

# AD-A237 113



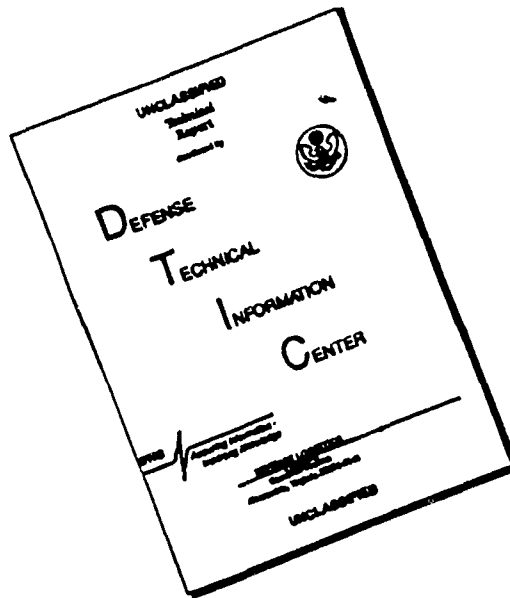
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Form Approved  
OMB No 0704-0188

Public reporting burden for this collection of information is estimated to average 1 hour per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204 Arlington, VA 22202-4302 and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503

1. AGENCY USE ONLY (Leave blank)	2. REPORT DATE 1 Sep 89	3. REPORT TYPE AND DATES COVERED Aug 88 - Sept 89	
4. TITLE AND SUBTITLE Technology Insertion (TI)/Industrial Process Improvement (IPI) Task Order No. 1  Data Base Documentation Book for OC-ALC/MABPAB (Sheet Metal)			5. FUNDING NUMBERS  Contract
6. AUTHOR(S)  McDonnell Douglas Missile Systems Company			
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES)  McDonnell Douglas Missile Systems Company St. Louis, Missouri 63166			8. PERFORMING ORGANIZATION REPORT NUMBER  F33600-88-D-0567
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)  HQ AFLC/LGME WPAFB OH 45433			10. SPONSORING/MONITORING AGENCY REPORT NUMBER  F33600-88-D-0567
11. SUPPLEMENTARY NOTES  Prepared in cooperation with OC-ALC & HQ AFLC			
12a. DISTRIBUTION/AVAILABILITY STATEMENT  Distribution Statement A			12b. DISTRIBUTION CODE
13. ABSTRACT (Maximum 200 words)  Technology Insertion (TI)/Industrial Process Improvement (IPI) Data Base Documentation Book Volume, for OC-ALC/MABPAB (Sheet Metal). This document contains detailed information about layouts equipment and processes for this RCC.			
14. SUBJECT TERMS MAINTENANCE, DATABASE, EQUIPMENT, TECHNOLOGY INSERTION, AFLC, AF, MABPAB, METALS, SHEET METALS,			15. NUMBER OF PAGES 554
			16. PRICE CODE
17. SECURITY CLASSIFICATION OF REPORT Unclassified	18. SECURITY CLASSIFICATION OF THIS PAGE Unclassified	19. SECURITY CLASSIFICATION OF ABSTRACT Unclassified	20. LIMITATION OF ABSTRACT Unclassified

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

**DATABASE DOCUMENTATION BOOK**

**OC-ALC**

**MABPAB**

**CONTRACT SUMMARY REPORT  
11 SEPTEMBER 1989**

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

Approved for	
by	
on	
for	
initial	
A-1	



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

Distribution Statement A. Approved for public release;  
distribution is unlimited.

**91-02814**



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Memo To: MASE  
MAB

11 April 1989

Subject: Technology Insertion (TI) Project

1. I attended a TI Technical Coordination meeting at McDonnell Douglas Missile System Company (MDMSC), St. Louis, Mo. from 28-30 Mar 89. The attached MAWF memo gives full details on attendees and agenda items.
2. MDMSC personnel returned to OC-ALC/Tinker AFB on 31 Mar 89 to resume gathering data for TASK Order #1 (Process Characterization). Their target completion date for this phase has been extended to Sept 89, however, MDMSC has agreed to complete the MAEPAB Sheetmetal Shop Process Characterization through experimentation by 15 Jun 89 to facilitate our planned move. MDMSC began work on the additional information for MAEPAB on 3 Apr 89. Attached is the first week status report completed by MDMSC representatives indicating a start and due date for each required profile element.
3. MDMSC Deputy Program Manager, Lou Mavros and Model Development and Experimentation Manager, Mike McCoy plan to visit Tinker AFB on 12 and 13 April. (See attached MDMSC Organization Chart). We have scheduled time on MAB calendar to meet with them at 14:00 hours 13 Apr 89. They have a program briefing and can answer questions on the simulation model.

*Earl E. Stamps*  
EARL E. STAMPS, Chief  
MISTR Planning Resources &  
Standards Unit

3 Atch

1. MAWF Memo, 3 Apr 89
2. MAEPAB Status, 7 Apr 89
3. MDMSC TI Org Chart

**TECHNOLOGY INSERTION**

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**EARL'S WISH LIST**

- DECREASE FLOW TIMES
- DECREASE SPACE REQUIREMENT
- DECREASE LABOR HOURS
- INCREASE OUTPUT
- IMPROVE CONTROL/ORG. STRUCTURE

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E. STAMP  
07 JUNE 1989

**AFLC/MDMSC**

**TECHNOLOGY INSERTION**

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**PROBLEM STATEMENT:**

**HOW TO RELOCATE MABPAB (SHEETMETAL SHOP) FROM**

**ITS CURRENT 95,000sq ft. FACILITY TO A 60,000 sq ft.**

**FACILITY AND MAINTAIN FY-90 WORKLOAD & SURGE CAPACITY**

**E. STAMP**

**07 JUNE 1989**

**AFLC/MDMSC**

## EXECUTIVE SUMMARY.

### BACKGROUND

#### RELOCATION OF MABPAB SHEET-METAL SHOP

- After the Nov 84 Fire the sheet-metal shop moved to building 95.
- DS WAREHOUSE AT 98% SATURATION
- CC INSTRUCTED MA TO VACATE MABPAB by Sep 89.
- MA Directed establishment of a Facility Plng. Group.
- Relocation of MABPAB to building 2101
- Current space in Bldg 95 is 95,000 SF
- Available space in Bldg 2101 is 61,000 SF.

# MABPAB

## OVERVIEW

THE SHEET METAL BACK SHOP RELOCATED TO BLOC 95  
AFTER THE NOV 84 FIRE. AND SHARES SPACE WITH:

MABPAB	101,634	SF
DFS SUPPLY	460	SF
SAC ENGINES	13,255	SF
(QUALITY) MAQBA	128	SF
ADMIN	1444	SF
RESTROOMS	1338	SF
UTILITY	541	SF
	<hr/>	
	118,800	SF

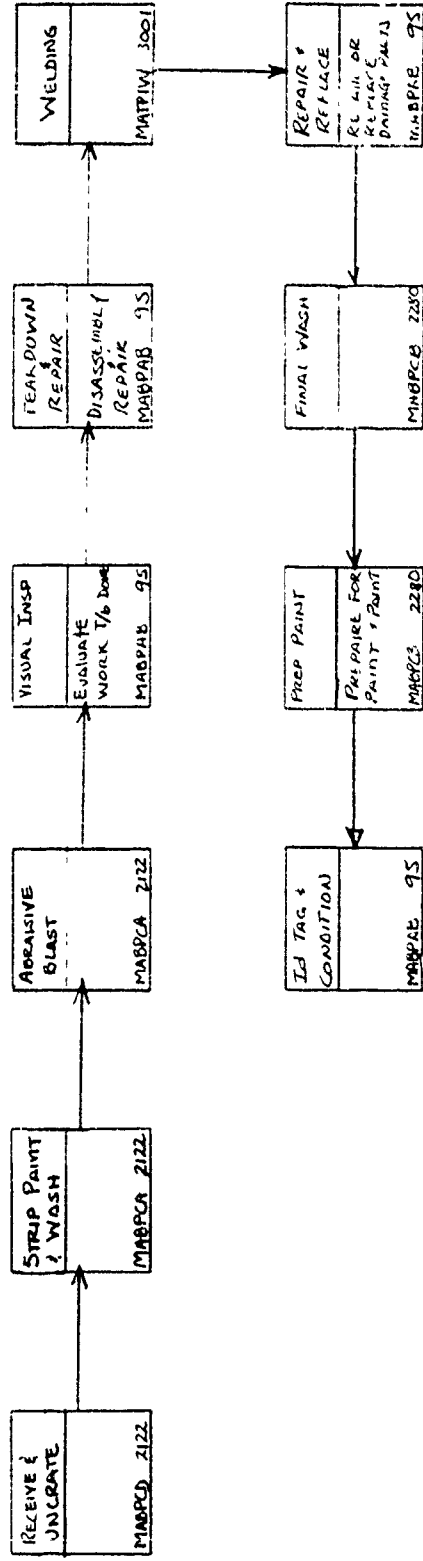
101,634 SF INCLUDES PRODUCTION AREA OF 56,753 SF  
AND PRODUCTION STORAGE 45,259 SF. (TEMPORARY STORAGE)

MABPAB RESTORE PARTS FOR KC 135 AIRCRAFT. THE  
80/20 LIST INCLUDES END ITEMS LIKE:

- COWL (RH & LH PANEL)
- NOSE COWL
- FLAPS / FORE FLAPS
- AILERONS
- DOOR (MLG)
- TAIL CONE
- SLEEVE
- FAIRINGS

# MABPAB PROCESS CHARACTERIZATION.

SIDE COWL PANEL



Equipment

MABPAB FIXTURES

FLIGHT CONTROLS

NAME	PART NO.	QTY	APPLICATION
FILLET FLAP	SC65-1062T1	1	E3A/135
RUDDER	590CJ1130	1	E3A/135
INBD FLAP	SC65-106311	1	E3A
LH/RH ELEVATOR	SC5-96190T1	1	E3A
LH/RH ELEVATOR	590CJ1120	1	135
INBD AILERON	590CJ1010	3	E3A/135
OTBD MAIN FLAP	590CJ1030	1	E3A/135
INBD MAIN FLAP	590CJ1020	1	135
OTBD SPOILER	590CJ1060	1	E3A/135
INBD SPOILER	590CJ1050	1	E3A/135
OTBD AILERON	590CJ1000	3	E3A/135

DOORS

OTBD MLG	590CJ1110	4	E3A/135
INBD MLG	590CJ1100	4	E3A/135

MISC

HOG NOSE FAIRING	65-10607-46	1	135
OTBD ENG STRUT	590CJ1150	1	135
INBD ENG STRUT	590CJ1140	1	135
BOTTOM PANEL TF33 P9	FAJ64-8327-621	1	135
TAIL CONE	762/259	1	135
KNEE CAP FAIRING	TJ5-85654	1	135
BOOM POD FAIRING		1	135
NOSE WHEEL FAIRING	2FAJ5-73139-1	1	135
NOSE WHEEL FAIRING	FRJ5-73139-1	1	135
NOSE WHEEL FAIRNG	FAJ5-73139-1	1	135

COWLING

RH SIDE COWL	SC65-2549T	1	E3A
LH SIDE COWL	SC65-2549T1	1	E3A
RH SIDE COWL J57	3AJ5-85638	2	135
LH SIDE COWL J57	3AJ5-85637	2	135
RH SIDE COWL TF33P5	0C75-64-8327-438	1	135
LH SIDE COWL TF33P5	0C75-64-8327-487	1	135
NOSE COWL	204-70099-3ASMJ	1	E3A
NOSE COWL	204-70099-TRMJ	1	E3A
NOSE COWL J57	AJ5-85655	1	135



MABPAB EQUIPMENT

NAME	MODEL #/TYPE	QUANTITY
BENDING MACHINE (HAND)	416	1
LARGE BAND SAWS		2
ROTEX PUNCH PRESS		1
DRILL (FLOOR MODEL)	1200-118	1
GRINDER FLOOR MODEL, 2 WHEEL ELECT.		1
PRESS BRAKE (CHICAGO STEEL CO.)	000323	1
POWER SQUARING MACHINE	002741	1
PRESS BRAKE	4560G	1
SMALL METAL SHEAR	241-C	1
SMALL DRILL PRESS		1
GRINDER 1 WHEEL, FLOOR MODEL	WG6566	1
PUNCH PRESS	P41P	1
SANDER (BELT) FLOOR MODEL		1
BENDING MACHINE (HAND)	BB-316	1

MABPFF FIXTURES

NAME	PART NO.	QTY
ELEV/RUDDER BALANCE	RP046	1
BOMB BAY DOOR (LARGE)	FME35-30600-3	2
BOMB BAY DOOR (LARGE)	FME35-30600-1	2
BOMB BAY DOOR (LARGE)	FME35-30600-2	2
BOMB BAY DOOR (SMALL)	AJ5-46867-3	1
BOMB BAY DOOR (SMALL)	AJ5-46867-4	2
BOMB BAY DOOR (SMALL)	AJ5-46868-28	1
BOMB BAY DOOR (SMALL)	AJ546868-27	1
BOMB BAY DOOR (SMALL)	AJ5-46867-3	1

MABPFF EQUIPMENT

NAME	MODEL #/TYPE	QUANTITY
DOUBLE SANDER DISK (FLOOR MODEL)		1
DRILL PRESS (FLOOR MODEL)		4
GRINDING MACHINE	WISSOTA E8M	1
WELDER	MILLER 330ST	1
BRAKE, MECH		1
BRAKE, MECH FORMING ROLLER	0617	2
BRAKE, HAND	NATIONAL	2
METAL STREACHER (FLOOR MODEL)		1
PRESS ARBOR	FAMCO	2
PUNCH, MECH	ROTEX	1
POWER SHEAR	MASPERI CM500A	1
DIMPLER	300	1
BRAKE PRESS	65M75	1
DOALL SAW	3613-2	1

# FY90

## EQUIPMENT PROFILE

CODE	DESCRIPTION	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>rd</sup> - SHIFT	END ITE.
25	BENCH/WORK STA	13	15	13	15025A
113	"	13	13	13	15113A
119	"	3	3	3	15119A/15219A
126	"	3	3	3	15126A/15300A
136	"	6	6	6	15136A/15137A
140	"	7	7	7	15140A
150	"	18	18	18	15150A
175	"	3	3	3	15175A
178	"	5	5	5	15178A
188153	"	6	6	6	{ 15188A / 15189A 15191A / 15192A 15188ASUB1 / 15189ASUB1 15191ASUB1 / 15192ASUB1         }
188154	"	6	6	6	
236		4	4	4	15236A
249		7	7	7	15250A/1524

Phone Conversation w/ Larry

6/1/89

# FIXTURE PROFILE

CODE	Noun	QUANTITY			END ITEM
		1 <sup>s</sup>	2 <sup>d</sup>	3 <sup>r</sup>	
F 335-02		1	1	1	
F 135-01		1	1	1	
✓ F 335-03		2	2	2	15136A / 15137A
335-04		1	1	1	15188A / 15189A
135-02		1	1	1	15191A / 15192A
335-05		1	1	1	
✓ 335-07		1	1	1	15249A / 15250A
✓ " -08		3	3	3	15119A / 15321A
✓ " -09		3	3	3	
135-04		1	1	1	
135-05		1	1	1	
135-06		1	1	1	
135-07		1	1	1	
" -08*		1	1	1	15140A
" -09		1	1	1	
" -10		1	1	1	
" -11		1	1	1	
" -12		1	1	1	
" - <del>18</del>		3	3	3	15175A
" -13		2	2	2	15113A
" -14		2	2	2	15025A
" -15		1	1	1	
" -16		1	1	1	
✓ F 335-10		3	3	3	15188ASub1 / 15189ASub1

FIXTURES PROFILE CONT

CODE	NOUN	1 <sup>s</sup>	2 <sup>d</sup>	3 <sup>r</sup>	END ITEM
FE3A-05		1	1	1	
" -06		1	1	1	
F135-17		1	1	1	15150A

MANPOWER.

FY 89 MANPOWER REQUIREMENTS (PE'E)

	<u>QTR 1</u>	<u>QTR 2</u>	<u>QTR 3</u>	<u>QTR 4</u>	<u>FY TOTAL</u>
MABPAB	287 <del>296</del>	296 <del>260</del>	298 <del>-13</del>	298 <del>206</del>	295 <del>24-</del>
MABPIF	<del>85</del> 14	<del>83</del> 87	<del>85</del> 84	85 65	85 11
MABPCA * INPUT/STRIP	24	24	25	25	24
MABPCB * PAINT	14	14	14	14	14
MABPCD * REC/UNCREAT	3	3	3	3	3

\* MISTR PE'S ONLY



SKILL CODES

U.163806 - (10)

MABPAB	AS	LEFT HAND SIDE COWL
	BS	RIGHT HAND SIDE COWL
	CS	NOSE COWL
	DS	FLAPS
	ES	FLIGHT CONTROLS
	FS	MISC
	GS	DOOR SHOP
	HS	FLIGHT CONTROL } → CMT PROPOSAL
MABPFF	AS	SPOILERS, HATCHES, TIP GEAR, POP-UP ANTENNA, SUPPLY B/B DOORS
	WS	FLAPS, RUDDERS, ELEVATORS
	YS	NOSE COWL, SIDE COWL
	3S	PDM
MABPCA	WL	EQUIPMENT CLEANERS
MABPCB	B3	PAINTERS
MABPCD	MQ	MOVERS
	CQ	CRANE OPERATORS
	EQ	CHECKERS

