SYMET PART IN 4 JAW   PRO RATE 4 OPER          .09095          .026
0030 E      RLA-HP-C4   .25 IRREG PART IN 4 JAW CHUCK   PRORATE/4 OPERATIONS     .22097          .063
0040 E      RGR-HP-L3   .25 LOAD EX LRG PRT GAP GR FIXT PRORATE/4 OPERATIONS     .36081          .103
0050 E      KMG-GW-LK  3.00                          LOCATE IDICATOR/3 PLACES    .06761          .233
0060 E      KMM-SU-A1  3.00 DIAL ONE AXIS LONG OR CROSS 3 PLACES                 .03892          .134
0070 E      RJP-PW-C1 24.00 WRITE CRITICAL DIMENSION   24 READINGS              .00601          .165
0080 E      RJP-PW-R1  1.00 MEN RPL PAPRWRK SIGN OFF DOC                          .01001          .011
0445     JA 01  15          1.00                         CHK LOWER BORE TO DIA A     1.025  .154   1.179    4
0010 E      RGR-SU-I2   .25 SET UP LRG INTERNAL GRINDER PRORATE/4 OPERATIONS     1.53372         .440
0020 E      RLA-HP-C3   .25 CHUCK SYMET PART IN 4 JAW   PRO RATE 4 OPER          .09095          .026
0030 E      RLA-HP-C4   .25 IRREG PART IN 4 JAW CHUCK   PRORATE/4 OPERATIONS     .22097          .063
0040 E      RGR-HP-L3   .25 LOAD EX LRG PRT GAP GR FIXT PRORATE/4 OPERATIONS     .36081          .103
0050 E      KMG-GW-LK  3.00                          LOCATE INDICATOR/3 PLACES   .06761          .233
0060 E      KMM-SU-A1  3.00 DIAL ONE AXIS LONG OR CROSS 3 PLACES                 .03892          .134
0070 E      RJP-PW-C1 24.00 WRITE CRITICAL DIMENSION   24 READINGS              .00601          .165
   ) E      RJP-PW-R1  1.00 MEN RPL PAPRWRK SIGN OFF DOC                          .01001          .011
     JA 01  15          .00                          LABOR STANDARD HISTORY      .000   .000   .000     0
0010                    30MAY85 UPDATED OCCURRANCE FACTORS/WORK PREVIOUSLY
0011                            DONE ON OPER A0010 <OLD STD>19.57
0012                            AND OPER A0270 <OLD STD> 8.00
0020                    29JAN86 UPDATED OCC FACTORS <OLD STD> 30.13
0030                    21APR87 RESTRUCTURED LABOR STANDARD TO MATCH NEW
0031                            AFLC FORM 958: NO TIME CHANGE
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17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	CH D	S T L	S K	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
RB002		S	E	JA EA	3		J 86030	.67	PERCENT ENGR 88.2	GRIND INNER CYLINDER C-5A	23.19		15.53			
0001				JA 01		00		1.00		PART NUMBER/NSN	.000	.000	.000		0	
0010									4G11414-107A	1620004176249						
0130				JA 01		15		.63		1ST GRIND CYL O.D.	7.242	.684	5.247		23	
0010	E					RGR	SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218			
0020	E					RGR	HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT	OCC FOR EXTREME SIZE	.36081		.829			
0030	E					RLA	HP-C3	3.00	CHUCK SYMET PART IN 4 JAW	DIAL IN/EXTREME SIZE	.09095		.313			
0040	E					RGR	GE-S2396	.00	GR STEEL OD (OCC FACT L X D)36	LENGTH X 11 DIAMETER	.01093		4.977			
0050	E					RGR	GE-D2	11.00	DWELL (GAP GRINDER STEEL OD)11	DIAMETER	.01014		.128			
0060	E					RGR	WD-G2	3.00	WHEEL DRESS GAP GRINDER	3 PER OPERATION	.08334		.287			
0070	E					RGR	HM-T2	3.00	ADJUST TAPER - GAP GRINDER	3 PER OPERATION	.02632		.090			
0080	E					RGR	HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134			
0090	E					RLG	RS-F4	69.00	FILE/GRIND & POL NICK/BURR	CIRCUMFERENCE BOTH ENDS	.00415		.329			
0095	E					RJP	PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0100	E					RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0140				JA 01		15		.07		1ST GRIND UP BRNG O.D.	3.425	.036	.276		1	
0010	E					RGR	SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218			
0020	E					RGR	HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT	OCC FOR EXTREME SIZE	.36081		.829			
0030	E					RLA	HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	DIAL IN/EXTREME SIZE	.09095		.209			
0040	E					RGR	GE-S2	77.00	GR STEEL OD (OCC FACT L X D)7	LENGTH X 11 DIAMETER	.01093		.967			
0050	E					RGR	GE-D2	11.00	DWELL (GAP GRINDER STEEL OD)11	DIAMETER	.01014		.128			
0060	E					RGR	WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095			
0070	E					RGR	HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0080	E					RGR	HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111			
0090	E					RLG	RS-F4	69.00	FILE/GRIND & POL NICK/BURR	CIRCUMFERENCE BOTH ENDS	.00415		.329			
0095	E					RJP	PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0100	E					RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0150				JA 01		15		.07		HONE I.D. TO CLEAN UP	2.691	.028	.217		1	
0010	E					RHO	SU-V1	1.00	SET UP LARGE VERTICAL HONE	,	.55195		.634			
0020	E					RHO	HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST	,	.17802		.204			
0030	N							1.00		HONE I.D.	1.65000		1.897			
0040	E					RTL	SU-G1	1.00	SET UP A DIAL BORE GAGE	,	.08248		.094			
0050	E					RGR	HM-C4	2.00	HANDLE & MEAS LENGTH 12 - 24	MEASURE TWICE	.10674		.245			
0060	E					RJP	PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0070	E					RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	,	.01001		.011			
0160				JA 01		15		.19		GRIND I.D. STANDARD	12.423	.354	2.714		12	
0010	E					RGR	SU-I2	1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763			
0020	E					RGR	HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT	LOAD PART IN INTERNAL	.36081		.829			
0022									GRINDER/OCC FOR EXTREME SIZE							
0030	E					RLA	HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	DIAL IN AXIS/OCCURANCE	.09095		.209			
0032									FOR EXTREME SIZE							
0040	E					KMG	ID-SE	8.00	GRIND OUT .010 ID X 3	OCC FOR 47.0 IN. LONG X 11.0	1.19745		11.016			
0042									DIA .005-.008 MATERIAL REMOVAL							
0050	E					KMG	DW-ID	3.00	DRESS INTERNAL WHEEL	3 TIMES PER OPERATION	.02458		.084			
0060	E					RTL	SU-G1	1.00	SET UP A DIAL BORE GAGE		.08248		.094			
0070	E					RGR	HM-C5	2.00	HANDLE & MEAS LENGTH 24 - 36	47 IN/3 TIMES/3 PLACES	.11700		.269			
0075	E					RJP	PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006			
0080	E					RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
				JA 01		15		.05		HONE CYL I.D.	2.591	.019	.149		1	
0010	E					RHO	SU-V1	1.00	SET UP LARGE VERTICAL HONE	,	.55195		.634			
0020	E					RHO	HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST	,	.17802		.204			
0030	N							1.00		HONE CYL I.D. TO REMOVE BURN	1.65000		1.897			
0031									INDICATIONS AND MAINTAIN FINISH							
0040	E					RTL	SU-G1	1.00	SET UP A DIAL BORE GAGE	,	.08248		.094			
											.10474		.122			

0060	E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS		.00601		.013	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
0350		JA 01	15	1.00		HONE CYL I.D. AFTER SHOTPEEN		2.591	.389	2.980	13
[redacted]0	E		RHO-SU-V1	1.00	SET UP LARGE VERTICAL HONE	,		.55195		.634	
[redacted]0	E		RHO-HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST	,		.17802		.204	
0030	N			1.00		HONE CYL I.D. TO REMOVE BURN		1.65000		1.897	
0031					INDICATIONS AND MAINTAIN FINISH						
0040	E		RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	,		.08248		.094	
0050	E		RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24,			.10674		.122	
0060	E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS		.00601		.013	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
0380		JA 01	15	.38		REIDENTIFY		.017	.001	.008	0
0010	E		GID-SA-A1	1.00	STAMP WITH METAL STAMP	,		.00342		.003	
0020	E		GID-SA-A2	2.00	STAMP W/METAL STAMP ADDL	TWO NUMBERS		.00187		.004	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
0390		JA 01	15	.63		FINISH GRIND CYL O.D.		11.745	1.110	8.510	37
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938		1.218	
0020	E		RGR-HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT	OCC FOR EXTREME SIZE		.36081		.829	
0030	E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	DIAL IN PART OCC FOR EXTREME		.09095		.209	
0032						SIZE					
0040	E		RGR-GE-C2396.00		GR CHROM OD (OCC FACT L X D)	36.0 X 11.0		.02189		9.768	
0050	E		RGR-GE-D3	11.00	DWELL (GAP GRINDER CHROM OD)	11.0 IN DIA		.02029		.256	
0060	E		RGR-HM-T2	5.00	ADJUST TAPER - GAP GRINDER	OCC FOR EXTREME SIZE		.02632		.151	
0070	E		RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER	OCC FOR EXTREME SIZE		.08334		.383	
0080	E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0090	E		GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL			.00678		.007	
0100	E		RLG-RS-F4	69.00	FILE/GRIND & POL NICK/BURR	USE AIR MOTOR & FLAPWHEEL TO		.00415		.329	
0102					BREAK EDGES & BLEND RADIOUS	OCC/CIRCUM EA END					
[redacted]05	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,		.00601		.006	
[redacted].0	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
04uv		JA 01	15	.13		FINISH GRIND UP BEARING		4.637	.090	.693	3
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938		1.218	
0020	E		RGR-HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT	OCC FOR EXTREME SIZE		.36081		.829	
0030	E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	DIAL IN AXIS OCC FOR EXTREME		.09095		.209	
0032						SIZE					
0040	E		RGR-GE-C2	77.00	GR CHROM OD (OCC FACT L X D)	7.0 X 11.0		.02189		1.938	
0050	E		RGR-GE-D3	11.00	DWELL (GAP GRINDER CHROM OD)	11.0 IN DIA		.02029		.256	
0060	E		RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER	1 TO SQ WHEEL TO PART 2 FOR		.08334		.383	
0062						ROUGH & 1 FOR FINISH GRIND					
0070	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0080	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12			.09717		.111	
0090	E		GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL			.00678		.007	
0100	E		RLG-RS-F4	69.00	FILE/GRIND & POL NICK/BURR	USE AIR MOTOR & FLAP WHEEL O		.00415		.329	
0102					FLASHON TO BREAK EDGES & BLEND RADIOUS	OCC/INCH					
0104					OF CIRCUMFERENCE UPPER & LOWER END OF BRG SFC						
0105	E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,		.00601		.006	
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0410		JA 01	15	1.00		INSPECT I.D.		.023	.004	.027	0
0010	E		GIT-HP-A3	1.00	VISUAL INSPECT WITH LIGHT			.00143		.001	
0015	E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS		.00601		.013	
0020	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0420		JA 01	15	.32		HONE CYL I.D.		2.591	.124	.954	4
0010	E		RHO-SU-V1	1.00	SET UP LARGE VERTICAL HONE	,		.55195		.634	
[redacted]020	E		RHO-HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST	,		.17802		.204	
[redacted]40	N			1.00		HONE CYL I.D. TO REMOVE BURN		1.65000		1.897	
.1					INDICATIONS AND MAINTAIN FINISH						
0040	E		RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	,		.08248		.094	
0050	E		RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24,			.10674		.122	
0060	E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS		.00601		.013	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
0520		JA 01	15	.69		FIN GRIND METER PIN BUSH		1.785	.185	1.416	6
0010	E		RGR-SU-R1	1.00	SET UP PLANETARY GRINDER						

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0020 E        RGR-HP-L2  2.00 LOAD EXTRA LRG PRT GAP GRNDRLOAD PART IN PLANETARY GR      .16231        .373
0022                                          OCC FOR EXTREME SIZE
0030 E        RML-AL-CC  2.00 ALIGN HOLE TO SPINDLE MAG BSOCC FOR EXTREME SIZE          .07261        .167
   ) E        KMG-ID-KB  1.00 GRIND OUT .010-4.5 IN ID X 1                             .20899        .240
  .0 E        KMG-DW-ID  2 .. DRESS INTERNAL WHEEL        1 TO SQ WHEEL 1 FOR FINISH   .02458        .056
0060 E        RTL-SU-G1  .00  ET UP A DIAL BORE GAGE                                   .08248        .094
0070 E        RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5 CHECK I.D. 3 PLACES 3 TIMES  .08102        .093
0080 E        RLG-RS-F4 12.00 FILE/GRIND & POL NICK/BURR  BREAK EDGES BLEND RADIOUS    .00415        .057
0082                                          OCC FOR EXTREME SIZE
0085 E        RJP-PW-C1  2.00 WRITE CRITICAL DIMENSION    TWO DIMENSIONS               .00601        .013
0090 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001        .011
9000      JA 01   15      .01                              LABOR STANDARD HISTORY      .009  .000    .000      0
0010                          30JAN86 RESTRUCTURED LABOR STD TO MATCH AFLC FORM
0011                                  958/UPDATED OCC FACTORS/ADDED SUB OP 0150
0012                                  WORK PREVIOUSLY DONE ON OPER A0090
0013                                  <OLD STD> 13.63
0900                                  N MONROE  MANEAA  75357


TO INTERROGATE LABOR STANDARDS, INPUT

 RCC PRD NROP NR
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1234567890123456  ELSE PUT IN END
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17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

CH STEP	S D	S L	W R K	F A C	PF DC	A/R FA	REV SUPPORT EMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RB005	S	E	JA	EA	3		J 89012	.17	PERCENT ENGR 99.9	GRD UPR DRAG SHAFT	3.77		.64		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4G13538-101A	1620001164434					
0060			JA	01	15			1.00		1ST GRIND UPPER DRAG SHAFT	1.346	.202	1.549		41
0010	E				RGR	SU	C2	1.00	SET UP SMALL MED CYL GRINDER	O.D. GRIND	.29197		.335		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RLA	HM	T8	1.00	ADVANCE & RETURN TAILSTOCK		.00305		.003		
0040	E				RGR	GE	S2	51.00	GR STEEL OD (OCC FACT L X D)	3 OD X 17 LENGTH	.01093		.641		
0045	E				RGR	GE	D2	3.00	DWELL (GAP GRINDER STEEL OD)	3 OD	.01014		.034		
0050	E				KMG	DW	OD	2.00	DRESS EXTERNAL WHEEL	2 PER OPERATION	.02308		.053		
0060	E				KMG	GW	LK	2.00	LOCATE WHEEL TO POSITION	2 PER OPERATION	.06761		.155		
0070	E				RGR	HM	C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080	E				RLG	RS	F4	18.00	FILE/GRIND & POL NICK/BURR	CIRCUMFERENCE BOTH ENDS	.00415		.085		
0100	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130			JA	01	15			1.00		FINISH GRIND UP DRAG SHAFT	1.936	.290	2.226		59
0010	E				RGR	SU	C2	1.00	SET UP SMALL MED CYL GRINDER	O.D. GRIND	.29197		.335		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RLA	HM	T8	1.00	ADVANCE & RETURN TAILSTOCK		.00305		.003		
0040	E				RGR	GE	C2	51.00	GR CHROM OD (OCC FACT L X D)	3 OD X 17 LENGTH	.02189		1.283		
0045	E				RGR	GE	D3	3.00	DWELL (GAP GRINDER CHROM OD)	3 OD	.02029		.070		
0050	E				KMG	DW	OD	2.00	DRESS EXTERNAL WHEEL	2 PER OPERATION	.02308		.053		
0060	E				KMG	GW	LK	2.00	LOCATE WHEEL TO POSITION	2 PER OPERATION	.06761		.155		
0070	E				RGR	HM	C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080	E				RLG	RS	F4	18.00	FILE/GRIND & POL NICK/BURR	CIRCUMFERENCE BOTH ENDS	.00415		.085		
0100	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	15			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									01JUL83 OCC FACTOR CHG AVG 3 STUDIES						
0020									PREVIOUS STD HRS 1.34						
0030									05DEC85 UPDATE OCCURRANCE FACTORS/RESTRUCTURED						
0031									LABOR STANDARD TO MATCH AFLC FORM 958						
0032									OLD OPER NO. A0140 <OLD STD> 1.01						
0900									N MONROE MANEMA 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD HROP NR
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1234567890123456 ELSE PUT IN END
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               LABOR STANDARD  OPERATION RESOURCE STANDARD AND METHOD ANALYSIS   02/15/89   A-E046B-MM1-DY-M45  PAGE  0001
       17575A    C5A MLG  4G11020-107A                    RCC MNPRB               4S1-93-3                  84013
        'I S S    W F PF A/R REV
 S[illegible]      T K  #R A FA SUPPORT   OCC <------------------ DESCRIPTION ------------------>  BASE    PFD    STD          A
     STEP D L    K C DC ELEMENT  FACT             STORED                        SUPPLEMENTAL       HOURS   TIME   HOURS   DLY PCT C
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 B00[illegible]                    89006   .21 PERCENT ENGR 99.9           GRD LOWER DRAG SHAFT         4.88           1.02
  0001       JA 01    00          1.00                                 PART NUMBER/NSN               .000   .000    .000        0
     0010                               4G13539-101A          1620001164435
  0060       JA 01    15          1.00                                 1ST GRIND LOWER SHAFT --60--  1.682  .252   1.934        40
     0010 E           RGR-SU-C2  1.00 SET UP SMALL MED CYL GRINDERO.D. GRIND                          .29197          .335
     0020 E           RLA-HP-C3  1.00 CHUCK SYMET PART IN 4 JAW                                       .09095          .104
     0030 E           RLA-HM-T8  1.00 ADVANCE & RETURN TAILSTOCK                                      .00305          .003
     0040 E           RGR-GE-[illegible] [illegible].50 GR STEEL OD (OCC FACT L X D)4.5 OD X 17 LENGTH     .01093          .961
     0045 E           RGR-GE-D2  4.50 DWELL (GAP GRINDER STEEL OD)4.5 OD                              .01014          .052
     0050 E           KMG-DW-OD  2.00 DRESS EXTERNAL WHEEL          2 PER OPERATION                   .02308          .053
     0060 E           KMG-GW-LK  2.00 LOCATE WHEEL TO POSITION      2 PER OPERATION                   .06761          .155
     0070 E           RGR-HM-C4  1.00 HANDLE & MEAS LENGTH 12 - 24                                    .10674          .122
     0080 E           RLG-RS-F4 28.00 FILE/GRIND & POL NICK/BURR  CIRCUMFERENCE BOTH ENDS             .00415          .133
     0100 E           RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                    .01001          .011
  0130       JA 01    15          1.00                                 FINISH GRIND LO SHAFT —130-   2.566  .385   2.951        60
     0010 E           RGR-SU-C2  1.00 SET UP SMALL MED CYL GRINDERO.D. GRIND                          .29197          .335
     0020 E           RLA-HP-C3  1.00 CHUCK SYMET PART IN 4 JAW                                       .09095          .104
     0030 E           RLA-HM-T8  1.00 ADVANCE & RETURN TAILSTOCK                                      .00305          .003
     0040 E           RGR-GE-C2 76.50 GR CHROM OD (OCC FACT L X D)4.5 OD X 17 LENGTH                  .02189         1.925
     0045 E           RGR-GE-D3  4.50 DWELL (GAP GRINDER CHROM OD)4.5 OD                              .02029          .105
     0050 [illegible]           [illegible]-DW-OD  2.00 DRESS EXTERNAL WHEEL          2 PER OPERATION                   .02308          .053
     [illegible]0 E           KMG-GW-LK  2.00 LOCATE WHEEL TO POSITION      2 PER OPERATION                   .06761          .155
     [illegible]0 [illegible]           RGR-HM-C4  1.00 HANDLE & MEAS LENGTH 12 - 24                                    .10674          .122
     [illegible]080 E           RLG-RS-F4 28.00 FILE/GRIND & POL NICK/BURR  CIRCUMFERENCE BOTH ENDS             .00415          .133
     0100 E           RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                    .01001          .011
     0900                                       F.COLLINS TECHN MANEAA
  9000       JA 01    15           .01                                 LABOR STD HISTORY              .000   .000    .000        0
     0010                               01JUL83 OCC FACTOR CHG AVG 3 STUDIES
     0020                                       PREVIOUS STD HRS 2.65
     0030                               26DEC85 UPDATE OCCURRANCE FACTORS
     0031                                       RESTUCTURED LABOR STD TO MATCH
     0032                                       AFLC FORM 958
     0033                                       WORK PREVIOUSLY DONE ON OPER A0080
     0034                                       OLD STD WAS 2.12 HRS
     0900                                       N MONROE  MANEAA  73357
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TO INTERROGATE LABOR STANDARDS, INPUT

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RCC PRD NROP NR
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1234567890123456  ELSE PUT IN END
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17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	H T D	S K L	S W K	F A C	PF DC	A/R FA	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
B007	S	E	JA	EA	3		J 86015	1.00	PERCENT ENGR 99.9	GRIND C5A MLG SPLINED TUBE	1.65		1.65		
0001			JA	01		00		.00		PART NUMBER / NSN	.000	.000	.000		0
0010									4G13413-101A NSL						
0025			JA	01		15		1.00		CHECK SEAL GROOVE/CONCENTRIC	.402	.060	.463		28
0010	E					RGR-SU-C2		.50	SET UP SMALL MED CYL GRINDER	PRORATE 2 OPERATIONS	.29197		.167		
0020	E					RLA-HP-C3		.50	CHUCK SYMET PART IN 4 JAW	PRORATE 2 OPERATIONS	.09095		.052		
0030	E					RGR-HM-H1		.50	ADJUST HEADSTOCK GAP GRINDER	PRORATE 2 OPERATIONS	.08590		.049		
0040	E					RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER	PRORATE 2 OPERATIONS	.02632		.015		
0050	E					RML-AL-CC		2.00	ALIGN HOLE TO SPINDLE MAG BS2 DIAMETERS		.07261		.167		
0060	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0026			JA	01		15		1.00		CHECK SPLINES	.475	.071	.547		33
0010	E					RGR-SU-C2		.50	SET UP SMALL MED CYL GRINDER	PRORATE	.29197		.167		
0020	E					RLA-HP-C3		.50	CHUCK SYMET PART IN 4 JAW	PRORATE	.09095		.052		
0030	E					RGR-HM-H1		.50	ADJUST HEADSTOCK GAP GRINDER	PRORATE	.08590		.049		
0040	E					RGR-HM-T2		.50	ADJUST TAPER - GAP GRINDER	PRORATE	.02632		.015		
0050	E					RML-AL-CC		3.00	ALIGN HOLE TO SPINDLE MAG BS3 DIAMETERS		.07261		.250		
0060	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01		15		.13		1ST GRIND SEAL GROOVE	1.828	.036	.273		17
0010	E					RGR-SU-G1		1.00	SET UP A GAP GRINDER		1.05938		1.218		
0020	E					RGR-HP-L3		1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414		
0030	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
40	E					RGR-GE-S2		3.25	GR STEEL OD (OCC FACT L X D)		.01093		.040		
50	E					RGR-GE-D2		6.00	DWELL (GAP GRINDER STEEL OD)		.01014		.069		
0060	E					RGR-WD-G2		1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0070	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0080	E					RGR-HM-C3		1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111		
0090	E					RLG-RS-F4		1.00	FILE/GRIND & POL NICK/BURR		.00415		.004		
0100	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0160			JA	01		15		.13		FINISH GRIND SEAL GROOVE	1.864	.036	.279		17
0010	E					RGR-SU-G1		1.00	SET UP A GAP GRINDER		1.05938		1.218		
0020	E					RGR-HP-L3		1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414		
0030	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0040	E					RGR-GE-C2		3.25	GR CHROM OD (OCC FACT L X D)		.02189		.081		
0050	E					RGR-GE-D2		6.00	DWELL (GAP GRINDER STEEL OD)		.01014		.069		
0060	E					RGR-WD-G2		1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0070	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0080	E					RGR-HM-C3		1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111		
0090	E					RLG-RS-F4		1.00	FILE/GRIND & POL NICK/BURR		.00415		.004		
0100	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0170			JA	01		15		.63		CHAMFER SEA GROOVE	.129	.012	.094		6
0010	E					RGR-WD-G2		1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0020	E					KMG-OD-AF		1.00	GRIND .040 FROM 1/2D X 1		.03633		.041		
0030	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									08JUL85 UPDATED OCCURRANCE FACTORS/RESTRUCTURED						
0011									LABOR STANDARD TO MATCH AFLC FORM 958						
0012									<OLD STD 2.54 HRS ON OPER A0120						
20									15JAN86 UPDATED OCC FACTORS <OLD STD> 1.53						
30									N MONROE MANEAM 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRN MRNP NR

PP81751SAR3015

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 03/17/89 4-E0469-HM1-0Y-M4C PAGE 0001