# FY90

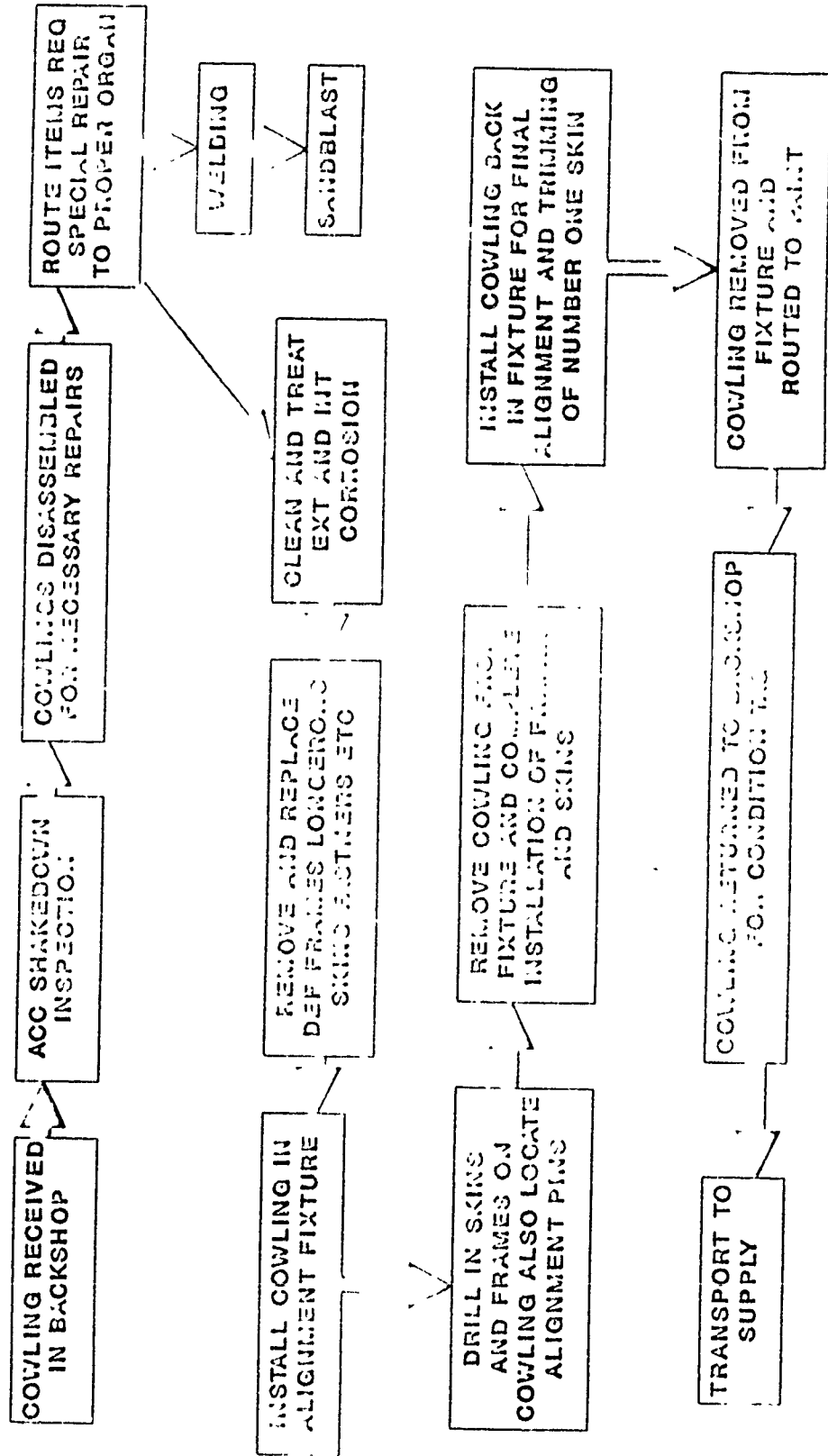
## MAN-POWER

	Quantity				FACTOR			
	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>r</sup>	4 <sup>th</sup>	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>r</sup>	4 <sup>th</sup>
AS	13	18	16	17	5.0	5.3	6.1	5.9
BS	14	16	15	16	"	"	"	"
CS	10	16	16	12	"	"	"	"
DS	7	9	8	8	"	"	"	"
ES	75	72	72	71	"	"	"	"
FS	78	78	78	80	"	"	"	"

Phone Conversation w/ Larry

6/1/89

# FLOW CHART SIDE COWL REPAIR SHOP



## GENERAL PRODUCT FLOW

- STEP
- 1 ITEMS ARE RECEIVED & UNCRATED OUTSIDE  
Bldg. 2122 by MABPCD
  - 2 MOVED TO INSIDE TO STRIP PAINT / BLAST /  
By MABPCA.
  - 3 MOVED TO BUILDING 95 FOR SHAKEDOWN INS  
(3 miles)
  - 4 IF NEEDED WELDING MOVED TO Bldg 3001 (2 m  
MOVE TO BLDG 95  
IF NEEDED BLAST / WASH MOVE TO 2122 (MABPCD)
  - 5 DISASSEMBLY FOR REPAIR
  - 6 IF NEED CLEANING OR INTERNAL BLASTING  
MOVED TO BLDG 2122
  - 7 CLEAN TREAT FOR CORROSION
  - 8 { INSTALL ON FIXTURE
  - 9 { R/R DEFECTIVE PARTS (SKINS, LONGERONS, RIBS, PLATES
  - 8 { (R/R: DRILL, FILE, ALIGNMENT, SHOT-BUCK RIVETS)
  - 10 { REMOVE FROM FIXTURE . PLACE PART ON STA.
  - 11 { COMPLETE ASSY.
  - 9 12 ROUTE TO PAINT SHOP . BLDG 2280  
CLEAN & PAINT by MABPCB
  - 10 13 MOVE TO SHEET METAL . FOR ID : TAG  
Bldg 95 . TAG = CONDITIONING by MABPAB
  - 11 14 MOVE TO STORAGE / SUPPLY.

SEE FLOW

## IMPROVE FLOW

DISASSY. TO THE LOWEST END ITEM

RECEIVE & UNCRATE

STRIP PAINT / BLAST / WASH

INSPECT FOR CRACKS

ROUTE IF NEED WELDING

ROUTE TO SHEET METAL SHOP

DISASSY FOR REPAIR

IN HOUSE CLEANING / BLASTING

R/R DEFECTIVE PARTS

IN HOUSE WASH / PAINT

TAG & CONDITIONING.

SEE FLOW

"MISTR" SHEETMETAL REPAIR

FY-89

SCOPE

STRUCTURAL & SHEETMETAL BACKSHOP  
OVERHAUL REPAIR OF B-52, -135, E-3A & B1  
EXCHANGEABLES INCLUDE ENGINE COMILING,  
FLIGHT CONTROL SURFACES, FAIRINGS, TABS,  
DOORS, HATCHES, ENGINE SLEEVES & ENGINE STRUTS

173 ITEMS

1328 PIECES/CTR

WORKLOAD

427,826	DPSH	(PROGRAMMED MISTR)
97,189	DPSH	(PROGRAMMED PDM)
19,787	DPSH	(UNPROGRAMMED - F&M JOBS)
544,802	TOTAL	
412,099	DPSH	-135 & E3A BACKSHOP (MADPF) - BLDG 95)
132,703	DPSH	B-52 BACKSHOP (MADPF) - BLDG 2121)

MABPAB - (135)

MISTR Production Numbers - 197

	<u>MANHOURS</u>	<u>PERCENT</u>
MISTR	334,914	81
PDM	68,963	17
TEMPORARY	<u>8,222</u>	<u>2</u>
	412,099	100

MABPFF - (B52)

MISTR Production Numbers - 51

	<u>MANHOURS</u>	<u>PERCENT</u>
MISTR <sup>4</sup>	92,912	70
PDM	28,226	21
TEMPORARY	<u>11,565</u>	<u>9</u>
	132,703	100



MISTR ENGINEERED COVERAGE

48 ITEMS = 72% <sup>Total</sup> PROJECTED WORKLOAD

MABPAB 26 ITEMS  
25 ENGINEERED -  
1 NON-ENGINEERED

MABPFF 22 ITEMS  
19 ENGINEERED  
3 NON-ENGINEERED

→ WORK SAMPLE  
Block of OPS

NAME:  
AST NAME

ALC: OC

PLC: HABPAB

ITEM NUMBER	WCD #	WL TYPE	HIST F. TIME	STAND HOURS	EXPECT HOURS
15025A	15025A	4		151.0	
15113A	15113A	4		147.	
15119A	15119A	4		87.75	
15121A	15119A	4		70.24	
15126A	15126A	4		88.	
15129A	15126A	4		78.1	
15136A	15136A	4		7.18	
15137A	15136A	4		9.18	
15140A	15140A	4		51.65	
15150A	15150A	4		85.15	
15175A	15175A	4		73.86	
15178A	15178A	4		18.97	
15188A	15153A	4		120.7	
15189A	15153A	4		120.7	
15188A	15154A	4		15	
15189A	15154A	4		15	
15191A	15151A	4		118.7	
15192A	15151A	4		118.7	
15191A	15152A	4		15	
15192A	15152A	4		15	
15236A	15236A	4		121.6	
15237A	15237A	4		29.6	
15249A	15249A	4		110.5	
15250A	15249A	4		111	
15237A	15236B	4		28.6	

FLOW DAY STUDY SUMMARY SHEET

	<u>QUEUE</u> <u>HOURS</u>	<u>STD</u> <u>HRS.</u>
RECEIVE 2122		
PROCESS SUPPORT	4	
UNCRATE 2122		
PROCESS SUPPORT	4	16
WASH/STRIP 2122		
PROCESS SUPPORT	4	
MOVE 95		
PROCESS SUPPORT	4	
SHAKEDOWN 95		
PROCESS SUPPORT	5	
OVERHUL 95		
PROCESS SUPPORT	7	
MOVE 2280		22
PROCESS SUPPORT	8	
WASH/PAINT 2280		10
PROCESS SUPPORT	7	
MOVE 95		
PROCESS SUPPORT	5	
TOTAL	48	

AVERAGE PROCESS SUPPORT TO OTHER DIVISIONS IS 24 HOURS\*

TIMES DETERMINED FROM SAMPLE STUDY OF TEN EACH FLAPS, LH SIDE COWL,  
OIL COOLER TABS, AND MLG DOOR.

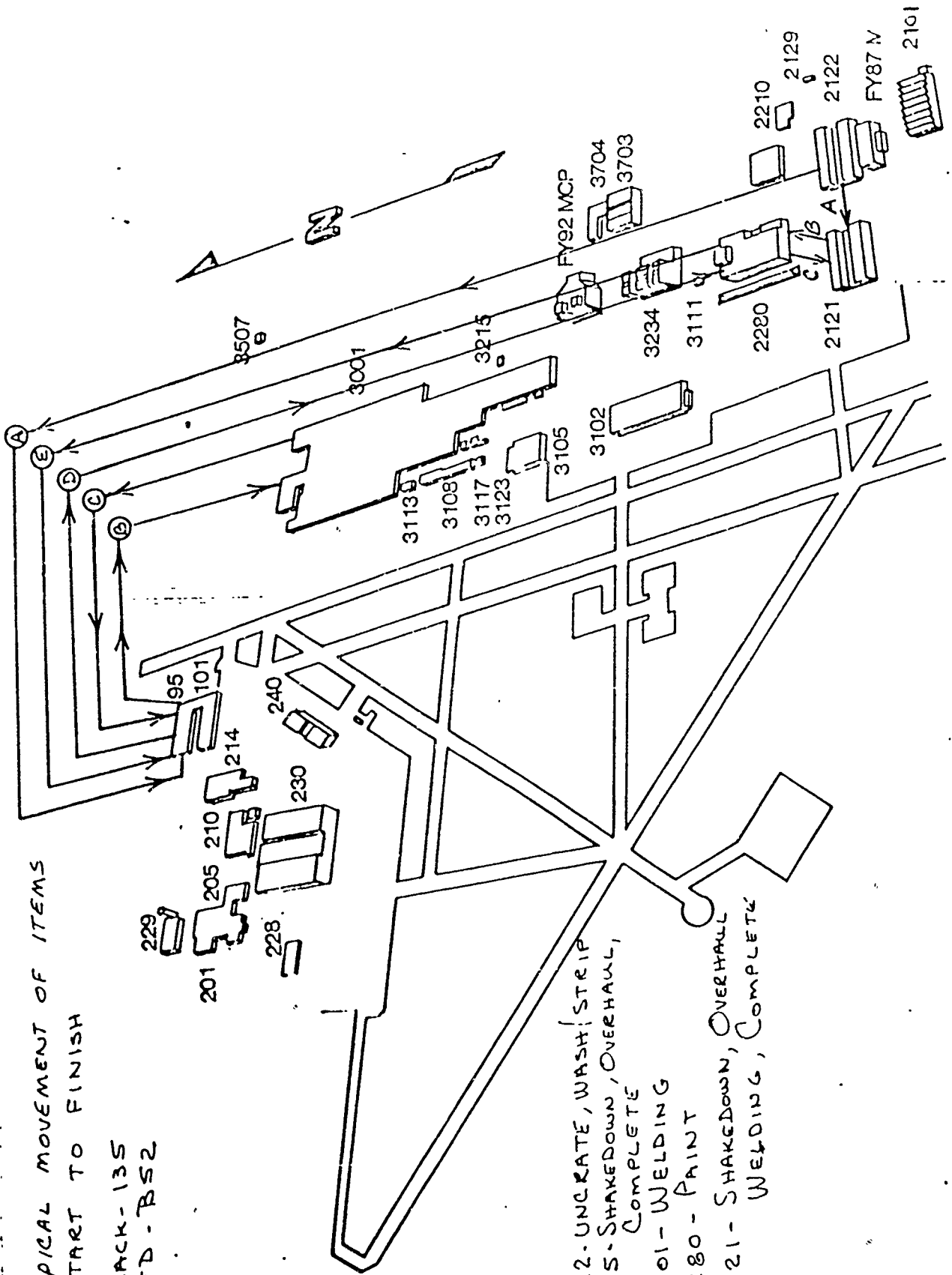
\* MODIFY THESE HOURS BY OCCURANCE FACTOR OF ROUTED ITEM.

TYPICAL MOVEMENT OF ITEMS

START TO FINISH

BLACK-135

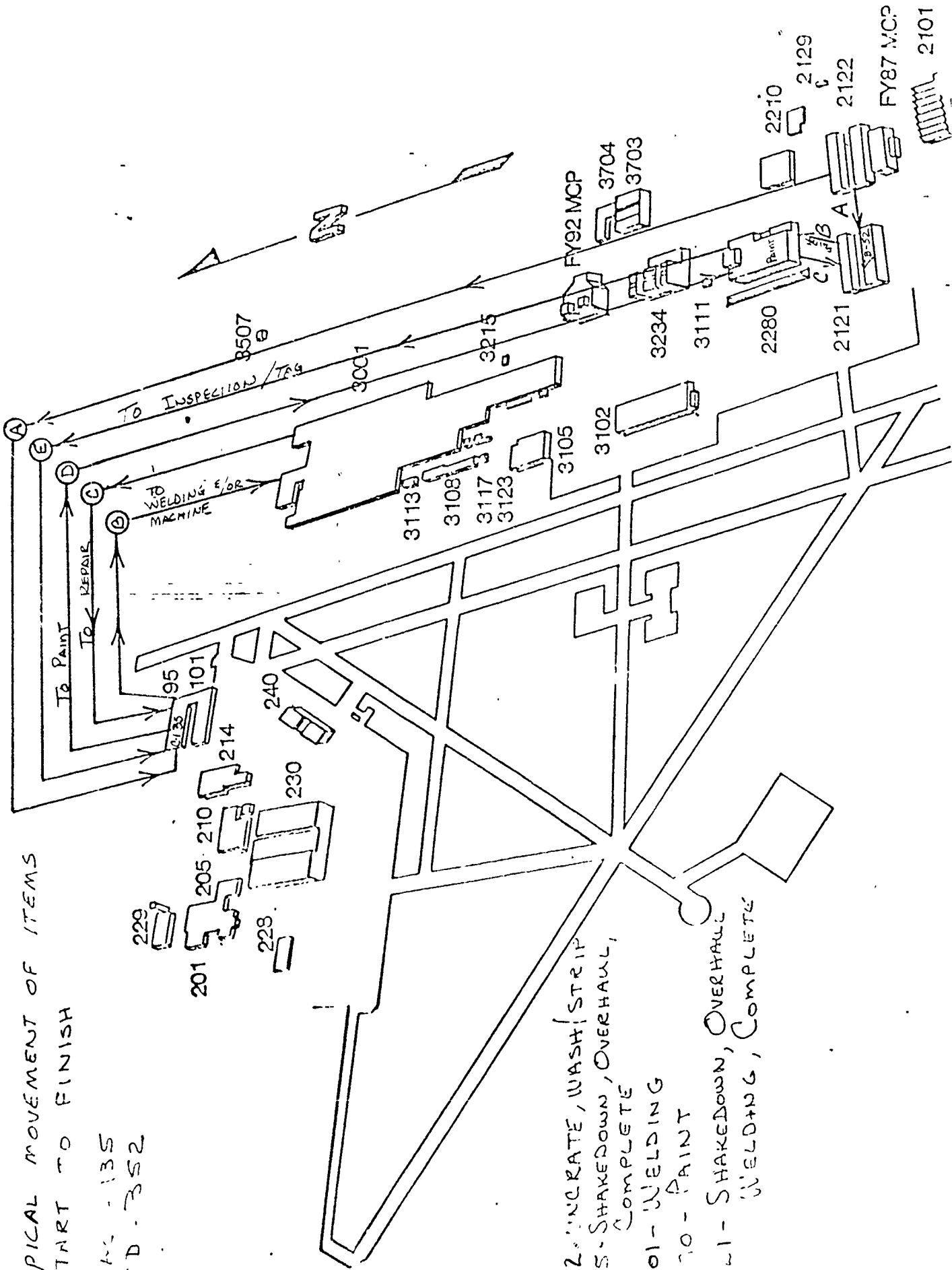
RED-B52



- 2122 - UNCRATE, WASH STRIP
- 95 - SHAKEDOWN, OVERHAUL, COMPLETE
- 3001 - WELDING
- 2280 - PAINT
- 2121 - SHAKEDOWN, OVERHAUL
- WELDING, COMPLETE

TYPICAL MOVEMENT OF ITEMS  
 START TO FINISH

BLK - 135  
 RED - 352



2122 - CONCRETE, WASH STRIP  
 95 - SHAKEDOWN, OVERHAUL, COMPLETE  
 3001 - WELDING COMPLETE  
 2270 - PAINT  
 2121 - SHAKEDOWN, OVERHAUL, WELDING, COMPLETE

OC - MABPAE

PCN	WCD
*****	*****
15025A	15025A
15113A	15113A
15119A	15119A
15126A	15126A
15136A	15136A
15137A	15136AA
15140A	15140A
15150A	15150A
15175A	15175A
15178A	15178A
15188A	15153A
15188ASUB1	15154A
15189ASUB1	15154AA
15189A	15153AA
15191A	15151A
15191ASUB1	15152A
15192A	15151AA
15192ASUB1	15152AA
15236A	15236A
15237ASUB1	15236B
15237A	15237A
15249A	15249A
15250A	15249AA
15300A	15126AA
15321A	15119AA

COMP

OC

221 to 51

135

17515052 ALCTC 3019C T123  
MANAGEMENT OF ITEMS SUBJECT TO  
LISTING IN STR FILE

CBS	WOD DCN	ANSN	NOUN	WSA	UC	QDF
1	15025	1560005205602FL-50	PANEL COWL	KC135		
2	15113	1550010419310FL-50	PANEL	KC135	1642200	168
3	15150	156000067420FL-50	NOSE COW	KC135	2205400	150
4	15188	1560000506181FL-50	FLAP	KC135	005400	97
5	15191	1560000506180FL-50	FLAP	KC135	4740435	194
6	15250	1560000722401FL-50	AILERON	KC135	1814970	126
7	15249	1560000722400FL-50	AILERON	KC135	4740500	204
8	15192	1560000656201FL-50	FLAP	KC135	4313300	112
9	15300	1560003409215FL-50	DOOR	KC135	5082000	112
10	15136	1560004413621FL-50	DOOR	KC135	4740500	204
11	15321	1560003404191FL-50	DOOR	KC135	2037855	100
12	15128	156000340215FL-50	DOOR	KC135	6474600	80
13	15119	1560003397220FL-50	DOOR	KC135	2037855	82
14	15119	1560003397220FL-50	DOOR	KC135	1305810	90
15	15119	1560003397220FL-50	DOOR	KC135	1250412	89
16	15119	1560003397220FL-50	DOOR	KC135	909200	80
17	15119	1560003397220FL-50	DOOR	KC135	1051755	88
18	15140	1560004637577FL-50	FAIRING	KC135	2566600	1490
19	15174	1560006256548FL-50	FAIRING	KC135	504200	594
20	15277	1560007862633FL	STRUT	KC135	1158400	315
21	15294	1560006256547FL	FAIRING	KC135	5942000	1905
22	15104	1560000555583FL	NOSEGEAR	EC-RC135	745325	370
23	15279	1560007862633FL	STRUT	KC135	1294000	1563
24	15278	1560007862633FL	STRUT	KC135	6743300	2533
25	15121	1560003404202FL	HATCH	KC135	2030300	1938
26	15284	1560002517056FL	RUDDER	KC135	4535700	271
27	15284	1560002517056FL	RUDDER	KC135	7384800	2388
28	15118	1560003314843FL	DOOR	KC135	8943490	363
29	15257	1560009748817FL	COWL	KC135	2441500	1563
30	15130	1560003409248FL	FLAP	KC135	1075500	765
31	15240	1560008564054FL	FAIRING	KC135	450000	322
32	15213	1560006738927FL	SPOILER	EC135	809400	504
33	15115	1560002499370FL	RUDJEVAT	E/KC135	465589	211
34	15246	1560008701639FL	PANEL	KC135	5028068	1300
35	15280	1560003701549FL	PANEL	KC-135	3382900	1300
36	15179	1560005522936FL	DOOR	C135B	2336586	1444
37	15226	1560007310564FL	TAB ASSY	KC135	459600	234
38	15129	1560003409247FL	FLAP	KC135	835400	765
39	15245	1560003701606FL	ELEVATOR	KC135	2236655	1171
40	15275	1560005577205FL	SPOILER	C135A	489060	480
41	15350	156010085283AW	AILERON	EGA	8323200	968
42	15144	15600056003965FL	DOOR	EC135C	1083568	570
43	15276	1560006730065FL	SPOILER	C135T	484500	384
44	15293	1560007539152FL	TAB	KC135	300600	233
45	15299	1560005670342FL	DOOR	KC135	1625873	1424
46	15281	1560008701667FL	DOOR	KC135	275900	97
47	15145	1560005403966FL	DOOR ASS	EC135C	474958	543
48	15142	1560007862634FL	STRUT	C135A	5755500	2004
49	15230	1560007551350FL	TAB ASSY	KC135	407300	229
50	15235	1560003075320FL	RING	C135B	002300	721
51	15260	1560009761953FL	DOOR	KC135	995230	320
52	15314	156000508274FL	SPOILER	KC135A	622300	575

DS=450A

19

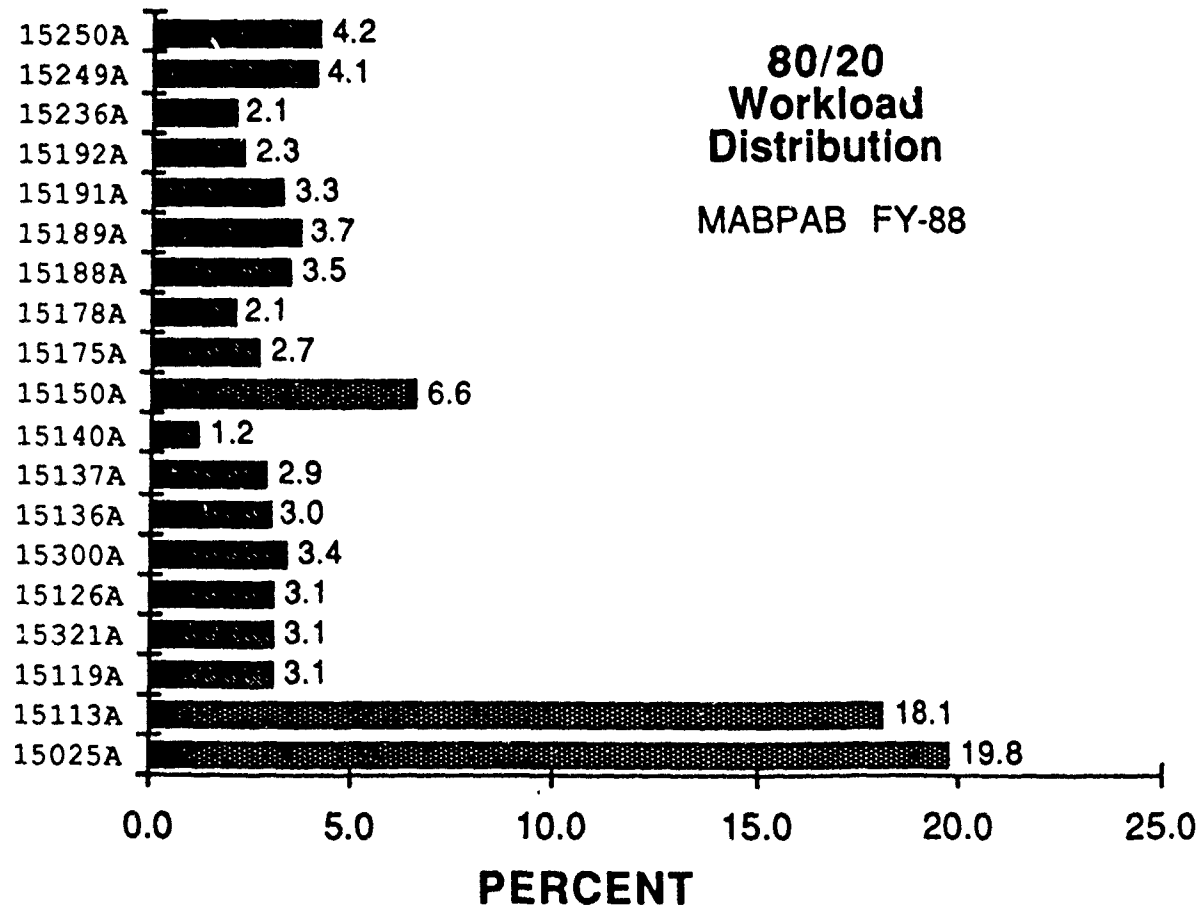
IN

OUT

197,500  
14,350  
propus  
y  
2 2.5

271 K pieces  
EC135

**80/20  
Workload  
Distribution**  
MABPAB FY-88





**ENV \_ \_ \_ OP**  
**(For Internal Use, Not a Model Input)**

ALC DC      RCC MABLAB      EQUIPMENT CODE \_\_\_\_\_

TOTAL VOLUME OF EQUIPMENT IN CU. FT. \_\_\_\_\_

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

NOT A PROCESS APPLICABLE ITEM EQ

5 DKS/MSK  
 B 4/11/89  
 APR 89  
 19-C-CA-CA-MCE

## ITEM CHECKLIST

(For Internal Use, Not a Model Input)

NAME <u>R. Bolanos</u>		AIC	OC	DATE	4/9/89	RCC	MAB/PAB	SHEET <u>1</u> OF <u>2</u>					
ITEM NUMBER	SPECIFY IF MSN PIN	WCD NO.	WCD DATE	OPERATION PROFILE	DS/AS PROFILE	PARALLEL OPS PROFILE	HISTORICAL DATA	INDUCTION SELL DATE	BLANK WCD	STAMPED OFF WCD REVISIONS	STANDARD HOURS	STANDARD FLOW TIMES	PROCESS FLOW CHARTS
15025A	PCN	15025A	88054	✓	N/A	N/A		6/7	✓		✓	36	✓
15113A		15113A	88054	✓					✓		✓	36	✓
15119A		15119A	89073	✓							✓	33	✓
15321A		"	"	✓							✓	33	✓
15126A		15126A	89073	✓							✓	33	✓
15300A		"	"	✓							✓	33	✓
15136A		15136A	88205	✓					✓		✓	34	✓
15137A		"	"	✓							✓	34	✓
15140A		15140A	89073	✓							✓	21	✓
15150A		15150A	88054	✓							✓	31	✓
15175A		15175A	89073	✓							✓	38	✓
15178A		15178A	88054	✓	↘				✓		✓	19	✓
15188A		15153A	88055	✓	✓						✓	35	✓
15189A		"	"	✓	✓				✓		✓	35	✓
15188A		15154A	88055	✓					✓		✓	✓	✓
15189A		"	"	✓					✓		✓	✓	✓
15191A		15151A	88055	✓	✓						✓	36	✓
15192A		"	"	✓	✓				✓		✓	36	✓
15191A		15152A	88055	✓					✓		✓	✓	✓
15192A		"	"	✓					✓		✓	✓	✓
15236A		15236A	88054	✓	✓			✓	✓		✓	44	✓

3.0 811es to 24 Hcs

LSC 20099A



ITEMS SUMMARY

(For Internal Use, Not a Model Input)

NAME <u>R. BOLANDS</u>		ALC <u>OC</u>	DATE <u>4/9/89</u>	RCC <u>MABPA/B</u>	SHEET <u>1</u> OF <u>2</u>
ITEM NUMBER	WCD	WORKLOAD TYPE	HISTORICAL FLOW TIME	STANDARD HOURS	EXPECTED HOURS
1 NSN P/N 15025A	15025A	4		163.49	
2 NSN P/N 15113A	15113A			147.72	
3 NSN P/N 15119A	15119A			89.76	
4 NSN P/N 15300A	"			90.24	
5 NSN P/N 15136A	15136A			88.73	
6 NSN P/N 15300A	"			98.31	
7 NSN P/N 15136A	15136A			79.18	
8 NSN P/N 15137A	"			79.18	
9 NSN P/N 15140A	15140A			51.65	
10 NSN P/N 15150A	15150A			85.15	
11 NSN P/N 15175A	15175A			73.86	
12 NSN P/N 15178A	15178A	✓		18.97	

NOTE: HISTORICAL FLOW TIME WILL BE GENERATED BY DATA PROCESSING. IF NO HISTORY IS COLLECTED ON WCD DATA COLLECTION SYSTEM, THIS INFORMATION MUST BE OBTAINED ON-SITE. EXPECTED HOURS WILL BE GENERATED FROM OPS. PROFILES BY DATA PROCESSING.

# ITEM SUMMARY

(For Internal Use, Not a Model Input)

	NAME <u>R. BOLANOS</u>	ALC <u>α</u>	DATE <u>4/9/89</u>	RCC <u>MABPAB</u>	SHEET <u>2</u> OF <u>2</u>	
	ITEM NUMBER	WCD	WORKLOAD TYPE	HISTORICAL FLOW TIME	STANDARD HOURS	EXPECTED HOURS
13	<input checked="" type="checkbox"/> NSN 15188A	15153A	4		120.73	
14	<input checked="" type="checkbox"/> NSN 15189A	"			120.73	
15	<input checked="" type="checkbox"/> NSN 15188A	15154A			15.00	
16	<input checked="" type="checkbox"/> NSN 15189A	"			15.00	
17	<input checked="" type="checkbox"/> NSN 15191A	15151A			118.72	
18	<input checked="" type="checkbox"/> NSN 15192A	"			118.72	
19	<input checked="" type="checkbox"/> NSN 15191A	15152A			15.00	
20	<input checked="" type="checkbox"/> NSN 15192A	"			15.00	
21	<input checked="" type="checkbox"/> NSN 15236A	15236A			121.58	
22	<input checked="" type="checkbox"/> NSN 15237A	15237A			28.60	
23	<input checked="" type="checkbox"/> NSN 15249A	15249A			110.53	
24	<input checked="" type="checkbox"/> NSN 15250A	"	Y		110.99	
25	<input checked="" type="checkbox"/> PCN 15237A	15236B	4		28.60	

NOTE: HISTORICAL FLOW TIME WILL BE GENERATED BY DATA PROCESSING. IF NO HISTORY IS COLLECTED ON WCD DATA COLLECTION SYSTEM, THIS INFORMATION MUST BE OBTAINED ON-SITE. EXPECTED HOURS WILL BE GENERATED FROM OPS. PROFILES BY DATA PROCESSING.

# RCC CK KLIST

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

NAME R. BOLANOS ALC OC DATE 4/9/89 SHEET 1 OF 1

RCC	DATABASE DOCUMENTATION							PROCESS CHARACTERIZATION				
	FACILITY LAYOUT	EQUIPMENT	WORK FORCE	REPAIR WORK TECHNOLOGY	WORKLOAD INX & VOLUME	MATERIAL HANDLING	STORAGE	FLOW CHARTS	EQUIPMENT PROFILE	MANPOWER PROFILE	WORKLOAD PROFILE	8070 ANALYSIS
MABPAB	✓	✓	✓	✓	✓			✓	✓	✓	✓	✓

# MANPOWER PROFILE

NAME <u>R Bolanos</u> ALC <u>OC</u>		DATE <u>4/11/89</u>		RCC <u>MABPAB</u>		SHEET <u>1</u> OF <u>2</u>		MANPOWER AVAILABLE (HOURS)												ALTERNATE SNGL CODE/LEVEL
								QUANTITY AVAILABLE				WORK WEEK				HOLIDAYS				
								WORK WEEK		WEEKEND		WEEKEND		HOLIDAYS		WORK WEEK		WEEKEND		
SNGL CODE/LEVEL	JOB DESCRIPTION	QUARTER	1	2	3	1	2	3	1	2	3	1	2	3	1	2	3			
AS 10	LEFT HAND SIDE COWL	1	15															BS10, CS10, DS10, ES10, FS10.		
		2	7																	
		3	4																	
		4	8																	
BS 10	RIGHT HAND SIDE COWL	1	16															AS10, CS10, DS10, ES10, FS10		
		2	15																	
		3	22																	
		4	19																	
CS 10	NOSE COWL	1	10															AS10, BS10, DS10, ES10, FS10		
		2	11																	
		3	15																	
		4	10																	
DS 10	FLAPS	1	19															AS10, BS10, CS10, ES10, FS10		
		2	10																	
		3	4																	
		4	2																	
ES 10	FLIGHT CONTROL	1	23															AS10, BS10, CS10, DS10, FS10		
		2	26																	
		3	35																	
		4	27																	

LSC 200011

FORM 10-80

# MANPOWER PROFILE

NAME <u>R. B. BIANOS</u> ALC <u>OC</u>		DATE <u>4/11/89</u>		RCC <u>MABPAB</u>		SHEET <u>2</u> OF <u>2</u>		MANPOWER AVAILABLE (HOURS)												ALTERNATE SKILL CODE/LEVEL								
								QUANTITY AVAILABLE				WORK WEEK				WEEKEND					HOLIDAYS							
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK			WEEKEND			HOLIDAYS										
			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	1	2	3								
FS 10	Misc.	1	29																					ASD, B, S, M, P, C, S, I, O D, S, M, E, S, I, O				
		2	28																									
		3	34																									
		4	30																									
GS 10		1	8																						ASD, B, S, M, C, S, I, O D, S, M, E, S, I, O, F, S, I, O			
		2	8																									
		3	9																									
		4	8																									
		1																										
		2																										
		3																										
		4																										
		1																										
		2																										
		3																										
		4																										

4/19 33



ALL AIRCRAFT CASES  
HAVE 08 + 10

# MANPOWER PROFILE

ALC		DATE	RCC	LIBRARY	SHEET 1 OF 2													
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE												ALTERNATE SKILL CODE/LEVEL			
			WORK WEEK			WEEKEND			HOLIDAYS			MANPOWER AVAILABLE (HOURS)						
			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	
FS 08	LEFT HAND SIDE COWL	1																BS, CS, DS ES, FS, GS AS-10 08 + 10
		2	4															
		3	2															
		4	1															
ES 08	RIGHT HAND SIDE COWL	1																AS, CS, DS ES, FS, GS 08 + 10
		2	5															
		3	5															
		4	7															
CS 08	NOSE COWL	1																AS, BS, DS ES, FS, GS 08 + 10
		2	3															
		3	3															
		4	5															
DS 08	FLAPS	1																AS, BS, CS, ES, FS, GS 08 + 10
		2	4															
		3	3															
		4	1															
ES 08	FLIGHT CONTROL	1																AS, BS, CS, DS, FS, GS 08 + 10
		2	8															
		3	8															
		4	12															

# MANPOWER PROFILE

SKILL CODE/LEVEL		JOB DESCRIPTION	QUARTER	DATE <u>4/1/71</u> RCC <u>144514E</u> SHEET <u>1</u> OF <u>1</u>												ALTERNATE SKILL CODE/LEVEL	
				QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)							
				WORK WEEK		WEEKEND		HOLIDAYS		WORK WEEK		WEEKEND		HOLIDAYS			
1	2	3	1	2	3	1	2	3	1	2	3	1	2	3			
FS 08	Misc.	1	9													AS, BS, CS DS, ES, GS	
		2	9														
		3	11														
		4	10														08510
GS 08		1	1													LS, ES, CS DS, ES, FS	
		2	1						56								
		3	1						57								
		4	1						59								08510
		1															
		2															
		3															
		4															
		1															
		2															
		3															
		4															
		1															
		2															
		3															
		4															

133 4

# MANPOWER PROFILE

ALL ALTERNATE  
CODES HAVE  
OS 08 + 10

JOB DESCRIPTION		QUARTER	QUANTITY AVAILABLE							MANPOWER AVAILABLE (HOURS)							ALTERNATE SKILL CODE/LEVEL	
			WORK WEEK		WEEKEND		HOLIDAYS			WORK WEEK		WEEKEND		HOLIDAYS				
SKILL CODE/LEVEL			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	
AS OS	LEFT HAND SIDE COWL	1	6									5.6						BS, CS, DS ES, FS, GS
		2	3						5.7									
		3	3						5.9									
		4	3						5.8									OS, 08 + 10
BS OS	RIGHT HAND SIDE COWL	1	6						5.6									AS, CS, DS ES, FS, GS
		2	4						5.7									
		3	8						5.9									
		4	7						5.8									OS, 08 + 10
CS OS	NOSE COWL	1	4						5.6									AS, BS, DS ES, FS, GS
		2	4						5.7									
		3	5						5.9									
		4	4						5.8									OS, 08 + 10
DS OS	FLAPS	1	7						5.6									AS, BS, CS, ES, FS, GS
		2	4						5.7									
		3	1						5.9									
		4	1						5.8									OS, 08 + 10
ES OS	FLIGHT CONTROL	1	9						5.6									AS, BS, CS
		2	10						5.7									DS, FS, GS
		3	13						5.9									
		4	10						5.8									OS, 08 + 10

FORM 3-60 ALC DATE 11/1/50 RCC MAREPAS SHEET 1 OF 2

# MANPOWER PROFILE

		ALC		DATE		RCC		SHEET		OF								
		DC		4/11/89		MARBAB		2		3								
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)						ALTERNATE SKILL CODE/LEVEL			
			WORK WEEK		WEEKEND		HOLIDAYS		WORK WEEK		WEEKEND		HOLIDAYS					
			1	2	3	1	2	3	1	2	3	1	2	3		1	2	3
FS OS	Misc.	1															AS, BS, CS DS, ES, GS	
		2	11															
		3	11															
		4	12															
AS OS		1															OS, DS, TD	
		2																
		3																
		4																
		1															AS, BS, CS DS, ES, FS	
		2																
		3																
		4																
		1															OS, DS, TD	
		2																
		3																
		4																