175759 DSA MLS 4811020-107A ROD MNPRB 491-PC-C 84013

TECH	S	B	W	F	PF	A/R	REV										
	T	K	PR	A	FA	SUPPORT	DOC	<---------- DESCRIPTION ---------->			BASE	PFD	STD		A
	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS	DLY	PCT	C
0015	S	E	DA	EA	3	J 85019	.20	PERCENT ENGR 99.9	HONE YOKE/4811430-113	501	4.04		.90			
0001			DA	01	00		1.00		PART NUMBER/MSN		.000	.000	.000		0	
0010								4811430-113B	1620001750909							
0050			DA	01	15		1.00		HONE CENTER HOLE		2.310	.332	2.542		03	
0010	E				RHO-SU-H2		1.00	SET UP VERY LARGE HONE			.99152		1.140			
0020	E				RHO-HP-L1		1.00	LOAD UNLOAD HONE WITH HOIST			.17802		.204			
0030	E				HMS-ID-TD		1.00	GRIND OUT .010 12 ID X 2.0			1.01510		1.167			
0040	E				RLG-EI-07		3.00	MIKE I/D WARE CHK BY MEASRNG CHECK ID 3 TIMES			.00574		.018			
0050	E				RIP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0215			DA	01	15		1.00		HONE CENTER HOLE TO 64 RMS		1.309	.196	1.506		07	
0010	E				RHO-SU-H2		1.00	SET UP VERY LARGE HONE			.99152		1.140			
0020	E				RHO-HP-L1		1.00	LOAD UNLOAD HONE WITH HOIST			.17802		.204			
0030	E				HMS-ID-ED		1.00	GRIND OUT .010 2.0 ID X 1.5			.13033		.149			
0040	E				RIP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
9000			DA	01	15		.01		LABOR STANDARD HISTORY		.000	.000	.000		0	
0010								170ANGS NEW REQUIREMENT/INITIAL INPUT								
0900								N MONROE/MANEAP								

I INTERROGATE LABOR STANDARDS, INPUT

[redacted] MRCP MS

[redacted] LD45= ELSE PUT IN END

17575A C5A MLG 4G11020-107A RCC MMPRB 4S1-93-3 84013

STEP	TH	S	S	W	F	PF	A/R	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB016		S	E	JA	EA	3		J	89026	.58	PERCENT ENGR 99.9	GRD.POSITIONING COLLAR C5AM	7.95		4.61		
0001				JA	01		00			.00		PART NUMBER / NSN	.000	.000	.000		0
0010											4G11476-107A	1620005581485					
0020											4G11476-101B	1620001157415					
0090				JA	01		15			.93		GRIND TOP OF SMALL TEETH	5.872	.819	6.281		79
0010	E					RGR-SU-J1				1.00	S/U JIG GRINDER SML FIXTURE .		.75732		.870		
0020	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS.		.08531		.098		
0030	E					RML-AL-CC				1.00	ALIGN HOLE TO SPINDLE MAG BS,		.07261		.083		
0040	E					KMG-DW-ID				3.00	DRESS INTERNAL WHEEL	2 ROUGH. 1 FINISH CUT	.02458		.084		
0050	E					KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0060	E					KMG-ID-TD				1.00	GRIND OUT .010 12 ID X 2.0	GRIND TEETH TO REMOVE CORR.	1.01513		1.167		
0070	E					KMG-DW-ID				3.00	DRESS INTERNAL WHEEL	2 ROUGH 1 FINISH CUT	.02458		.084		
0080	E					KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0090	E					KMG-ID-TD				1.50	GRIND OUT .010 12 ID X 2.0	GRIND SML TEETH LEFT SIDE	1.01513		1.751		
0091												OCCURRANCED FOR DEPTH					
0100	E					RLG-EI-C3				2.00	CHK FACE TO FACE I/S OR O/S	2 MEASURMENTS REQUIRED	.01427		.032		
0110	E					KMG-DW-ID				3.00	DRESS INTERNAL WHEEL	2 ROUGH. 1 FINISH CUT	.02458		.084		
0120	E					KMG-GW-LK				3.00	LOCATE WHEEL TO POSITION	AFTER EACH DRESS	.06761		.233		
0130	E					KMG-ID-TD				1.50	GRIND OUT .010 12 ID X 2.0	GRIND SML TEETH RIGHT SIDE	1.01513		1.751		
0131												OCCURANCED FOR DEPTH					
0140	E					RLG-EI-C3				2.00	CHK FACE TO FACE I/S OR O/S	2 MEASURMENTS REQUIRED	.01427		.032		
0150	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC.		.01001		.011		
				JA	01		15			.86		CHAMFER LARGE TEETH	.356	.046	.352		4
0010	E					RBW-SU-G1				.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
0020	E					RBW-BU-C1				2.00		CHAMFER 2 TEETH	.10435		.240		
0030	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120				JA	01		15			.14		1ST GRIND COLLAR FACE	1.594	.033	.257		3
0010	E					RGR-SU-I1				1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS.		.08531		.098		
0030	E					KMG-DW-ID				2.00	DRESS INTERNAL WHEEL	1 ROUGH, 1 FINISH GRIND	.02458		.056		
0035	E					KMG-GW-LK				2.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.155		
0040	E					KMG-ID-TC				1.00	GRIND OUT .010 12 ID X 1.5		.78780		.905		
0050	E					RLG-EI-C3				2.00	CHK FACE TO FACE I/S OR O/S	2 MEASUREMENTS	.01427		.032		
0060	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130				JA	01		15			.07		1ST GRIND I.D.	2.121	.022	.171		2
0010	E					RGR-SU-I1				1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E					RLA-HP-C4				1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254		
0030	E					KMG-DW-ID				2.00	DRESS INTERNAL WHEEL	1 ROUGH. 1 FINISH GRIND	.02458		.056		
0035	E					KMG-GW-LK				2.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.155		
0040	E					KMG-ID-SE				1.00	GRIND OUT .010 10 ID X 3		1.19745		1.377		
0050	E					RLG-EI-C7				2.00	MKE I/D WARE CHK BY MEASRNG	2 MEASUREMENTS	.00534		.012		
0060	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0230				JA	01		15			.21		FINISH GRIND FACE	2.590	.082	.626		8
0010	E					RGR-SU-I1				1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E					RML-HP-CA				1.00	HAND HANDLE NO WRAP 2 CLAMPS.		.08531		.098		
0030	E					KMG-DW-OD				4.00	DRESS EXTERNAL WHEEL	3 ROUGH. 1 FINISH GRIND	.02308		.106		
0035	E					KMG-GW-LK				4.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.311		
0040	E					KMG-ID-TH				1.00	GRIND OUT .040 12 ID X 1.5		1.60594		1.846		
0050	E					RLG-EI-C3				2.00	CHK FACE TO FACE I/S OR O/S	2 MEASUREMENTS	.01427		.032		
0060	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0240				JA	01		15			.07		FINISH GRIND I.D.	3.380	.035	.272		3
0010	E					RGR-SU-I1				1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E					RLA-HP-C4				1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254		
0030	E					KMG-DW-ID				4.00	DRESS INTERNAL WHEEL	3 ROUGH. 1 FINISH GRIND	.02458		.113		
0035	E					KMG-GW-LK				4.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.311		

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0040 E          KMG-ID-SK  1.00 GRIND OUT .040  10 ID X3                                  2.27158          2.612
0050 E          RLG-EI-C7  2.00 MKE I/D WARE CHK BY MEASRNG 2 MEASUREMENTS               .00534           .012
0060 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001           .011
      JA 01   15          .01                              LABOR STANDARD HISTORY      .000  .000  .000       0
  .0                          11DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM
 0011                                 958/UPDATED OCC FACTOTS/WORK PREVIOUSLY
 0012                                 DONE ON OPER A0110 [illegible] 2.46
 0900                                 N MONROE  MANEAA  73357


TO INTERROGATE LABOR STANDARDS, INPUT

 RCC PRD NROP NR
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12345678901234567  ELSE PUT IN END
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MMPRD 4S1-93-3 84013

STEP	D	T	S K	S #R	W A	F C	PF DC	A/R FA	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
B017	S	E	JA	EA	3		J		88364	.17	PERCENT ENGR 99.9	GRIND APEX SHAFT C-5A	2.06		.35		
0001			JA	00			00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010											4G1356!-101A	5315001321925					
0060			JA	01			15			1.00		FIRST GRIND O.D.	.772	.116	.888		43
0010	E						RGR-SU-C2			.50	SET UP SMALL MED CYL GRINDER	PRORATE OVER 2 PARTS	.29197		.167		
0020	E						RLA-HP-C6			1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E						RGR-HM-T2			.50	ADJUST TAPER - GAP GRINDER	PRORATE OVER 2 PARTS	.02632		.015		
0040	E						KMG-DW-OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0045	E						KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E						KMG-OD-FD			2.00	GRIND .010 2 1/2 OD X 2 1/2	OCCURRANCE FOR LENGTH	.18000		.414		
0055	E						RGR-GE-D2			3.00	DWELL (GAP GRINDER STEEL OD).		.01014		.034		
0060	E						RGR-HM-C3			1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111		
0070	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130			JA	01			15			1.00		FINISH GRIND O.D.	1.022	.153	1.176		57
0010	E						RGR-SU-C2			.50	SET UP SMALL MED CYL GRINDER	PRORATE OVER 2 PARTS	.29197		.167		
0020	E						RLA-HP-C6			1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E						RGR-HM-T2			.50	ADJUST TAPER - GAP GRINDER	PRORATE OVER 2 PARTS	.02632		.015		
0040	E						KMG-DW-OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0045	E						KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E						KMG-OD-FJ			2.00	GRIND .040 2 1/2 OD X 2 1/2	OCCURRANCE FOR LENGTH	.29000		.667		
0055	E						RGR-GE-D3			3.00	DWELL (GAP GRINDER CHROM OD).		.02029		.070		
0060	E						RGR-HM-C3			1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111		
0070	E						RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01			15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010											26DEC85	UPDATE OCCURRANCE FACTORS/RESTRUCTURED					
0011												LABOR STANDARD TO MATCH AFLC FORM 958					
0012												OLD OPER A0050 <OLD STD> .23					
0900												N MONROE MAMEAA 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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12345[illegible]23456 ELSE PUT IN END

17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	T	K	W R	F A	PF C	A/R DC	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION <STORED>	DESCRIPTION <SUPPLEMENTAL>	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
B018	S	E	JA	EA	3	J	89017	.17	PERCENT ENGR 99.9	GRD RETRACT ARM C-5AM		8.31		1.41		
0001			JA	01	00			.17		PART NUMBER/NSN		.000	.000	.000	0	
0010									4G11448-107A	1620001157390						
0100			JA	01	15			1.00		1ST GRIND O.D.		3.041	.456	3.498	42	
0010	E				RGR	SU	G1	1.00	SET UP A GAP GRINDER			1.05938		1.218		
0020	E				RLA	HP	C4	1.00	IRREG PART IN 4 JAW CHUCK	,		.22097		.254		
0040	E				RGR	GE	S2	98.00	GR STEEL OD (OCC FACT L X D)7 X 14			.01093		1.231		
0050	E				RGR	GE	D2	7.00	DWELL (GAP GRINDER STEEL OD)7 IN. O.D.			.01014		.081		
0060	E				RGR	WD	G2	2.00	WHEEL DRESS GAP GRINDER	2 PER OPERATION		.08334		.191		
0065	E				KMG	GW	LK	2.00	LOCATE WHEEL TO POSITION	2 PER OPERATION		.06761		.155		
0070	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030		
0080	E				RGR	HM	C4	1.00	HANDLE & MEAS LENGTH 12 - 24			.10674		.122		
0090	E				RLG	RS	F4	42.00	FILE/GRIND & POL NICK/BURR	CIRCUMFERENCE OF BOTH ENDS		.00415		.200		
0095									42 SQ INCHES							
0100	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0160			JA	01	15			1.00		2ND GRIND O.D.		4.186	.628	4.815	58	
0010	E				RGR	SU	G1	1.00	SET UP A GAP GRINDER			1.05938		1.218		
0030	E				RLA	HP	C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254		
0040	E				RGR	GE	C2	98.00	GR CHROM OD (OCC FACT L X D)7 X 14			.02189		2.467		
0050	E				RGR	GE	D3	7.00	DWELL (GAP GRINDER CHROM OD)7 IN. O.D.			.02029		.163		
0060	E				RGR	WD	G2	2.00	WHEEL DRESS GAP GRINDER	2 PER OPERATION		.08334		.191		
70	E				KMG	GW	LK	2.00	LOCATE WHEEL TO POSITION	2 PER OPERATION		.06761		.155		
80	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030		
0090	E				RGR	HM	C4	1.00	HANDLE & MEAS LENGTH 12 - 24			.10674		.122		
0100	E				RLG	RS	F4	42.00	FILE/GRIND & POL NICK/BURR	CIRCUMFERENCE OF BOTH ENDS		.00415		.200		
0110	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
9000			JA	01	15			.00		LABOR STANDARD HISTORY		.000	.000	.000	0	
0010									26DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM							
0011									958/UPDATED OCCURRANCE FACTOR/WORK							
0012									PREVIOUSLY DONE ON OPER A0020 <OLD SRD>.98							
0900									NED MONROE MANEAA 73357							

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD NROP NR
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17575A C5A MLG 4G11020-107A RCC MMPRB 4S1-93-3 84013

STEP	CH	S T	S K	W R	F A	PF FA	A/R DC	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RB019	S	E	JA	EA	3		J 89006		PERCENT ENGR 99.9	.05		GRD TRUNNION PIN	10.23		.51		
0001			JA	01		00				.00		PART NUMBER/NSN	.000	.000	.000	0	
0010									4G12400-101A		1620001162099						
0070			JA	01		15				1.00		1ST GRIND O.D.	3.058	.459	3.517	34	
0010	E				RGR-SU-C2					1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E				RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-MM-T2					1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD					1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-PE					4.00	GRIND .010 7DIA X 3 LONG	OCC FOR LENGTH	.59268		2.726		
0065	E				RGR-GE-D2					7.00	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.081		
0070	E				RGR-MM-C4					1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01		15				.05		1ST GRIND I.D.	3.672	.028	.211	2	
0010	E				RGR-SU-I1					1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E				RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				KMG-DW-ID					1.00	DRESS INTERNAL WHEEL		.02458		.028		
0040	E				KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E				KMG-ID-NE					4.00	GRIND OUT .010 6.0 ID X 3.0	OCC FOR LENGTH	.71847		3.304		
0060	E				RGR-MM-C4					1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0070	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01		15				1.00		POLISH LABOR	.372	.056	.428	4	
)10	E				RBW-SU-G1					.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
0020	E				RTL-SU-G1					1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0030	E				RTL-MM-M1					1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.005		
0040	E				ZPO-BP-C2					1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0050	E				ZIT-VI-B2					1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0060	E				RJP-PW-F1					1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0132			JA	01		15				1.00		FINISH GRIND O.D.	4.596	.689	5.286	52	
0010	E				RGR-SU-C2					1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E				RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-MM-T2					1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD					2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-PK					4.00	GRIND .040 7DIA X 3 LONG	OCC FOR LENGTH	.95369		4.386		
0065	E				RGR-GE-D3					7.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.163		
0070	E				RGR-MM-C4					1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0170			JA	01		15				.05		FINISH GRIND I.D.	6.274	.047	.361	4	
0010	E				RGR-SU-I1					1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E				RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				KMG-DW-ID					2.00	DRESS INTERNAL WHEEL		.02458		.056		
0040	E				KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E				KMG-ID-NK					4.00	GRIND OUT .040 6.0 ID X 3.0	OCC FOR LENGTH	1.36294		6.269		
0060	E				RGR-MM-C4					1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0070	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
75			JA	01		15				1.00		POLISH LABOR	.372	.056	.428	4	
)10	E				RBW-SU-G1					.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
020	E				RTL-SU-G1					1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0030	E				RTL-MM-M1					1.00	MIKE ID OR 2 FLAT SURFACES		.00481		.005		
0040	E				ZPO-BP-C2					1.00	BUTTERFLY POLISH CYL I.D.		.15445		.177		
0050	E				ZIT-VI-B2					1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0060	E				RJP-PW-F1					1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
9000			JA	01		15				.00		LABOR STANDARD HISTORY	.000	.000	.000	0	

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0011                    958/UPDATED OCCURRANCE FACTOR/WORK
0012                    PREVIOUSLY DONE ON OPER A0020 <OLD SRD>.98
0900                    NED MONROE  MANEAM  73357


TO INTERROGATE LABOR STANDARDS, INPUT

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17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

CH S S W F PF A/R REV

STEP	D	T L	K	#R A C	FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB020	S	E JA	EA	3	J	88270	1.00	PERCENT ENGR 99.9	GRIND ANTI ROTATION BOLT	1.77		1.77		
0001		JA	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010								4G12433-101A	1620001177319					
0050		JA	01	15			1.00		1ST GRIND BOLT SHANK	.695	.104	.800		45
0010	E			RGR	SU	C2	1.00	SET UP SMALL MED CYL GRINDER,		.29197		.335		
0020	E			RLA	HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E			RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER ,		.02632		.030		
0040	E			KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E			KMG	OD	DD	2.00	GRIND .010 1 1/2 OD X 2 1/2	OCCURANCE FOR LENGTH	.10917		.251		
0055	E			RGR	GE	D2	2.00	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.023		
0060	E			RGR	HM	C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 ,		.08102		.093		
0070	E			RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120		JA	01	15			1.00		FINISH GRIND BOLT SHANK	.849	.127	.977		55
0010	E			RGR	SU	C2	1.00	SET UP SMALL MED CYL GRINDER,		.29197		.335		
0020	E			RLA	HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E			RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER ,		.02632		.030		
0040	E			KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E			KMG	OD	DJ	2.00	GRIND .040 1 1/2 OD X 2 1/2	OCCURANCE FOR LENGTH	.17584		.404		
0055	E			RGR	GE	D3	2.00	DWELL (GAP GRINDER CHROM OD)	OCCURANCED FOR DIA	.02029		.046		
0060	E			RGR	HM	C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 ,		.08102		.093		
0070	E			RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
		JA	01	15			.00		LABOR STANDARD HISTORY	.000	.000	.000		0
010								24DEC85	RESTRUCTURED LABOR STD TO MATCH AFLC FORM					
0011									958/UPDATED OCC FACTORS/WORK PREVIOUSLY					
0012									DONE ON OPER A0220 <OLD STD> .41					
0900									MED MONROE MAMEAA 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	TCH	S	T	S	K	W	R	F	A	PF	FA	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A C
RB024		S	E	JA	EA	3			J			88344	.50	PERCENT ENGR 99.9	GRIND TRUNNION C BOLT C5A M	3.36		1.68			
0001				JA	01				00				.00		PART NUMBER/NSN	.000	.000	.000			0
0010														4613347-101A	5306004541547						
0060				JA	01				15				1.00		1ST GRIND SHANK	1.209	.181	1.391			41
0010	E								RGR		SU	C2	.50	SET UP SMALL MED CYL GRINDER	PRORATE 2 PARTS	.29197		.167			
0020	E								RLA		HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028			
0030	E								RGR		HM	T2	1.00	ADJUST TAPER - GAP GRINDER	,	.02632		.030			
0040	E								KMG		DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026			
0050	E								KMG		GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
0060	E								KMG		OD	FE	3.70	GRIND .010 2 1/2 OD X 3	OCC FOR LENGTH	.21334		.907			
0065	E								RGR		GE	D2	2.50	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.029			
0070	E								RGR		HM	C3	1.00	HANDLE & MEAS LENGTH 5 TO 12,		.09717		.111			
0080	E								RJP		PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0130				JA	01				15				1.00		FINISH GRIND SHANK	1.715	.257	1.973			59
0010	E								RGR		SU	C2	.50	SET UP SMALL MED CYL GRINDER	OCC FOR 2 PARTS	.29197		.167			
0020	E								RLA		HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028			
0030	E								RGR		HM	T2	1.00	ADJUST TAPER - GAP GRINDER	,	.02632		.030			
0040	E								KMG		DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026			
0050	E								KMG		GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
0060	E								KMG		OD	FK	3.70	GRIND .040 2 1/2 OD X 3	OCC FOR LENGTH	.34334		1.460			
0065	E								RGR		GE	D3	2.50	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.058			
0070	E								RGR		HM	C3	1.00	HANDLE & MEAS LENGTH 5 TO 12,		.09717		.111			
0080	E								RJP		PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0000				JA	01				15				.00		LABOR STANDARD HISTORY	.000	.000	.000			0
0010														05NOV85	RESTRUCTURED LABOR STD TO MATCH AFLC FORM						
0011															958/UPDATED OCC FACTORS/WORK PREVIOUSLY						
0012															DONE ON OPER A0170 <OLD STD> .46						
0020														16JAN86	UPDATED OCC FACTORS <OLD STD> 1.36						
0900															MED MONROE MANEAA 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-BY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	H	S	T	D	S	K	W	R	F	A	C	PF DC	A/R FA	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
8025		S		E		JA	EA	3				J	89017		.29	PERCENT ENGR 99.9	GRIND S.B. APEX BOLT C-5A M	3.48		1.00		
0001						JA	01					00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010														4G13537-101A		1620001164433						
0050						JA	01					15			1.00		1ST GRIND SHANK	1.247	.187	1.435		41
0010			E									RGR	SU-C2		.50	SET UP SMALL MED CYL GRINDER	PRORATE 2 PARTS	.29197		.167		
0020			E									RLA	HP-C6		1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030			E									RGR	HM-T2		1.00	ADJUST TAPER - GAP GRINDER	.	.02632		.030		
0040			E									KMG	DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050			E									KMG	GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060			E									KMG	OD-GE		3.20	GRIND .010 3 OD X 3	OCC FOR LENGTH	.25700		.945		
0065			E									RGR	GE-D2		3.00	DWELL (GAP GRINDER STEEL OD)	OCCURANCED FOR DIA	.01014		.034		
0070			E									RGR	HM-C3		1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111		
0080			E									RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120						JA	01					15			1.00		FINISH GRIND SHANK	1.779	.267	2.046		59
0010			E									RGR	SU-C2		.50	SET UP SMALL MED CYL GRINDER	PRORATE 2 PARTS	.29197		.167		
0020			E									RLA	HP-C6		1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030			E									RGR	HM-T2		1.00	ADJUST TAPER - GAP GRINDER	.	.02632		.030		
0040			E									KMG	DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050			E									KMG	GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060			E									KMG	OD-GK		3.20	GRIND .040 3 OD X 3	OCC FOR LENGTH	.41367		1.522		
0065			E									RGR	GE-D3		3.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.070		
0070			E									RGR	HM-C3		1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111		
0			E									RJP	PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
90..						JA	01					15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010																05NOV85	RESTRUCTURED LABOR STD TO MATCH AFLC FORM					
0011																	958/UPDATED OCC FACTORS/WORK PREVIOUSLY					
0012																	DONE ON OPER A0040 <OLD STD> 1.09					
0900																	N. MONROE MANEAA 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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STEP	TECH	S	S	T	K	SR	A	F	PF	A/R	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
RB034		S	E						JA	EA	3	J 88174	.41	PERCENT ENGR 99.9	GRD ANCHOR SHAFT C-5A	2.80		1.14			
0001									JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0	
0010														4G13366-101A	3040302284716LE						
0080									JA	01	15		.92		1ST GRIND O.D.	.584	.081	.619		22	
0010	E											RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083			
0020	E											RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104			
0030	E											RGR-MM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0040	E											KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026			
0050	E											KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
0060	E											KMG-OD-EC	2.00	GRIND .010 2 OD X 2		.11834		.272			
0070	E											RGR-GE-D2	2.00	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.023			
0080	E											RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042			
0090	E											RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0090									JA	01	15		.97		1ST GRIND O.D.	.455	.066	.508		18	
0010	E											RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083			
0020	E											RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104			
0030	E											RGR-MM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0040	E											KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026			
0050	E											KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
0060	E											KMG-OD-CC	2.00	GRIND 010 1 OD X 2		.05867		.134			
0070	E											RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.011			
0080	E											RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042			
090	E											RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
									JA	01	15		.92		GRIND CHROME	.840	.116	.890		32	
0010	E											RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083			
0020	E											RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104			
0030	E											RGR-MM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0040	E											KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053			
0050	E											KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION		.06761		.155			
0060	E											KMG-OD-EH	2.00	GRIND .040 2 OD X 2		.19084		.438			
0070	E											RGR-GE-D3	2.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.046			
0080	E											RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042			
0090	E											RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0180									JA	01	15		.97		GRIND CHROME O. D.	.628	.091	.701		25	
0010	E											RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083			
0020	E											RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104			
0030	E											RGR-MM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0040	E											KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053			
0050	E											KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION		.06761		.155			
0060	E											KMG-OD-CH	2.00	GRIND .040 1 OD X 2		.09467		.217			
0070	E											RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.023			
0080	E											RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042			
0090	E											RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0185									JA	01	15		1.00		POLISH EDGES OF JOURNALS	.075	.011	.087		3	
0010	E											ZPO-BP-C1	1.00		POLISH EDGES OF JOURNALS	.06549		.075			
0020	E											RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0000									JA	01	15		.01		LABOR STD HISTORY	.000	.000	.000		0	
0010														01JUL83 OCC FACTOR CHG AVG 3 STUDIES							
020														PREVIOUS STD HRS 2.83							

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/16/89 A-E0468-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4611020-107A RCC MMPRB 4S1-93-3 84013

STEP	D	T H	K L	S R	S K	W C	F DC	PF FA	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
0040	E	N	JA	EA	3		J	88334		1.00	PERCENT ENGR 42.3	C5A M. FLUID TRANS. HOUSING	.59		.59		
0001			JA	01		00				.00		PART NUMBER/NSN	.000	.000	.000		0
0010											4G12583-103A	1620001157419					
0045			JA	01		15				1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188		31
0010	E					ZHO	SU	S2		.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061		
0020	N									1.00		HONE BUSHING	.10000		.115		
0030	E					RJP	PW	R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0050			JA	01		15				1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188		31
0010	E					ZHO	SU	S2		.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061		
0020	N									1.00		HONE BUSHING	.10000		.115		
0030	E					RJP	PW	R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01		15				1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188		31
0010	E					ZHO	SU	S2		.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061		
0020	N									1.00		HONE BUSHING	.10000		.115		
0030	E					RJP	PW	R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0093			JA	01		15				1.00		POLISH I.D.	.029	.004	.034		6
0010	E					RSG	JP	05		1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018		
0020	E					RBW	BU	P1		1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003		
0030	E					RJP	PW	R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		00				.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010											9 JUNE 88 INITIAL INPUT MRPII						
0900											NED MONROE MANEL 73255 MR BIG						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