157 22

# WORKLOAD PROFILE

NAME <u>R. Bolanos</u>		ALC <u>OC</u>	DATE <u>4/7/89</u>	RCC <u>MAPPAB</u>	SHEET <u>1</u> OF <u>2</u>						
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK Avail. for use	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM WIP.	STANDARD HOURS
					GOV'L	GOV'L	GOV'L	GOV'L			
1 NSN PIN 15025A	C-135	15025A	4		56	55	54	75	4	15	163.49
2 NSN PIN 15113A		15113A	4		60	60	53	70		22	147.72
3 NSN PIN 15119A	R	15119A	4		13	16	20	20		4	87.76
4 NSN PIN 15321A	L	"	4		13	16	20	20		4	90.24
5 NSN PIN 15126A		15126A	4		13	16	20	20		5	88.73
6 NSN PIN 15330A		"	4		13	16	20	20		5	98.31
7 NSN PIN 15136A		15136A	4		13	18	23	22		4	79.18
8 NSN PIN 15137A		"	4		13	16	23	21		4	79.18
9 NSN PIN 15140A		15140A	4		1	0	4	40		8	51.65
10 NSN PIN 15150A		15150A	4		25	25	38	66		17	85.15
11 NSN PIN 15175A	B7C	15175A	4		25	12	8	26		3	73.86
12 NSN PIN 15178A	L	15178A	4		36	50	59	75		7	18.97
13 NSN PIN 15188A		15188A	4		13	13	15	17		8	120.73

163.5

# WORKLOAD PROFILE

NAME <u>R. Bolados</u>		ALC <u>OC</u>	DATE <u>4/7/89</u>	RCC <u>MABPAB</u>	SHEET <u>2</u> OF <u>2</u>						
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM WIP.	STANDARD HOURS
					1	2	3	4			
15189A <small>NSN P/N</small>	C-135	15153A	4		13	15	15	17		8	12073
15188A <small>NSN P/N</small>		15154A	4	2							15.00 ✓
15189A <small>NSN P/N</small>		"	4	2							15.00 ✓
1519A <small>NSN P/N</small>		15151A	4		11	11	16	17		7	118.72
15192A <small>NSN P/N</small>		"	4		6	6	10	17		8	118.72
15191A <small>NSN P/N</small>		15152A	4	2							15.00
15192A <small>NSN P/N</small>		"	4	2							15.00
15236A <small>NSN P/N</small>		15236A	4		6	10	9	9		4	121.58
15237A <small>NSN P/N</small>		15237A	4							1	28.60
15249A <small>NSN P/N</small>		15249A	4		13	18	23	20		3	110.55
15250A <small>NSN P/N</small>		"	4		13	18	23	20		3	110.55
15236A <small>NSN P/N</small>		15236A	4	2						1	28.60

18  
15  
16  
17  
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21  
22  
23  
24  
25



MAEOR	MAEPAB		FY 1988 UNITS BY QUARTER *		
	LAEOB	# UNITS	Q1	Q2	Q3
1	15111	53.5	26	25	25
2	15112	55.7	60	60	53
3	15113	92.4	25	25	42
4	15114	193.9	13	15	15
5	15115	145.9	13	13	15
6	15116	201.8	11	11	16
7	15117	110.5	13	12	23
8	15118	110.5	13	12	15
9	15119	201.8	6	6	10
10	15120	98.3	13	16	20
11	15121	79.2	13	12	23
12	15122	90.2	13	16	20
13	15123	99.7	13	16	20
14	15124	39.8	13	16	20
15	15125	74.9	13	12	15
16	15126	74.9	15	12	2
17	15127	24.0	36	50	59
18	15128	142.6	6	10	9
19	15140	58.7	1	0	4

\* IAW A-GØ19C - CAA-CA-MCE  
 DATED 16 JUN 1988



CPK Puck  
 Entered 11-28-80

MABPAB FIXTURES

TI DELVP. CODES  
 FLIGHT CONTROLS

<u>EQUIP CODE NO.</u>	<u>NAME</u>	<u>PART NO.</u>	<u>QTY.</u>	<u>APPLICA</u>
F 335-01	FILLET FLAP	SC65-1062T1	1	E3A/135
02	RUDDER	590CJ1130	1	E3A/135
FE3A 01	INBD FLAP	SC65-1063T1	1	E3A
02	L'H/RH ELEVATOR	SC5-96190T1		E3A
F135- 01	L'H/RH ELEVATOR	590CJ1120	1	135
F 335-03	INBD AILERON	590CJ1010	3	E3A/135
" " 04	OTBD MAIN FLAP	590CJ1030	1	E3A/135
F 135-02	INBD MAIN FLAP	590CJ1020	1	135
F 335-05	OTBD SPOILER	590CJ1060	1	E3A/135
07	OTBD AILERON	590CJ1000	3	E3A/135
<u>DOORS</u>				
F 335-08	OTBD MLG	590CJ1110	4	E3A/135
09	INBD MFG	590CJ1100	4	E3a/135
<u>MISC</u>				
F 135-03	Hog Nose Fairing	65-10607-46	1	135
04	OTBD ENG STRUT	590CJ1150	1	135
05	INBD ENG STRUT	590CJ1140	1	135
06	BOTTOM PANEL TF33 P9	FAJ64-8327-621	1	135
07	TAIL CONE	7627259	1	135
08	KNCE CAP FAIRING	TJ5-85654	1	135
09	BOOM POD FAIRING		1	135
10	NOSE WHEEL FAIRING	2FAJ5-73139-1	1	135
11	NOSE WHEEL FAIRING	FRJ5-73139-1	1	135
12	NOSE WHEEL FAIRING	FAJ5-73139-1	1	135
18	BOOM TAIL CONE	600CJ809	3	135
<u>COWLING</u>				
F33A-03	RH SIDE COWL	SC65-2549T	1	E3A
04	LH SIDE COWL	SC65-2549T1	1	E3A
F135-13	RH SIDE COWL J57	3AJ5-85638	2	135
14	LH SIDE COWL J57	3AJ5-85637	2	135
15	RH SIDE COWL TF33P5	OC75-64-8327-488	1	135
16	L'H SIDE COWL TF33P5	OC75-64-8327-487	1	135
FE3A- 05	NOSE COWL	204-70099-3ASMJ	1	E3A
06	NOSE COWL	204-70099-TRMJ	1	E3A
F135 -17	NOSE COWL J57	AJ5-85655	1	135

Logar 736-5265  
OC.

TI DEVL. CODES		B-52 MABPFF FIXTURES		
<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>PART NO.</u>	<u>QTY</u>	
FB 52-01	ELEV/RUDDER BALANCE	RP04G	1	
02	BOMB BAY DOOR (LARGE)	FME35-30600-3	2	
03	BOMB BAY DOOR (LARGE)	FME35-30600-1	2	
04	BOMB BAY DOOR (LARGE)	FME35-30600-2	2	
05	BOMB BAY DOOR (SMALL)	AJ5-48467-3	1	
06	BOMB BAY DOOR (SMALL)	AJ5-46867-4	2	
07	BOMB BAY DOOR (SMALL)	AJ5-46868-28	1	
08	BOMB BAY DOOR (SMALL)	AJ5-46868-27	1	
FB 52-09	BOMB BAY DOOR (SMALL)	AJ5-46867-3	1	

## MABPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
E 135-01	Bending MACHINE (HAND)	416	1
" 02	LARGE BAND SAWS		2
" 03	ROTEX PUNCH PRESS		1
" 04	DRILL' (FLOOR MODEL)	1200-118	1
" 05	GRINDER FLOOR MODEL, (2WHEEL ELECT)		1
" 06	PRESS BRAKE (CHICAGO STEEL CO.)	80023	1
" 07	POWER SQUARING MACHINE	002741	1
" 08	PRESS BRAKE	4560G	1
" 09	SMALL METAL SHEAR	241-C	1
" 10	SMALL DRILL PRESS		1
" 11	GRINDER 1WHEEL,(FLOOR MODEL)	WF6566	1
" 12	PUNCH PRESS	P41P	1
" 13	SANDER (BELT) FLOOR MOD.		1
" 15	BENDING MACHINE (HAND)	BB-316	1

B-52

MABPFF EQUIPMENT

<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>MODEL #TYPE</u>	<u>QTY.</u>
EB 52-01	DOUBLE SANDER DISK (FLOOR MODEL)		1
02	DRILL PRESS (FLOOR MODEL)		4
03	GRINDING MACHINE	WISSOTA E8M	1
04	WELDER	MILLER 330ST	1
05	BRAKE, MECH		1
06	BRAKE, MECH FORMING ROLLER	0617	2
07	BRAKE, HAND	NATIONAL	2
08	METAL STREACHER (FLOOR MOD)		1
09	PRESS ARBOR	FAMCO	2
10	PUNCH, MECH	ROTEX	1
11	POWER SHEAR	MASPERI CM500A	1
12	DIMPLER	300	1
13	BRAKE PRESS	65M75	1
14	DOALL SAW	3613-2	1

SKILL CODES

MABPAB

_____	*AS	LEFT HAND SIDE COWL
_____	*BS	RIGHT HAND SIDE COWL
_____	*CS	NOSE COWL
_____	*DS	FLAPS
_____	*ES	FLIGHT CONTROLS
_____	*FS	MISC

MABPFF

_____	*AS	SPOILERS, HATCHES, TIP GREAR, POP-UP
_____	*WS	ANTENNA, SUPPLY B/B DOORS
_____	*YS	FLAPS, RUDDERS, ELEVATORS.
_____	*3S	NOSE COWL, SIDE COWL
_____		PDM

MABPCA

_____	*WL	EQUIPMENT CLEANERS
-------	-----	--------------------

MABPCB

_____	*B3	PAINTERS
-------	-----	----------

MABPCD

_____	*M <sub>4</sub>	MOVERS
_____	*CQ	CRANE OPERATORS
_____	*EQ	CHECKERS

AA

SYSTEMS (ELECTRIC)

10 hrs  
90 EQUIPMENT PROFILE

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT		DOWNTIME				PERCENT USED FOR OTHER RCCS (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	PREVENTIVE MAINT	UNPLANNED BREAKDOWN REPAIR TIME			MIN	MAX		
		FREQ.			SHIFT	MTBF	MTTR					
E135-01	BENDING MACHINE (HAND) MODEL 516	1			3-0090 Days		.2					PRELIMINARY - AFCC 600170 FOR PRELIMINARY USE UNRESCHEDULED
E135-02	LARGE BAND SAWS 1-AF20065 2-05-2982	1			2-1000 HRS 3-0090 Days		.5					
E135-03	ROTEX PUNCH PRESS	1			4-1000 HRS 3-0090 Days 3-1000 HRS		.5 .5 1.0					
E135-04	DRILL (FLOOR MODEL) 1200-118 LET AND CIRCULAR	1			3-1000 HRS		.5					
E135-05	GRINDER FOR MODEL - (2) WHEEL ELECT	1			2-0180 Days 3-0090 Days		.5 .5					
E135-06	PRESS BRAKE (CHICAGO STEEL CO.) MODEL 80023	1			2-180 Days 3-090 Days		.5 .5					
E135-07	POWER SQUARING MACHINE MODEL 002741	1			3-0060 Day 3-3000 HRS 3-5000 HRS		.3 .5 1.0					
E135-08	PRESS BRAKE MODEL 45606 HUNTBURG	1			2-180 Days 2-4000 HRS 3-1000 HRS		.5 .5 .5					
E135-09	SMALL METAL SHEAR MODEL 241-C	1			3-0090 Days		.2					
E135-10	SMALL DRILL PRESS	1			3-1000 HRS		.5					
E135-11	GRINDER - 3 WHEEL (Floor Model)											No LONGER IN SHOP
E135-12	PUNCH PRESS MODEL P41P VICKERS	1			2-1000 HRS 3-0090 Day		.5 .2					

ALC OC TALE DATE 4/13 89 RCC MABPAB SHEET 1 OF 2

ROUTING TIME (HR)

# EQUIPMENT PROFILE

COMPANY: ALC DC-ALC      DATE: 4/13/89      RCC: \_\_\_\_\_      SHEET 2 OF 2

EQUIPMENT NO.	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (9. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR	MIN		MAX			
E135-13	SANDER (BELT) FLOOR MGD OC5799	1			3-180 Days	Days	.5				0				
E135-15	BEARINGS MACHINE (HAND) MODEL BB-316	1			0090		.2				0				
E135-16	DUMPER (HAND) MODEL AT25655	1			2-365 Days	Days	1.0				0				
E135-17	HOISTING ELEVATOR - DIS JOE MODEL 1518-K5	1			3-0090 Days	Days	1.5				0				
E135-18	718 HOIST T-211	1			3-0090 Days	Days	1.5				0				
E135-19	AIR HOIST T-211	1			Daily Visual		.1				0				
E135-20	ELECTRIC HOIST MODEL 50299	1			2-365 Days	Days	1.0				0				
E135-21	METAL FORMER 735683	1			3-0090 Days	Days	.2				0				
E135-22	METAL SHEAR (HAND) 107-12-78	1			3-0090 Days	Days	.2				0				
E135-23	SURVIVAL SURVIVAL MACHINE OC3590	1			3-0090 Days	Days	.2				0				
E135-24	AIRBOS (HAND) OC0685	1			3-0090 Days	Days	.2				0				

ELECTRICAL = 2

*Fixture*  
**EQUIPMENT PROFILE**

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (9. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR					
F335-01	FLAP FLAP E3A/135 PW SC65-1062T1	1			365	1	16HR			0			INTERVIEW: DON COLLINS / MHT PIT 12-2-84	
F335-02	RUBBER E3A/135 PW 590CJT1130	1								0				
FE3A-01	INBD FLAP E-3A PW SC65-1063T1	1								0				
FE3A-02	LH-RH ELEVATOR E-3A SCS-96190T1	1								0				
F335-01	LH-RH ELEVATOR 135 590CJT1120	1								0				
F335-03	INBD AILERON E3A/135 590CJT1010	3								0				
F335-04	OTBD MAIN FLAP E3A/135 590CJT1030	1								0				
F135-02	INBD MAIN FLAP 135 590CJT1020	1								0				
F335-05	OTBD SPOILER E3A/135 590CJT1060	1								0				
F335-07	OTBD AILERON E3A/135 590CJT1000	3								0				
F335-08	OTBD MLG E3A/135 590CJT1110	4								0				
F335-09	INBD MLG E3A/135 590CJT1100	4			365	1	16HR			0				

ALC. OC DATE 4/13/89 RCC 1111 SHEET 1 OF 3



# EQUIPMENT PROFILE

NAME L. MULINDA X ALC QC - ALC DATE 4/13/89 RCC MARINE SHEET 2 OF 3

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (if TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	UNPLANNED BREAKDOWN REPAIR TIME						
								MTBF	MTTR					
F135-03	HOG NOSE FAIRING 65-10607-416	1			365	1	16HRS							
F135-04	OTBD ENG STRUT 590CJ1150	1												
F135-05	INBD ENG STRUT 590CJ1150	1												
F135-06	BOTTOM PANEL FAJ 64-6327-621	1												
F135-07	TAIL CONE 7627259	1												
F135-08	KNEE CAP FAIRING TJ5-85654	1												
F135-09	BOOM PUL FAIRING	1												
F135-10	NOSC WHEEL FAIRING 2 FAJ5-73139-1	1												
F135-11	NOSC WHEEL FAIRING FRJ5-73139-1	1												
F135-12	NOSC WHEEL FAIRING FAJ5-73139-1	1												
F135-18	BOOM TAIL CONE 600CJ809	3												
FE3A-03	RH SIDE COWL SC65-2549T	1			365	1	16HRS							

\*  
4/11

# EQUIPMENT PROFILE

NAME L. MULLINAX ALC OC-ALC DATE 4/13/81 RCC MALPOL SHEET 2 OF 3

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCCs (0% TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR				
		135		135		135		135					
FE3A-04	LH SIDE COWL SC 65-254971 E3A	1			365	1	16 Hrs			0			
F135-13	RH SIDE COWL (J-57) 3AJS-85638 135	2			365	1	2.4 Hrs			0			
F135-14	LH SIDE COWL (J-57) 135	2			365	1	2.4 Hrs			0			
F135-15	R. SIDE COWL (FF33PS) OC 75-64-8327-488 135	1			365	1	16 Hrs			0			
F135-16	LH SIDE COWL (FF33PS) OC 75-64-8327-487 135	1								0			
FE3A-05	Nose Cowl 204-70099-3ASMJ E3A	1								0			
FE3A-06	Nose Cowl 204-70099-TRMJ E3A	1								0			
F135-17	Nose Cowl (J57) AJS-85655 135	1			365	1	16 Hrs			0			

WORK ACTIONS  
EQUIPME. PROFILE

NAME		ALC		DC		DATE		RCC		SHEET		OF		
R. Bolanos						4/20/89		MABPAB		1		2		
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (0-9. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	BREAKDOWN MTBF	UNSCHEDULED REPAIR TIME	MTTR				
25	BENCH (Work Stn)	10												T. Hall 15025A.
113	"	16												15113A.
119	"	4												15119A + 15321A
126	"	4												15126A + 15300A
136	"	4												15136A + 15137A
140	"	5												15140A
150	"	16												15150A
175	"	3												15175A
178	"	5												15178A
181/53	"	12												15153A + 15151A
188/54	"	6												15154A + 15152A
236	"	4												15236A

WORK - VISION  
EQUIPMENT PROFILE

NAME <u>R. Bolanos</u>		ALC <u>OC</u>		DATE <u>4/20/</u>		RCC <u>MABPAB</u>		SHEET <u>2</u> OF <u>2</u>			
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME			PERCENT USED FOR OTHER RCCS (i.e. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	PREVENTIVE MAINT. SHIFT	DOWN TIME				
237	BENCH (Work Sta)	1							1 / 1		15237A
249	"	5									15249A 15250A
	"										
	"										
	"										
	"										
	"										
	"										
	"										
	"										
	"										
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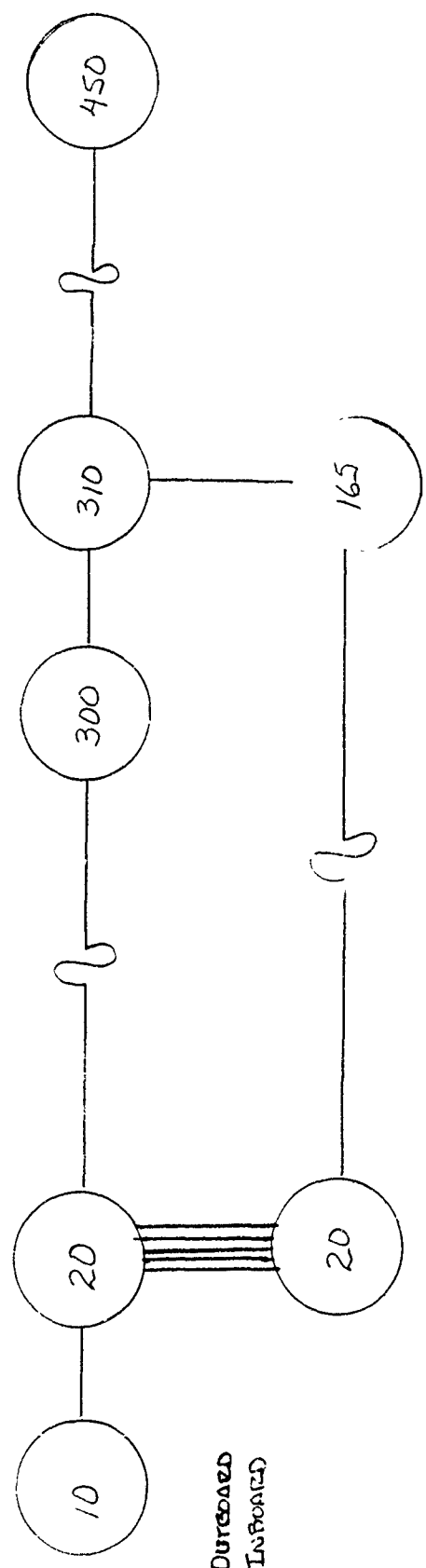
HADPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
115-01	ROLLING MACHINE (HAND)	16	1
" 02	17" (17.5) SHEARS		2
" 03	TEXTURE MACHINES		1
" 04	WHEEL (FLOOR MODEL)	115-116	1
" 05	POWER ROLLER MILL, (WHEEL EFFECT)		1
" 06	WHEEL SHAPE (CHICAGO MILL CO.)	13	1
" 07	ROLLING MACHINE	11	1
" 08	METAL SHEAR	11-6	1
" 09	METAL SHEAR	11-6	1
" 10	SMALL DRILL PRESS		1
" 11	POWER WHEEL, (FLOOR MODEL)	115-116	1
ab 14			1
			1
			1
16	DIMPLING MACHINE	AT256SS	1
17	PORTABLE ELEVATOR	1518-R5	1
18	AIR HOIST 1TON	S2T18-20S	1
19	AIR HOIST 1TON	S2T18-20S	1
20	ELECTRONIC PROG	SQ 200	1
21	METAL FORMER	381D	1
22	METAL SHEAR (HAND)	107-12-78	1
23	SHRINKING/STRETCHING MACHINE	8028	1
24	ARBOR (HAND)	0685	1