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

1234567890123456 ELSE PUT IN END

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17575A C5A MLG 4G11020-107A RCC MMPRB 4S1-93-3 84013

S STEP	D	T L	K	W R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
0001		JA	01			00				.00		PART NUMBER/NSN	.000	.000	.000		0
0010											4G13605-103A	5315001481779					
0050		JA	01			15				1.00		FIRST GRIND O.D.	.674	.101	.775		44
0010	E							RGR	SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE 4 PARTS	.29197		.083		
0020	E							RLA	HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0025	E							KMG	DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0030	E							RGR	HM-T2	.25	ADJUST TAPER - GAP GRINDER	PRORATE 4 PARTS	.02632		.007		
0040	E							RLG	EI-C8	1.00	MKE O/D WRE CHK BY MEASURING		.00485		.005		
0050	E							KMG	DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0060	E							KMG	GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0070	E							KMG	OD-EE	2.00	GRIND .010 2 OD X 3	OCC FOR LENGTH	.17200		.395		
0080	E							RGR	HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111		
0090	E							RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0110		JA	01			15				1.00		FINISH GRIND O.D.	.855	.128	.984		56
0010	E							RGR	SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE 4 PARTS	.29197		.083		
0020	E							RLA	HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E							RGR	HM-T2	.25	ADJUST TAPER - GAP GRINDER	PRORATE 4 PARTS	.02632		.007		
0040	E							KMG	DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E							KMG	GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E							KMG	OD-EK	2.00	GRIND .040 2 OD X 3	OCC FOR LENGTH	.27684		.636		
0070	E							RGR	HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111		
0080	E							RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000		JA	01			15				.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010											28FEB85 INITIAL INPUT						
0020											26DEC85 UPDATED OCCURRANCE FACTORS						
0900											N MONROE MANEAA 73357						

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR
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1234567890123456 ELSE P[illegible] FND
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 03/09/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MNPRB 4S1-93-3 84013

STEP	CH T	S K	S #R	W A	F C	PF FA DC	A/R SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RB053	S	E	JA	EA	3	J	89068	.50	PERCENT ENGR 99.9	GRIND C5A METERING TUBE BASE	1.28		.64		
0001			JA	01	00			.00		PART NUMBER / NSN	.000	.000	.000	0	
0010									4G13519-101A	1620001233790					
0045			JA	01	15			1.00		IST GRIND O.D.	.497	.075	.572	45	
0010	E				RGR	SU	C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	JA	1.00	GRIND .010 4 OD X 1		.12900		.148		
0070	E				RGR	GE	D2	4.00	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.046		
0080	E				RTL	MM	M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0087			JA	01	15			1.00		GRIND CHROME	.618	.093	.712	55	
0010	E				RGR	SU	C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	JF	1.00	GRIND .040 4 OD X 1		.20967		.241		
0070	E				RGR	GE	D3	4.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.093		
0080	E				RTL	MM	M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042		
90	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
[illegible]			JA	01	00			1.00		LABOR STD HISTORY	.000	.000	.000	0	
0900									LLOYD A. HARGIS MANEL-1 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
<---><----><--->
1234567890123456 ELSE PUT IN END

[redacted] CONTROL DOCUMENT (MEDS)

1 DATE 89040 | PAGE 1 OF ___ PAGES

3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
	MNPDP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
15576-2R	1663-2-80-3 AS-L-102 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C-5A MAIN	MSL	74652A
13. SERIAL NUMBER	14. NOUN	
	BALLAST	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DOWNGRADE TEST AFLCP 66-3 MANDI 66-3 BLAST IAW MIL-STD-15[illegible] BAKE IAW AS-L-102			
		MADI 74-12 CAP IAW MIL-[illegible]-19[illegible] P/O MC[illegible]			
		P/O [illegible] SEAL PLATE IAW MIL-STD-[illegible] [illegible]			
		[illegible] IAW [illegible]			
		[illegible] IAW [illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			

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

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—646-163

WORK CONTROL DOCUMENT (MEDS)

1. DATE	PAGE __ OF __ PAGES
89040	2

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

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

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

13. SERIAL NUMBER	14. NOUN
	[illegible]

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	[illegible]	8 15572-2R			
[redacted]	*RE00*	DISASSEMBLE *C/P MOVE		001 MNR 002 01 003 [illegible]	GF 3
[redacted]	*RE00*	CHEM CLEAN *C/P MOVE		001 MNR 002 03 003 [illegible]	GW 1
[redacted]	*RE00*	BLAST CLEAN *C/P MOVE		001 MNR 002 03 003 SC0	GW 1
[redacted]	*RE00*	BAKE 4 HRS AT 350-400F DATE IN ______ TIME IN ______		001 MNR 002 03 003 BK0	GW [illegible]
		DATE OUT ______ TIME OUT *C/P MOVE			
[redacted]	*RE00*	*C/P MOVE		[illegible] [illegible] 003 [illegible]	
[redacted]	*RE00*	E & I NOT VISUAL INSPECT FOR PITTING GOUGING, CORROSION, REMOVE MINOR NICKS *C/P MOVE		001 MNR 002 04 003 EI0	GW 1
25	020	VAPOR DEGREASE *C/P MOVE		001 MNR 002 03 003 DG0	RC 1

21. FINAL DESTINATION: DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
		A	C	21066N
		B	D	3626

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: [illegible]

21066N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040 | PAGE 3 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	BOLT NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 [redacted]	028	STRIP CAD *C/P MOVE		001 MH 002 02 003 C501	MC
26 [redacted]	032	STRIP RUST *C/P MOVE		001 MH 002 02 003 M502	MC
26 [redacted]	035	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED *C/P MOVE		001 MH-RT 002 01 003 BL02	
26 [redacted]	040	CAD PLATE I.D. *C/P MOVE		001 MH 002 [illegible] 003 [illegible]	MC
26 [redacted]	050	EPOXY PRIMER PER [illegible] ENDS OF PLATE [illegible]		001 MH 002 01 003 P501	MC
		DATE CUT TIME OUT *C/P MOVE			
[redacted]		* * * * * * N O T E * * * * * * * IF LAST NDI OPERATION [illegible] TIME, TAKE PRECAUTIONS [illegible]	M	[illegible]	
		* * * * * * * * * * * * * * * * * * * *			
26 [redacted]	061	IVD PLATE (INITIATED BY PLATING) *C/P MOVE			
26 [redacted]	062	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21066N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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21066N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040 | PAGE 4 OF 4 PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	060	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
26	070	PRIOR TO PHOSPHATE, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED *C/P MOVE		001 MNFRC 002 01 003 BL02	
26	070	PHOSPHATE COAT BALL TRACK TYPE M CLASS II *C/P MOVE		001 MNFRC 002 03 003 PH01	
26B	080	BAKE MIN OF 6 HRS AT 210-225F DATE IN ____ TIME IN ____		001 MNFRC 002 02 003 BK02	
		DATE OUT ____ TIME OU ____ *C/P MOVE			
5	095	INSPECT *C/P MOVE		001 MNFRC 002 02 003 IN01	
[redacted]	0-0	FINAL ASSEMBLY AND [illegible] DOCUMENT FOR COMPLETION & ACCEPT[illegible] OF ALL PREVIOUS OPERATIONS [illegible]		20 MNFRC 002 02 003 [illegible]	
[redacted]	100 *REQD*	FINAL PROOFLT VISUAL [illegible] *C/P MOVE		001 MNFRC 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21066N
		B	D	

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

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21067N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE: 89040 | PAGE 1 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
74652A		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
B15576-13R	1603-2-80-3/4S-1-182 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C5A MAIN	1620010064608	

13. SERIAL NUMBER	14. NOUN
	DOG STOP

15. DISPATCH STATION	16. PERF RCC/CP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BAKE IAW 4S-1-182 MAOI 74-12			
		IVD PLATE IAW MIL-C-83488A			
		CAD PLATE IAW MIL-STD-870 TP II CL II			
		FMPI IAW MIL-STD-1949			
		ALODINE IAW MIL-C-5541 P/O N01561			
		BLAST IAW MIL-STD-1504			
		MAT'L: STEEL (204,000 KSI)			
		COST: $296.37			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND		*	
		T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH			
		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH			
		STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF			
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES.			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21067N
		B	D	

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21067N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 2 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	B15576-13R			
34C5	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SL03	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
34B	009 *REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL07	
34B	011 *REQD*	BAKE 4HR AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
34M	013 *REQD*	FMPI *C/P MOVE	M	001 MNPNA 002 05 003 MS03	
34E	030 *REQD*	E & I VISUAL INSPECT /REMOVE MINOR NICKS *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	032	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	034	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21067N
		B	D	

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21067N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 3 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	DOG STOP

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	036	STRIP RUST *C/P MOVE		001 MN	PRC
				002 02	
				003 CS	02
26	038	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MN	PRC
				002 01	
				003 BL	04
26	040	CAD PLATE TIME OUT_____DATE OUT_____ *C/P MOVE		001 MN	PRC
				002 03	
				003 CA	01
26B	050	BAKE 23HR AT 350-400F WITHIN 4 HRS OF CAD PLATE. DATE IN_____TIME IN_____		001 MN	PRC
				002 02	
				003 BK	01
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	060	IRIDITE *C/P MOVE		001 MN	PRC
				002 02	
				003 IR	01
8A	065	FMPI *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *	M	001 MN	PNA
				002 06	
				003 ML	04
26	066	IVD PLATE(INITIATED BY PLATING) *C/P MOVE		001 MN	PRC
				002 03	
				003 IV	01
26	067	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MN	PRC
				002 03	
				003 TA	01

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21067N
		B	D	

21067N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 4 OF 4 PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	DOG STOP

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34P	068	PAINT DOG STOP *C/P MOVE		001 MNPGP 002 09 003 WB03	
34C5	070 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
34C5	080 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21067N
		B	D	

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21068N WORK CONTROL DOCUMENT (MEDS)

1 DATE: 89040 | PAGE 1 OF __ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
74652A		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
B15576-10	16G3-2-80-3/4S-1-182 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C-5A M.L.G.	5310010060370	

13. SERIAL NUMBER	14 NOUN
	HEX NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		ALODINE IAW MIL-C-5541 IVD PLATE IAW MIL-C-83488A			
		BLAST IAW MIL-STD-1504 BAKE IAW 4S-1-182 MAOI 74-12			
		EMPI IAW MIL-STD-1949			
		CAD PLATE IAW P/O N01561 MIL-STD 870 TP II CL II			
		COST: $54.34			
		MAT'L STEEL 196,000 KSI			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"**********			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21068N
		B	D	

21068N WORK CONTROL DOCUMENT (MEDS)

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	001	B15576-10			
34C5	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SL03	
34C	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
34B	009 *REQD*	BLAST CLEAN *C/P MOVE		001 MNPGW 002 03 003 BL07	
34B	011 *REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
34M	013 *REQD*	FMPI *C/P MOVE	M	001 MNPNA 002 05 003 MS03	
34E	030 *REQD*	E & I - VISUAL INSPECT/ REMOVE MINOR DEFECTS *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	032	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	034	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	

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

13. SERIAL NUMBER	14 NOUN
	HEX NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	036	STRIP RUST *C/P MOVE		001 MNPRC 002 03 003 CS02	
26	038	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	040	CAD PLATE DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	050	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	060	IRIDITE*C/P MOVE		001 MNPRC 002 02 003 IR01	
8A	070	F.M.P.I. *C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
		* * * * * * * * * * * * * * * * * * * *			
26	072	IVD PLATE(INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	074	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TA01	

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

13. SERIAL NUMBER	14 NOUN
	HEX NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34C5	080 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
34C5	090 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		MNPGP		

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MLG		AF DWG 7926445 4S1-93-3 4S1-182

13. SERIAL NUMBER	14. NOUN
	PISTON SUB-ASSY

17687A
17575A
4
7
8

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANI...	19. ...	20. QU...
P/N 7926445		NSN 1620010805925 C/N 17687A, 17575A, 17576A, 17577A, 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51, MANO1 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	7926445			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	010	* *MATCH - UP* * NEW/SERVICEABLE REWORKED NO REWORK INNER CYL		001 MNHGP 002 01 003 MU06	
		21002N FLOATING PISTON 21047N PISTON CARRIER			
		21052N PISTON STOP TUBE 21043N METERING TUBE BASE			
		21053N GAUGE 21059N			
34C5	015 *REQD*	PREASSEMBLY CLEANING; INSPECT ALL CAVITIES AND PASSAGES FOR CLEANLINESS AND SCRATCHES OK TO ASSEMBLE/OR CLOSE		001 MNHGP 002 01 003 PA07	
34C5	020 *REQD*	ASSEMBLE TOGETHER ALL PARTS REQUIRED TO BUILD THE HIGH PRESSURE PISTON ASSY AND INSTALL INTO INNER CYL		001 MNHGP 002 01 003 PA07	
34C5	025 *REQD*	POUR APPROX 1 PT LIGHT OIL INTO LOWER CHAMBER. PLACE SUBASSY INTO TEST FIXTURE AN SECURE.		001 MNHGP 002 01 003 PA07 004 PA0001	
34C5	030 *REQD*	CHARGE PISTON SUBASSY WITH 2500 PSI AND TEST IAW 4S1-93-3 PARA 6-6 PAGE 6-10		001 MNHGP 002 01 003 PA07 004 PA0001	
34C5	035 *REQD*	RECORD LEAKAGE; 1ST HOUR_____ 2ND HOUR_____ 3RD HOUR 4TH HOUR		001 MNHGP 002 01 003 PA07 004 PA0001	
34C5	040 *REQD*	UPON COMPLETION OF TEST, DRAIN OFF NITROGEN AND SAFETY WIRE AS REQUIRED *C/P MOVE		001 MNHGP 002 01 003 PA07	

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

13. SERIAL NUMBER	14. NOUN
	PISTON SUB-ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34P	045 *REQD*	CLEAN, MASK AND PAINT IAW 451-182 AND SUPPLEMENTS Painted as Inner cylinder		001 MNH 002 09 003 WB03	6P
34P	050 *REQD*	DECAL AS REQUIRED *C/P MOVE		001 MNH 002 09 003 WB03	6P
34C5	055 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95[illegible]		001 MN 002 01 003 ML[illegible]6	6P
34C5	060 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 M[illegible] 002 01 003 M[illegible]6	6P

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3 4S1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C-5A		
13. SERIAL NUMBER	**14. NOUN**	
	MLG STRUT DISASSY	

15. DISPATCH STATION	16 PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
4G1102D-107A		1620010054191 17575A			
4G1102D-105A		1620010054192 17576A			
4G1102D-101A		1620010054193 17577A			
4G1102D-103A		1620010054194 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
		YOKE SERIAL NUMBER. _____ OUTER SERIAL NUMBER. _____ (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		INNER CYL SERIAL NUMBER_____ SPLINED TUBE SERIAL NO._____			
		ROLL PIN SERIAL NUMBER_____			
	001	4G11020-107A 4G11020-105A 4G11020-101A 4G11020-103A			
34C5	[illegible] *REQD*	OPEN SHIPPING CRATE AND REMOVE TIE DOWN STRAPS FROM CRADDLES. REMOVE APEX PIN, SIDE BRACE ARMS AND ATTACHING HARDWARE FROM STRUT.		001 MNPGP 002 01 003 CC22	
		~~ATTACH~~ WORK ~~CONTROL~~ DOCUMENT AND ~~ROUTE~~.			
34C5	[illegible] *REQD*	WITH A STRAP HOLD THE INNER CYL IN COLLAPSED POSITION. ATTACH LIFTING SLING THROUGH THE ROLL PIN AND LIFT STRUT TO THE VERTICLE POSITION UP		001 MNPGP 002 01 003 CC22	
		SIDE DOWN.			
34C5	[illegible] *REQD*	REMOVE "Y" BLOCK AND DRAIN HYDRAULIC FLUID FROM UPPER CHAMBER INTO A WASTE OIL DRUM. REMOVE TRUNNION PIN AND RETRACT ARM ASSY. DISASSEMBLE		001 MNPGP 002 01 003 CC22	
		RETRACT ARM. ~~ATTACH WCD AND ROUTE~~			
34C5	[illegible] *REQD*	ROLL STRUT INTO UPRIGHT POSITION AND MOVE INTO DISASSEMBLY STAND. BE SURE LOWER CHAMBER HAS NO AIR IN (CONTINUED)		001 MNPGP 002 01 003 SD03 004 PM6573	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IT. (REMOVE ROLL POSITIONERS, CLEAN AND TAG COND ~~"F"~~.			
34C5	[illegible] *REQD*	REMOVE ROLL PIN AND ATTACHING PARTS. REMOVE FLUID TRANSFER HOUSING., ~~ATTACH WCD'S AND ROUTE.~~ REMOVE STAND PIPE, FLEX HOSE, AND JUNCTION BOX.		001 MNPGP 002 01 003 SD03 004 PM6573	
34C5	030 *REQD*	REMOVE ALL HYD LINES AND TUBING FROM THE KNEELING SYSTEM. REMOVE THE HYD MOTOR, HYD BRAKE AND GEAR BOX. DRAIN HYD FLUID CLEAN AND CAP. ~~TAG COND "F"~~.		001 MNPGP 002 01 003 SD03 004 PM6573	
34C5	[illegible] *REQD*	REMOVE CHAIN COVER, KNEELING CHAINS, GEAR DRIVE HOUSING. ~~DISASSEMBLE THE GEAR DRIVE HOUSING~~. ATTACH ~~WCD'S AND~~ ROUTE.		001 MNPGP 002 01 003 SD03 004 PM6573	
34C5	[illegible] *REQD*	REMOVE NORM & ENG ROTATION CYLS. DRAIN, CAP AND CLEAN. ~~TAG COND "F"~~. REMOVE ALL HYD TUBING AND FLEX HOSES TO CROSS WIND CYLS. CLEAN TUBING AND HOSES AND STORE FOR REUSE.		001 MNPGP 002 01 003 SD03 004 PM6573	
		* * * * * * * N O T E * * * * * * * ON COMPONENTS BEING STORED FOR REUSE VISUALLY INSPECT FOR ~~CLEANLINESS AND SERVICEABILITY~~ BEFORE STORING			
34C5	045 *REQD*	DISCONNECT ELECT WIRES AT ELECT JUNCTION BOX. REMOVE LINEAR SHUTOFF VALVES FROM BRACKETS. DRAIN, CAP, (CONTINUED)		001 MNPGP 002 01 003 SD03 004 PM6573	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CLEAN AND TAG--COND-"F". REMOVE LINEAR TRANSDUCERS CLEAN AND STORE			
		* * * * * * * * N O T E * * * * * * * * * USE CARE IN REMOVING ELECT. WIRING HARNESS TO AVOID DAMAGE. ELECT WIRING HARNESS SHOULD BE REUSED.			
		* * * * * * * * * * * * * * * * * * * *			
34C5	[illegible] *REQD*	REMOVE AND CLEAN ID'S OF CROSS WIND APEX BOLT AND ANTI ROTATION BOLTS. ATTACH WCD'S AND ROUTE. REMOVE AND DRAIN, CAP AND CLEAN CROSS WIND		001 MNPGP 002 01 003 SD03 004 PM5573	
		CYLS, NORM & EMG LOCK CYLS TAG F CONDITION.			
34C5	[illegible] *REQD*	REMOVE ALL HYD TUBING AND FLEX LINES IN SEQUENCE, ALL HYD FITTINGS AND VALVES. CLEAN AND STORE FOR REUSE. REMOVE ELECT. WIRING HARNESS,		001 MNPGP 002 01 003 SD03 004 PM5573	
		SYNCHRO TRANS. ATTACH WCD'S & ROUTE			
34C5	[illegible] *REQD*	REMOVE ROTATION SHAFTS, BRACKETS AND COVERS, BALLSCREW CROSS PINS. REMOVE ELECT. INSERT, CROSS WIND AND ROTATION MANIFOLDS. DRAIN, CAP AND		001 MNPGP 002 01 003 SD03 004 PM5573	
		CLEAN. TAG COND "F".			
34C5	[illegible] *REQD*	REMOVE STOP PLATE, ROTATION COLLAR, AND INSERTS. REMOVE AND DISASSEMBLE THE LOCK RING ASSY. LOCK ACT COLLAR (CONTINUED)		001 MNPGP 002 01 003 SD03 004 PM5573	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	MLG STRUT DISASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		AND POSITIONING COLLAR. ATTACH WORK CONTROL DOCUMENTS AND ROUTE.			
34C5	670 *REQD*	UNSCREW PACKING NUT FROM OUTER CYL DROP THE SPLINED TUBE INTO THE INNER CYL I.D. PLACE INNER CYL IN HOLDING CART AND SEPARATE THE INNER CYL FROM		001 MNPGP 002 01 003 SD03 004 PM5573	
		THE OUTER CYL. MOVE FROM UNDER STAND			
34C5	675 *REQD*	REMOVE OUTER CYL FROM YOKE, AND PLACE IN A "V" CART. ~~REMOVE ALL BUSHINGS.~~ REMOVE BALLSCREWS FROM YOKE AND ~~DISASSEMBLE. ATTACH WCD'S AND ROUTE~~		001 MNPGP 002 01 003 SD03 004 PM5573	
34C5	680 *REQD*	REMOVE AND DISASSEMBLE SPLINED TUBE, DISASSEMBLE HIGH PRESSURE PISTON ASSEMBLY FROM INNER CYL. REMOVE YOKE ASSY. FROM STAND, CLEAN EXCESS		001 MNPGP 002 01 003 SD03 004 PM5573	
		GREASE FROM TRUNNIONS. ~~ATTACH WCD'S AND~~ ROUTE.			
34C5	685 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.		001 MNPGP 002 01 003 SD03	
34C5	690 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 SD03	

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		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	451-182 451-22-3 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MLD		17575A
13. SERIAL NUMBER	**14. NOUN**	
	SWIVEL FTG ASSY-MLG	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20.
P/N 4612586-101A		NSN 1620001157078 S/N 17575A 17576A 17577A 17578A			6 7 8
		GOVERNING DIRECTIVES: AFLCR 66-51 MANO 66-3			
		BLAST IAW MIL-STD-1504 PPI IAW MIL-STD-6866			
		ALODINE IAW MIL-C-5541 CAD PLATE IAW MIL-STD-870 TP II CL II			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN TECHNICALLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS BE OBSERVED. THE APPLICABLE SAFETY PRECAUTIONS AND WARNINGS WILL			
		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *QUALIFICATIONS TO BE VERIFIED BEFORE ASSIGNMENT*			
		MOVED AS NEEDED TO ACCOMPLISH STATIONS. **********WARNING********** MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REWORK (MANDATORY REQUIREMENT) IN (CONTINUED)			

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BLOCK IS [illegible] DELTA STAMP			
	001	[illegible]			
	005	[illegible]		[illegible] 001 [illegible]	DP [illegible]
	REQD				
		[illegible] MOVE		[illegible]	
	REQD				
		[illegible]		[illegible]	
	REQD				
		[illegible] MOVE		[illegible]	
	REQD			002 [illegible] 005	
		[illegible]		[illegible]	
	REQD	END HOLE [illegible]			001
		0.9 [illegible]			
		C/P MOVE		001 MNP GW 002 04 003 E101	
69	040	END HOLE OVERSIZE REPAIR. OVERSIZE TO CLEAN UP NOT TO EXCEED I.D. 0.9 [illegible] *C/P MOVE*		001 MNP RA 002 02 002 LE02	

(CONTINUED)

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

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☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	[illegible]	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF THREADED END IS DAMAGED OR NOTE: CRACKED THERE IS A REPAIR TO CUT OFF AND MAKE A RE[illegible]			
69	045	THREADED END REPAIR. IF DAMAGED, [illegible] *C/P MOVE		[illegible] 001 02 002 [illegible]	
69	050	DRILL ALL HOLES IN FITTING AS PER [illegible] PAGE 5-10 SEC PART 2 *C/P MOVE		[illegible] 001 02 002 [illegible]	
[illegible]	[illegible]	[illegible] *C/P MOVE		[illegible]	
69	060	LOCALLY MFG A STUD (URGENT) AS SHOWN IN FIG 5-21 OF 451-93-3 USING 4130 [illegible]		[illegible] 001 02 002 [illegible]	
[redacted]		[illegible] *C/P MOVE		[illegible]	
[illegible]	[illegible]	[illegible]		[illegible]	
26	[illegible]	[illegible]		[illegible] 001 03 002 DA01	
26	[illegible]	IRIDITE *C/P MOVE		001 MNFRC 002 02 003 IR01	
26	080	IVD PLATE (UNITAPE BY PLATING) *C/P MOVE		001 MNFRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