# DISASSEMBLY/ASSEMBLY . ROFILE

NAME R. Balanes ALC OC DATE 4/5/89 RCC MABPAB SHEET 1 OF 2

TOP ASSEMBLY		REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY		SAME REMOVED ITEM INSTALLED INTO ASST. Y/N
ITEM NUMBER	WCD			WCD DATE	ITEM NUMBER	
<input checked="" type="checkbox"/> PCN NSM PIN	15188A	20	310	15188A	15154A	N
<input checked="" type="checkbox"/> PCN NSM PIN	15189A	20	310	15189A	15154A	N
<input checked="" type="checkbox"/> PCN NSM PIN	15191A	20	310	15191A	15152A	N
<input checked="" type="checkbox"/> PCN NSM PIN	15192A	20	310	15192A	15152A	N
PCN NSM PIN						



OUTBOARDED  
INBOARDED

PCN	NSM	PIN	RIGHT	LEFT
			15192A	15191A
			15153A	15188A

IN BOARDED 15151A  
OUTBOARDED 15153A

FORE-FLAPS 15152A  
15154A

RIGHT 15192A  
15189A

LEFT 15191A  
15188A

LSC-20005A

# DISASSEMBLY/ASSEMBLY PROFILE

NAME R. Bolanos AIC DC DATE 4/10/89 RCC MAEPAB SHEET 2 OF 2

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REPORTED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHK'D WCD	CHK'D WCD DATE	
PCN NSN PIN	15236A	88054	50	290	15237A	15236B	88069	N
PCN NSN PIN								
PCN NSN PIN								
PCN NSN PIN								

PARENT

```

graph TD
    10 --- 20 --- 30 --- 40 --- 50 --- 60
    50 --- 290 --- 300 --- 310 --- 320
    50 --- 220 --- 230
    50 --- 330 --- 340 --- 350
            
```

CHILD

```

graph TD
    50 --- 220 --- 230
            
```

\* IF TOP ASSY (SLEEVE ASSY) IS INDICATED AS 15236A, A SUB-ASSY (FAIRING AFT) IS A 5236B HOWEVER & (FAIRING AFT) CAN BE INDICATED AS 15237A ALONE. IT CAN NOT GO INTO 15236A)

LSC 20095A

MABFABFF-PP  
REQ. PLW

OC

TURNER, AFB OF OKLAHOMA CITY, OK.

4/28/1987  
RCC - MABFAB

* * * ITEM NUMBER	* * * FARENT PAR( WCD	* * * WDATE	* * * WDATE	BEG UPN	END UPN	* * * ITEM NUMBER	* * * CHILD PROCESS INFORMATION * WCD	WDATE
15025A	15025A	88054	88054	65	370	MISC25	15025B	88054
15113A	15113A	88054	88054	65	370	MISC13	15113B	88054
15136A	15136A	88205	88205	40	160	MISC16	15136B	88105
15137A	15136AA	88205	88205	40	160	MISC17	15136BA	88205
15150A	15150A	88054	88054	30	130	MISC50	15150B	88054
15140A	15140A	89073	89073	30	130	MISC40	15140B	89073
15175A	15175A	89073	89073	60	180	MISC75	15175B	89073
15178A	15178A	88054	88054	22	90	MISC78	15178B	88054
15188A	15153A	88055	88055	60	170	MISC88	15153B	88055
15189A	15153AA	88055	88055	60	170	MISC89	15153BA	88055
15191A	15151A	88055	88055	60	170	MISC91	15151B	88055
15192A	15151AA	88055	88055	60	170	MISC92	15151BA	88055
15236A	15236A	88054	88054	80	150	MISC136	15236BA	88054
15237A	15237A	88054	88054	60	150	MISC137	15237B	88054
15249A	15249A	88055	88055	55	70	MISC149	15249B	88055
15250A	15250A	88055	88055	55	70	MISC150	15250B	88055
15126A	15126A	89073	89073	30	110	MISC26	15126B	89073
15200A	15126AA	89073	89073	30	110	MISC300	15126BA	89073



# PARALLEL PROCESS PROFILE

NAME Bolanos ALC OC DATE 4/24/84 RCC MIKBPAB SHEET 1 OF 2

ITEM NUMBER	PARENT WCD	PARENT WCD DATE	BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
					ITEM NUMBER	CHILD WCD	CHILD WCD DATE
<del>PCN</del> NSN PIN 15025A	15025A	88054	65	370	<del>PCN</del> NSN PIN Misc 15025A	15025A	88054
<del>PCN</del> NSN PIN 15113A	15113A	88054	65	370	<del>PCN</del> NSN PIN Misc 15113A	15113A	88054
<del>PCN</del> NSN PIN 15136A	15136A	88205	40	160	<del>PCN</del> NSN PIN Misc 15136A	15136A	88205
<del>PCN</del> NSN PIN 15137A	15136A	88205	40	160	<del>PCN</del> NSN PIN Misc 15136A	15136A	88205
<del>PCN</del> NSN PIN 15150A	15150A	88054	30	130	<del>PCN</del> NSN PIN Misc 15150A	15150A	88054
<del>PCN</del> NSN PIN 15140A	15140A	89073	30	130	<del>PCN</del> NSN PIN Misc 15140A	15140A	89073
<del>PCN</del> NSN PIN 15175A	15175A	89073	60	180	<del>PCN</del> NSN PIN Misc 15175A	15175A	89073
<del>PCN</del> NSN PIN 15178A	15178A	88054	22	90	<del>PCN</del> NSN PIN Misc 15178A	15178A	88054
<del>PCN</del> NSN PIN 15183A	15153A	88055	60	170	<del>PCN</del> NSN PIN Misc 88 15153A	15153A	88055
<del>PCN</del> NSN PIN 15179A	15153A	88055	60	170	<del>PCN</del> NSN PIN Misc 89 15153A	15153A	88055
<del>PCN</del> NSN PIN 15191A	15151A	88055	60	170	<del>PCN</del> NSN PIN Misc 91 15151A	15151A	88055
<del>PCN</del> NSN PIN 15172A	15151A	88055	60	170	<del>PCN</del> NSN PIN Misc 92 15151A	15151A	88055

# PARALLEL PROCESS PROFILE

NAME Bofano ALC DC DATE 4/24/89 RCC \_\_\_\_\_ SHEET 2 OF 2

ITEM NUMBER	PARENT WCD	PARENT WCD DATE	BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
					ITEM NUMBER	CHILD WCD	CHILD WCD DATE
<del>PCN</del> NSN PIN 15236A	15236A	88054	80	150	Misc	15236A	88054
<del>PCN</del> NSN PIN 15237A	15237A	88054	60	150	Misc	15237A	88054
<del>PCN</del> NSN PIN 15249A	15249A	88055	55	70	Misc	15249A	88055
<del>PCN</del> NSN PIN 15250A	15250A	88055	55	70	Misc	15250A	88055
<del>PCN</del> NSN PIN 15126A	15126A	89073	30	120	Misc 26	15126A	89073
<del>PCN</del> NSN PIN 15300A	15126A	89073	30	120	Misc. 300	15126A	89073
<del>PCN</del> NSN PIN							
<del>PCN</del> NSN PIN							
<del>PCN</del> NSN PIN							
<del>PCN</del> NSN PIN							
<del>PCN</del> NSN PIN							
<del>PCN</del> NSN PIN							
<del>PCN</del> NSN PIN							



1) 1st 180 hrs  
15 swing  
2) 2nd 180  
14

### MANPOWER PROFILE

JOB DESCRIPTION	COUNTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)						ALTERNATE SKILL CODE/LEVEL													
		WORK WEEK		WEEKEND		HOLIDAYS		WORK WEEK		WEEKEND		HOLIDAYS															
		1	2	3	1	2	3	1	2	3	1	2	3		1	2	3										
FS MISC	1	48			10								5.6														
	2	48			7								5.7														
	3	50			15								5.9														
	4	57			11								5.8														
FS SWING	1		15																								
	2		14																								
	3		16																								
	4		14																								
	1																										
	2																										
	3																										
	4																										

RCC \_\_\_\_\_ DATE \_\_\_\_\_ SHEET \_\_\_\_\_ OF \_\_\_\_\_

### **5.1 PROFILE DATA FILES**

The profile data files for RCC MABPAB were previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

## **5.2 MODEL INPUT FILES**

The model input files for RCC MABPAB were previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

## **6.0 VALIDATION OF INPUT DATA**

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

# TI VALIDATION FORM

RCC  
MABPAB

ALC  
OC-ALC

TITLE SHEET METAL SHOP

REMARKS THE SIMULATION MODEL FOR OC-ALC MABPAB, SHEET METAL SHOP, IS AN APPROXIMATION OF THE MABPAB "AS IS" CONDITION AND ESTABLISHES A BASELINE RECOMMENDED TO BE ACCEPTED AND USED FOR EXPERIMENTATION AND RELEASE. THE FOLLOWING CONTINGENCY APPLY FOR FINAL ACCEPTANCE:

1. VERIFY THAT THE MODEL WILL LOAD AND RUN ON THE OC-ALC VAX SYSTEM.

MDMSC WILL BRING THE MODEL TO OC-ALC, LOAD AND RUN THE MODEL TO ASSURE COMPATIBILITY WITH THE OC-ALC VAX SYSTEM AS A CONDITION FOR FINAL ACCEPTANCE OF THE MODEL AND THE DATA FROM BOTH THE OC-ALC & MDMSC VAX SYSTEMS ARE COMPARABLE

2. PROVIDE TO OC-ALC AND HQ AFLC A COPY OF THE UPDATED MODEL FLAT FILES TO VERIFY THAT INPUTS MADE TO THE MANPOWER AND OPERATIONS PROFILES CHANGED THE OUTPUTS AS PREDICTED PROVIDING AN ACCEPTED BASELINE.

CHANGES

(A) REDUCTION OF 10.87% BY EACH OPERATIONS

(B) UPGRADE MANPOWER FACTOR BY 11.2%

(C) REDUCTION OF 19.5% OF MANPOWER

APPROVAL RECOMMENDED

ALC

Earl E. Stamp  
5-24-89

AFLC REP.

Luise A. Brown  
5/24/89

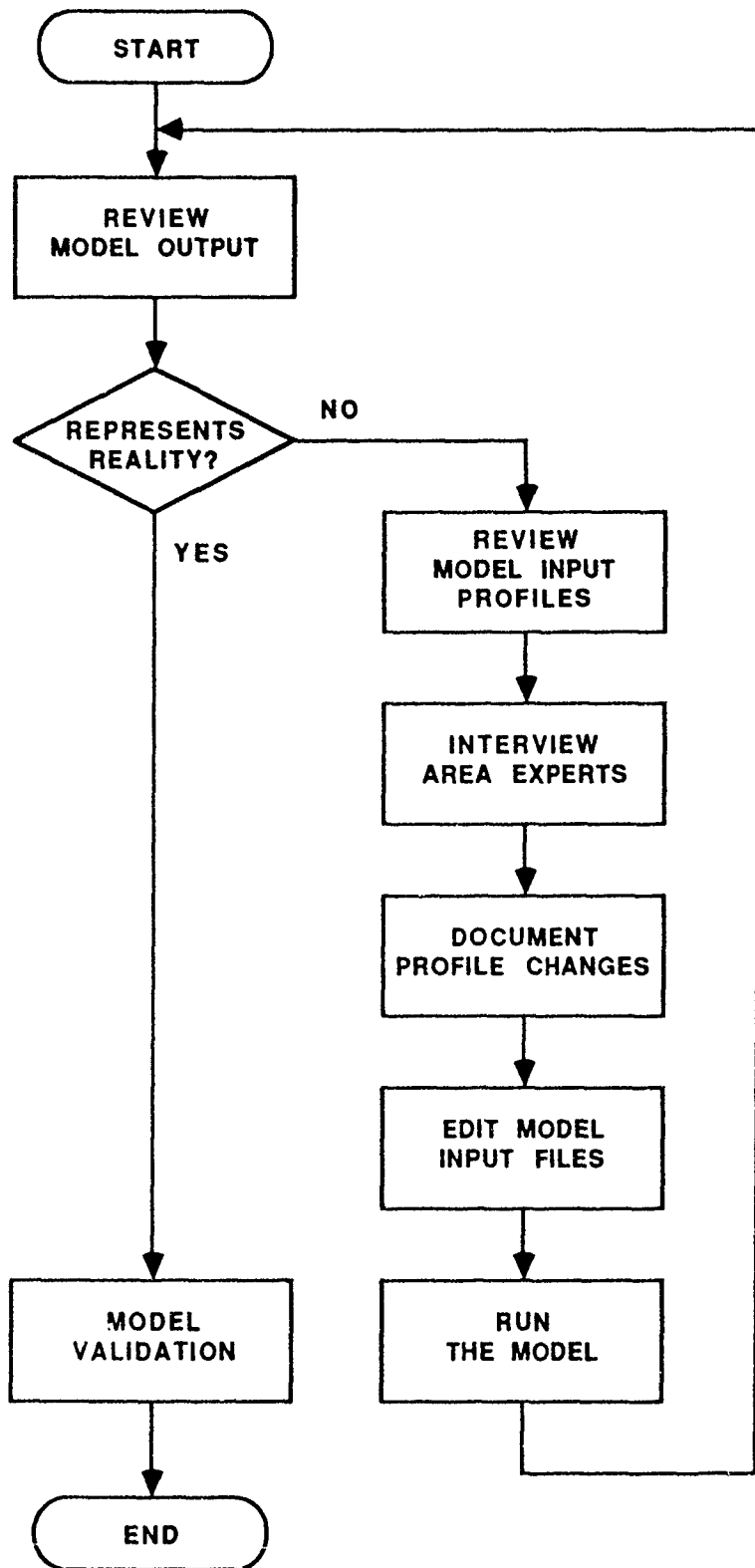
MDMSC

R. Boland 5/24/89

AFLC HQ..

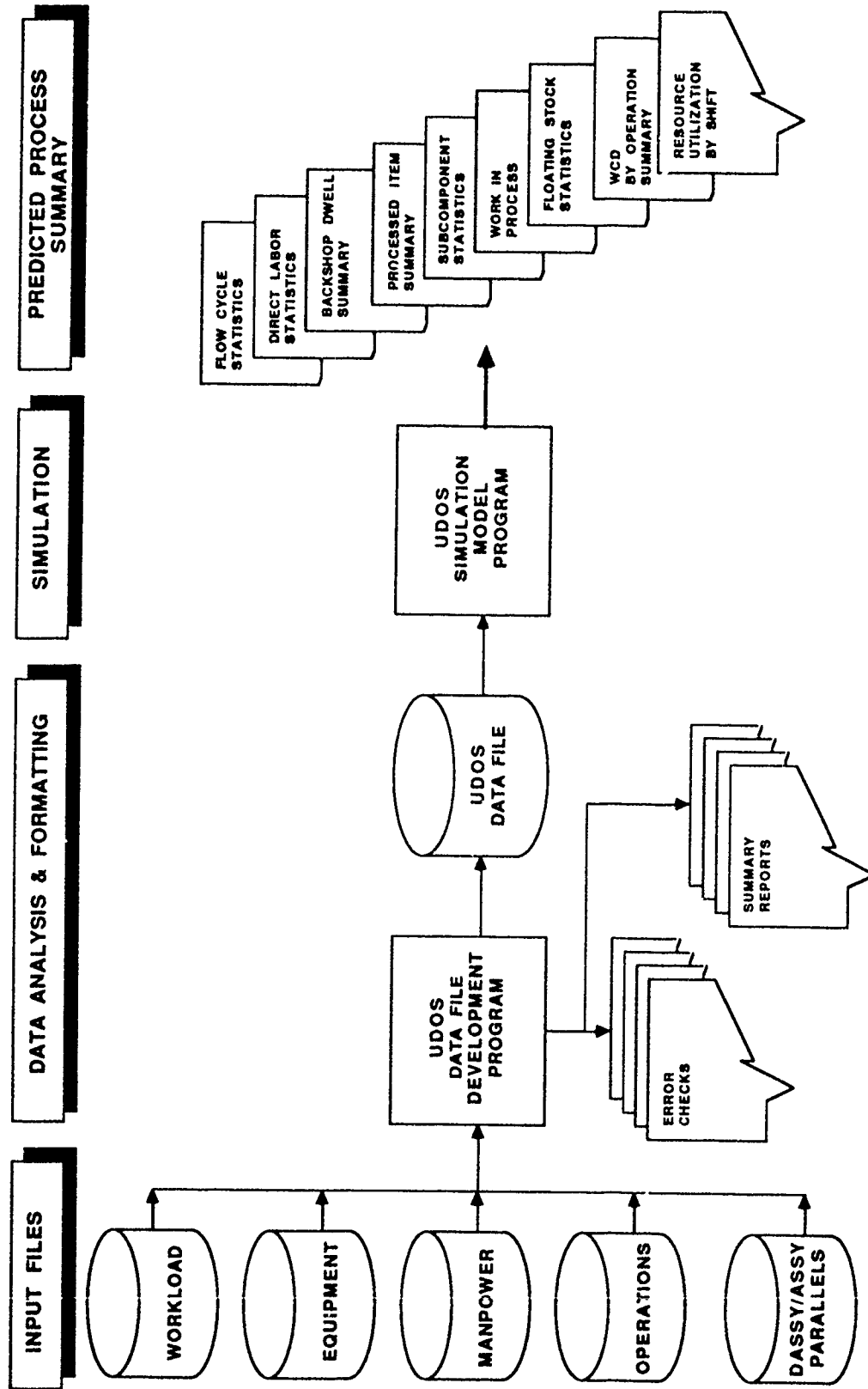
-----  
D. Cripe





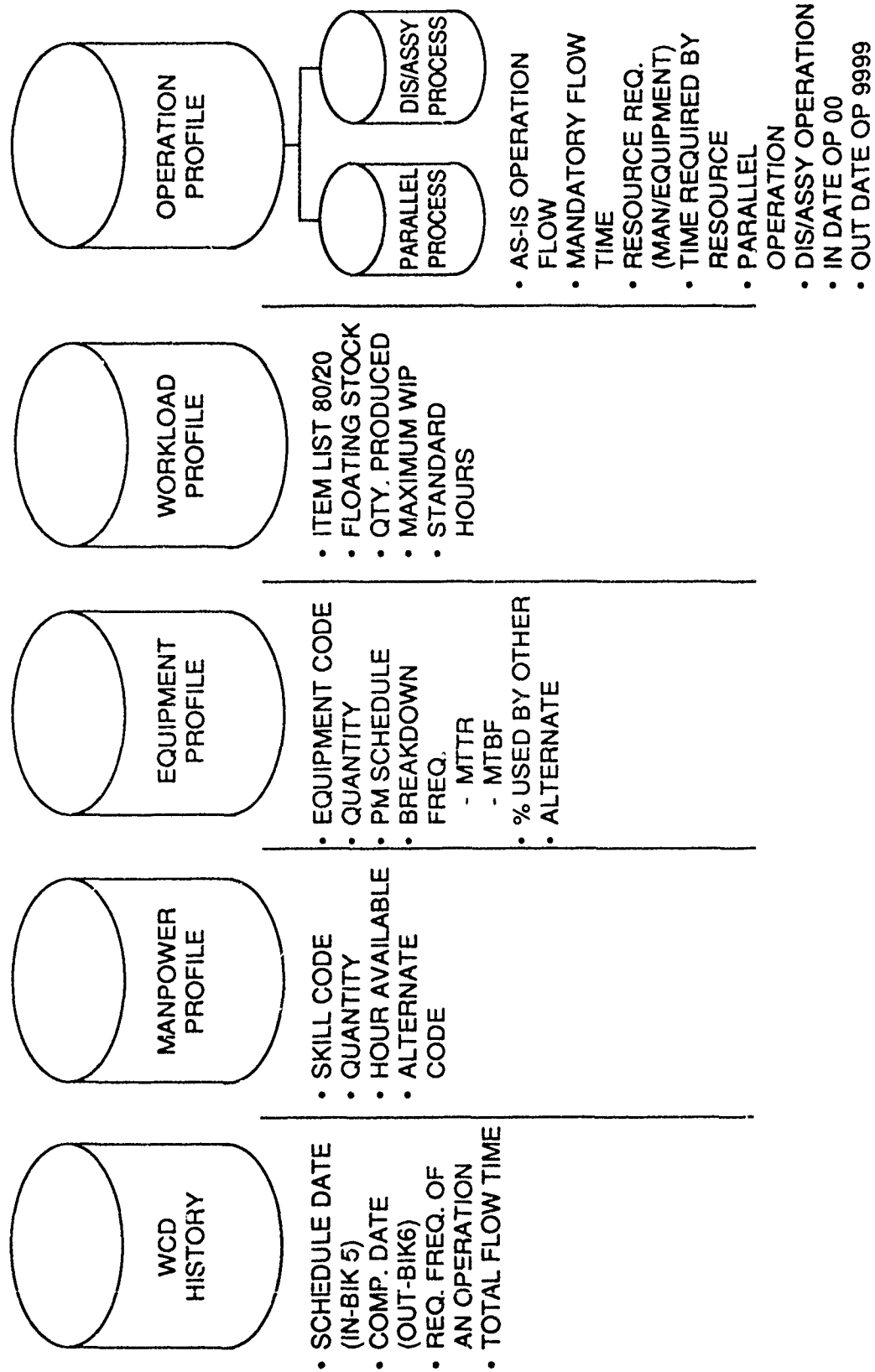
LSC-20456

### MABPAB MODEL VALIDATION PROCESS



LSC-20462

UNIVERSAL DEPOT OVERHAUL SIMULATOR (UDOS 2.0) FUNCTIONAL FLOW DIAGRAM



### TI DATA BANK/SIMULATION MODEL

VALIDATION PROCEDURE FOR OC-ALC

DRAFT

1. List all assumptions used during data collection
2. Determine criterion the model output must meet to be considered valid (i.e. 80% confidence level)
3. Compare historical flow time to simulated flow time and number of samples to FY89 output. Compare the two areas by calculating the variance and percent variance between the two (Atch 1). (For flow time comparison can use the statistical validation can be used if available)
4. Any comparisons not within the confidence level must be investigated further to determine reasons for not meeting this criterion (Atch 2).
  - Check inductions (are they constant or sparatic)
  - Check percent variance between merchanics estimate, standord and history for labor hours. If large discrepancy, may need to investigate each source once again)
  - Check equipment utilization and verify with shop floor
  - Check personnel utilization and verify with shop floor
  - Check queuing on there resources and verify with shop floor
5. Once these areas have all been evaluated, does everyone feel they understand why the discrepancy is there or can it be adjusted using information obtained through the evaluation. If everyone is comfortable with the model output then we can conclude the model is valid. If there are several items that can not be explained then the model is not valid.

FLOW CYCLE TIME STATISTICS

SAMPLE	ITEM	HISTORICAL FLOW TIME HOURS	AVERAGE SIMULATED FLOW TIME HOURS	STANDARD DEVIATION	SIMULATED MINIMUM FLOW HOURS	SIMULATED MAXIMUM FLOW HOURS	NUMBER OF SAMPLES	VAR	%V
54	1513A	1.276	809.79	104.56	566.19	107.36	233	10	4
24	1502A	1.628	847.98	104.08	459.98	148.13	214	26	12
41	1517A	1.177	711.08	87.93	435.98	200.19	65	4	6
30	1506A	1.015	561.39	83.38	271.45	209.93	68	4	6
35	1526A	1.925	363.41	33.55	271.45	220.72	73	2	1
18	1537A	374.00	451.11	34.58	336.93	602.75	67	3	4
14	1540A	440.8	481.56	22.74	436.93	502.75	73	3	4
19	1535A	1.335	687.42	22.58	481.56	705.85	45	4	5
21	1533A	1.433	871.84	150.75	481.56	1229.75	154	32	164
22	1532A	4.182	710.54	114.93	481.56	1050.00	71	3	2
10	1578A	300	110.64	11.49	342.00	400.50	220	18	2
44	1588A	1.011	108.64	11.63	79.73	171.64	58	2	8
5	1589A	1.752	158.18	11.63	79.73	271.64	60	6	3
10	1589A	1.136	125.89	11.63	79.73	271.64	55	8	1
14	1591A	1.027	105.82	11.63	79.73	271.64	15	6	1
11	1592A	1.334	105.82	11.63	79.73	271.64	39	8	1
17	1592A	1.728	125.89	11.63	79.73	271.64	15	0	1
13	1536A	1.634	776.89	117.27	652.80	915.00	34	7	1
7	1537A	156	963.55	120.01	699.43	1249.39	74	9	1
1	1534A	1.332	953.13	117.27	700.73	1499.30	74	9	1
1	1535A	1.731	243.60	117.27	122.80	363.79	24	9	1

ITEM	VAR	%VAR
1513A	10	4
1502A	26	12
1517A	4	6
1506A	4	6
1526A	2	1
1537A	3	4
1540A	3	4
1535A	4	5
1533A	32	164
1578A	3	2
1588A	18	2
1589A	2	8
1589A	6	3
1591A	8	1
1592A	6	1
1592A	8	1
1536A	0	1
1537A	7	1
1534A	9	1
1535A	9	1
1536A	0	1
1537A	7	1
1538A	9	1
1539A	7	1
1540A	9	1
1541A	7	1
1542A	9	1
1543A	7	1
1544A	9	1
1545A	7	1
1546A	9	1
1547A	7	1
1548A	9	1
1549A	7	1
1550A	9	1
1551A	7	1
1552A	9	1
1553A	7	1
1554A	9	1
1555A	7	1
1556A	9	1
1557A	7	1
1558A	9	1
1559A	7	1
1560A	9	1
1561A	7	1
1562A	9	1
1563A	7	1
1564A	9	1
1565A	7	1
1566A	9	1
1567A	7	1
1568A	9	1
1569A	7	1
1570A	9	1
1571A	7	1
1572A	9	1
1573A	7	1
1574A	9	1
1575A	7	1
1576A	9	1
1577A	7	1
1578A	9	1
1579A	7	1
1580A	9	1
1581A	7	1
1582A	9	1
1583A	7	1
1584A	9	1
1585A	7	1
1586A	9	1
1587A	7	1
1588A	9	1
1589A	7	1
1590A	9	1
1591A	7	1
1592A	9	1
1593A	7	1
1594A	9	1
1595A	7	1
1596A	9	1
1597A	7	1
1598A	9	1
1599A	7	1
1600A	9	1

- 1st Time need fixture - time series  
AS RATIO OF HISTORICAL AND SIMULATED  
VALUES 1 - This got higher previous

ITEM	VAR	%VAR
1513A	10	4
1502A	26	12
1517A	4	6
1506A	4	6
1526A	2	1
1537A	3	4
1540A	3	4
1535A	4	5
1533A	32	164
1578A	3	2
1588A	18	2
1589A	2	8
1589A	6	3
1591A	8	1
1592A	6	1
1592A	8	1
1536A	0	1
1537A	7	1
1534A	9	1
1535A	9	1
1536A	0	1
1537A	7	1
1538A	9	1
1539A	7	1
1540A	9	1
1541A	7	1
1542A	9	1
1543A	7	1
1544A	9	1
1545A	7	1
1546A	9	1
1547A	7	1
1548A	9	1
1549A	7	1
1550A	9	1
1551A	7	1
1552A	9	1
1553A	7	1
1554A	9	1
1555A	7	1
1556A	9	1
1557A	7	1
1558A	9	1
1559A	7	1
1560A	9	1
1561A	7	1
1562A	9	1
1563A	7	1
1564A	9	1
1565A	7	1
1566A	9	1
1567A	7	1
1568A	9	1
1569A	7	1
1570A	9	1
1571A	7	1
1572A	9	1
1573A	7	1
1574A	9	1
1575A	7	1
1576A	9	1
1577A	7	1
1578A	9	1
1579A	7	1
1580A	9	1
1581A	7	1
1582A	9	1
1583A	7	1
1584A	9	1
1585A	7	1
1586A	9	1
1587A	7	1
1588A	9	1
1589A	7	1
1590A	9	1
1591A	7	1
1592A	9	1
1593A	7	1
1594A	9	1
1595A	7	1
1596A	9	1
1597A	7	1
1598A	9	1
1599A	7	1
1600A	9	1

DIRECT LABOR STATISTICS

ITEM	EXPECTED HOURS	STANDARD HOURS	SIMULATED AVERAGE LABOR HOURS	STANDARD DEVIATION	SIMULATED MINIMUM LABOR HOURS	SIMULATED MAXIMUM LABOR HOURS	NU	SA
113A	123.49	147.70	318.29	864.51	103.36	136.29	1	
1150	112.50	133.80	122.82	385.67	86.30	134.20	1	
1121	101.86	90.20	198.66	14.35	96.30	199.42	1	
1151	156.40	200.30	112.69	95.76	103.87	164.57	1	
1152	67.66	300.70	56.08	178.97	27.18	65.90	1	
1153	34.08	200.70	33.94	157.37	20.91	45.87	1	
1154	64.02	170.00	69.75	27.82	40.64	74.89	1	
1155	12.26	90.00	54.22	15.27	16.15	27.80	1	
1156	23.59	90.00	19.77	11.33	14.01	27.80	2	
1157	14.88	90.00	22.71	3.86	11.85	25.63	2	
1158	14.88	90.00	22.71	3.86	11.85	25.63	2	
1159	14.33	90.00	22.71	3.86	11.85	25.63	2	
1191	14.70	80.00	19.24	3.76	10.47	25.63	2	
1192	14.70	80.00	19.24	3.76	10.47	25.63	2	
1193	14.70	80.00	19.24	3.76	10.47	25.63	2	
1194	14.70	80.00	19.24	3.76	10.47	25.63	2	
1195	14.70	80.00	19.24	3.76	10.47	25.63	2	
1196	14.70	80.00	19.24	3.76	10.47	25.63	2	
1197	14.70	80.00	19.24	3.76	10.47	25.63	2	
1198	14.70	80.00	19.24	3.76	10.47	25.63	2	
1199	14.70	80.00	19.24	3.76	10.47	25.63	2	
1200	14.70	80.00	19.24	3.76	10.47	25.63	2	
1201	14.70	80.00	19.24	3.76	10.47	25.63	2	
1202	14.70	80.00	19.24	3.76	10.47	25.63	2	
1203	14.70	80.00	19.24	3.76	10.47	25.63	2	
1204	14.70	80.00	19.24	3.76	10.47	25.63	2	
1205	14.70	80.00	19.24	3.76	10.47	25.63	2	
1206	14.70	80.00	19.24	3.76	10.47	25.63	2	
1207	14.70	80.00	19.24	3.76	10.47	25.63	2	
1208	14.70	80.00	19.24	3.76	10.47	25.63	2	
1209	14.70	80.00	19.24	3.76	10.47	25.63	2	
1210	14.70	80.00	19.24	3.76	10.47	25.63	2	
1211	14.70	80.00	19.24	3.76	10.47	25.63	2	
1212	14.70	80.00	19.24	3.76	10.47	25.63	2	
1213	14.70	80.00	19.24	3.76	10.47	25.63	2	
1214	14.70	80.00	19.24	3.76	10.47	25.63	2	
1215	14.70	80.00	19.24	3.76	10.47	25.63	2	
1216	14.70	80.00	19.24	3.76	10.47	25.63	2	
1217	14.70	80.00	19.24	3.76	10.47	25.63	2	
1218	14.70	80.00	19.24	3.76	10.47	25.63	2	
1219	14.70	80.00	19.24	3.76	10.47	25.63	2	
1220	14.70	80.00	19.24	3.76	10.47	25.63	2	
1221	14.70	80.00	19.24	3.76	10.47	25.63	2	
1222	14.70	80.00	19.24	3.76	10.47	25.63	2	
1223	14.70	80.00	19.24	3.76	10.47	25.63	2	
1224	14.70	80.00	19.24	3.76	10.47	25.63	2	

VAR

0.6(116)  
 (74.6)  
 (-45.2)  
 12.5  
 24.2  
 (55.8)  
 (62.7)  
 (110.5)  
 (132.3)  
 (5.2)  
 (41.1)  
 (27.4)  
 (2)  
 (1.2)  
 (1.8)  
 (13.2)  
 (3.2)  
 (2)  
 (2.3)  
 (24.8)  
 (46.6)  
 (43.5)  
 (19.2)

VALUES

NO

RECDED \*\*

SUBI

PCN: 15140A

DRAFT

- Simulated flow hours are 36.4% higher than standard flow hours
- Inductions 1, 0, 4, 40
  - sparatic (this will cause problems)
- Mechanic estimate 25.3% higher than standard
  - contributes to variance
- Equipment
  - 140 bench: until .06 1st
    - queue quantity = Avg= .07 , MAX=4 Time=hrs=3.26
    - operations 30-40, 100-270
  - F135 - 08: until 19% 1st
    - Queue quantity Avg=.61 Max=15 hrs=4.75
    - Operations 50-90 (large queues these operations) 25 hrs vs 105.16
- Manpower FS: Until 40% (not available 37%)
  - queue quantity Avg=18.94, Man=72, Time=1.10 hrs
- CC\_ALC feels that the 36.4% error is due to the following reasons:
  - large inductions 4th. quarter (Production worked many different hours 10hrs, 12hrs, 2nd shift 2-5 days a week and weekends when necessary. Production also assigned personnel to specifically work these items 100% of time out of GS skill level, the model does not reflect this because 90% of the time GS skill is alternate for all other skills and not specifically assigned to work one item. Due to all these different Scenarios CC-ALC feels that the model handles this PCN the best way possible since it was their decision to keep data in a business as usual form and not Taylor it to handle special cases.
- Equipment Utilization is 24%, this looks low but keep in mind utilization is based on one year and 95% of the workload for this, PCN was done in the 4th quarter.
- Bench Utilization is low because mechanic uses bench to set tools etc., but the part is not actually tying up the bench.

DRAFT

PCN: 15126A (Main Landing Gear Door)

- Simulated flow hours are 23.9% lower than STD flow hours
- Inductions 13, 16, 20, 20
  - Consistent
- Mechanic Estimate is 55.8% lower than standard
  - Contributes to variance
- Equipment
  - 126 bench utility 14%
    - queue quantity Avg = .01 MAX = 5 Hrs = .33
    - operations 30-70 and 210 -220
  - F335 - 09 util 32%
    - operations 80-200 (19.5 Hrs vs 93.89 hr)
    - queue quantity Avg=.05, MAX=7, hrs=.42
- Manpower FS util = 40% (not available 37% time)
  - queue quantity Avg=18.94 MAX=72, Time=1.10
- DC-ALC feels that the 23.9% error is due to the mechanics estimate and personnel shortage. The model basically depict the "As Is" condition for FY88.



DRAFT

PCN: 15119A (Main Landing Gear Door)

- Simulated Hrs is 25.2% higher than STD hours
- Induction 13, 16, 20, 20
  - Consistant
- Mechanic estimated flow-times 12.5% higher than std.
  - This plays in the variance
- Equipment
  - 119 bench: util 46% day
    - Operation 30-60, 190-200, 230 (53.2hrs 52.7% vs 167.47)
    - Queue quantity Avg=.51 Max.=11 Hrs = 2.21
  - F335-08 - utili=40%
    - Operation 70-170, 210 (18.93Hrs vs 77.06 Hrs)
    - Queue quantity Avg=.32' Max=10 Hrs=1.91
- Manpower FS - util = 40 (unavailable 37%)
- DC-ALC feels that the 25.2% error is due to personnel shortage and mechanics estimate, since model shows basically what happens on the shop floor.

PCN: 15175A

... DRAFT

- Simulated flow hours are 35.8% higher than standard flow hours
- Inductions 25, 12, 8, 26
  - Sparatic (most work done 1st and 4th quarter)
- Mechanic Estimate is 41.1% lower than standard
  - unusual situation the simulated flow time is higher than standard and mechanics estimate is lower
- Equipment
  - 175 bench: util 4%
    - operation 20, 40, 60, 425, 480
    - queue quantity = Avg = .01 , Max=2. Time=.9 Hrs -
  - F135 -18: 64% (91% 1st and 2nd quarter)
    - operation 70-310
    - queue quantity Avg=.66 Max=9 Time= 1.48 Hrs
- Manpower FS: Util - 40% (not available 37%)
  - Queue quantity Avg=18.94 Max=72. Time=1.10
- Bench 175 utilization so low because mechanic actual uses bench for tools and personnel items. the part does not tie up the bench it ties up the fixture.

DRAFT

PCN: 15321A (Main landing Gear Door)

- Simulated Hrs are 23.2% higher than STD hours
- Inductions 13, 16, 20, 20
  - Consistant
- Mechanic Estimates 26.2% higher than STD
  - This definitely contributes to variance
- Equipment
  - 119 bench util 46%
    - operation 30-60, 230
    - queue quantity Avg =.51. MAX=11 Hrs=2.21
  - F335-08 Util 40%
    - operations 70-220
    - queue quantity Avg=.32 MAX=10, Hrs=1.91
- Manpower FS - Util
- CC\_ALC feels that the 23.2% error is due to personnel shortage and mechanics estimate. Model basically depicts the "As Is" condition for FY82.