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

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

13. SERIAL NUMBER	14 NOUN
	[illegible]

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	080	ABRASIVE IVD PLATED AREAS [illegible] BY PLATING *O/P MOVE*		001 M[illegible] 002 03 003 TA01	
69	085	MACHINE END HOLE BUSHINGS P/N [illegible]41-124010 [illegible]		001 [illegible] 002 02 003 [illegible]2	
69	090	INSTALL END HOLE BUSHINGS DIAMETER I.D 0 7505/0.7515 *O/P MOVE		001 [illegible] 002 02 003 BE01	
69	095	INSTALL INSERT IN FITTING WITH LOCTITE MIL-S-22473 [illegible]		[illegible]	
69	100	IF INSERT HAS BEEN HEAT TREATED CHASE THREADED END AFTER HEAT TREAT *O/P MOVE		[illegible]	
[redacted]	[illegible]	[illegible] IAW [illegible] *O/P MOVE*		[illegible] 002 03 [illegible]	
[redacted]	[illegible] [illegible]	[illegible] [illegible] FOR COMPLETENESS [illegible] [illegible]		[illegible]	
[redacted]	[illegible] *REWO*	FINAL [illegible] *O/P MOVE		[illegible] 002 01 003 MOV6	

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

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
[illegible]			[illegible]045	[illegible]

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
	[illegible]	[illegible] 17575A
13. SERIAL NUMBER	14. NOUN	
[illegible]		

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20.
					6
		[illegible]			7
		[illegible]			8
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		MANY OF THE [illegible] PROCEDURES [illegible] EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE [illegible]			
	001	*RANK* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP #912627-1078			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	[illegible]1094N 390

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
21094N			[illegible]	[illegible]

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[illegible]	[illegible]	[illegible]		001 [illegible]	[illegible]
	[illegible]	[illegible]		[illegible]	
	[illegible]	[illegible]		[illegible]	
	[illegible]	[illegible]		[illegible]	
	[illegible]	[illegible]		[illegible]	
	[illegible]	[illegible]		[illegible]	
	[illegible]	[illegible]		[illegible]	
[illegible]	[illegible]	REINSTALL [illegible]		001 [illegible]	
	[illegible]	CHAINS AND [illegible] PLUGS FOR CHAIN DRIVE [illegible]		002 01 003 PA04	
[illegible]	[illegible]	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPDP	
	[illegible]	DOCUMENT [illegible] OF ALL PRECEDING OPERATIONS THIS [illegible]		002 01 003 PA04	
[illegible]	[illegible]	FINAL PRODUCT VISUAL INSPECTION		001 MNPDP	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	003 PA04
		B	D	21094N

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
[redacted]4662A		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
4G94034-101A	16G3-2-80-3 4S1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C5A MLG	1620001486466	
13. SERIAL NUMBER	14. NOUN	
	BALLSCREW DISASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	4G94034-101A			
34C5	[redacted] *REQD*	CUT SAFETY WIRE AND REMOVE HEX NUT AND DOG STOP FROM END OF BALLSCREW		001 MNPGP 002 01 003 SD03	
34C5	[redacted] *REQD*	ROTATE BALLNUT OFF THE END OF THE BALLSCREW AND REMOVE ALL THE BALL BEARING FROM I.D. OF BALLNUT		001 MNPGP 002 01 003 SD03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21098N
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34C5	[redacted] *REQD*	REMOVE GREASE FROM BALL BEARINGS AND RECORD THE SIZE OF THE BALLS FOR REFERENCE UPON REASSEMBLY OF BALL-SCREW.		001 MNPGP 002 01 003 SD03	
34C5	[redacted] *REQD*	CLEAN SEALANT FROM RETURN TUBES AND TUBE STRAP, CUT SAFETY WIRE AND REMOVE HEX NUT HOLDING DEFLECTOR YOKES. REMOVE SCRAPERS AND DRIVE PINS AND RETURN TUBES.		001 MNPGP 002 01 003 SD03	
34C5	[redacted] *REQD*	SCRAPE SEALANT FROM BALLNUT TO REMOVE AS MUCH AS POSSIBLE. REMOVE ZERK FITTING AND REMOVE "D" RING AND DISCARD.		001 MNPGP 002 01 003 SD03	
34C5	[redacted] *REQD*	REMOVE EXCESS GREASE FROM BALLNUT AND ATTACH WORK CONTROL DOCUMENTS & ROUTE.		001 MNPGP 002 01 003 SD03	
34C5	[redacted] *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 SD03	
34C5	[redacted] *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 SD03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21098N
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21093N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89045 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	451-182 451-92-7 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MLO		17575A
13. SERIAL NUMBER	**14. NOUN**	
	SNE [illegible] PTO [illegible]	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4612588-101A		MWR 1&2200115739? LOA 17575A 17576A 17577A 17578A		6 7 8	
		COVERING DIRECTIVES: AFLCR [illegible] MAMCR [illegible]			
		WELDING CAW MIL-STD-1504 BRAZING CAW MIL-STD-[illegible]			
		ALUMINUM CAW MIL-C-5541 ETCH PLATE CAW MIL-C-81706 CAD PLATE CAW MIL-STD-870 TO BE USED			
		ALL PERSONNEL INVOLVED IN THE WORK INCLUDED SPECIFIED IN THIS ASSIGNMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O. AND SUPPLEMENTS [illegible]			
		PLANS TO BE USED IN ACCOMPLISHMENT OF THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED [illegible]			
		MOVES BETWEEN OPERATIONS/WORK STATIONS **********W A R N I N G********** MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

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

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

13. SERIAL NUMBER	14. NOUN
	SWIVEL FIT[illegible]

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BLOCK IS SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	4612555-101A			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE*		001 MNHGW 002 01 003 SD03	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE*		001 MNHGW 002 03 003 AC01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE*		001 MNHGW 002 03 003 BL07	
[redacted]	*REQD*	[redacted] *C/P MOVE*	M	001 [illegible] 002 05 003 [illegible]5	
[redacted]	*REQD*	[illegible] INSPECT[illegible] FITTING SHANK (LARGE) O.D. 0.749/0.750 WEAR 0.747 END HOLE BUSHING I.D. 0.7505/[illegible] WEAR 0.7525 MAX END HOLE BORE ACTUAL		001 [illegible] 002 04 003 [illegible]	
		I.D. 0.939 *C/P MOVE			
[redacted]	[redacted]	REMOVE BUSHINGS *C/P MOVE		001 MNHGW 002 04 003 EI01	
69	040	END HOLE OVERSIZE REPAIR OVERSIZE TO CLEANUP NOT TO EXCEED I.D. 0.999 IF THREADED END IS DAMAGED OR (CONTINUED)		001 MNHRA 002 02 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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1. DATE 89045 | PAGE 3 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
175-76A				

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C5A MLG		
13. SERIAL NUMBER	**14. NOUN**	
	SWIVEL FTG (INT)	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		NOTE: CRACKED. THERE IS A REPAIR TO CUT OFF AND MAKE A REPLACEMNT INSERT *C/P MOVE			
69	045	THREADED END REPAIR IF DAMAGED. CRACKED OR BROKE. CUT OFF THREADED END AND FACE OFF END OF FITTING *C/P MOVE		001 MNP RA 002 02 003 [illegible]	
69	050	DRILL ALL HOLES IN FITTING AS [illegible] 4S1-93-3 PARA 5-10 SUB PARA 1 *C/P MOVE		[illegible] MP RA 002 02 003 LE 2	
25	055	[illegible] ALL REWORKED AREAS *C/P MOVE		001 MP RC 002 [illegible] 003 [illegible]	
69	060	LOCALLY MFG A STUD (INSERT) AS SHOWN IN FIG 5-21 OF 4S1-93-3 USING 4130 HEAT TREATED STEEL OR EQUIVALENT *C/P MOVE		[illegible] MP RA 002 02 003 [illegible]	
[redacted]		INSERT) TO 40-250 *C/P MOVE*		[illegible] MP RA 002 02 003 MP01	
25	070	PREPARE INSERT FOR CAD PLATE (W/ PLATE) SHIP BLAN *C/P MOVE*		[illegible] MP RC 002 02 003 [illegible]	
25	075	CADMIUM PLATE (PSEL) *C/P MOVE*		[illegible] MP RC 002 02 003 CA01	
25	077	IRIDITE *C/P MOVE*		001 MNP RC 002 02 003 IR01	
26	080	IVD PLATE (INITIATED BY PLA ING) *C/P MOVE		001 MNP RC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6 DATE COMPLETED

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	SWIVEL PTG (UNIT)	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	080	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE*		001 MNPRL 002 03 003 TA01	
69	085	MACHINE END HOLE BUSHINGS *P/N MS21271-12A010*		001 MNPRA 002 02 003 EE02	
69	090	INSTALL END HOLE BUSHINGS DIAMETER I.D. 0.7505/0.7515		001 MNPRA 002 02 003 EE01	
69	095	INSTALL INSERT IN FITTING WITH LOCTITE MIL-S-22473		001 MNPRA 002 02 003 EE01	
69	100	IF INSERT HAS BEEN HEAT TREATED CHASE THREADED END AFTER HEAT TREAT		001 MNPRA 002 02 003 EE01	
[redacted]	105	DEGREASE AND MASK, PAINT AND PAINT TAW 401-182 *C/P MOVE*		001 MNPSP 002 09 003 WE09	
[redacted]	10	FINAL ACCEPTANCE OF THIS CONTROL DOCUMENT FOR COMPLETION AND RELEASE OF ALL PRECEDING OPS		001 MNQA 002 01 003 E	
[redacted]	115	FINAL ASSEMBLY DETAIL PARTS *C/P MOVE		001 A 002 A 003 MOVE	

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-102 4S1-93-3 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MLG		17575A

13. SERIAL NUMBER	14. NOUN
	SWIVEL [illegible]

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G12564-101A		NSN C/N 1620001157396 17575A 17576A 17577A		6 7	
		17578A		8	
		GOVERNING DIRECTIVES: AFLCR [illegible] MANOI [illegible] BLAST IAW MIL-STD-[illegible] EPT IAW MIL-[illegible]			
		ALODINE IAW MIL-C-5541 CAD PLATE IAW MIL-[illegible] TY II CL [illegible] [illegible] IAW MIL-[illegible]			
		[illegible] IN [illegible] PROCESSES SPECIFIED IN THIS [illegible] HAVE BEEN THOROUGHLY TRAINED AND [illegible] FAMILIAR WITH ALL PERTINENT [illegible]			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND [illegible] SUPPLEMENTS REFERENCED. THE [illegible] [illegible]			
		[illegible] THIS [illegible] [illegible] [illegible]			
		[illegible] STATIONS. [illegible] MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6 DATE COMPLETED

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

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

13. SERIAL NUMBER	14. NOUN
	SLEEVE, FTG (LINER)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BUSH IS SERVED THE SAME PURPOSE AS DELTA STAMP			
		1125A4-1014			
		ILLEGIBLE *C/P MOVE*			
		C/P MOVE			
		ONLY *C/P MOVE*			
34Z	015	FPI *C/P MOVE*			
34E		L & I INSPECTION *C/P MOVE* O.D. 0.749/0.750 MEAS 3.74 HOLE SHOP NO I.D. 0.75 0.750 MAX C-D MLF			
		0.99 *C/P MOVE*			
34E	035	REMOVE BUSHINGS *C/P MOVE*		001 MNPGN 002 04 003 S101	
69	040	END HOLE OVERSIZE REPAIR OVERSIZE TO CLEAN UP NOT TO EXCEED I.D. 0.999 *C/P MOVE*		001 MNPRA 002 02 003 LE02	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21092N
		B	D	899

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17575A				

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C5-A		
13. SERIAL NUMBER	14. NOUN	
	[illegible]	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF THREADED END IS DAMAGED OR NOTE: CRACKED THERE IS A REPAIR TO CUT OFF AND MAKE A REPLACEMENT INSERT			
69	045	THREADED END REPAIR IF DAMAGED, [illegible] *C/P MOVE		001 MNR 002 02 003 [illegible]	WW
69	050	DRILL ALL HOLES IN FITTING AS PER MS1-93-3 PARA 5-10 SUB PARA 2. *C/P MOVE		001 MNR 002 02 003 [illegible]	WW
26	055	ALIGNING PIN [illegible] *C/P MOVE		001 MNR 002 [illegible] 003 [illegible]	WW
69	060	LOCALLY MFG A STUD (INSERT) AS PER FIG 5-21 OF MS1-93-3 USING 4130 HEAT TREATED STEEL OR EQUIVALENT *C/P MOVE		001 MNR 002 02 003 [illegible]	WW
25	065	HEAT TREAT STUD (INSERT) TO 90-120 KSI IF NEEDED *C/P MOVE*		001 MNR 002 03 003 [illegible]	WW
26	070	REMOVE INSERT FOR [illegible] PLATE [illegible] *C/P MOVE*		001 MNR 002 [illegible] 003 [illegible]	WW
25	075	CADMIUM PLATE INSERT *C/P MOVE*		001 MNR 002 [illegible] 003 [illegible]	WW
26	077	IRIDITE *C/P MOVE*		001 MNR 002 02 003 IR01	RL
25	080	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNR 002 03 003 IV01	RL

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	**14. NOUN**	
	[illegible]	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[illegible]	080	ALODINE [illegible] PLATED AREAS (UNLESS BY PLATING) *C/P MOVE*		[illegible]	
69	085	MACHINE END HOLE BUSHINGS [illegible] *C/P MOVE		[illegible]	
69	090	INSTALL END HOLE BUSHINGS DIAMETER I.D. 0.7505/0.7515 *C/P MOVE		[illegible]	
69	095	INSTALL INSERT IN FITTING WITH [illegible] TIE MIL-S-21473 *C/P MOVE		[illegible]	
69	100	IF INSERT HAS BEEN HEAT [illegible] CHASE THREADED END AFTER HEAT TREAT *C/P MOVE		[illegible]	
[illegible]	105	DEGREASE AND MASK [illegible] IAW [illegible] *C/P MOVE*		[illegible]	
[illegible]	[illegible]	FINAL INSPECT [illegible] INSPECTION REQ [illegible] OF ALL PREVIOUS OPERATIONS			
[illegible]	110 *RECOD*	FINAL INSPECT [illegible] *C/P MOVE		[illegible]	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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3. QUANTITY	4 PRODUCTION REC/RCC ANPG	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER 13996-1	8. TECH DATA 16G3-2-80-3 4S-1-182 AND SUPPLEMENTS	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES C5A MAIN	11 STOCK NUMBER NSL	12 OPTIONAL
13. SERIAL NUMBER	14 NOMN SCREW	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. GOVERNING DIRECTIVES — WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		AFLCR 66-51			
		BLAST IAW MIL-STD-1504			
		BAKE IAW 4S-1-182 MAOI 74-12			
		SHOTPEEN IAW MIL-S-13165			
		FPI IAW MIL-STD-6866			
		BRUSH PLATE IAW MIL-STD-865			
		FMPI IAW MIL-STD-1949 P/O N01561			
		GRIND IAW MIL-STD-866			
		FLAME SPRAY IAW MIL-STD-869			
		TEMPER ETCH IAW MIL-STD-867			
		CHROME PLATE IAW MIL-STD-1501 TYPE II CLASS III			
		STRIP IAW MIL-STD-871			
		**********STEEL 298,000 **********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPELMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL			
		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. ****WARNING**** MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP CND	17. B-15576-1 WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34CS	005	DISASSEMBLE *C/P MOVE		001 MNPGP	
	REQD			002 01 003 SI03	
34C	007	CHEM CLEAN *C/P MOVE		001 MNPGW	
	REQD			002 03 003 SL01	
34B	009	BLAST CLEAN *C/P MOVE		001 MNPGW	
	REQD			002 03 003 BL01	
34B	011	BAKE 4 HRS AT 350/400F		001 MNPGW	
	REQD	DATE IN_____TIME IN_____		002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
34M	013	FMPI *C/P MOVE		001 MNPNA	
	REQD		M	002 05 003 ML04	
34Z	015	F.P.I. FOR CRACK VERIFICATION		001 MNPNA	
		IF REQ'D *C/P MOVE	M	002 05 003 ZY05	
34E	016	E AND I		001 MNPGW	
	REQD	CROSS PIN HOLES 1.600/1.603/1.607 SERVICE O/S PIN HOLES 1.690/1.700 MAX UPPER END O.D. 3.747/3.748/3.745		002 04 003 EI01	
		SERVICE NOTE: A MINIMUM OF TWO FMPI'S (CONTINUED)			

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. ARE REQUIRED ON THIS PART. Work to be Accomplished	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26	018	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 DG01	
24	019	STRIP CHROME FROM UPPER END ONLY		001 MNPRC	
		IF REQUIRED.		002 02	
		*C/P MOVE		003 SC02	
69	021	MACHINE CENTER ON SMALL INTERNAL DIA		001 MNPRA	
		AT UPPER END .060 X 60 DEG.		002 02	
		*C/P MOVE		003 LE09	
69	022	POLISH BALL GROOVE AREA TO REMOVE		001 MNPRA	
		ROUGH AND SCORED AREAS.		002 02	
		*C/P MOVE		003 LE09	
8	025	GRIND UPPER END OF SHAFT TO 3.733MIN		001 MNPRB	
		FOR CHROME PLATE IF IT DOES NOT		002 03	
		CLEAN UP , GO TO OPERATION 030 &		003 GE06	
		INITIATE ALL APPLICABLE OPERATIONS			
		*C/P MOVE			
8	030	GRIND FOR FLAME SPRAY NOT TO EXCEED		001 MNPRB	
		3.705 MINIMUM *C/P MOVE		002 03	
				003 GE06	
69	035	MACHINE AS REQUIRED TO REMOVE FLAME		001 MNPRA	
		SPRAY NOT TO EXCEED 3.705 MINIMUM.		002 02	
		*C/P MOVE		003 LE09	
69	040	MACHINE CROSS BOLT HOLES OVERSIZE TO		001 MNPRA	
		1.690/1.700 TO CLEANUP *NOTE REMOVE		002 03	
		ONLY ENOUGH MAT'L TO CLEAN UP		003 MV01	
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. *C/P MOVE WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	060	NITAL ETCH	M	001 MNPNA 002 06 003 TE03	
		TIME OUT_____DATE OUT_____ *C/P MOVE * * * * * * * * N O T E * * * * * * * *			
26B	070	IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT * BAKE 4 HRS AT 350/400F WITHIN 8 HRS		001 MNPRC	
		OF ETCH DATE IN_____TIME IN_____		002 02 003 BK01	
8A	080	DATE OUT_____TIME OUT_____ *C/P MOVE FMPI *C/P MOVE		001 MNPNA	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
26	085	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 03 003 DG01	
26	090	SHOTPEEN REWORKED AREAS .012/.016 *C/P MOVE		001 MNPRC 002 01 003 SP02	
69	091	MACHINE CROSS PIN BUSHING FOR FLAMESPRAY. P/N 66C33001-107ST. *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	092	INSTALL BUSHING FOR FLAMESPRAY ONLY WITH 0.003-0.004 INCH INTERFERENCE FIT. *C/P MOVE			
26	096	PREPARE O.D. FOR CHROME PLATE TYPE II CLASS 3 MASK/FIXTURE/ETC. *MECHANIC SIGN OFF REQUIRED-------> *C/P MOVE		001 MNPRC 002 02 003 BB01	
26	098	PREPARE O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	100	CHROME PLATE O.D. TYPE II CLASS 3 SUFFICIENT TO GRIND BACK TO 3.748 DATE OUT_____TIME OUT_____ *MECHANIC SIGN OFF REQUIRED-------> *C/P MOVE		001 MNPRC 002 02 003 CP01 008 CP010	
26B	110	BAKE 23 HRS AT 350/400F WITHIN 4 HRS OF CHROME DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
8	120	FINISH GRIND TO 3.747/3.748 WITH 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GB06	
26B	130	BAKE 4 HRS AT 350/400F DATE IN_____TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUME T/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
8A	140	FMPI , *C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT *			
26	145	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26A	150	FPI , *C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ZS01	
		HERE, TAKE PRODUCTION COUNT *			
25B	152	VAPOR DEGREASE, PRIOR TO FLAME SPRAY *C/P MOVE		001 MNPWW 002 08 003 DG01	
25B	154	MASK, PRIOR TO FLAME SPRAY *C/P MOVE		001 MNPWW 002 08 003 BE01	
25B	156	GRIT BLAST, PRIOR TO FLAME SPRAY *C/P MOVE		001 MNPWW 002 08 003 BL01	
25B	160	FLAME SPRAY .004/.007 USING METCO 405 BOND COAT & BUILDUP WITH METCO #5 STAINLESS AS REQUIRED TO MACHINE (CONTINUED)		001 MNPWW 002 08 003 FS08 005 XF929451	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

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

13. SERIAL NUMBER	14 NOUN
	BALL SCREW

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BACK TO 3.765 *C/P MOVE			
25B	164	UNMASK AND CLEAN OVER SPRAY *C/P MOVE		001 MNPWW 002 08 003 FS08	
25B	166	SEAL FLAME SPRAY *C/P MOVE		001 MNPWW 002 08 003 FS08	
69	170	ROUGH MACHINE FLAME SPRAY TO 3.765 *C/P MOVE		001 MNPRA 002 02 003 LE06	
69	173	CLEAN UP CROSS PIN HOLES AFTER FLAME SPRAY *C/P MOVE		001 MNPRA 002 02 003 MV01	
8	175	FINISH GRIND FLAMESPRAY 3.747/3.748. MAINTAIN 64RMS FINISH AFTER GRIND. BLEND TAPERED AREA TO MAINTAIN 1.50 RAD. CHAMFER TOP END 20DEG. BY .200 *C/P MOVE		001 MNPRB 002 03 003 GB06	
69	178	BRUSH LHE CAD CHROME/FLAME SPRAY FADE OUT AREA (TAPERED END) IF REQUIRED. *C/P MOVE		001 MNPRA 002 02 003 BB01	
69	190	MACHINE CROSS PIN BUSHING P/N 66C33001-107ST. *C/P MOVE		001 MNPRA 002 02 003 MV05	
69	191	INSTALL/FINISH BUSHING I.D. 1.600-1.603. 0.003-0.004 INTERFERENCE FIT. *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
34P	200	PRE-PAINT I.D. OF BALL SCREW *C/P MOVE		001 MNPGP 002 09 003 PR01	
34C5	210 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 MU06	
34C5	220 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 MU06	

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17575A C5A MLG 4G11020-107A RCC MNPRA 4S1-93-3 84013

	H S S W F PF A/R REV T K #R A C FA SUPPORT	OCC	DESCRIPTION		BASE	PFD	STD	A
STEP	D L K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
0001	S E JA EA 1 J 88305	.79	PERCENT ENGR 99.8	MACHINE C5A OUTER CYL.	33.68		26.61	
0001	JA 01 00	.00		PART NUMBER/NSN	.000	.000	.000	0
0010			4G11415-107A	1620004463776				
0120	JA 01 15	.16		2ND REPAIR AREA C	3.398	.082	.625	2
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E	KMM-BD-LB	4.00	BORE HOLE 6 X 1 GROUP 4		.74190		3.412	
0060 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0070 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0121	JA 01 15	.16		CHECK & RECORD DIM.	.741	.018	.136	0
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 N		1.00		CHECK & RECORD DIM.	.31700		.364	
0060 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0125	JA 01 15	.16		REPAIR COLLAR AREA	2.446	.059	.450	1
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E	RML-BD-HD	2.00	BORE HOLE 4.5 X 2 GROUP 4		1.00775		2.317	
0060 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	RECORD BASE METAL DIM.	.00601		.006	
0070 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0130	JA 01 15	.16		REPAIR COLLAR FACE	1.316	.032	.242	1
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E	KML-FR-JA	2.00	FACE ROUGH 5-6 DIA. GROUP 1	2 PASSES	.42654		.981	
0060 E	KML-FF-JA	1.00	FACE FINISH 5 TO 6 GROUP 1		.03259		.037	
0070 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	RECORD FLANGE THICKNESS	.00601		.006	
0080 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0135	JA 01 15	.21		MACHINE SHOULDER	1.326	.042	.320	1
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E	RML-BD-JA	2.00	BORE HOLE 5 X 1/2 GROUP 4		.44802		1.030	
0060 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	RECORD WASHER THICKNESS	.00601		.006	
0070 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0140	JA 01 15	.42		REP BALLSCREW HOLE RGT SIDE	5.030	.317	2.430	7
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E	RML-BD-GM	2.00	BORE HOLE 4 X 6 GROUP 4		2.28979		5.289	

0060 E		RJP-PW-C1	1.00 WRITE CRITICAL DIMENSION			.00601		.006		
0070 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
	JA 01	15	.42		REP BALLSCREW HOLE LFT SIDE	.646	.041	.312		1
0 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248		
0060 E		RJP-PW-C1	1.00 WRITE CRITICAL DIMENSION			.00601		.006		
0070 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0150	JA 01	15	.32		O/S HOLE ON MILL/SMALL PART	.915	.044	.337		1
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BD-LA	1.00 BORE HOLE 6 X 1/2 GROUP 4			.49100		.564		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0155	JA 01	15	.32		O/S HOLE ON MILL/SMALL PART	.640	.031	.236		1
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0160	JA 01	15	.16		OVERSIZE HOLE WITH REAMER	.349	.008	.064		0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RLG-HP-V7	1.00 OBJ IN/OUT STP VISE-HST HAND			.06831		.078		
0030 E		RBW-BU-R2	3.00 REAM WITH LEMPCO REAMER		3 PASSES	.07337		.253		
0 E		RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004		
0 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0165	JA 01	15	.16		OVERSIZE HOLE WITH REAMER	.349	.008	.064		0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RLG-HP-V7	1.00 OBJ IN/OUT STP VISE-HST HAND			.06831		.078		
0030 E		RBW-BU-R2	3.00 REAM WITH LEMPCO REAMER		3 PASSES	.07337		.253		
0040 E		RBW-DB-A1	1.00 DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.004		
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0170	JA 01	15	.16		O/S HOLE ON MILL/SMALL PART	1.083	.026	.199		1
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BD-DD	1.00 BORE HOLE 2.5 X 2 GROUP 4			.65881		.757		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0175	JA 01	15	.27		O/S HOLE ON MILL/SMALL PART	.640	.026	.199		1
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0180	JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.640	.005	.037		0
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248		

0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0190	JA 01	15	.11		O/S HOLE ON MILL/SMALL PART	.640	.011	.081	0	
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0205	JA 01	15	.05		LOCATE & DRILL 1 HOLE	.150	.001	.009	0	
0010 E		KML-CD-P1	1.00 CENTER DRILL			.01519		.017		
0020 E		RSG-JP-03	1.00 PREP HAND DRILL FOR USE			.00861		.009		
0030 E		RLA-DR-CA	3.00 DRILL HOLE 1/8-1/4 DIA (1/2			.03903		.134		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0210	JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.793	.006	.046	0	
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	3.00 ALIGN HOLE TO SPINDLE ROD		OCC. FOR 3 HOLES	.07609		.262		
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0408	JA 01	15	.83		TURN BUSHING GROUP 4/STEEL	1.750	.218	1.671	5	
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KML-TD-JC	1.00 DIA 5.00-6.00 REM .033-.250			.40208		.462		
0040 E		KML-TD-JD	5.00 DIA 6.00 REM .250 ADD INCH			.24071		1.384		
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0410	JA 01	15	.83		INST SET FLANGED BUSHINGS	.082	.010	.079	0	
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS		NO POLISH	.05133		.029		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0413	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	.915	.137	1.053	3	
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BD-LA	1.00 BORE HOLE 6 X 1/2 GROUP 4			.49100		.564		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0418	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.314	.047	.362	1	
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KML-TA-HC	2.00 DIA 4.00-5.00 REM .033-.250			.08497		.195		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0419	JA 01	15	1.00		INST STRAIGHT BUSH NO POLISH	.077	.012	.089	0	
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0420	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.327	.049	.377	1	
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.023		
0030 E		KML-TA-HC	1.00 DIA 4.00-5.00 REM .033-.250			.08497		.097		
0040 E		KML-TA-HD	4.00 DIA 5.0 REM .250 ADD INCH			.02185		.100		
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0421	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.082	.012	.095	0	
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS		NO POLISH	.05133		.029		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		

0422	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0423	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.108	.016	.124	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0424	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.145	.172	1.317	4
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP	2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-BD	2.00	BORE HOLE 1.5 X 2 GROUP 3	OCC. FOR 2 HOLES	.36029		.828	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0426	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0427	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.108	.016	.124	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0428	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.145	.172	1.317	4
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP	2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-BD	2.00	BORE HOLE 1.5 X 2 GROUP 3	OCC. FOR 2 HOLES	.36029		.828	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0431	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.569	.235	1.804	5
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP	2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1		1.14431		1.315	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0432	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.153	.173	1.327	4
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP	2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-LA	2.00	BORE HOLE 6 X 1/2 GROUP 3	OCC. FOR 2 HOLES	.36440		.838	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0433	JA 01	15	1.00		CHECK AND RECORD DIMENSIONS	1.015	.152	1.167	3
0010 E		RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OVER FOUR PARTS	1.03687		.298	
0020 E		KMM-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP		.14995		.172	
0030 E		KMM-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.05266		.060	
0040 E		KMM-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.14457		.166	
0050 E		KMM-AL-AA	7.00	ALIGN HORIZ AXIS ROD	PICH UP SURFACE/ 7 EACH	.05266		.423	
0060 E		RJP-PW-C1	5.00	WRITE CRITICAL DIMENSION	FIVE EACH DIMENSIONS	.00601		.034	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.630	.095	.725	2
0 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	

0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KML-TA-GC	6.00 DIA 3.00-4.00 REM .033-.250			.07800		.538		
0040 E		KML-TA-GD	1.00 DIA 4.0 REM .250 ADD INCH			.01707		.019		
0 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.082	.012	.095		0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS		NO POLISH	.05133		.029		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0471	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.881	.282	2.164		6
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTR		PRORATE OVER 4 PARTS	.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BC-GM	1.00 BORE HOLE 4 X 6 GROUP 3			1.45667		1.675		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0474	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.314	.047	.362		1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KML-TA-HC	2.00 DIA 4.00-5.00 REM .033-.250		2 PASSES	.08497		.195		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0475	JA 01	15	1.00		INST STRAIGHT BUSH NO POLISH	.077	.012	.089		0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0476	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.881	.282	2.164		6
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTR		PRORATE OVER 4 PARTS	.50518		.145		
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146		
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087		
0050 E		RML-BC-GM	1.00 BORE HOLE 4 X 6 GROUP 3			1.45667		1.675		
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0478	JA 01	15	1.00		TURN BUSHING GROUP 4/STEEL	.409	.061	.471		1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		OCC. FOR 2 BUSHINGS	.01006		.023		
0030 E		KML-TD-EC	1.00 DIA 1.50-2.00 REM .033-.250			.17225		.198		
0040 E		KML-TD-ED	1.00 DIA 2.00 REM .250 ADD INCH			.08233		.094		
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0480	JA 01	15	1.00		INST/REAM SET STRAIGHT BUSH	.278	.042	.321		1
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.22231		.255		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0484	JA 01	15	1.00		TURN BUSHING GROUP 4/STEEL	.409	.061	.471		1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.023		
0030 E		KML-TD-EC	1.00 DIA 1.50-2.00 REM .033-.250			.17225		.198		
0040 E		KML-TD-ED	1.00 DIA 2.00 REM .250 ADD INCH			.08233		.094		
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0485	JA 01	15	1.00		INST/REAM SET STRAIGHT BUSH	.278	.042	.321		1
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.22231		.255		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0488	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.222	.033	.255		1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK		OCC. 2 BUSH.	.01006		.023		
0 E		KML-TA-EC	1.00 DIA 1.50-2.00 REM .033-.250			.06699		.077		
0 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		

0500	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.082	.012	.095	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.029	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.040	.156	1.196	4
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-CB	2.00	BORE HOLE 2 X 1 GROUP 3	OCC.2 HOLES	.30779		.707	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0504	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	OCC. FOR 2 BUSH.	.01006		.023	
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250	OCC. FOR 2 BUSH.	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0505	JA 01	15	1.00		INST STRAIGHT BUSH NO POLISH	.097	.015	.113	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	2.00	INSTALL ONE STRAIGHT BUSHING	OCC. FOR 2 BUSH.	.02062		.047	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0507	JA 01	15	1.00		INST/REAM SET STRAIGHT BUSH	.278	.042	.321	1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.255	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0509	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.222	.033	.255	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	OCC. FOR 2 BUSH.	.01006		.023	
0030 E		KML-TA-EC	1.00	DIA 1.50-2.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00		INST SET FLANGED BUSHINGS	.082	.012	.095	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.029	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0512	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.881	.282	2.164	6
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-GM	1.00	BORE HOLE 4 X 6 GROUP 3		1.45667		1.675	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0514	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.211	.032	.244	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KML-TA-EC	1.00	DIA 1.50-2.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0515	JA 01	15	1.00		INST STRAIGHT BUSH NO POLISH	.077	.012	.089	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0516	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	1.881	.282	2.164	6
0010 E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-GM	1.00	BORE HOLE 4 X 6 GROUP 3		1.45667		1.675	
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	

0519	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.345	.052	.398	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250		.06699		.231	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0520	JA 01	15	1.00		INST/REAM SET FLANGED BUSH	.771	.116	.887	3
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	3.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.822	
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0524	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.366	.055	.421	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	3.00	1ST PART IN-OUT SCROLL CHUCK	OCC. FOR 3 BUSHINGS	.01006		.034	
0030 E		KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250	OCC. FOR 3 BUSHINGS	.06699		.231	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0525	JA 01	15	1.00		POLISH I.D.	.104	.016	.120	0
0010 E		RBW-BU-A4	3.00	INSTALL ONE STRAIGHT BUSHING	OCC. FOR 3 BUSHINGS	.01603		.055	
0020 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0030 E		RBW-BU-P1	3.00	BUTTERFLY POLISH BUSHING I D	OCC. 3 BUSHINGS	.01001		.034	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	00	.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010				9 JUNE 88 INITIAL INPUT MRPII					
0900				NED MONROE MANEL 73255 MR BIG					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/89 A-E046B-MM1-DY-M45 PAGE 0001

17575A C5A MLG 4G11020-107A RCC MMPRA 4S1-93-3 84013

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	C
A007	S	E	JA	EA	1	J 88277	.25	PERCENT ENGR 99.9	MACH C-5A MLG SPLINED TUBE	.04		.01		
0001			JA	01	00		.00		PART NUMBER / NSN	.000	.000	.000	0	
0010								4G13413-101A NSL						
0050			JA	01	15		.05		RECENTER PIN--60--	.721	.005	.042	90	
0010	E				RLA	SU-S3	1.00	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.574		
0020	E				RLA	HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	BOTH SIDES	.09095		.209		
0030	E				KML	CD-P1	2.00	CENTER DRILL		.01519		.034		
0050	E				RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	15		.05		NICK AND BURR MEDIUM PART	.077	.001	.004	10	
0010	E				RLG	RS-N3	1.00	NICK & BURR MED STRUT PART		.06711		.077		
0020	E				RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	15		.01		LABOR STD HISTORY	.000	.000	.000	0	
0010								23JUN83 OCC FACTOR CHG AVG 3 STUDIES						
0020								PREVIOUS STD HRS 0.62						
0030								27AUG85 UPDATE OCCURANCE FACTORS/RESTRUCTURED						
0031								LABOR STANDARD TO MATCH AFLC FORM 958						
0032								WORK PREVIOUSLY DONE ON OPERATION B0170						
0033								OLD STANDARD .57 HOURS						
0900								N MONROE MANEAA 73357						

'O GATE LABOR STANDARDS. INPUT

RCC PRD NROP NR
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17575A C5A MLG 4G11020-107A RCC MMPRA 4S1-93-3 84013

OPER STEP	H T	S K	S #R	W A	F C	PF DC	A/R FA	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA002	S	E	JA	EA	1		J	88280	.67	PERCENT ENGR 99.9	C5A INNER CYL	22.12		14.82		
0001			JA	01		00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010										4G11414-107A	1620004176249					
0050			JA	01		15			.50		LARGE ATT LUG REPAIR	6.021	.452	3.463		16
0010	E					KMM-SU-V1			1.00	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.580		
0020	E					RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E					RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					RML-BD-JG			3.00	BORE HOLE 5 X 3 1/2 GROUP 4		1.73940		6.000		
0060	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01		15			.38		SMALL ATT LUG REPAIR	3.851	.220	1.683		8
0010	E					KMM-SU-V1			1.00	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.580		
0020	E					RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E					RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					RML-BD-LE			2.00	BORE HOLE 6 X 2 1/2 GROUP 4		1.52384		3.504		
0060	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01		15			.63		REP SMALL LUG FACE	2.051	.194	1.486		7
0010	E					RML-SU-V3			1.00	S/U VERT MIL BORE FXTR HOISTLUCAS BORING MILL		1.03687		1.192		
0020	E					RML-AL-CA			1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB			1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CC			1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E					RML-BD-LB			1.00	BORE HOLE 6 X 1 GROUP 4	ELEMENT FOR FACE ON MILL	.74921		.861		
.51										NOT AVAILABLE. USED BORING						
0052										ELEMENT INSTEAD OF ESTIMATE.						
0070	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01		15			.05		POSITIONER LUG REPAIR	.489	.004	.028		0
0010	E					RBW-BU-S1			1.00	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.214		
0020	E					RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E					RBW-BU-R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
0040	E					RBW-DB-A1			1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0050	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01		15			.19		2ND METERING PIN REPAIR	2.130	.061	.465		2
0010	E					KMM-SU-V1			1.00	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.580		
0020	E					RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E					RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					RML-BD-JB			2.00	BORE HOLE 5 X 1 GROUP 4		.66325		1.525		
0060	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0509			JA	01		15			1.00		ODMACH METER PIN BUSH	1.283	.192	1.476		7
0010	E					RLA-SU-S3			1.00	SET UP SMALL MEDIUM LATHE		.49962		.574		
0020	E					KML-TD-JA			1.00	DIA 5.00-6.00 REM (.033	FLANGE	.26581		.305		
0030	E					KML-TD-JB			1.00	DIA 6.00 REM .033 ADD INCH	FLANGE	.16047		.184		
0040	E					KML-TD-HA			1.00	DIA 4.00-5.00 REM (.033	OD	.22607		.259		
0050	E					RLA-RC-KA			1.00	RECESS 4.5-5 DIA. 1/8 DP G1		.04514		.051		
0060	E					RLA-FF-LG			1.00	FACE FINISH 7 - 8 GROUP 4		.07619		.087		
0140	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0510			JA	01		15			1.00		MFG/INST METER PIN BUSH	.223	.034	.258		1
0	E					RBW-BU-S1			1.00	SET UP TO REBUSH BOSSES		.18669		.214		

0110 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		
0120 E		RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I DADDITIONAL POLISH REQ'D		.00333		.007		
0140 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
	JA 01	15	1.00		MACH LARGE ATTACH BUSHINGS	3.172	.476	3.648		16
010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	1 S/U PER LGE & SML	.49962		.287		
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMPPLACE FIXTURE IN LATHE		.15776		.181		
0030 E		RLA-HP-C4	3.00	IRREG PART IN 4 JAW CHUCK	OCC TO DIAL FACE AND	.22097		.762		
0031				O.D. WITH IN .001						
0040 E		RLA-PT-DJ11	5.00	MACH TIME 60 SFPM .004 FEED	OCC FACTOR BASED ON LXDXNUMB	.01819		2.405		
0041				OF CUTS 10.5 X 7.5 X 3						
0150 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0540	JA 01	15	1.00		INST LRGE ATTACH BUSHING	.123	.018	.142		1
0050 E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATED OVER 2 HOLES	.18517		.106		
0060 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		
0150 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0542	JA 01	15	1.00		MACHINE FINISH LARGE ATT	3.299	.495	3.794		17
0010 E		KMM-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.580		
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050 E		RML-BC-JH	2.00	BORE HOLE 5 X 4 GROUP 3	USE PROPER ELEMENT/TABLE	1.24799		2.870		
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0548	JA 01	15	1.00		MACH SMALL ATTACH BUSHINGS	.895	.134	1.029		5
0010 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	1 S/U PER LGE & SML	.49962		.574		
0020 E		KML-TC-JC	1.00	DIA 5.00-6.00 REM .033-.250		.24985		.287		
0030 E		KML-TC-JD	1.00	DIA 6.0 REM .250 ADD INCH		.13553		.155		
0150 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0550	JA 01	15	1.00		INST SMALL ATTACH BUSHING	.123	.018	.142		1
0010				A						
040 E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATED OVER 2 HOLES	.18517		.106		
050 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		
0150 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0551	JA 01	15	1.00		MACHINE SMALL ATT	1.958	.294	2.252		10
0010 E		KMM-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.580		
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050 E		RML-BC-LF	1.00	BORE HOLE 6 X 3 GROUP 3		1.15457		1.327		
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0559	JA 01	15	1.00		MACH POSITIONER BUSHINGS	1.324	.199	1.523		7
0010 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	FOR 4 BUSHINGS	.49962		.574		
0020 E		KML-TC-CA	4.00	DIA .501-1.00 REM (.033		.06381		.293		
0030 E		RLA-BO-BE	4.00	BORE HOLE 1/2 TO 1 DIA 1 DP		.10497		.482		
0040 E		RLA-CO-BE	4.00	CUT OFF 1/2 - 1 DIA. GROUP 3		.03486		.160		
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0560	JA 01	15	1.00		INST POSITIONER BUSHINGS	.641	.096	.738		3
0050 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214		
0060 E		RBW-BU-B2	2.00	REBUSH A SET OF 2 BOSSES	2 SETS OF 2	.22231		.511		
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000	JA 01	15	.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010				27AUG85 UPDATED OCCURANCE FACTORS/RESTRUCTURED						
0011				LABOR STD TO MATCH AFLC FORM 958						
0012				<OLD STANDARD> 17.36						
0020				28JAN86 UPDATED OCC FACTORS <OLD STD> 20.26						
0030				04FEB86 CHANGED SUB-OP 0560, 0570, 0580 TO SUB-OP						
031				0540, 0550, AND 0560 TO MATCH UPDATED AFLC						