DRAFT

PCN: 15300A (Main Landing Gear Door)

- Simulated flow hours are 25.5% lower than standard flow hours
- Inductions 13, 16, 20, 20
  - consistent
- Mechanics estimate is 62.7% lower than standard
  - contributes to variance
- Equipment
  - 126 bench util=14%
    - Operation 30-70
    - queue quantity=Avq=.01, Max=5 Hrs=.33
  - F335-09 Util=32%
    - Operations 80-220
    - Queue quantity = Avg .05, Max 7, Hrs =.42
- Manpower FS utility 40% (not available 37%)
  - queue quantity Avq=4.75, Max=15, Time = .77hrs
- DC\_ALD feels that 25.5% error is due to the mechanics estimate and personnel shortage. The model basically depicts the "As Is" condition for FY88.

1

**TECHNOLOGY INSERTION ENGINEERING SERVICES  
UNIVERSAL DEPOT OPERATIONS SIMULATOR (UDOS)  
VERSION 2.0  
VALIDATION AND BRAINSTORMING SESSION  
FOR  
OKLAHOMA CITY AIR LOGISTICS CENTER (OC-ALC)  
RESOURCE CONTROL CENTER (RCC) MABPAB  
22-24 MAY 1989**

**VALIDATION MINUTES**

**CONTRACT NO. F33600-88-D-0567**

-----  
**TRIXIE BROWN  
AFLC/MAQF**

-----  
**RICARDO BOLANOS  
MDMSC**

-----  
**LOU MAVROS  
MANAGER, PROCESS  
CHARACTERIZATION  
MDMSC**

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

## **1.0 PURPOSE AND OBJECTIVE**

This validation and brainstorming session was conducted at the Oklahoma City Air Logistics Center (OC-ALC), Tinker AFB, building 95 on 22-24 May 1989 to perform validation using the Universal Depot Operations Simulator (UDOS) Version 2.0 with Resource Control Center (RCC) MABPAB Sheet Metal Shop data sets. On the afternoon of 24 May 1989, after conditional validation of the Model, a Brainstorming Session, involving the same participants, was conducted.

The objective of the UDOS 2.0 Validation was to establish the MABPAB Model as a valid baseline characterization of the RCC "As-Is" condition.

The objective of the Brainstorming Session was to identify the Taguchi factors and levels to be used in UDOS 2.0 model experimentation for MABPAB.

## **2.0 SUMMARY**

The following presentations were made during the OC-ALC/MABPAB UDOS 2.0 Validation:

- Introduction - Mr. Earl Stamps OC-ALC/MABEBS
- MABPAB Overview - Mr. Ricardo Bolanos MDMSC
- Model Input Profiles - Mr. Ricardo Bolanos MDMSC
- Model Expectations - Mr. Ricardo Bolanos MDMSC
- Model Output Profiles - Mr. Scott Vroman MDMSC
- Conclusions - Mr. Ricardo Bolanos MDMSC

No formal presentations were made during the Brainstorming Session. This session was conducted as described in paragraph 2.7.

All discussions during the Validation and Brainstorming Session are summarized in the following subordinate paragraphs. The list of attendees, revised agenda, presentation materials, validation form, action items and model input/output file printouts are included as enclosures referenced in paragraphs 3.0 through 8.0 respectively.

## **2.1 INTRODUCTION**

Mr. Earl Stamps, MABEBS Branch Manager, introduced the purpose of the session: validation of the MABPAB UDOS 2.0 Model. Subsequently, Mr. Stamps asked each participant to introduce himself/herself to the group by stating his/her name and the organization he/she represented. (Enc. 1)

## **2.2 MABPAB OVERVIEW**

Mr. Ricardo Bolanos, MDMSC representative and session chair-person, opened by stating that this was the culmination of MDMSC/ALC effort. He emphasized the fact that it was the total cooperation of all MABPAB personnel that enabled MDMSC personnel to arrive at a valid model of MABPAB. Mr. Bolanos specifically thanked Mr. Earl Stamps, Mr. Jim Dodson, Mr. Larry Mullinax and Ms. Janis Wood for their considerable contributions to the MABPAB process characterization effort. After a brief review of the MABPAB Process Characterization schedule, the Flow Process Charts utilized to depict RCC "As-Is" condition and an explanation of the process that would be used to validate the MABPAB UDOS 2.0 Model, Mr. Bolanos proceeded to review the Model input data profiles.

## **2.3 MODEL INPUT DATA PROFILES**

### **2.3.1 Workload Profile**

Mr. Bolanos explained that Mr. Stamps had provided FY88 actual production figures which enabled development of an approximation of workload percentages for MABPAB. Ricardo used Item Codes 15025A, 15113A, 15140A and 15150A as examples to explain the fluctuations in the fourth quarter workload which would require special conditions to accomplish this workload given the resources and time available. A lengthy discussion followed, during which explanations were given of the special conditions that enabled this performance.

### **2.3.2 Manpower Profile**

Next, Mr. Bolanos presented the manpower profile of MABPAB. He stated that the basis for this profile was FY88 data gathered from extensive interviews and record review. The labor profile presented was divided into Work Week (Monday - Friday, Shifts 1 - 3), Week Ends (Saturday & Sunday, Shifts 1 - 3) and Holidays (Shifts 1 - 3). Each category was further subdivided into quarters. Mr. Bolanos went on to explain the Quantity Available versus Manpower Available sections of the profile. He explained

that the 5.6 and 7.1 manpower factors presented provide an ability for the model to account for time not available by each individual due to breaks, absence, vacation, training, etc. in a given eight hour work shift.

### 2.3.3 Equipment Profile

The equipment profile for MABPAB was presented next. Mr. Bolanos explained that the equipment profile addresses large pieces of equipment only (not hand tools). He went on to explain that unscheduled maintenance down time (MTBF & MTTR) data was not available for MABPAB. (MTBF and MTTR data for MABPAB equipment has not been retained. Mr. Bolanos went on to explain the data pertinent to the equipment characterized, tied to the 80/20 workload of the RCC was available. In response to a question from Mr. Stamps, Ricardo explained that the 43% figure shown for some equipment under "% USED NOT AVAILABLE" represents time that the equipment is in use for tasks not defined in the 80/20 workload.

### 2.3.4 Operation Profile

Ricardo explained that this profile is directly related to the Flow Process Chart presented earlier in his presentation. He proceeded to describe the profile using the example Flow Process Chart. He explained that the frequency (Occurrence Factor) for each operation was obtained from shop floor interviews with mechanics. In response to Mr. Gene Leiterman's question regarding supervisory involvement in these occurrence factor assessments, Ricardo responded that both mechanics and supervisors were involved in these assessments. In addressing the lack of WCD history, Ricardo explained that the bench mark for evaluating the reality of the interview data was comparison of the model with Standard Flow Days which would be covered later in the presentation. It was also stated that the historical flow times that were available were of insufficient accuracy for meaningful comparison. The following are examples:

<u>PART NO.</u>	<u>WCD FLOW HOURS</u>	<u>SIMULATED FLOW HOURS</u>
15025A	1,628	848
15113A	1,276	810
15119A	1,178	571
15175A	4,183	716



It would not be possible to simulate FY88 production actuals using the historical WCD data for these parts.

### **2.3.5 Disassembly & Assembly Profile**

This profile was also explained in relation to the Flow Process Chart.

## **2.4 MODEL EXPECTATIONS**

Mr. Bolanos stated that in order to validate the model three items must be established to the satisfaction of the group:

- The Model does Simulate an Approximation of Reality
- The Model Establishes a Baseline
- The Model Provides a Useful Tool For Exploring the Effect of Change.

## **2.5 MODEL OUTPUT PROFILES**

### **2.5.1 Process Times Summary**

Ricardo presented the 80/20 work load simulation flow hours summary for one year of RCC production: waiting for resources, processing hours, back shop hours. Lengthy discussions regarding the basis for expected flow days. Due to the lack of historical WCD data for FY88, MDMSC used shop floor interview data to calculate these expected flow days and then compared these calculations to standard flow days. After much detailed discussion and lengthy explanations, it was agreed that what was actually produced in FY88 was input to the model and that this would be the key to validating model throughput. Next lengthy and detailed discussions of personnel utilization and overtime. Mr. Stamps summarized this by stating that he had no problem moving the resources around to match the real world, provided the bottom line remained the same. Ricardo introduced Mr. Scott Vroman who conducted the remainder of the discussions and presentations concerning Model output.

### **2.5.2 Workload Distribution Profile**

Mr. Vroman explained this profile with emphasis on what MABPAB actually produced in FY88 versus what the model simulation produced.

### **2.5.3 Direct Labor Hours Profile**

After explaining the profile, Scott was asked how closely the mechanics interview times compared with the standard times. He responded that in many cases they were very close and that in some cases they varied widely. He went on to state that since the later case represented only 2 - 3% of the workload, the impact on model performance was negligible. Ricardo stated that a summary report of interviews versus standard hours, by part number, will be available and that any statistical model output data will also be available. There was consensus that the numbers, when compared to control numbers are very close.

### **2.5.4 Estimated Flow Days Vs. Simulated Flow Days Profile**

There was also concurrence that this profile made sense. Mr. Stamps emphasized that the group must be satisfied that this profile represents a good baseline. Scott suggested that this could be accomplished by comparing estimated vs. simulated columns in the profile, using the estimated flow days column as the control column.

### **2.5.5 Processing Summary**

Scott presented three summaries: back shop hours, initial waiting hours (for manpower, equipment and subcomponents) and processing hours. Mr. Stamps and Ms. Wood offered clarification that the initial waiting represents the total time waiting between operations. A lengthy discussion regarding the results presented for part numbers 15113A and 15025A.

### **2.5.6 Back Shop Hours and Occurrence Factor Profile**

This presentation resulted in lengthy discussion and explanation of the use of interview data for back shop occurrence factors. Various control documents were reviewed. It was finally agreed that historical data would be the best source of this model input. However, due to the lack of accurate history, the interview data was the best currently available and must be used. Inconsistencies similar to the examples given in paragraph 2.3.4 existed for back shop historical data.

### **2.5.7 What If Scenarios**

Scott proceeded to present three "What If?" scenarios. First, he explored the results of reducing all skill code manpower by 20%. He explained that any reduction in manpower must consider the workload. Otherwise, queues will build all over the place. Discussions regarding these effects.

The second "What If?" scenario presented involved reducing only the ES and SF skill codes by 20%. This exercise demonstrated that there was little impact on model output due to the fact that ES and FS skill codes are primarily involved with operations outside of the 80/20 workload of the RCC.

The third "What If?" scenario addressed the effects of increasing the workload for part 15113A to 90 per quarter. This resulted in an increase in flow time from 46 days to 70 days

#### **2.5.8 Trial Install of MABPAB UDOS 2.0 Model on OC-ALC VAX**

There were discussions concerning the desirability to trial install and run the model on the OC-ALC VAX computer to insure that it would run properly when delivered. Mr. Mavros, MDMSC Deputy Program Manager, agreed that this would be desirable for all concerned and directed MDMSC personnel in St. Louis to cut a tape of all required files and ship the tape to OC-ALC. Mr. Mavros emphasized that this would not constitute delivery of the software which was governed by other contractual requirements. The tape was subsequently shipped and a trial run was attempted. This attempt was unsuccessful due to problems with the tape. Mr. Vroman returned to OC-ALC 1 June 1989 with a good tape and successfully completed the trial run.

#### **2.6 VALIDATION & CONCLUSIONS**

All attendees concurred that the model of MABPAB met the expectations established for validation, and the Validation Form was signed by Mr. Stamps, Ms. Brown and Mr. Bolanos. This validation is contingent on MDMSC performance of the two action items cited on the Validation Form.

## ISSUES TO VALIDATE\*

5/24/89

- \* 1) Print-out with new numbers Down 10.87% by OP  
{ UP 11.2% MP EFF.  
Down 19.5%
- 2) GS ALTERNATE to all.
- 3) 15140A 4<sup>th</sup> Qtr
  - EXCEPTIONAL USE
  - 4<sup>th</sup> Qtr high INDUCTIONS
  - CHERRY PICKED.
  - ASSIGNED SELECTED PERSONEL to that ARE
  - 2<sup>nd</sup> shift.
- 4) 19.5% MAN-POWER REDUCTION.
- 5) CHANGE STDS to update REV. on 15119A, 15321A, 15126A, 15300A, 15136A, 15137A, 15175A & 152.
- \* 6) LOAD MODEL & RUN ON VAX AT MLC.

# TI VALIDATION FORM

RCC

MABPAB

ALC

OC-ALC

TITLE SHEET METAL SHOP

## REMARKS

THE SIMULATION MODEL FOR OC-ALC MABPAB SHEET METAL SHOP, IS AN APPROXIMATION OF THE MABPAB "AS IS" CONDITION AND ESTABLISHES A BASELINE RECOMMENDED TO BE ACCEPTED AND USED FOR EXPERIMENTATION AND RELEASE. THE FOLLOWING CONTINGENCY APPLY FOR FINAL ACCEPTANCE:

1. VERIFY THAT THE MODEL WILL LOAD AND RUN ON THE OC-ALC VAR SYSTEM.

MDMSC WILL BRING THE MODEL TO OC-ALC, LOAD AND RUN THE MODEL TO ASSURE COMPATIBILITY WITH THE OC-ALC VAR SYSTEM AS A CONDITION FOR FINAL ACCEPTANCE OF THE MODEL AND THE DATA FROM BOTH THE OC-ALC & MDMSC VAR SYSTEMS ARE COMPARABLE

2. PROVIDE TO OC-ALC AND HQAFLC A COPY OF THE UPDATED MODEL FLAT FILES TO VERIFY THAT INPUTS MADE TO THE MANPOWER AND OPERATIONS PROFILES CHANGED THE OUTPUTS AS PREDICTED PROVIDING AN ACCEPTED BASELINE.

CHANGES

(a) REDUCTION OF 10.87% BY EACH OPERATIONS

(b) UPGRADE MANPOWER FACTOR BY 11.2%

(c) REDUCTION OF 19.59% OF MANPOWER

APPROVAL RECOMMENDED

ALC

Earl E. Stamps  
5-24-89

AFCLC REP.

Tracy R. Brown  
5/24/89

MDMSC

K. J. [Signature] 5/24/89

AFCLC HQ..

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D. Cripe

FLOW CYCLE TIME STATISTICS

ITEM	OBS #	STAMPED W.C.D.'s FLOW HOURS	HISTORICAL FLOW TIME HOURS	AVERAGED SIMULATED FLOW TIME HOURS	STANDARD DEVIATION	SIMULATED FLOW TIME HOURS	SIMULATED FLOW TIME HOURS	SIMULATED FLOW TIME HOURS	NUMBER OF SAMPLES
113A	54	1276	864.00	640.87	59.56	64.47	843.13	242	
1125A	28	1628	432.00	881.03	73.56	47.47	1083.18	227	
1120A	44	1178	456.00	661.91	166.68	79.30	1794.86	68	
1126A	20	1015	432.00	532.61	83.28	34.43	7587.16	67	
1133A	36	893	456.00	326.97	27.47	25.82	522.02	70	
1137A	18	376	450.00	416.38	79.13	43.23	587.87	5	
1140A	11	441	504.00	171.97	57.68	23.74	1081.08	23	
1150A	19	1235	504.00	651.05	208.96	55.29	1186.22	1	
1175A	34	1453	528.00	511.53	193.81	74.05	1868.10	2	
1178A	24	1183	456.00	418.98	42.95	33.09	556.85	207	
1189A	2	360	840.00	918.27	128.23	50.95	1206.85	4	
1188A	40	1011	0.00	156.81	95.57	50.93	323.49	5	
1189A	44	873	0.00	217.5	120.57	50.93	373.48	5	
1189A	5	715	0.00	262.03	150.75	63.84	1230.40	60	
1191A	10	814	0.00	249.28	115.47	63.84	378.49	4	
1192A	41	1028	892.00	928.79	150.38	82.02	1362.70	40	
1192A	9	731	0.00	269.06	97.03	66.82	367.31	7	
1192A	6	3235	0.00	79.06	50.6	170.6	1056.38	3	
1236A	13	1728	840.00	856.53	106.20	52.79	1153.24	68	
1237A	N/A	1639	984.00	850.26	103.44	67.9	1312.24	63	
1239A	4	N/A	984.00	223.96	139.11	143.25			
1250A	7	156	0.00	NO VALUES					
1257A	8	833	0.00	NO VALUES					
1257A	8	1731	0.00	NO VALUES					

UPDATE THE MANPOWER FACTOR WITH OVERTIME

IN DS, ES, FS UPGRADE O.T FACTOR FROM 7.1 TO 7.24

IN BS INCREASE MANPOWER LEVELS BY 7, 6, 7, 6

80.5% WL

1 <sup>st</sup>	→	4.50
2 <sup>nd</sup>	→	4.59
3 <sup>rd</sup>	→	4.75
4 <sup>th</sup>	→	4.67

5.83

LINE	DESCRIPTION	ITEM	QTY	DATE	QTY	DATE	QTY
69	INDUCTIONS OF (MISSTR)	ITEM 15113A	53	60	53	70	
70	INDUCTIONS OF (MISSTR)	ITEM 15025A	54	55	54	75	
71	INDUCTIONS OF (MISSTR)	ITEM 15114A	20	10	20	20	
72	INDUCTIONS OF (MISSTR)	ITEM 15321A	20	16	20	20	
73	INDUCTIONS OF (MISSTR)	ITEM 15126A	20	16	20	70	
74	INDUCTIONS OF (MISSTR)	ITEM 15300A	20	16	20	20	
75	INDUCTIONS OF (MISSTR)	ITEM 15136A	23	19	23	22	
76	INDUCTIONS OF (MISSTR)	ITEM 15137A	23	16	23	21	
77	INDUCTIONS OF (MISSTR)	ITEM 15140A	4	0	4	40	
78	INDUCTIONS OF (MISSTR)	ITEM 15150A	35	25	35	66	
79	INDUCTIONS OF (MISSTR)	ITEM 15175A	8	12	8	15	
80	INDUCTIONS OF (MISSTR)	ITEM 15178A	55	50	55	75	
81	INDUCTIONS OF (MISSTR)	ITEM 15128A	15	13	15	17	
82	INDUCTIONS OF (MISSTR)	ITEM 15189A	15	14	15	17	
83	INDUCTIONS OF (MISSTR)	ITEM 15120ASUB1	15	14	15	17	
84	INDUCTIONS OF (MISSTR)	ITEM 15189ASUB1	15	15	15	17	
85	INDUCTIONS OF (MISSTR)	ITEM 15191A	16	11	16	17	
86	INDUCTIONS OF (MISSTR)	ITEM 15192A	10	0	10	17	
87	INDUCTIONS OF (MISSTR)	ITEM 15191ASUB1	15	11	15	17	
88	INDUCTIONS OF (MISSTR)	ITEM 15192ASUB1	10	0	10	17	
89	INDUCTIONS OF (MISSTR)	ITEM 15236A	9	10	9	9	
90	INDUCTIONS OF (MISSTR)	ITEM 15237A	0	0	0	0	
91	INDUCTIONS OF (MISSTR)	ITEM 15249A	23	18	23	20	
92	INDUCTIONS OF (MISSTR)	ITEM 15250A	23	16	23	20	
93	INDUCTIONS OF (MISSTR)	ITEM 15237ASUB1	10	7	10	9	