0032
0900

958/ NO TIME CHANGE
N MONROE MANEAA 73357

TO INTERROGATE LABOR STANDARDS. INPUT

```
 RCC PRD NROP NR
<---><----><--->
1234567890123456  ELSE PUT IN END
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21041N

WORK CONTROL DOCUMENT (MEDS)

1. DATE

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 'OPTIONAL
	GEAR DRIVE HOUSING ASSY	

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. MATCH-UP WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 001 MNHR 002 "P" 001	20. "Q"
		NEW/SERVICEABLE REWORKED NO REMARK UPPER PLATE 210-2N		003 MU 16	
[redacted]	015	LOWER PLATE 210-2R PERFORM INSPECTION OF ALL PLAINED STEEL TO INSURE THAT ALL PARTS ARE		001 MNHR OP 002 01	
	READ	OPERATIONS ON ASB'S HAVE BEEN C/N BEFORE ASSY OF THE CHAIN DRIVE ROLLING ASSY.		003 MU 4	
[redacted]	020	PRESS TOGETHER DRIVE SPROCKET, SPACER ASSY KEY AND LOWER INPUT SHAFT		001 MNHR OP 002 01	
	READ	SPROCKET ASSY IN THIS ASSEMBLY PRESS IN NEEDLE BEARINGS, RACES AND SPACERS.		003 PA 4 004 PA 2	
[redacted]	025	PRESS THRUST BEARING INTO LOWER PLATE INSTALL IN LOWER HOUSING		001 MNHR OP 002 01	
	READ	AND 2 EA ALUM SHAFT, PRESS SPACER BEAR INTO THRUST BRNG, PLACE THRUST WASHERS & SPROCKETS ON SHAFTS		001 MNHR 002 PA	
[redacted]	030	PLACE THRUST WASHERS ON TOP OF SPROCKETS INSTALL UPPER PLATE AND		001 MNHR OP 002 01	
	READ	UPPER THRUST BRNG, INSTALL BEARING RETAINER, RETAINER BOLTS AND TOP PLATE NUTS.		003 PA 8 004 PA 002	

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

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
	GEAR DRIVE MOUNTING ASY	
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
	RECDR	T.O. 451-93-3 AND SAFETY WIRE AS NEEDED.		003 PA04 004 PA0002 001 ANFGP	
[redacted]	040	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY			
	RECDR	OF ALL PRECEDING OPERATIONS THIS WSB			
[redacted]	045	FINAL PRODUCT VISUAL INSPECTION			
	RECDR			003 PA04	

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

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MNPDP

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		4S-1-1827491-9S-2 &		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
C-5A MLG	SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
	[illegible]	17575A 7464A

13. SERIAL NUMBER	14. NOUN

6

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
4C12408-101A		NSN C/N 4730001[illegible]			
	4C 1240 B 101C	17576A# 17577A 17578A 24[illegible]	7		
		GOVERNING DIRECTIVES: AFLCP 66-31 [illegible]	8		
		F.P.I. IAW MIL-STD-6866 SHOTPEEN IAW MIL-S-13165 ALODINE IAW MIL-C-5541 [illegible]			
		*****MATERIAL: A L U M I N U M***** ALL PERSONNEL INVOLVED IN THE [illegible] [illegible] SPECIFIED IN THIS [illegible]			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE [illegible] TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH [illegible]			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (CMP [illegible]) [illegible] MOVES BETWEEN OPERATIONS/[illegible] STATIONS			
		************W A R N I N G************ MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF			
		EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21046N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*READY (DAMAGE ASSESSMENT) IN			
	001	COLUMN 16 IS EQUIVALENT TO DELTA STAMP. 4G12408-101A			
[redacted]	005	DISASSEMBLE *C/P MOVE		001 MNFDP 002 01	
	REQD			003 SD03	
[redacted]		DEGREASE *C/P MOVE		001 MNFDG 002 02	
	REQD			003 DG02	
[redacted]		*C/P MOVE		001 MNFHA 002 03	
	REQD			003 ZY02	
[redacted]		E & I 0.0 10.110-10.100-10.105 MIN		001 MNFGA 002 04	
	REQD	PISTON RING GROOVE 9.760-9.770 9.755 MIN INSERT I.D. 2.295 MAX *C/P MOVE		001 LI01	
[redacted]		NICK & BURR REPAIR *C/P MOVE		001 MNFJA 002 05	
26	025	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03	
26	030	SHOTPEEN REWORKED AREAS .004-.008 A2		003 DG01 001 MNFRC 002 01	
		*C/P MOVE		003 SP01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
		ALODINE TCP MOVE		001 MNPRC 002 "P" 03	"Q"
				003 TA01	
[redacted]	050	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMP. CTRNESS & ACCURACY		001 MNPSP 002 01	
	RECD	OF ALL PRECEDING OPERATIONS THIS YSS		003 MU06	
[redacted]	050	FINAL PRODUCT VISUAL INSPECTION TCP MOVE		001 MNPSP 002 01	
	CLOSE			003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1. DATE 89035 | PAGE 1 OF ___ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	AF DWG 7926447 & SUPPLEMENTS 4S-1-182 4S1-94-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MINN		

13. SERIAL NUMBER	14. NOUN
	FLOATING PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
4G1351	0-101A	1620001164430 17575A 17576A 17577A 17578A 17687A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		F.P.I. IAW MIL-STD-6866 STRIP ANODIZE IAW MIL-STD-871 SHOT PEEN IAW MIL-S-13165			
		ANODIZE IAW MIL-A-8625 TYPE II CLASS II ALODINE IAW MIL-C-5541 COST: $1362.60			
		MATERIAL: ALUMINUM			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH			
		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH			
		STATIONS. "WARNING" MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21047N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1. DATE 89035 | PAGE 2 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17.	18. MECHANIC	19. "P"	20. "Q"
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
	001	*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP. 4G13510-101A			
34C5	005	DISASSEMBLE *C/P MOVE		001 MNPGP 002 01 003 SD03	
	REQD				
34D	006	DEGREASE ONLY *C/P MOVE		001 MNPGW 002 02 003 DG02	
	REQD				
		[redacted] *C/P MOVE		001 MNPNA 002 05	
	REQD		M	003 ZY05	
34E	020	E & I		001 MNPGW 002 04 003 EI01	
	REQD	PISTON RING GROOVE OD 9.760/9.770/9.758			
		SEAL GROOVE OD 9.697/9.700/9.695 LOWER END OD 10.115/10.120/10.112			
		SEAL AREA ID 2.743/2.745/2.747 SURFACE AREA ID 2.502/2.504/2.506 *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21047N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035 | PAGE 3 OF 3 PAGES

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

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

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

13. SERIAL NUMBER	14 NOMENCLATURE
	FLOATING PISTON

15. DISPATCH STATION	16. PERF RCC/OP (MEDS)	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
		REMOVE NICKS, SCRATCHES AND		001 MNPRA	
		CORROSION		002 02	
		*C/P MOVE		003 BE01	
26	040	STRIP ANODIZE COMPLETE		001 MNPRC	
		*C/P MOVE		002 03	
				003 AN04	
				001 MNPNA	
		*C/P MOVE	M	002 06	
		* * * * * * * N O T E * * * * * * *		003 ZA02	
		IF LAST NDI OPERATION IS COMPLETED*			
		TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			
26	050	SHOT PEEN REWORKED AREAS INTENSITY		001 MNPRC	
		OF .005/.010 A2		002 01	
				003 SP01	
26	100	ANODIZE COMPLETE TYPE II		001 MNPRC	
				002 03	
		*C/P MOVE		003 AS03	
				005 X857907	
26	105	ALODINE		001 MNPRC	
		*C/P MOVE		002 03	
				003 TA01	
34C5	110	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 ML06	
34C5	120	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
		*C/P MOVE		002 01	
	REQD			003 ML06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21047N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

MNFOP

1. DATE	PAGE__OF__PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		43-1-132		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	451-43-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
		17575A
13. SERIAL NUMBER	14. NOUN	6

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. NSN C/N WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "T"	20. "Q"
4G1258	3-103A	17576A 17577A 17578A		9	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	929
		B	D	318

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WORK CONTROL DOCUMENT (MEDS)

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO AVOID INJURY.			
[redacted]					
[redacted]					
[redacted]					
[redacted]		Z & I INSPECTION			
		HOUSING I.D. 1.559/1.560 WEAR 1.562			
		WEAR 1.490 (CONTINUED)			

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

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		.7525 .7535 WEAR .7520 BASE METAL .9390 MAX			
		.2005/.2015 WEAR .2000 BASE METAL .6252 MAX			
		STRIP INDUCE FROM O.D.			
		GRIT ANNEAL FROM I.D.			
		[redacted]			
		IF LAST MCI OPERATION IS [illegible]			
B	045	1ST HONE I.D. TO 1.561 MAX 63 RMS			
B	050	2ND HONE TO 1.564 MAX 63 RMS I.D. TO REMOVE CORROSION & NICKS IF NECESSARY.		001 [illegible] 002 01	
69	056	*C/P MOVE NICK & BURR REPAIR - BLEND MINOR SCRATCHES AND NICKS TO PARENT METAL		003 HH01 001 MNRPA 002 02	
		*C/P MOVE		003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
	[illegible] TRANSFER NO. [illegible]	
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20. "Q"
		FITTING LUG HOLE (SML) BORE AS [illegible]		001 MN RR 002 "P" 02	
		.150 WALL THICKNESS. MACHINE OUTSIDE FACE OF LUG A MIN. OF .040 CHAMFER BORE .04/.07 X 45 DEGREES [illegible]		003 MVQ1	
69	065	FITTING LUG HOLE (LG) BORE AS [illegible]		001 MN RR 002 02	
		.200 WALL THICKNESS. MACHINE [illegible] TO EXCEED MIN THICKNESS OF .350 [illegible]		003 MVQ1	
69	070	*C/P MOVE MACHINE O.D. TO 1.760 MIN. WITH A MIN. WALL OF .120		001 MN [illegible]	
69	075	*C/P MOVE PIN HOLES REPAIR IF EXISTING HOLES [illegible]		001 MN [illegible] 002 [illegible]	
69	080	3.375 MIN & 0.400 MAX. *C/P MOVE SHOTPEEN LOCAL REWORK AREA [illegible]		003 MVQ1 001 MN [illegible]	
69	085	*C/P MOVE SHOTPEEN FINISHED I.D. OF [illegible]		[illegible]	
69	090	*C/P MOVE HONE I.D. AFTER SHOTPEEN NOT TO EXCEED [illegible] *C/P MOVE		001 [illegible] 002 01	
69	093	HAND POLISH I.D. AFTER SHOTPEEN NOT TO EXCEED [illegible]		003 RR01 001 MN RR 002 01	
				003 REQ1	

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

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WORK CONTROL DOCUMENT (MEDS)

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

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

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

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" "Q"
		ANODIZE HOUSING O.D. TYPE II CLASS 2 *RC/P MOVE		001 MNRRC 002 03 003 AS03
26	100	ANODIZE HOUSING I.D. TYPE II CLASS II *RC/P MOVE		001 MNRRC 002 03 003 AS03
26	105	HARD ANODIZE I.D. COMPLETE TYPE III CLASS 1 *RC/P MOVE		001 MNRRC 002 03 003 AH01 004 AI010
26	110	ALODINE MINOR REWORK REPAIR *RC/P MOVE		001 MNRRC 002 03 003 TA01
[redacted]		ING SLOW DIE AR *RC/P MOVE		001 MNRRA 002 03 003 PS03
69	120	MACHINE FLAME SPRAY TO 1.998/1.996 DIAMETRAL DIMENSIONS IF REQUIRED LIMITS ARE EXCEEDED *RC/P MOVE		001 MNRRA 002 03 003 MA01
69	~~124~~	MACHINE SMALL BUSHING P/N 66C32000-57A01 *RC/P MOVE		001 MNRRA 002 03 003 LE02
69	125	INSTALL (SMALL) BUSHING P/N 66C32000-57A01 USE .0005/.0015 PRESS FIT. REAM TO 0.6248/0.6252. *RC/P MOVE		001 MNRRA 002 03 003 BE01
69	~~127~~	MACHINE LARGE BUSHING P/N 66C32000-53A01		001 MNRRA 002 03 003 LE02

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

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WORK CONTROL DOCUMENT (MEDS)

1 DATE

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
	E-1171 TRANSFER MODULE	

13. SERIAL NUMBER	14. NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 001 MNHR "P"	20. "O"
3405	135	USE .0005/.0015 PRESS FIT. REAM TO 0.9376/0.9390 *C/P MOVE PRESSURE TEST & MARK LEAKING PLUGS *C/P MOVE		005 BE01 001 MNHRP 005 01	
69	140	REMOVE DEFECTIVE LEE PLUGS AS MARKED & RE-INSTALL WITH A NEW LEE PLUG *C/P MOVE P/N 469101 P/N 478101		005 BE01 00 MNHRA 00 02	
69	145	FITTING LUG (SMALL) BUSHING INSTALLATION USE BUSHING PRESS FIT .0005/.0015 *C/P MOVE MS21241-08A012 P/N MS21241-08A06		005 BE01	
69	150	INSTALL HELICOILS *C/P MOVE		001 MNHR	
69	155	FITTING LUG (LARGE BUSHING INSTALLATION USE BUSHING PRESS FIT .0005/.0015 *C/P MOVE MS21241-12A012 P/N MS21241-12A06			
69	158	MACHINE PIN BUSHINGS (4 EA) FROM 4130 STEEL		001 MNHRA 002 02 005 LE02	

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

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WORK CONTROL DOCUMENT (MEDS)

1. DATE

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
	FLUID TRANSFER [illegible]	
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	160	INSTALL 4 EA PIN BUSH MADE FROM [illegible] EQUALENT BRUSH CAD PLATE 0.0004/0.0007 PRESS FIT. REAM TO .313/.315 [illegible]		001 MNHRA 002 [illegible] 003 BE01	
		LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING [illegible] LIMITS			
		RC/P MOVE			
[redacted]	165	PRESSURE TEST RC/P MOVE		001 MNHOP 002 01 003 BE01	
[redacted]	170	PAINT RC/P MOVE		001 MNH[illegible] 002 [illegible] 003 [illegible]	
[redacted]	175	FINAL ACCEPTANCE OF WORK CONTROL [illegible] FOR COMPLETION [illegible] OF ALL PRECEDING OPERATIONS THIS [illegible]		001 MNH[illegible] 002 [illegible] 003 [illegible]	
[redacted]	180	FINAL PRODUCT VISUAL INSPECTION [illegible]		001 MNH[illegible] 002 [illegible] 003 [illegible]	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	2 [illegible]
		B	D	485

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1 DATE

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MNPGE

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
C-5A, M.G.	DRAWING 4613571 4S-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
	LOCK & FIND NUT	481-93-3 & SUPPLEMENTS
13. SERIAL NUMBER	14. NOUN	
		17575A

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. NSN C/N WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		17576A 17577A 17578A			6 7 8
		GOVERNING DIRECTIVES: AFLCR 66-31 MANOI 66-3			
		IVD PLATE IAW MIL-C-81406A PMP1 IAW MIL-STD-1747 P/O N01561			
		BAKE IAW 4S-1-182 MAUI 74-12			
		COPPER STCH IAW MIL-STD-867 ALODINE IAW MIL-C-5541 PAINT PLATE IAW MIL-STD-[illegible] TP 11 CL 3			
		BLAST IAW MIL-STD-1504 *MS* L STEEL 180,000 - 220,000 PSI COAT: AGA 40			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND PRECAUTIONS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 12 OF THIS WORK CONTROL DOCUMENT. USE APPROPRIATE			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE	PAGE__OF__PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCESSES OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		READ (MANDATORY REQUIREMENT) IN ORDER TO BE FOLLOWED BY [illegible]			
	001	STAMP, 4213571-101A			
34C5	005	DISPOSABLE *C/P MOVE		001 MNHSP [illegible]	
34D	*REQD* 00A	DEGREASE ONLY *C/P MOVE		002 SE03 [illegible]	
34M	*REQD* 00A	BLAST CLEAN ONLY *C/P MOVE		003 SB02 001 MNHSM [illegible]	
34J	*REQD* 013	MAGNAFLUX AT [illegible]		[illegible]	
	REQD	DATE IN [illegible] TIME IN [illegible] DATE OUT [illegible] TIME OUT [illegible] *C/P MOVE		[illegible]	
34M	013	FMPI *C/P MOVE	M	001 MNFNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1. DATE

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. E & I WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 001 MNR 002 "QA" 003	20. "Q"
	REQD	VISUAL INSPECTION AND MINOR REMOVAL OF NICKS, BURRS, SCRATCHES, & CORROSION. *C/P MOVE		003 EI01	
26	040	TEMPER ETCH REWORKED AREAS		001 MNRNA 002 QA	
		DATE OUT_____ TIME OUT_____ *C/P MOVE * * * * * * * * * N U T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*		003 IE03	
26B	050	HERE, TAKE PRODUCTION COUNT * BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH		001 MNRC 002 03	
		DATE IN TIME IN DATE OUT TIME OUT		003 BK01	
26	060	*C/P MOVE FMPI *C/P MOVE *		001 MNRNA 002 QA	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		003 MT01	
26	062	VAPOR DEGREASE *C/P MOVE		001 MNRRC 002 03	
26	064	STRIP CAD *C/P MOVE		003 DG01 001 MNRRC 002 02	
				003 CS01	

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

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AFLC FORM 858 NOV 80

PREVIOUS EDITION MAY BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

WORK CONTROL DOCUMENT (MEDS)

1 DATE

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STRIP RUST *C/P MOVE		001 MNPRC	
				003 CS02	
26	068	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 03	
				003 BL02	
26	070	CAD PLATE TYPE 2 CLASS 3 DATE OUT TIME OUT		001 MNPRC 002 03	
		*C/P MOVE		003 CA01	
26B	080	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN TIME IN		001 MNPRC 002 02	
				003 BK01	
		DATE OUT TIME OUT *C/P MOVE			
26	090	IRIDITE (CHROMATE CONVERSION COATING)		001 MNPRC 002 02	
		*C/P MOVE		003 IR01	
8A	100	F.P.I. *C/P MOVE * * * * * * * * N O T E * * * * * * * *		001 MNPRA 002 03	
		IF FPI NDI INSPECTION IS COMPLETED HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * *		003 FP02	
26	102	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03	
				003 IV01	
26	104	ALODINE IVD PLATED AREAS (INITIATED BY PLATING)		001 MNPRC 002 03	
		*C/P MOVE		003 TA01	

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

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (MEDS)

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20. "Q"
	NEW	HOLD FOR RE-ASSEMBLY		001 MNHRA 002 "02 003 BE01	
24C5	120	FINAL ACCEPTANCE OF WORK CONTROL		001 MNHGP 002 01	
	NEW	OF ALL PRECEDING OPERATIONS THIS 958		003 MU06	
24C5	120	FINAL PRODUCT VISUAL INSPECTION		001 MNHGP 002 01	
	NEW			003 MU06	

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

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[redacted] DOCUMENT (MEDS)

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3.	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
	MNPGP		

7.	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-93-3	

10. SECTION-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MLG		17575A
13. SERIAL NUMBER	**14. NOUN**	6
	BALLSCREW PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 7 8	20. "Q"
P/N 4013605-103A		NSN 5315001451779 C/N 17575A [redacted] 17577A 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANO1 66-3 BAKE IAW 4S-1-182 MAUI 74-12			
		BLAST IAW MIL-STD-1504 FPI IAW MIL-STD-6866 STRIP IAW MIL-STD-871 [redacted] IAW MIL-STD-886			
		SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 TP II CL III COST: $107.16			
		MAT'L: STAINLESS 200,000 PSI			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED IN BLOCK 9 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21051N
		B	D	44

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985-461-105

21051N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040

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

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

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

13. SERIAL NUMBER	14. NOUN
	BALLSOCKET PIN

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PREVENT INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	501	ASSEMBLY			
[redacted]	[redacted]	DISASSEMBLE *C/P MOVE		001 MNHNA 002 01 003 SD03	
[redacted]	*REQD*	DEGREASE ONLY *C/P MOVE		001 MNHNA 002 02 003 DG02	
[redacted]	*REQD*	[redacted] *C/P MOVE		001 MNHNA 002 03 003 [redacted]	
[redacted]	*REQD*	BAKE AND AGE AT 300°F-400°F DATE IN _____ TIME IN _____		001 MNHNA 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNHNA 002 05 003 ZY05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21051N
		B	D	442

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21051N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89040 | PAGE 3 OF PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	BALLSCREW PIN

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E & I		001 MNPRW 002 04 003 EI01	
	REQD	PIN O.D. 1.5950/1.5985 *C/P MOVE			
69	040	RECENTER ENDS FOR GRIND IF REQUIRED *C/P MOVE		001 MNTRA 002 02 003 LA06	
18	050	FIRST GRIND PIN O.D. TO CLEAN-UP MINIMUM 1.5925 *C/P MOVE		001 MNTRB 002 01 003 GE00	
28	070	VARIA GRINDING *C/P MOVE		001 MNPRC 002 02 003 BK01	
28	080	GRIND PILOT DIA. TO O.D. 0.0002/.0012 CT *C/P MOVE		001 TMPRC 002 01 003 SP01	
28	090	PRIMARY CLN FOR CHROME PLATE MASK FOR PLATE *CLEAN* SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 CL01	
28	095	STEP GRIND O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 GR01	
28	100	CHROME PLATE PER [redacted] GRIND BACK TO .005 DATE OUT TIME OUT		001 MNPRC 002 02 003 CP01 004 C0010	
		MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE			
268	300	BAKE 23HRS AT 350-400 WITHIN 4HRS OF CHROME DATE IN TIME IN (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21051N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21051N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040 | PAGE 4 OF 4 PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT TIME OUT *RCC MOVE			
8	110	FINISH GRIND PIN O.D. [illegible]			
[illegible]	[illegible]	[illegible] DATE IN [illegible]			
		DATE OUT [illegible] [illegible]			
[redacted]		[illegible]			
		* * * * * * * * * * * * * * * * * * * *			
[redacted]	[illegible]	[illegible]			
[redacted]	[illegible] *FINAL*	FINAL [illegible] *RCC* -QUE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21051N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21052N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040 | PAGE 1 OF ___ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-93-3 & SUPPLEMENTS	

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
4G135	4-101A	1620001164431 17575A 17576A 17577A 17578A 17687A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		F.P.I. IAW MIL-STD-6866 STRIP ANODIZE IAW MIL-STD-871			
		ANODIZE IAW MIL-A-8625 ALODINE IAW MIL-C-5541 COST: $297.25 ********MAT'L 7075-T73 ALUMINUM*******			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC-			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21052N
		B	D	

21052N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040 | PAGE 2 OF ___ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G13514-101A			
34C5	005	DISASSEMBLE *C/P MOVE		001 MNPGP	
	REQD			002 01 003 SD03	
34D	006	DEGREASE ONLY *C/P MOVE		001 MNPGW	
	REQD			002 02 003 DG02	
[redacted]		*C/P MOVE		001 MNPNA	
	REQD		M	002 05 003 ZY05	
34E	020	E & I I.D. SEAL GROOVE 1.995-1.997 SERVICE LIMIT 2.000		001 MNPGW	
	REQD	O.D. 2.498-2.500 SERVICE LIMIT 2.496 *C/P MOVE		002 04 003 EI01	
34E	030	NICK & BURR REPAIR		001 MNPGW	
		*C/P MOVE		002 04 003 EI01	
26	040	STRIP ANODIZE		001 MNPRC	
		*C/P MOVE		002 03 003 AN04	
[redacted]		*C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)	M	002 02 003 ZA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21052N
		B	D	

21052N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040 | PAGE 3 OF 3 PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. HERE, TAKE PRODUCTION COUNT * Work To Be Accomplished	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * * * * * * * * * * * *			
26	060	ANODIZE TYPE II COMPLETE		001 MNPRC	
		*C/P MOVE		002 03	
				003 AS03	
26	070	ALODINE		001 MNPRC	
		*C/P MOVE		002 03	
				003 TA01	
34C5	080	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
	*REQD	DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
		OF ALL PRECEDING OPERATIONS THIS 958		003 MU06	
34C5	090	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
	REQD	*C/P MOVE		002 01	
				003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21052N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21053N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89069 | PAGE 1 OF ___ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	T.O. 4S1-93-3 4S-1-182 AND SUPPLEMENTS	

10. MDS/DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C-5A-HEO		
13. SERIAL NUMBER	14 NOMEN METERING TUBE BASE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
4613519	9-101A	1620001233790		17575A 17576A 17577A 17578A 17687A			
		GOVERNING DIRECTIVES:		AFLCR 66-51 MANOI 66-3			
		FPI	IAW	MIL-STD-6866			
		IVD PLATE	IAW	MIL-C-83488A			
		FMPI	IAW	MIL-STD-1949			
				P/O N01561			
		SHOTPEEN	IAW	MIL-S-13165			
		CAD-PLATE	IAW	MIL-STD-870 TP II CL II			
		BAKE	IAW	4S-1-182 MAOI 74-12			
		TEMPER ETCH	IAW	MIL-STD-867			
		ALODINE	IAW	MIL-C-5541			
		BLAST	IAW	MIL-STD-1504			
		CHROME PLATE	IAW	MIL-STD-1501			
		GRIND	IAW	MIL-STD-866			
		* * * * * * * * S T E E L * * * * * * * *					
		MAT'L: 4330 200,000-220,000 KSI COST: $711.37					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY					
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL					
		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. (CONTINUED)					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

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21053N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89069 | PAGE 2 OF __ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 METERING TUBE BASE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G13519-101A			
34C5	005	DISASSEMBLE *C/P MOVE		001 MNPGP	
	REQD			002 01 003 SD03	
34C	007	CHEM CLEAN *C/P MOVE		001 MNPGW	
	REQD			002 03 003 SL01	
34B	009	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW	
	REQD			002 03 003 BL07	
34B	011	BAKE 4 HRS AT 350-400F		001 MNPGW	
	REQD	DATE IN_____TIME IN_____ (CONTINUED)		002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE 89087 | PAGE 3 OF _ PAGES

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

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

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOMENCLATURE: METERING TUBE BASE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. DATE OUT WORK TO BE ACCOMPLISHED *C/P MOVE	18. MECHANIC	19. "P"	20. "Q"
34M	018	F.M.P.I. *C/P MOVE		001 MNPNA	
	REQD		M	002 05	
				003 MS03	
34E	020	E & I		001 MNPGW	
	REQD	I.D. 1.251-1.253 SERVICE 1.255 I.D. SEAL GROOVE 1.491-1.493 SERVICE 1.495 O.D. 4.490-4.492 SERVICE 4.488		002 04 003 EI01	
34E	030	O.D. SEAL GROOVE 4.120-4.122 SERVICE 4.118 *C/P MOVE NICK & BURR *C/P MOVE		001 MNPGW	
26	040	VAPOR DEGREASE *C/P MOVE		002 04 003 EI01 001 MNPRC	
26	050	STRIP CAD *C/P MOVE		002 02 003 DG02 001 MNPRC	
26	060	STRIP RUST *C/P MOVE		002 02 003 CS01 001 MNPRC	
8	070	1ST GRIND SEAL GROOVE O.D. AS		002 02 003 CS02 001 MNPRB	
26	080	REQUIRED TO CLEAN UP NOT TO EXCEED A MINIMUM DIMENSION OF 4.108. *C/P MOVE TEMPER ETCH *C/P MOVE		002 02 003 GE02 001 MNPNA	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)	M	002 06 003 TE03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21053N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89069 | PAGE 4 OF __ PAGES

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

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

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

13. SERIAL NUMBER	14 NUMERING TUBE BASE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. Work to be Accomplished	18. MECHANIC	19. "P"	20. "Q"
		HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * * * *			
26B	090	BAKE 4 HRS AT 350-400F WITHIN 8 HRS		001 MNPRC	
		OF ETCH.		002 02	
		DATE IN_____TIME IN_____		003 BK01	
		DATE OUT_____TIME OUT_____*C/P MOVE			
8A	100	F.M.P.I. ; *C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED*		003 ML04	
		HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * * * *			
26	110	VAPOR DEGREASE		001 MNPRC	
		*C/P MOVE		002 02	
				003 DG02	
26	120	SHOTPEEN LOCALLY REWORKED AREA		001 MNPRC	
		0.008-0.013A2 *C/P MOVE		002 01	
				003 SP02	
26	130	SHOTPEEN SEAL GROOVE O.D. 0.008-		001 MNPRC	
		0.013A2		002 01	
		*C/P MOVE		003 SP02	
26	140	PREPARE O.D. SEAL GROOVE FOR CHROME		001 MNPRC	
		PLATE. MASK/FIXTURE/ETC.		002 01	
		MECHANIC SIGNOFF REQUIRED--------->		003 BE01	
		*C/P MOVE			
26	150	PREPARE O.D. SEAL GROOVE FOR CHROME		001 MNPRC	
		PLATE, GRIT BLAST.		002 01	
		*C/P MOVE		003 BL04	
26	160	CHROME PLATE SEAL GROOVE SUFFICIENT		001 MNPRC	
		TO GRIND BACK TO 4.122.		002 01	
		MECHANIC SIGNOFF REQUIRED--------->		003 BL02	
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE 89069 | PAGE 5 OF ___ PAGES

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

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

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOMENCLATURE: NUMBERING TUBE BASE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. TIME OUT WORK TO BE ACCOMPLISHED DATE OUT	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26B	170	BAKE 4 HOURS AT 350-400 DEG F		001 MNPRC	
		WITHIN 4 HOURS OF CHROME.		002 02	
		TIME IN_____DATE IN_____		003 BK02	
		TIME OUT_____DATE OUT_____			
		*C/P MOVE			
8	180	FINISH GRIND SEAL GROOVE TO 4.122-		001 MNPRB	
		4.120 16 RMS.		002 02	
		*C/P MOVE		003 GB02	
26B	190	BAKE 4 HOURS AT 350-400 DEG F		001 MNPRC	
		DATE IN_____TIME IN_____		002 02	
				003 BK02	
		DATE OUT_____TIME OUT_____			
		*C/P MOVE			
26	200	CAD PLATE ALL AREAS NOT CHROME		001 MNPRC	
		PLATED.		002 03	
		*C/P MOVE		003 CA01	
26B	210	BAKE 23 HRS AT 350-400F WITHIN 4 HRS		001 MNPRC	
		OF CAD		002 02	
		DATE IN_____TIME IN_____		003 BK01	
		DATE OUT_____TIME OUT_____			
		*C/P MOVE			
26	220	IRIDITE *C/P MOVE		001 MNPRC	
				002 02	
				003 IR01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

21053N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89069 | PAGE 6 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14. NOMENCLATURE
	METERING TUBE BASE

15. DISPATCH STATION	16. PERF RCC/OP 2ND	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
		F.M.P.I. *C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT		003 ML04	
		* * * * * * * * * * * * * * * * * * * *			
26	240	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 02	
				003 DG02	
				MNPNA	
26A	250	F.P.I.		001 ~~MNPRC~~	
		**********NOTE**********	M	002 03	
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT		003 IV01	
		**********			
		*C/P MOVE			
26	260	IVD PLATE (INITIATED BY PLATING)		001 MNPRC	
		NOTE: IF CHROME REWORK WAS DONE, OPERATION 210 MUST BE ACCOMPLISHED PRIOR TO IVD OPTION.		002 03	
		*C/P MOVE		003 IV01	
26	270	ALODINE IVD PLATED AREAS		001 MNPRC	
		(INITIATED BY PLATING)		002 03	
		*C/P MOVE		003 TA01	
34P	280	PAINT *C/P MOVE		001 MNPGP	
		1. CLEAN 4. 1ST COAT PAINT		002 09	
		2. MASK 5. 2ND COAT PAINT		003 WB03	
		3. PRIME			
34C5	290	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 ML06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

21053N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89069 | PAGE 7 OF 7 PAGES

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

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

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 METERING TUBE BASE	

15. DISPATCH STATION	16. PERF RCC/OP SEQ	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
		FINAL PRODUCT TEST/INSPECTION		001 MN	PGR
	REQD	*C/P MOVE		002 01	
				003 MU	06

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

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AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

21055N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040

PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-9S-3/4S-1-182 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
C-5A MAIN LAND [illegible]		17575A 6 7 8
13. SERIAL NUMBER	**14. NOUN**	
	SPLINED SL RING	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	"Q"
FZR 461349	-103A	NSN 1620001213792 C/N 17575A 17576A 17577A 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MAROI 66-3			
		FPI IAW MIL-STD-[illegible]			
		BLAST IAW MIL-[illegible] COST: $1858.94 [illegible]			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL			
		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED [illegible] FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. ************W A R N I N G************ MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21055N
		B	D	455

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

21055N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040

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

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

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

13. SERIAL NUMBER	14. NOUN
	SPLICED SLEEVING

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	ROUTE/TRAVEL			
[redacted]	005	JIGGING/MOUNTING *C/P MOVE		001 MNP GP 002 01 003 SD03	
	REQD				
[redacted]		DEGREASE ONLY *C/P MOVE		001 MNP GW 002 02 003 DG02	
	REQD				
[redacted]		WET BLAST TO CLEAN IF REQUIRED *C/P MOVE		001 MNP GW 002 02 003 BR05	
	REQD				
[redacted]		*C/P MOVE	M	001 MNP GA 002 05 003 ZP05	
	REQD				
[redacted]		SPLICING WIRE 22610/20.009 SERVICE LIMIT 6 900 SPLICE [illegible] SPLICE [illegible]		SP MNP GA 002 [illegible] 003 [illegible]	
	REQD				
		PIAS *C/P MOVE			
[redacted]	040	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 01 003 MU06	
	REQD				
[redacted]	050	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 01 003 MU06	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21055N
		B	D	

21059N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 | PAGE 1 OF ___ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3/4S-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C-5A M.L.G.		17575A 72877A & 17687A
13. SERIAL NUMBER	**14. NOUN**	
	GUAGE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 63714 4694407-101A		NSN C/A 6685002283784 17575A 6685002283784 17576A 17577A	7 8		
		17578A 72877A 17687A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANUI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDERS AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (O/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		[illegible] MANY OF THE FOLLOWING REPAIR PROCEDURES [illegible]			
		WHICH ARE [illegible] PERSONNEL. ADEQUATE [illegible] AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	63714 4694407-101A			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21059N
		B	D	157

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21059N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89040 | PAGE 2 OF 2 PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	SIGHT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[illegible]	005 *RECD*	DISASSEMBLE/REMOVE PROTECTIVE SPRING LOADED COVER & SCREW RETAIN FOR REASSEMBLY *C/P MOVE		001 MN 02 002 01 003 MU21	
[illegible]	010 *RECD*	HAND WASH [illegible]		001 MN 09 002 01 003 MU21	
69	020	PLACE GUAGE IN LATHE & ROLL CRIMP BACK TO REMOVE PLASTIC LENS *C/P MOVE		001 MN 02 002 02 003 LA12	
[illegible]	030	SUMMARY OF PRE-LENS OPERATIONS MARKED, APPLIED 2 COATS OF WHITE ENAMEL PAINT OVER THE METAL TUBE MARKINGS *C/P MOVE		001 MN 02 002 02 003 MU21	
[illegible]	040	ATTACH LENS & GUIDE TO GUAGE & CLAMP TO STATION 69 *C/P MOVE		001 MN 02 002 01 003 MU21	
69	050	INSTALL TUBE & LENS-USE SEALANT MIL-S-8802 AROUND EDGE OF LENS & CRIMP TO RETAIN LENS		001 MN 02 002 01 003 MU21	
[illegible]	060	INSTALL COVER & SPRING CLIP *C/P MOVE		001 MN 02 002 01 003 MU21	
[illegible]	070 *RECD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS WSS		001 MN 09 002 01 003 MU26	
[illegible]	080 *RECD*	FINAL PRECOAT VISUAL INSPECTION *C/P MOVE		001 MN 02 002 01 003 MU26	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21059N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040 | PAGE 1 OF ___ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3/4S-1-182	

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

13. SERIAL NUMBER	14 STORAGE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
G3714 4G94407-101A		6685002283784 17575A 6685002283784 17576A 17577A 17578A 72877A 17687A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC-			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. **********"W A R N I N G"**********			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN			
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	G3714			
		4G94407-101A			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21059N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1 DATE [illegible] | PAGE ___ OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14 GUAGE

15. DISPATCH STATION	16. PERF RCC/OP (MED)	17. DISASSEMBLE/REMOVE PROTECTIVE [illegible]	18. MECHANIC	19.	20.
		SPRING LOADED COVER & SCREW/		002 01	
	REQD	RETAIN FOR REASSEMBLY		003 BE01	
		*C/P MOVE			
34C5	008	HAND WASH *C/P MOVE		001 MNPGP	
				002 01	
	REQD			003 BE01	
69	020	PLACE GUAGE IN LATHE & ROLL CRIMP		001 MNPRA	
		BACK TO REMOVE PLASTIC LENS-		002 02	
		*C/P MOVE		003 LB02	
34P	030	SCRATCH OF THE 2 GREEN OPERATING		001 MNPGP	
		MARKS, APPLY 2 COATES OF WHITE		002 01	
		ENAMEL PAINT OVER THE MAIN & NOSE		003 WE03	
		MARKINGS			
		*C/P MOVE			
34C5	040	ATTACH LENS & TUBE TO GUAGE & RETURN		001 MNPGP	
		TO STATION 69		002 01	
		*C/P MOVE		003 BE01	
69	050	INSTALL TUBE & LENS-USE SEALANT		001 MNPRA	
		MIL-S-8802 AROUND EDGE OF LENS &		002 02	
		CRIMP TO RETAIN LENS		003 BE01	
		*C/P MOVE			
34C5	060	INSTALL COVER & SPRING ASSY		001 MNPGP	
		*C/P MOVE		002 01	
				003 BE01	
34C5	070	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 MU06	
34C5	080	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
		*C/P MOVE		002 01	
	REQD			003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21059N
		B	D	

AFLC FURM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3 & SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C5A MLG		
13. SERIAL NUMBER	14. NOUN	
	STRUT ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
4G11020-107A		1620010054191 17575A			
4G11020-105A		1620010054192 17576A			
4G11020-101A		1620010054193 17577A			
4G11020-103A		1620010054194 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********"W A R N I N G"********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	4G11020-107A 4G11020-105A 4G11020-101A (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	40 P

21058N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 | PAGE 2 OF ___ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		4G11020-103A			
34C5	010	* * * * * M A T C H - U P * * * * * NEW/SERVICEABLE REWORKED NO REWORK YOKE ASSY 21015N		001 MNPGP 002 01 003 MU06	
		BALLSCREW ASSY (2) 21069N BALLSCREW SPROCKET 21037N			
		KNEELING DRIVE GEAR ASSY 21045N UPPER SIDE BRACE ARM 21009N			
		UPPER SIDE BRACE SHAFT 21005N LOWER SIDE BRACE ARM 21013N			
		LOWER SIDE BRACE SHAFT 21006N SIDE BRACE APEX BOLT 21025N			
		RETRACT ARM ASSY 21018N TRUNNION PIN 21019N			
		TRUNNION CROSS BOLT (2) 21024N OUTER CYL ASSY 21001N			
		ANCHOR SHAFT (2) 21034N BALLSCREW CROSS PIN (2) 21051N			
		POSITIONING COLLAR 21016N ANTI ROTATION BOLT (2) (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

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21058N WORK CONTROL DOCUMENT (MEDS) | 1. DATE 89043 | PAGE 3 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		21020N CROSSWIND APEX BOLT 21017N PISTON SUB ASSY			
		21088N SPLINED ORIFICE TUBE 21007N RESTRICTOR			
		21046N SPLINED SLIDE RING 21055N PACKING NUT			
		21062N LOWER BEARING 21040N UPPER BEARING			
		LOCK RING ASSY 21030N COLLAR LOCK INSERT 21035N			
		COLLAR LOCK COLLAR 21026N THRUST BEARING 21041N			
		ROTATION COLLAR 21036N SPLINED TUB NUT 21060N			
		ROLL PIN 21041N ROLL PIN ROUND NUT 21038N			
		HEADLESS APEX PIN 21011N FLUID TRANSFER HOUSING 21048N			
		STEPPED SWIVEL FTG 21091N (INT) SWIVEL FTG (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	AE2

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21058N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89043 | PAGE 4 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		21092N LARGE SWIVEL FTG 21093N GAUGE (2)			
		21059N STRUT HEADER SHEET 000097			
34C5	015 *REQD*	PLACE YOKE UPSIDE DOWN IN YOKE FIXTURE AND INSTALL "O" RING AND THRUST WASHER		001 MNPGP 002 01 005 CC22	
34C5	020 *REQD*	ASSEMBLE BALLSCREWS, SPROCKETS, THRUST BEARINGS, RADIAL BEARINGS AND RETAINERS INTO THE BALLSCREW BORE		001 MNPGP 002 01 003 CC22	
34C5	025 *REQD*	PLACE YOKE ASSY IN PREASSY STAND AND INSTALL OUTER CYL AND ELECT INSERT ACCORDING TO PROPER CONFIGURATION		001 MNPGP 002 01 003 PA04	
34C5	030 *REQD*	PLACE POSITIONING COLLAR ON OUTER CYL AND INSTALL SHAFTS, BRACKETS, ELECT HARNESS ASSY MANIFOLDS AND HYD TUBING IN SEQUENCE		001 MNPGP 002 01 003 PA04	
34C5	035 *REQD*	INSTALL HYD FLEX LINES, CROSSWIND SYSTEM, VALVES AND LOCK CYLS, INSTALL KNEELING SYSTEM AND CHAIN COVER.		001 MNPGP 002 01 003 PA04	
34C5	040 *REQD*	INSTALL ROTATION CYL. CONNECT ALL ELECT LEADS AND COMPLETE ELECT HARNESS ASSY.		001 MNPGP 002 01 003 PA04	
34C5	045 *REQD*	TORQUE ALL HYD LINES, FITTINGS AND TUBING IAW TORQUE VALVE TABLE ON PAGE 9-4 IN T.O. 4S1-93-3		001 MNPGP 002 01 003 PA04	
34C5	050 *REQD*	MOVE STRUT INTO TEST STAND AND SECURE IT. CLEAN I.D. OF OUTER CYL TO REMOVE ANY AND ALL FOREIGN (CONTINUED)		001 MNPGP 002 01 003 FA05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21058N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89043 | PAGE 5 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MATERIAL-- OK TO ASSEMBLE OR CLOSE			
34C5	[redacted] *REQD*	ASSEMBLE ALL ITEMS REQUIRED TO BUILD UP THE O.D. OF THE PISTON SUB ASSY INSTALL SPLIED TUBE ASSY.		001 MNPGP 002 01 003 FA05	
34C5	[redacted] *REQD*	INSURE THAT ALL ALIGNING MARKS ON ALL ITEMS ARE PROPERLY ALIGNED. INSURE THAT ALL TABS ARE LOCKED PROPERLY.		001 MNPGP 002 01 003 FA05	
34C5	[redacted] *REQD*	GREASE I.D. OF OUTER AND UPPER & LOWER BEARINGS AND INSTALL PISTON SUBASSY IN OUTER CYL AND LOCK IN PLACE.		001 MNPGP 002 01 003 PA05	
34C5	[redacted] *REQD*	INSTALL ALL ITEMS USE TO BUILD UP THE TOP END. FILL UPPER CHAMBER WITH 13+/- GALS OF HYD FLUID STROKE STRUT TO REMOVE TRAPPED AIR.		001 MNPGP 002 01 003 FA05	
34C5	[redacted] *REQD*	CHARGE STRUT WITH 2500 +/- PSI IN LOWER CHAMBER AND 475 +/- PSI IN UPPER CHAMBER ALL PRESSURE TO STABILIZE APPROX 30 MIN.		001 MNPGP 002 01 003 FA05	
34C5	[redacted] *REQD*	USING A TOTALIZING VESSEL AT LOWER CHAMBER ALLOWABLE LEAKAGE IS 100 CC IN ONE HR WITH A PRESSURE GAUGE. THERE SHALL BE NO LOSS/GAIN FROM UPPER CHAMBER FOR 1 HR.		001 MNPGP 002 01 003 FA05	
34C5	[redacted] *REQD*	CYCLE STRUT 25 TIMES AT 300 PSI TO CHARGE ALL HYD LINES AND CYLS PERFORM LOW PRESSURE ROTATION TEST AND RECORD PRESSURES:		001 MNPGP 002 01 003 FA05	
		NORMAL ROTATION 0-90 DEGREES_____ NORMAL ROTATION 90-0 DEGREES_____ (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21058N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89043 | PAGE 6 OF 6 PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		LOCKED AT _____ EM9 ROTATION 90-0 DEGREES			
		LOCKED AT _____			
34C5	[illegible] *REQD*	CYCLE CROSSWIND CYLS 25 TIMES AT 3000 PSI AND CHECK ALL HYD LINES AND TUBES THERE SHALL BE NO LEAKAGE AT ANY CONNECTION		001 MNPGP 002 01 003 FA05	
34C5	[illegible] *REQD*	CHECK AND SET THE INTER LOCK SYSTEM SET AND CHECK BALLSCREW RIGGING AND SAFETY WIRE DOG STOPS AND HEX NUTS.		001 MNPGP 002 01 003 FA05	
34C5	[illegible] *REQD*	INSTALL FLUID TRANSFER HOUSING, IN FLIGHT BRAKE SYSTEM, ROLL PIN ASSY, SIDE BRACES, RETRACT ARM, AND TRUNNION PIN.		001 MNPGP 002 01 003 FA05	
34C5	[illegible] *REQD*	CLEAN OFF ALL EXCESS GREASE, OIL AND DIRT FROM ENTIRE STRUT. DECAL AND TOUCH UP PAINT A REQUIRED.		001 MNPGP 002 01 003 FA05	
34C5	[illegible] *REQD*	INSPECT STRUT OVER ALL FOR RUBBING AND CHAFING HYD LINES. WRAP AND PROTECT ELECT CANNON PLUGS.		001 MNPGP 002 01 003 FA05	
34C5	[illegible] *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 FA05	
34C5	[illegible] *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 FA05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

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21060N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	49-1-182 4S1-93-3 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C-5A MLG		17575A

13. SERIAL NUMBER	14. NOUN
	RIGHT MLG

6 7 8

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	"Q"
P/N 4013614-101A		NSN 5310004582848 C/N 17575A ~~17576A~~ 17577A 17578A			
		GOVERNING SPECIFICATIONS: AFLCR 66-31 MANUAL 66-3 I/D PLATE IAW MIL-C-83488A IAW MIL-STD-130			
		P/O N01561 BLAST IAW MIL-STD-1504 IAW MIL-STD-[illegible] IAW 4S-1-182			
		MAIL 74-12 ALCLAD IAW MIL-C-8541 [illegible] STEEL (220-240 KSI) [illegible] 205A T529 QT			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRECAUTIONS AND HAZARDS ASSOCIATED WITH THE SPECIFIED CHEMICAL UNITS (CU'S) IN			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21060N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21060N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89040 | PAGE 2 OF __ PAGES

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	M*UND NUT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES. *REJD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4013614-101A			
	002 *C130*	DISASSEMBLE *C/P MOVE		001 MNFNP 002 01 003 SD03	
[redacted]	*REJD*	[redacted] CLEAN *C/P MOVE		001 MNFSW 002 03 003 SL01	
[redacted]	*REJD*	[redacted] CLEAN JNLT *C/P MOVE		001 MNFSW 002 03 003 SL03	
[redacted]	*REJD*	[redacted] DATE IN _____ TIME IN _____		001 MNFSW 002 03 003 BR03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]	*REJD*	(ANY CRACKING SHALL BE CAUSE FOR CONDEMNATION.) *C/P MOVE	M	001 MNFNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21060N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21060N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89040 | PAGE 3 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	ROUND NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	E AND I: VISUAL INSPECT & HAND POLISH NICKS AND BURRS *C/P MOVE		001 MNF 002 04 003 EI01	
26	022	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 02 003 DG01	
26	024	STRIP CAD *C/P MOVE		001 MNFRC 002 02 003 CS01	
26	026	STRIP RUST *C/P MOVE		001 MNFRC 002 02 003 [illegible]	
26	028	PRIOR TO CAD/JU, GRIT BLAST ALL AREAS TO BE CAD/JU PLATED *C/P MOVE		001 MNF 002 .. 003 GB02	
26	030	CAD PLATE DATE OUT ___ TIME OUT ___ *C/P MOVE		001 MNF 002 03 003 CA01	
26	040	BAKE 23 HRS AT 375-400 DEG F MIN 4 HRS OF DAS DATE IN ___ TIME IN ___		001 MNF 002 .. 003 BA04	
		DATE OUT ___ TIME OUT ___ *C/P MOVE			
26	050	IRIDITE *C/P MOVE		001 MNFRC 002 02 003 IR01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)	M	001 MNFNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21060N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21060N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 | PAGE 4 OF 4 PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	ROUND OUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19 "P"	20. "Q"
		HERE, TAKE PRELIM ION COUNT *			
25	062	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MN 002 03 003 T	
26	064	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MN 002 03 003 T	
	070 *HOLD*	PRINT AS REQ'D *C/P MOVE		001 MN 002 03 003 T	
	080 *ROUND*	FINAL ACCEPTANCE OF WORK PER ALL DOCUMENT PLA COMPLETENESS & ACCURAC OF ALL PRECEDING OPERATIONS PER		001 MN 002 03 003 MU	
	090 *RELEASE*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 P 002 Q 003 T	01

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21060N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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21062N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89040 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182/4S1-93-3 DWG 401243?-105A	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C5 MLS		17575A 6

13. SERIAL NUMBER	14. NOUN
	PACKING NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
P/N 401343?-105A		NSN 4730011819672	L/N 17575A ~~17576A~~ 12547A 12570A				7 8
		GOVERNING SPECIFICATION		AFLCR 66-21 MANU 66-3			
		IVD PLATE	IAW	MIL-C-[illegible]			
		BLUEING	IAW	MIL-C-5541			
		PMPI	IAW	MIL-STD-1949 P/O 001581			
		TEMPER ETCH	IAW	MIL-STD-867			
		SHOT PEEN	IAW	MIL-S-13165			
		DAD PLATE	IAW	MIL-STD-870 IP II CL 21			
		BLAST	IAW	MIL-STD-15[illegible]			
		RAKE	IAW	4S-1-192 MAJI 74-11			
		MAT'L: 300M 280,000-300,000 PSI COST: $438.06 ALL PERSONNEL [illegible]					
		[illegible] HAVE BEEN INSTRUCTED TRAINED AND FAMILIAR WITH ALL [illegible]					
		THE BASIC [illegible] AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH					
		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVED) FOR MOVES BETWEEN OPERATIONS/DISPATCH					
		STATIONS. **********W A R N I N G********** MANY OF THE FOLLOWING REPAIR (CONTINUED)					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21062N
		B	D	42t

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS			
		DELTA STAMP			
	001	4010907-105A			
	002 *REQD*	[illegible] *C/P MOVE		001 MNRNA 002 05 003 MS03	
[redacted]	*REQD*	[illegible] *C/P MOVE		001 MNRNA 002 05 003 MS03	
[redacted]	*REQD*	[illegible] DATE IN _____ TIME IN _____		001 MNRNA 002 05 003 MS03	
		DATE OUT _____ TIME OUT *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNRNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21062N
		B	D	

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

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

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

13. SERIAL NUMBER	14. NOUN
	PACKING NUT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	VISUAL INSPECT ROUTE FOR MODIFICATION IF REQUIRED *C/P MOVE		001 MNHRSW 002 04 003 EI01	
[redacted]		NICK & BURR REPAIR *C/P MOVE		001 MNHRSW 002 04 003 LI01	
26	042	VAPOR DEGREASE *C/P MOVE		001 MNHRRC 002 36 003 DG01	
25	044	STRIP GAS *C/P MOVE		001 MNHRRC 002 02 003 [illegible]	
25	046	STRIP RUST *C/P MOVE		001 MNHRRC 002 02 003 SR02	
27	050	MACHINE MODIFY PUT IAW EWO 4021340 *C/P MOVE		001 MNHRRN 002 02 003 MF30 004 IS [illegible]	
				[illegible]	
[redacted]		DATE OUT TIME OUT *C/P MOVE * * * * * * * * N O T E * * * * * * * *		[illegible] 003 TE03	
		IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT * * * * * * * * * * * * * * * * * *			
28A	070	BAKE 4 HRS AT 350/400 DEGREES WITHIN 4 HRS OF ETCH DATE IN_____ TIME IN_____ (CONTINUED)		001 MNHRRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21062N
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1. DATE 89040

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT________TIME OUT________ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED MARK, TAKE PRODUCTION COUNT *	M	001 MN 002 06 003 M[illegible]	NA 4
		* * * * * * * * * * * * * * * * *			
26	080	VAPOR DEGREASE *C/P MOVE		001 MN 002 03 003 [illegible]	RC [illegible]
26	090	[illegible] REWORKED AREAS 0[illegible]0.010A *C/P MOVE		001 MN 002 01 003 SP	RC [illegible]
26	095	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MN 002 01 003 BL	RC 2
26	100	[illegible] TYPE II CLASS II DATE OUT______TIME OUT______ *C/P MOVE		[illegible]	[illegible]
[illegible]	110	BA[illegible] OF [illegible] DATE IN______ TIME IN______		001 [illegible] 002 [illegible] 003 BR	 1
		DATE OUT______TIME OUT______ *C/P MOVE			
26	120	IRIDITE (CHROMATE CONVERSION COAT- ING) *C/P MOVE		001 MN 002 02 003 IR	RC 01

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

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...K CONTROL DOCUMENT (MEDS)

...QUANTITY

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4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

8. TECH DATA	9. ITEM SERIAL NO.

11 STOCK ... NUMBER

12 OPTIONAL

14

17

WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
*C/P MOVE * * * * N O T E * * * * * * * NDI OPERATION IS COMPLETED* TAKE PRODUCTION COUNT * * * * * * * * * * * * * * *	M	001 [illegible] 002 06 003 ALO	MB 4
[illegible] BY PLATING) *C/P MOVE		001 [illegible] 002 [illegible] 003 [illegible]	[illegible] 1
IVD PLATED AREAS [illegible] BY PLATING) *C/P MOVE		[illegible] MA 002 [illegible] 003 [illegible]	KG
[illegible] *C P MOVE		001 [illegible] 002 [illegible] 003 [illegible]	[illegible] 1
REIDENTIFY TO 4013-27-1050 [illegible]		001 M[illegible] 002 0[illegible] 003 [illegible]	[illegible] 3
ACCEPTANCE OF WORK CONTROL [illegible] FOR COMPLETENESS & ACCURACY *RECORDING [illegible]		[illegible]	[illegible]
[illegible]		[illegible]	[illegible]

22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
	C	21062N
	D	

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21069N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89043 | PAGE 1 OF __ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED
74652A		ANPC*		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
4694034-101A		

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C5A MLG	1430001436466	LG 3-2-80-3 46-1-180 AND SUPPLEMENTS

13. SERIAL NUMBER	14. NOUN
	BALL BEARING ASSY.

74652A

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-31 MANO1 66-3 ALL PERSONNEL INVOLVED IN THE WORK			
		PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY REVIEWED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION			
		WITH THIS DOCUMENT. *COMPONENTS WILLBE THOROUGHLY CLEANED & PROTECTED FROM MOISTURE BETWEEN OPERATIONS IF REQUIRED			
		STATIONS. WARNING MANY OF THE FOLLOWING			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. APPROVED SAFETY AND			
		*SEAL JOINT MUST BE APPLIED TO PRECLUDE MOISTURE *SEAL (MAINTENANCE)			
		COLUMN 16 IS FOR MECH STAMP			
	001	4694034-101A			
	010	*MA-01-02 ----------ROUTED COMPONENTS---------- NEW/SERVICEABLE REWORK NO REWORK (CONTINUED)		001 MNPCP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21069N
		B	D	

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BALLSCREW 21065N BALL NUT			
		21065N DOG STOP 21067N HEX NUT			
		21066N			
[redacted]	010 *RELOD*	INSPECT BALL NUT AND BALLSCREW ARE A MATCHED SET		001 MNHGP 002 01 003 PA0003	
[redacted]	020 *RELOD*	PRE-OVERHAUL INSPECTION INSPECT ALL COMPONENTS FOR GENERAL CONDITION * NOTE * ANY BALL WARNINGS WILL BE		001 MNHGP 002 01 003 LA02	
		REPLACED 100% AT EACH OVERHAUL. REPLACEMENT BALLS MUST HAVE A DIAMETER EQUAL TO OR GREATER THAN THE DIAMETER OF BALLS REMOVED AT DISASSEMBLY.			
[redacted]	030 *RELOD*	INSTALL NEW SEALS IN SCRAPER AND INSTALL A NEW "O" RING ON THE SCRAPER WITH THE "O" RING GROOVE. INSTALL 4 EA SCRAPER DRIVE PINS IN BORE OF BALLNUT		001 MNHGP 002 01 003 LA02 004 PA0003	
[redacted]	040 *REQD*	ASSEMBLE - NOTE: BALLS MUST BE EQUAL TO OR GREATER THAN BALLS REMOVED AT DISASSEMBLY - ALSO, BALLS MUST BE (CONTINUED)	D	001 MNHGP 002 01 003 LA02 004 PA0003	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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1 DATE 89043

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		THE SAME SIZE. (DO NOT MIX SIZES) AND REPLACED 100%			
[redacted]	035 *REQD*	INSTALL SELECTED BALLS IN COUNTER BORE HOLES ONE CIRCUIT AT A TIME. BY DROPING IN SEVERAL BALLS AT A TIME AND [illegible] THE SCREW WHILE		001 MN 002 01 003 LA 004 PA	OP 02 003
		HOLDING NUT [illegible] TO MAKE ROOM FOR MORE BALLS. * * * * * * * N O T E * * * * * * * EACH OF THE TWO OUTER CIRCUITS OF			
		2 2/3 TURNS HOLD FROM 55 TO 57 BALLS. THE CENTER CIRCUIT OF 3-2/3 HOLDS 74 TO 76 BALLS			
[redacted]	[illegible] *REQD*	WHEN CIRCUIT IS FULL INSTALL REMAINDER OF BALLS IN RETURN TUBES FILL BOTH ENDS WITH GREASE TO KEEP BALLS FROM FALLING OUT.		001 MN 002 01 003 LA 004 PA	OP 02 003
		OF THE NUT.			
[redacted]	04[illegible] *REQD*	[illegible] TUBE HOLES OF FILLED CIRCUITS AND PRESS ON [illegible] GENTLY [illegible] OF TUBE IN BOTTOM OF [illegible]		001 MN 002 01 [illegible] [illegible]	OP [illegible] [illegible]
		HOLD IN PLACE WITH [illegible]			
[redacted]	050 *REQD*	LOAD THE COUNTER BORE OF THE CENTER CIRCUIT AND FILL THE LONG TUBE AND GENTLY PRESS INTO BALLNUT. REMOVE TAPE AND HEXNUTS AND POSITION CLAMP		001 MN 002 01 003 LA 004 PA	OP 02 003
		OVER TUBES AND SECURE HEXNUTS.			

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

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1. DATE 89043 | PAGE 4 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14. NOUN
	BALL SCREW ASSY.

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	030	USING A DIAL INDICATOR, CHECK BACK		001 MNHGP	
		LASH APPLY AN AXIAL FORCE OF APPROX		002 Q1	
	REQD	50 LBS. SET DIAL INDICATOR ON FACE		003 LA02	
		OF BALLNUT AND ZERO THE SUM OF		004 PA0003	
		READINGS MUST NOT EXCEED 0.040			
[redacted]	040	SAFETY WIRE THE NUTS SECURING		001 MNHGP	
		THE DEFLECTOR YOKES. APPLY SEALER		002 Q1	
	REQD	AROUND BALL RETURN TUBES WITH		003 LA02	
		PR-1422 A2 OR EQUIVALENT AND ALLOW		004 PA0003	
		TO CURE 24 HOURS.			