TOTAL ITEM INDUCTIONS : 405 445 519 667 2

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1ST QTR 2ND QTR 3RD QTR 4TH QTR



FLOW CYCLE TIME STATISTICS

NUMBER OF ITEM SAMPLES	HISTORICAL FLOWTIME HOURS	AVERAGE		SIMULATED		SIMULATED	
		FLOW TIME HOURS	STANDARD DEVIATION	MINIMUM FLOW TIME HOURS	MAXIMUM FLOW TIME HOURS		
15113A	864.00	828.94	103.23	579.25	1084.50		
15025A	864.00	848.63	209.84	479.69	1276.36		
15119A	792.00	586.63	89.70	482.98	822.11		
15321A	792.00	578.91	107.63	459.47	870.75		
15126A	792.00	351.01	36.90	171.70	509.41		
15300A	792.00	360.16	32.67	293.97	432.92		
15136A	816.00	490.58	62.41	391.67	654.72		
15137A	916.00	455.43	54.19	365.89	605.70		
15140A	504.00	692.48	230.00	338.75	1250.88		
15150A	744.00	811.12	178.99	510.09	1300.51		
15155A	912.00	715.37	157.21	459.68	1052.69		
15178A	456.00	397.97	95.19	346.34	529.68		
15186A	840.00	1053.72	114.41	777.48	1491.41		
15189A	840.00	1087.84	125.47	844.94	1348.59		
15189ASUB1	0.00	271.28	49.40	174.96	389.40		
15189ASUB1	0.00	257.90	77.81	174.16	327.38		
15191A	864.00	1060.67	118.02	761.85	1348.78		
15192A	892.00	1170.40	151.25	892.64	1445.41		
15191ASUB1	0.00	256.66	48.20	173.66	365.40		
15192ASUB1	0.00	281.76	49.64	175.59	387.20		
15236A	1056.00	767.39	55.50	675.28	915.00		
15237A	384.00	975.55	110.13	772.40	1501.10		
15249A	984.00	942.94	111.25	702.79	1517.65		
15250A	0.00	240.76	43.48	145.30	330.00		

\*\* NB VALUES RECORDED

ALC: 00  
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DIRECT LABOR STATISTICS

LATED IMUN BOR IYEM URS	SIMULATED		NUMBER EXPECTED OF SAMPLES	STANDARD HOURS	SIMULATED AVERAGE		STANDARD DEVIATION	SIMU MIN	
	MAXIMUM LABOR HOURS	LABOR HOURS			LABOR HOURS	HO			
15113A	137.72	123.49	234	147.70	121.57	5.88	10		
15025A	135.86	112.59	212	163.50	111.07	9.16	8		
15119A	99.30	101.01	64	89.80	99.91	0.73	9		
15321A	114.27	113.86	65	90.70	111.69	1.17	10		
15125A	60.69	56.93	69	88.70	53.70	3.87	4		
15206A	64.17	60.40	67	92.30	57.93	4.12	4		
15176A	45.90	37.66	73	79.20	36.47	5.30	3		
15137A	45.90	34.09	69	79.20	34.11	6.70	5		
15140A	72.20	64.80	17	51.70	64.46	4.89	5		
15150A	112.39	81.02	118	85.20	86.31	13.31	6		
15175A	65.25	52.36	68	73.90	57.05	5.16	4		
15178A	27.80	24.20	207	19.00	22.63	1.95	1		
15188A	292.34	193.59	57	120.70	194.00	38.01	11		
15189A	273.63	193.59	53	120.70	202.71	38.03	14		
15188ASUB1	57.01	14.88	57	15.00	50.08	14.50			
15189ASUB1	53.06	14.88	59	15.00	24.01	12.95			
15191A	261.24	178.33	47	118.70	179.33	36.40	9		
15192A	271.85	195.53	132	118.70	189.12	36.97	11		
15191ASUB1	53.50	14.70	51	15.00	31.87	13.03			
15197ASUB1	52.79	14.70	38	15.00	30.72	13.84	1		
15206A	124.07	104.59	104	121.60	103.60	10.65	8		
15207A	197.96	22.55	33	28.60	** ND VALUES RECORDED **	70.11	11		
15209A	196.62	161.99	161	110.50	163.22	23.65	9		
15237ASUB1		159.32	67	111.00	153.33	4.95			
15237ASUB1		24.00	69	18.60	23.81				

ALC: DC RCC: MABPAB QUARTER: 4 DATE: 23 MAY-89 TIME: 16:08:26 REPT.1  
Q: VALIDATI PAGE: 6

BACKSHOP DWELL SUMMARY

ITEM	AVERAGE SIMULATED BACKHOURS	STANDARD DEVIATION	SIMULATED MINIMUM BACKHOURS	SIMULATED MAXIMUM BACKHOURS	NUMBER OF SAMPLES
12A	172.00	0.00	172.00	172.00	21
125A	150.68	11.52	144.00	196.00	21
119A	96.00	0.00	96.00	96.00	21
111A	96.00	0.00	96.00	96.00	21
120A	96.00	0.00	96.00	96.00	21
112A	168.00	0.00	168.00	168.00	21
113A	197.00	0.00	197.00	197.00	21
115A	151.12	19.00	129.00	193.00	21
1178A	192.00	0.00	192.00	192.00	21
118A	163.02	10.90	160.00	196.00	21
119A	96.00	0.00	96.00	96.00	21
118A SUBI	96.00	0.00	96.00	96.00	21
119A SUBI	167.83	15.05	174.00	196.00	21
119A SUBI	164.20	18.80	174.00	196.00	21
119A SUBI	120.00	0.00	120.00	120.00	21
119A SUBI	277.04	15.98	264.00	311.00	21
119A SUBI	120.00	0.00	120.00	120.00	21
119A SUBI	148.00	0.00	148.00	148.00	21

NO VALUES RECORDED \*

23-MAY-89 TIME: 16:08:26 KUP1.1

PROCESS TIMES SUMMARY

OW ITEM	BACKSHOP HOURS	%	HISTOR. NUMBER FLOW OF HOURS OF SAMPLES	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	%	PROCESSING FL HOURS	%
15113A	192.0	23.2%	864.0	828.9	267.6	31.8%	273.4	45.0%
15025A	150.7	17.8%	864.0	848.6	402.9	47.5%	275.0	34.9%
15119A	96.0	16.4%	792.0	586.6	127.0	21.7%	363.5	61.9%
15116A	76.0	16.6%	792.0	578.9	18.0	3.1%	254.8	41.9%
15300A	76.0	27.3%	792.0	351.0	66.6	19.5%	196.4	53.1%
15136A	66.0	26.7%	792.0	360.2	69.5	19.3%	194.6	54.0%
15137A	63.0	24.2%	816.0	490.6	91.8	18.7%	230.7	47.0%
15140A	63.0	35.9%	816.0	455.4	20.6	17.7%	206.8	45.4%
15150A	51.1	13.9%	504.0	692.5	236.1	34.1%	260.4	52.0%
15175A	45.0	18.6%	744.0	811.1	221.6	27.3%	438.4	54.0%
15178A	42.0	20.3%	912.0	715.4	234.2	32.7%	336.2	47.0%
15188A	42.0	48.2%	456.0	398.6	35.8	8.5%	172.2	43.3%
15189A	42.0	15.9%	840.0	1053.7	202.3	19.2%	683.4	64.9%
1518ASUB1	42.0	15.0%	840.0	1087.8	205.1	18.9%	719.7	66.2%
15189ASUB1	42.0	15.0%	840.0	271.3	34.0	12.5%	141.3	52.1%
15191A	42.0	37.2%	864.0	257.9	32.8	12.7%	129.1	50.1%
15192A	42.0	15.8%	864.0	1060.7	214.6	20.2%	678.2	63.9%
15191ASUB1	42.0	14.0%	892.0	1170.4	290.7	24.8%	715.5	61.1%
15192ASUB1	42.0	45.8%	1056.0	256.7	45.2	17.6%	91.5	35.6%
15206A	42.0	42.6%	1056.0	281.8	44.0	15.6%	117.8	41.8%
15237A	42.0	35.1%	1056.0	767.4	101.5	13.2%	388.8	50.7%
15249A	42.0	12.3%	984.0	975.6	150.3	15.0%	699.4	71.2%
15250A	42.0	12.7%	984.0	942.9	145.4	15.4%	677.5	71.9%
1527ASUB1	42.0	19.9%	0.0	240.8	30.2	1.5%	162.6	67.5%

\*\* NO VALUES RECORDED \*\*

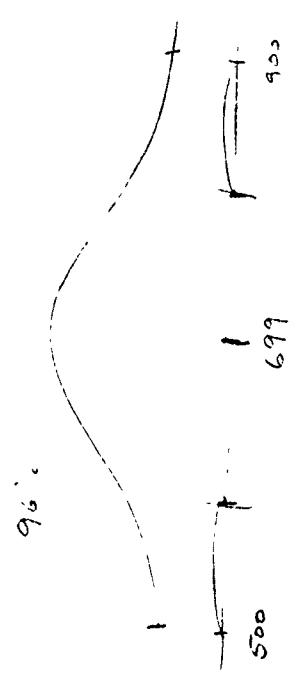
INDUCTIONS	1ST QTR	2ND QTR	3RD QTR	4TH QTR	YTD
15113A	60	60	54	70	244
15113B	56	55	40	75	226
15113C	33	16	20	20	89
15113D	33	16	20	20	89
15113E	33	16	20	20	89
15113F	33	16	20	20	89
15113G	11	18	22	21	72
15113H	15	16	34	40	105
15113I	55	20	39	66	180
15113J	60	20	55	27	162
15113K	33	15	17	17	62
15113L	33	15	17	17	62
15113M	33	15	17	17	62
15113N	33	15	17	17	62
15113O	33	15	17	17	62
15113P	33	15	17	17	62
15113Q	33	15	17	17	62
15113R	33	15	17	17	62
15113S	33	15	17	17	62
15113T	33	15	17	17	62
15113U	33	15	17	17	62
15113V	33	15	17	17	62
15113W	33	15	17	17	62
15113X	33	15	17	17	62
15113Y	33	15	17	17	62
15113Z	33	15	17	17	62
TOTAL ITEM	405	445	519	669	2038

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ITEM	HISTORICAL	AVERAGE SIMULATED FLOW TIME HOURS	STANDARD DEVIATION	SIMULATED MINIMUM FLOW TIME HOURS	SIMULATED MAXIMUM FLOW TIME HOURS	NUMBER OF SAMPLES
15113A	964.00	698.55	99.19	506.50	941.06	275
151125A	501.00	685.27	206.26	396.12	1173.01	215
151119A	507.00	525.40	101.93	434.37	750.72	68
1511321A	772.00	525.09	101.77	390.66	729.18	68
151126A	792.00	525.74	31.88	245.40	414.40	57
1511300A	816.00	454.56	51.07	271.50	435.30	70
151137A	916.00	421.90	54.79	265.90	538.24	69
151140A	916.00	475.82	265.73	319.33	550.24	69
151150A	744.00	737.58	162.00	383.34	1250.27	107
151175A	912.00	626.18	117.00	438.59	1211.22	156
151180A	456.00	626.27	99.72	339.50	1330.80	58
151189A	840.00	962.29	118.83	771.60	1337.87	59
151191A	0.00	1016.85	147.48	679.12	1338.31	59
151191A	0.00	243.51	40.77	173.80	338.31	51
151192A	867.00	923.69	108.84	699.06	1231.90	51
151197A	892.00	1023.61	142.56	799.76	1332.29	51
151197A	0.00	249.34	46.29	173.90	369.91	38
151207A	1056.00	710.70	49.30	630.56	821.21	64
151207A	387.00	843.16	105.86	277.50	1175.00	64
151210A	934.00	863.03	104.83	650.79	1152.57	64
151210A	934.00	863.15	146.36	122.30	1152.57	64
151217A	0.00	822.15	146.36	122.30	1152.57	64

NO VALUES RECORDED  
 48%





ICM	AVERAGE SIMULATED BACKSHOP HOURS	STANDARD DEVIATION	SIMULATED MINIMUM BACKSHOP HOURS	SIMULATED MAXIMUM BACKSHOP HOURS	NUMBER OF SAMPLES
150113A	172.00	0.00	172.00	172.00	2
150115A	151.70	12.37	144.00	196.00	2
150117A	96.00	0.00	96.00	96.00	2
150119A	96.00	0.00	96.00	96.00	2
150121A	96.00	0.00	96.00	96.00	2
150123A	96.00	0.00	96.00	96.00	2
150125A	168.00	0.00	168.00	168.00	2
150127A	175.24	0.00	168.00	168.00	2
150129A	147.20	16.45	172.00	172.00	2
150131A	145.00	0.00	145.00	145.00	2
150133A	192.00	0.00	192.00	192.00	2
150135A	165.00	0.00	144.00	168.00	2
150137A	195.00	0.00	195.00	195.00	2
150139A	96.00	0.00	96.00	96.00	2
150141A	170.76	14.97	174.00	157.00	2
150143A	120.00	0.00	120.00	120.00	2
150145A	120.00	0.00	120.00	120.00	2
150147A	127.06	11.10	124.00	129.00	2
150149A	120.00	0.00	120.00	120.00	2
150151A	128.00	0.00	128.00	128.00	2
150153A	128.00	0.00	128.00	128.00	2

ND VALUES RECORDED \*\*



A: DC RCC: MAEPAB QUARTER: 4 DATE: 23-MAY-59 TIME: 07:42:11 REP: ID: 001841 PAGE: 1  
 FOLLOWS TIMES SUMMARY

1:5M	HISTOR. FLOW ADJRS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	%	PROCESSED HOURS	PROCESSED %	WASTE HOURS	WASTE %
1501135A	864:0:0	698:5:4	157:2:7	22:6%	348:9	49:9%	172:0	27:5%
1501136A	792:0:0	652:8:1	291:6:7	37:5%	276:2	40:6%	151:7	19:2%
1501137A	792:0:0	523:5:1	354:3:7	39:7%	343:4	65:5%	129:5	16:2%
1501138A	816:0:0	434:7:6	51:7:0	12:0%	185:3	50:1%	70:4	9:1%
1501139A	504:0:0	421:1:8	55:5:9	13:0%	191:0	47:0%	108:0	14:2%
1501140A	742:0:0	675:6:2	249:3:7	36:8%	429:5	64:1%	147:7	19:2%
1501141A	456:0:0	626:2:3	150:3:4	24:0%	406:8	65:3%	145:5	19:2%
1501142A	480:0:0	962:3:7	177:4:2	18:2%	853:8	88:9%	125:8	16:2%
1501143A	0:0:0	1046:3:7	195:4:7	19:0%	851:9	81:8%	189:4	24:3%
1501144A	0:0:0	255:3:7	135:4:7	14:0%	123:8	48:2%	105:9	14:2%
1501145A	0:0:0	249:0:0	148:3:7	15:6%	143:8	57:4%	105:8	14:2%
1501146A	0:0:0	710:3:7	37:2:9	1:5%	691:8	97:5%	139:4	19:2%
1501147A	1056:0:0	144:0:0	55:2:3	9:0%	107:1	74:5%	38:0	5:1%
1501148A	934:0:0	843:0:1	86:1:6	9:0%	690:9	82:0%	143:0	18:2%
1501149A	934:0:0	863:2:1	86:1:6	9:0%	690:9	80:0%	143:0	18:2%
1501150A	0:0:0	222:0:0	22:0:0	1:0%	19:0	9:0%	3:0	1:0%

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ALC: OC RCCI MABPAB QUARTER: 4 DATE: 22-MAY-87 TIME: 16:09:43 REF: ID: VALIDATI PAL 2

ITEM INDUCTIONS	1ST QTR	2ND QTR	3RD QTR	4TH QTR	YTD	(MISISTR)
INDUCTIONS OF ITEM 15025A	60	60	53	70	243	(MISISTR)
INDUCTIONS OF ITEM 15025A	58	52	54	75	240	(MISISTR)
INDUCTIONS OF ITEM 15321A	13	16	20	20	69	(MISISTR)
INDUCTIONS OF ITEM 15300A	13	16	20	20	69	(MISISTR)
INDUCTIONS OF ITEM 15137A	13	16	23	22	76	(MISISTR)
INDUCTIONS OF ITEM 15150A	25	18	24	11	78	(MISISTR)
INDUCTIONS OF ITEM 15175A	25	15	38	40	118	(MISISTR)
INDUCTIONS OF ITEM 15178A	13	15	59	66	153	(MISISTR)
INDUCTIONS OF ITEM 15189A	13	15	15	77	220	(MISISTR)
INDUCTIONS OF ITEM 15189ASUB1	13	15	15	17	55	(MISISTR)
INDUCTIONS OF ITEM 15192A	11	11	16	17	55	(MISISTR)
INDUCTIONS OF ITEM 15192ASUB1	11	11	16	17	55	(MISISTR)
INDUCTIONS OF ITEM 15237A	4	10	9	19	42	(MISISTR)
INDUCTIONS OF ITEM 15237A	13	18	23	20	74	(MISISTR)
INDUCTIONS OF ITEM 15250A	13	10	10	20	53	(MISISTR)

TOTAL ITEM INDUCTIONS 405 446 518 669 2039

ORIGINAL MANPOWER FACTORS

FLOW CYCLE TIME SIMULATED AVERAGE FLOW TIME STANDARD DEVIATION RECORD VALUE

WATERING	FLOW TIME	AVERAGE FLOW TIME	STANDARD DEVIATION	RECORD VALUE	SIMULATED MINIMUM FLOW TIME	SIMULATED MAXIMUM FLOW TIME	NUMBER OF SAMPLES
15110A	864.00	1324.71	84.50	94.50	1013.00	1517.60	178
15111A	792.00	469.73	137.99	137.99	167.16	1790.98	68
15112A	792.00	306.73	137.05	137.05	243.00	1679.16	68
15113A	816.00	441.79	137.43	137.43	267.62	1412.87	68
15114A	504.00	638.55	137.00	137.00	364.16	1425.70	68
15115A	912.00	508.81	124.17	124.17	389.16	1432.48	157
15116A	840.00	544.30	126.88	126.88	315.68	1679.81	157
15117A	840.00	797.75	109.07	109.07	661.77	1669.03	157
15118A	840.00	837.46	109.60	109.60	690.89	1617.63	157
15119A	840.00	50.47	42.55	42.55	179.50	1671.56	157
15120A	0.00	235.35	137.00	137.00	69.00	1671.56	30
15121A	1056.00	691.92	109.00	109.00	171.00	1643.00	157
15122A	840.00	719.39	102.25	102.25	659.84	1678.81	157
15123A	0.00	716.12	102.00	102.00	115.00	1678.81	157

DIRECT LABOR STATISTICS

ITEM	EXPECTED	STANDARD	SIMULATED AVERAGE LABOUR HOURS	STANDARD DEVIATION	SIMULATED MINIMUM LABOUR HOURS	SIMULATED MAXIMUM LABOUR HOURS	NUMBER OF SAMPLES
15113A	139.54	147.70	138.63	6.27	131.40	159.30	5
15119A	124.75	132.50	124.75	10.67	107.90	153.80	5
15124A	112.60	89.80	110.58	1.84	118.90	131.40	5
15126A	60.70	88.70	58.56	4.34	50.90	69.30	5
15130A	47.25	79.60	60.94	5.74	50.50