[redacted]	050	INSTALL A NEW TO DEVICE ASSY AND		001 MNHGP	
		FILL BALLNUT WITH GREASE (B12.2)		002 Q1	
	REQD	UNTIL A SMALL AMOUNT COMES OUT THE		003 LA02	
		OUTLET OF BALLNUT.		004 PA0003	
[redacted]	060	FUNCTIONAL TEST ROTATE BALLNUT BY		001 MNHGP	
		HAND THROUGH ONE FULL STROKE IN		002 Q1	
	REQD	BOTH DIRECTIONS. THE UNIT SHOULD		003 LA02	
		ROTATE SMOOTHLY WITH EQUAL EFFORTS IN		004 PA0003	
		ALL PLANES OF TRAVEL			
[redacted]	070	APPLY A THIN COAT OF CORROSION PREVENT		001 MNHGP	
		BLOCK TO ENTIRE LENGTH OF SCREW.		002 Q1	
	REQD	APPLY A COAT OF EMRALON AMS - 3136		003 LA02	
		NO 310 OR EQUIVALENT TO THE TOP 2.5		004 PA0003	
		INS OF SCREW.			
[redacted]	080	FINAL ACCEPTANCE OF WORK CONTROL		001 MNHGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 Q1	
	REQD	ALL PRECEDING OPERATIONS THIS 958.		003 LA02	

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

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X U.S. GOVERNMENT PRINTING OFFICE: 1980 [illegible]

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	065	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MIN SP 002 01 003 LA02	

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

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CBA from Larry Lawson

1744 HRS/yr for COST SAVINGS.
145 HRS/month for COST SAVINGS.

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
		17575A
13. SERIAL NUMBER	14 NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
					6 7 8
		17576A			
		APPLICABLE [illegible] WILL ALWAYS [illegible] WITH [illegible]			
		CLEANED [illegible] MOVES BEHIND [illegible] STATIONS.			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	98.2

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1 DATE	PAGE__OF__PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		BAKE & HRS			
		DATE IN			
		DATE OUT			

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

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1 DATE

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		[illegible] INSPECT FOR DAMAGED		001 MMM	
		[illegible] DAMAGED [illegible]		[illegible]	
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
68	040	MACHINE 4 NEW WRENCHING SLOTS IN			
		DIAMETRICALLY EQUAL [illegible] .625+.000 WITH [illegible] & 45 DEG RELIEF ANGLE [illegible]		[illegible]	
		UP FROM .120 BELOW EACH SLOT 125 RMS FINISH OR BETTER			
69	045	MACHINE EXISTING SERVICABLE SLOTS		001 MMMRA	
		TO A DEPTH OF .120-.2[illegible] & [illegible] .625-.650 WITH A .030 RADIUS & A 45 DEG RELIEF ANGLE OUT EXTENDING UP FROM .120 BELOW EACH SLOT. [illegible]		002 QT 003 MMM2 005 X8745184	

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

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]					
[redacted]					
				001 MNPRC	
				002 01	
				003 SP02	
				001 MNPRC	
				002 01	
				003 BL04	
26		CADMIUM PLATE CLASS II TYPE II		001 MNPRC	
				003 CA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21038N

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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21039N				

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	117	PAINT			
	REQD 120	*C/P MOVE FINAL ACCEPTANCE OF WORK		002 QP 003 MUQS 001 INSPQP	
	REQD 130	DOCUMENT [illegible] OF ALL PRECEDING OPERATIONS FINAL PRODUCT VISUAL INSPECTION		002 QP 002 MUQS 001 INSPQP	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 003 MU06
		B	D	21039N

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21040N			82045	

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
	49-1-192	

13. SERIAL NUMBER	14 NOUN

17575A 6 7 8

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		17576A			
		CLEANED & PREPELLED (OR MOVES BETWEEN OPERATIONS			
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS SHOULD BE TAKEN TO AVOID INJURIES. (CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATED BY SIGNATURE/DATE		23. DOCUMENT/SN
		B	C	
		B	D	21040N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (MEDS)

1 DATE

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
[redacted]			990-5	2

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WORD (MANDATORY REQUIREMENT) IN COLUMN 20 IS AVAILABLE TO ALTA USERS.			
[redacted]		[redacted] *C/P MOVE*		[redacted]	
[redacted]	[redacted]	[redacted]		[redacted]	
[redacted]		[redacted]		[redacted]	
[redacted]	[redacted]	[redacted]		[redacted]	
[redacted]		[redacted]		[redacted]	
[redacted]		NICK & BURR SURFACE DEFECTS		001 MNPSW	
[redacted]		*C/P MOVE*		002 04 003 EI01	
[redacted]	[redacted]	ALODINE REWORKED AREAS *C/P MOVE*		001 MNPRC	
[redacted]				002 03 003 IA01	
[redacted]	129	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPSP	
		DOCUMENT ALL PRECEDING OPERATIONS THIS 958		002 MU03	
				003 MU06	

21. FINAL DESTINATION DISPATCH STATION	FUNCTIONAL CODE	COORDINATING/ESTIMATING RCC SIGNATURE/DATE		22 DOCUMENT/SN
		B	D	21040N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

987

WORK CONTROL DOCUMENT (MEDS)

1 DATE	PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
21040N				

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

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

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

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21040N

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1 DATE

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
21041N				

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN

17575A

6

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
					7
		17576A*			8
		CLEANED & [illegible] MOVES BETWEEN [illegible] DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS [illegible] TO PREVENT INJURIES. (CONTINUED)			

21. FINAL DESTINATION		22. [illegible] COORDINATION/INSPECTION/QCB SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	C		
		D		21041N

WORK CONTROL DOCUMENT (MEDS)

1 DATE [redacted] PAGE [redacted] OF [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21041N			82035	2 2

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		[illegible] MANDATORY [illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
69	025	MACHINE THRUST BEARING TO PRE-			
		[illegible]			
		[illegible]			
	045	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
	RECD	DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
		OF ALL PRECEDING OPERATIONS THIS WSB		003 MUQ6	
	040	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
	RECD	*C/P MOVE		002 01	
				003 MUQ6	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	21041N

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☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-183

21043N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-93-3 AND SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 EQUATION STOP TUBE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		1620001299168 17575A 17577A 17578A 17687A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-6866 SHOTPEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625			
		ALODINE IAW MIL-C-5541 COST: $1519.25 *****MAT'L: ALUMINUM 7075-T73*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLIC-			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21043N
		B	D	

AFLC FORM 958 NOV 80

WORK CONTROL DOCUMENT (MEDS)

1. DATE	PAGE
[redacted]	[redacted]

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

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

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 PISTON STOP TUBE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. PRECAUTIONS MUST BE EMPLOYED TO	18. MECHANIC	19. "P"	20. "Q"
		PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4612409-101B			
34C5	005	DISASSEMBLE *C/P MOVE		001 MNPGP	
	REQD			002 01 003 SD03	
34D	006	DEGREASE ONLY *C/P MOVE		001 MNPGW	
	REQD			002 02 003 DG02	
[redacted]		*C/P MOVE		001 MNPNA	
	REQD		M	002 05 003 ZY05	
34E	020	E AND I INSPECT		001 MNPGW	
	REQD	UPPER END O.D. 8.680 MIN *C/P MOVE		002 04 003 EI01	
34E	030	NICK AND BURR IAW FIG 5-38		001 MNPGW	
		T.O. 4S1-93-3 *C/P MOVE		002 04 003 EI01	
26	045	STRIP ANODIZE		001 MNPRC	
		*C/P MOVE		002 03 003 AN04	
[redacted]		*C/P MOVE		001 MNPNA	
		* * * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)		003 ZA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21043N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1. DATE 89035 | PAGE 3 OF 3 PAGES

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

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

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. PISTON STOP TUBE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. Work to be accomplished	18. MECHANIC	19. "P"	20. "Q"
		HERE, TAKE PRODUCTION COUNT			
		* * * * * * * * * * * * * * * * * * * *			
26	060	SHOT PEEN REWORKED AREAS		001 MNPRC	
		.008-.012 A		002 01	
		*C/P MOVE		003 SP01	
26	070	ANODIZE IAW MIL-A-8625 TYPEII		001 MNPRC	
		*C/P MOVE		002 03	
				003 AG03	
26	075	ALODINE		001 MNPRC	
		*C/P MOVE		002 03	
				003 TA01	
69	079	MACHINE PIN IAW DWG 4G19051		001 MNPRA	
		*C/P MOVE		002 02	
				003 LB02	
69	080	INSTALL PIN IAW		001 MNPRA	
		DWG 4G19051		002 02	
		*C/P MOVE		003 BB01	
34 C5	090	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
	REQD	DOCUMENT FOR COMPLETENESS & ACCURACY		002 01	
		OF ALL PRECEDING OPERATIONS THIS 958		003 MU06	
34 C5	100	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
		*C/P MOVE		002 01	
	REQD			003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SER
DISPATCH	FUNCTIONAL CODE	A	C	21043N
		B	D	

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[redacted] WORK CONTROL DOCUMENT (MEDS)

1. DATE

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		451-02		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
C-5A MLG	451-93-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
	[illegible]	17575A

13. SERIAL NUMBER	14. NOUN

15. P/N DISPATCH STATION	16. PERF RCC/OP NO.	17. NSN C/N WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
[redacted]		1620003[redacted]		6	
		17576A 17577A 17578A		7	
		GOVERNING DIRECTIVES: AFLCR 66-31 [illegible]			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND [illegible]		8	
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC[illegible]			
		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY [illegible]			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *** WARNING *** [illegible]			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & MATERIALS WHICH ARE POTENTIALLY [illegible]			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN BLOCK 1A SERVES THE SAME PURPOSE AS			
	001	DELTA STAMP 4G11416-101B			
	005A	Disassembly			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	994

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★ U.S. GOVERNMENT PRINTING OFFICE 1980—[illegible]

3 Aug 89

1. Wheels operation - okay

2. Brakes operation - okay

3. MLG STRUTS - Loading up this afternoon 3 Aug. 89.

4. Brakes operation files - look good

5. Wheels operation files - look good.

6. WRITE Para on Surge

7. Write Para on Non. Process IMPROVEMENT OPPORTUNITIES.

21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043 | PAGE 3 OF __ PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		21020N CROSSWIND APEX BOLT 21017N PISTON SUB ASSY			
		21088N SPLINED ORIFICE TUBE 21007N RESTRICTOR			
		21046N SPLINED SLIDE RING 21055N PACKING NUT			
[redacted]		21062N LOWER BEARING 21040N UPPER BEARING			
		LOCK RING ASSY 21030N COLLAR LOCK INSERT 21035N			
		COLLAR LOCK COLLAR 21026N THRUST BEARING 21041N			
		ROTATION COLLAR 21036N SPLINED TUB NUT 21060N			
		ROLL PIN 21041N ROLL PIN ROUND NUT 21038N			
		HEADLESS APEX PIN 21011N FLUID TRANSFER HOUSING 21048N			
[redacted]		STEPPED SWIVEL FTG 21091N. (INT) SWIVEL FTG (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

21058N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 | PAGE 4 OF ___ PAGES

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

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

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

13. SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		21093N LARGE SWIVEL FTG 21093N GAUGE (2)			
		21059N STRUT HEADER SHEET 000097			
34C5	015 *REQD*	PLACE YOKE UPSIDE DOWN IN YOKE FIXTURE AND INSTALL O" RING AND THRUST WASHER		001 MNPGP 002 01 005 CC22	
34C5	020 *REQD*	ASSEMBLE BALLSCREWS, SPROCKETS, THRUST BEARINGS, RADIAL BEARINGS AND RETAINERS INTO THE BALLSCREW BORE		001 MNPGP 002 01 003 CC22	
34C5	025 *REQD*	PLACE YOKE ASSY IN PREASSY STAND AND INSTALL OUTER CYL AND ELECT INSERT ACCORDING TO PROPER CONFIGURATION		001 MNPGP 002 01 003 PA04	
34C5	030 *REQD*	PLACE POSITIONING COLLAR ON OUTER CYL AND INSTALL SHAFTS, BRACKETS, ELECT HARNESS ASSY MANIFOLDS AND HYD TUBING IN SEQUENCE		001 MNPGP 002 01 003 PA04	
34C5	035 *REQD*	INSTALL HYD FLEX LINES, CROSSWIND SYSTEM, VALVES AND LOCK CYLS, INSTALL KNEELING SYSTEM AND CHAIN COVER.		001 MNPGP 002 01 003 PA04	
34C5	040 *REQD*	INSTALL ROTATION CYL. CONNECT ALL ELECT LEADS AND COMPLETE ELECT HARNESS ASSY.		001 MNPGP 002 01 003 PA04	
34C5	045 *REQD*	TORQUE ALL HYD LINES, FITTINGS AND TUBING IAW TORQUE VALVE TABLE ON PAGE 9-4 IN T.O. 4S1-93-3		001 MNPGP 002 01 003 PA04	
34C5	050 *REQD*	MOVE STRUT INTO TEST STAND AND SECURE IT. CLEAN I.D. OF OUTER CYL TO REMOVE ANY AND ALL FOREIGN (CONTINUED)		001 MNPGP 002 01 003 PA05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

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21058N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 | PAGE 5 OF 6 PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	STRUT ASSY

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "O"
		MATERIAL-- OK TO ASSEMBLE OR CLOSE			
34C5	055 *REQD*	ASSEMBLE ALL ITEMS REQUIRED TO BUILD UP THE O.D. OF THE PISTON SUB ASSY INSTALL SPLIED TUBE ASSY.		001 MNPGP 002 01 003 FA05	
34C5	060 *REQD*	INSURE THAT ALL ALIGNING MARKS ON ALL ITEMS ARE PROPERLY ALIGNED. INSURE THAT ALL TABS ARE LOCKED PROPERLY.		001 MNPGP 002 01 003 FA05	
34C5	065 *REQD*	GREASE I.D. OF OUTER AND UPPER & LOWER BEARINGS AND INSTALL PISTON SUBASSY IN OUTER CYL AND LOCK IN PLACE.		001 MNPGP 002 01 003 PA05	
34C5	070 *REQD*	INSTALL ALL ITEMS USE TO BUILD UP THE TOP END. FILL UPPER CHAMBER WITH 13+/- GALS OF HYD FLUID STROKE STRUT TO REMOVE TRAPPED AIR.		001 MNPGP 002 01 003 FA05	
34C5	075 *REQD*	CHARGE STRUT WITH 2500 +/- PSI IN LOWER CHAMBER AND 475 +/- PSI IN UPPER CHAMBER ALL PRESSURE TO STABILIZE APPROX 30 MIN.		001 MNPGP 002 01 003 FA05	
34C5	080 *REQD*	USING A TOTALIZING VESSEL AT LOWER CHAMBER ALLOWABLE LEAKAGE IS 100 CC IN ONE HR WITH A PRESSURE GAUGE. THERE SHALL BE NO LOSS/GAIN FROM UPPER CHAMBER FOR 1 HR.		001 MNPGP 002 01 003 FA05	
34C5	085 *REQD*	CYCLE STRUT 25 TIMES AT 300 PSI TO CHARGE ALL HYD LINES AND CYLS PERFORM LOW PRESSURE ROTATION TEST AND RECORD PRESSURES:		001 MNPGP 002 01 003 FA05	
		NORMAL ROTATION 0-90 DEGREES_____ NORMAL ROTATION 90-0 DEGREES_____ (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

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1 DATE 89043 | PAGE 1 OF __ PAGES

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

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-93-3 & SUPPLEMENTS	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
C5A MLG		
13. SERIAL NUMBER	14 NOUN	
	STRUT ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
4G11020-107A		1620010054191 17575A			
4G11020-105A		1620010054192 17576A			
4G11020-101A		1620010054193 17577A			
4G11020-103A		1620010054194 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.			
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********W A R N I N G********** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	4G11020-107A 4G11020-105A 4G11020-101A (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

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21058N WORK CONTROL DOCUMENT (MEDS)

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

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

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

13. SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		4G11020-103A			
3405	010	* * * * * M A T C H - U P * * * * * NEW/SERVICEABLE REWORKED NO REWORK YOKE ASSY 21015N		001 MNPGP 002 01 003 MU06	
		BALLSCREW ASSY (2) 21069N BALLSCREW SPROCKET 21037N			
		KNEELING DRIVE GEAR ASSY 21045N UPPER SIDE BRACE ARM 21009N			
		UPPER SIDE BRACE SHAFT 21005N LOWER SIDE BRACE ARM 21013N			
		LOWER SIDE BRACE SHAFT 21006N SIDE BRACE APEX BOLT 21025N			
		RETRACT ARM ASSY 21018N TRUNNION PIN 21019N			
		TRUNNION CROSS BOLT (2) 21024N OUTER CYL ASSY 21001N			
		ANCHOR SHAFT (2) 21034N BALLSCREW CROSS PIN (2) 21051N			
		POSITIONING COLLAR 21016N ANTI ROTATION BOLT (2) (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
TCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

21058N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89043 | PAGE 6 OF 6 PAGES

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

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

MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		LOCKED AT _____ EM9 ROTATION 90-0 DEGREES			
		LOCKED AT _____			
34C5	090 *REQD*	CYCLE CROSSWIND CYLS 25 TIMES AT 3000 PSI AND CHECK ALL HYD LINES AND TUBES THERE SHALL BE NO LEAKAGE AT ANY CONNECTION		001 MNPGP 002 01 003 FA05	
34C5	095 *REQD*	CHECK AND SET THE INTER LOCK SYSTEM SET AND CHECK BALLSCREW RIGGING AND SAFETY WIRE DOG STOPS AND HEX NUTS.		001 MNPGP 002 01 003 FA05	
34C5	100 *REQD*	INSTALL FLUID TRANSFER HOUSING, IN FLIGHT BRAKE SYSTEM, ROLL PIN ASSY, SIDE BRACES, RETRACT ARM, AND TRUNNION PIN.		001 MNPGP 002 01 003 FA05	
34C5	105 *REQD*	CLEAN OFF ALL EXCESS GREASE, OIL AND DIRT FROM ENTIRE STRUT. DECAL AND TOUCH UP PAINT A REQUIRED.		001 MNPGP 002 01 003 FA05	
34C5	110 *REQD*	INSPECT STRUT OVER ALL FOR RUBBING AND CHAFING HYD LINES. WRAP AND PROTECT ELECT CANNON PLUGS.		001 MNPGP 002 01 003 FA05	
34C5	115 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 01 003 FA05	
34C5	120 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 01 003 FA05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH STATION	FUNCTIONAL CODE	A	C	21058N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21035N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE [redacted] OF [redacted] PAGES

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

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	078	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		M	
26	080	CADMIUM PLATE TYPE II CLASS II DO NOT PLATE ACME THREADS DATE OUT_____TIME OUT_____ *C/P MOVE		M	
26B	090	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN TIME IN			
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	100	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		M	
[redacted]		*C/P MOVE * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	K	
		* * * * * * * * * * * * * * * * * * * *			
26	115	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		M	
26	120	ALODINE IVD PLATED AREAS. (INITIATED BY PLATING) *C/P MOVE		M	
[redacted]	130 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		M	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	582

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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21035N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 PAGE [redacted] OF [redacted] PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	COLLAR LOCK INSERT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	140 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		M	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	

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21036N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035 [redacted] PAGE__OF__PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182 4S1-93-3 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
C5A MLG		
13 SERIAL NUMBER	**14 NOUN**	
	ROTATION COLLAR (MLG)	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
P/N 4G13565-101B		NSN 1620004884553 C/N 17575A [redacted] 17577A 17578A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949 P/O N01561			
		TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CAD PLATE IAW MIL-STD-870 PHOSPHATE TREATMENT IAW DOD-P-16232			
		P/O N73061 TYPE M CLASS 4 BAKE IAW 4S-1-182 MAOI 74-12			
		MAT'L: 300M 280,000-200,000 KSI COST: $1016.61 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMNET			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND			
		T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE APPLI-CABEL T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH			
		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH			
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21036N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-183

21036N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89035 | PAGE 2 OF [redacted] PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	ROTATION COLLAR (MLG)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PERCAUTIONS MUST BE EMPLOYED TO PRECLUDE INJUIRES. *REQD* (MANDATORY REQUIREMENT) IN			
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G13565-101B			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		M	
[redacted]	*REQD*	DEGREASE ONLY *C/P MOVE		M	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		M	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____			
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	K	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21036N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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21036N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035 | [redacted] PAGE__OF__PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	ROTATION COLLAR (MLG)

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	E & I IAW 4S1-93-3 FIG 5-28 REMOVE MINOR NICKS AND DEFECTS. *C/P MOVE			
26	025	VAPOR DEGREASE *C/P MOVE			
26	030	STRIP CAD *C/P MOVE			
26	035	STRIP RUST *C/P MOVE			
[redacted]		TIME OUT_____DATE OUT_____ *C/P MOVE	M	K	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	050	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF TEMPER ETCH DATE IN_____TIME IN_____			
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	K	
		* * * * * * * * * * * * * * * * * * * *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21036N
		B	D	506

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21036N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89035 | PAGE 4 OF [redacted] PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	ROTATION COLLAR (MLG)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 [redacted]	063	VAPOR DEGREASE *C/P MOVE			
26 [redacted]	065	GRIT BLAST SPLINES TO REMOVE CORROSION *C/P MOVE		M	
26 [redacted]	070	SHOT PEEN ALL NICK & BURRED AREAS INTENSITY OF .008/.012 A2 NOTE: DO NOT PEEN THREADS *C/P MOVE		M	
26 [redacted]	080	SHOT PEEN REWORKED THREADS INTENSITY OF .005/.010 A2 SHOT SIZE 110 *C/P MOVE		M	
26 [redacted]	085	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		M	
26 [redacted]	090	CADMIUM PLATE TYPE II CLASS II (EXCEPT EXTERNAL SPLINE) 2.3 SQ FT AT 115-161 AMPS TIME OUT_____ DATE OUT_____		M	
		*C/P MOVE			
26B [redacted]	100	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN_____ TIME IN_____			
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)	M	K	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21036N
		B	D	

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21036N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035 | PAGE 5 OF [redacted] PAGES

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

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	ROTATION COLLAR (MLG)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		HERE, TAKE PRODUCTION COUNT *			
26	113	VAPOR DEGREASE *C/P MOVE			
26	117	PRIOR TO PHOSPHATE, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED *C/P MOVE		M	
26	120	PHOSPHATE EXTERNAL SPLINE *C/P MOVE		M	
26B	130	BAKE 8 HRS AT 210-225F IAW DATE IN_____TIME IN_____			
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	140	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		M	
[redacted]	150 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLTENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		M	
[redacted]	160 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		M	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21036N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1. DATE [illegible]

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2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
[illegible]			[illegible]035	[illegible]

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
	4S-1-[illegible] [illegible]	[illegible] 3 AND SUPPLEMENT [illegible] 17575A

13. SERIAL NUMBER	14 NOUN
[illegible]	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
P/N		NSN P/N			6
[illegible]	[illegible]	[illegible] 17575A 17576A 17577A [illegible]JA			7
					8
		******* UNIT COST: [illegible] *******			
		GOVERNING LINES [illegible] AFLCR [illegible] [illegible] [illegible] PLATE IAW MIL-[illegible] [illegible] IAW [illegible]			
		[illegible] SHOT PEEN IAW MIL-S-[illegible] CAD PLATE IAW MIL-STD-870 BAKE IAW 4S-1-[illegible]			
		[illegible] ALODINE IAW MIL-C-5541 MAT'L: 4[illegible]30 (2[illegible]0,000-240,0[illegible] KSI			
		[illegible]			
		PRACTICES [illegible] THE BASIC TECHNICAL [illegible] T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS			
		WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE [illegible]			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING/CERTIFICATION SIGNATURE/DATE		23. DOCUMENT/SN
		PROCEDURES REQUIRE THE USE OF (CONTINUED)		
		B	D	21037N 564

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WORK CONTROL DOCUMENT (MEDS)

1 DATE	PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
21037N			[redacted]	[redacted]

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

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

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EXERCISED TO PREVENT INJURIES.			
		REQ (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO VALID STEP.			
		[illegible]			
[redacted]		[illegible]			
	REQD				
[redacted]		[illegible]			
	REQD				
[redacted]		BLAST CLEAN			
	REQD				
[redacted]		BAKE 4 HRS AT 350-400F		001 MNFNA	
	REQD	DATE IN _____ TIME IN _____		002 QA 002 BKQ2	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
[redacted]		*C/P MOVE		001 MNFNA	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
REQ				003 MS03
		B	D	21037N

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WORK CONTROL DOCUMENT (MEDS)

1 DATE	PAGE ___ OF ___ PAGES

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

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

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]				001	
				003	
		*C/P MOVE			
		*C/P MOVE		001	
	060	CADMIUM PLATE TYPE II CLASS II		001	
	070	TIME OUT _____ DATE OUT _____ *C/P MOVE BAKE 23 HRS AT 350-400F WITHIN 4 HRS		002 003 001	
		OF CAD DATE IN _____ TIME IN _____		002 003 BK01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
		ABOVE	C	
		B	D	21037N

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WORK CONTROL DOCUMENT (MEDS)

1. DATE	PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
21037N			8/0 25	4 /

7. [illegible] NUMBER	8. TECH DATA	9. ITEM SERIAL NO

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

15. DISPATCH STATION	16. PERF RCC OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		[illegible] WORK TO BE ACCOMPLISHED			
		IRIDITE-CHROMATE CONVERSION COATING		021	
		MASK AREAS			
		** [illegible] ** IF LAST MEG OPERATION IS COMPLETED MEDS TAG REQUIRED **	M	003	
		[illegible] BY PLATOON MASK AREAS			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT
		B	D	21037N

FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED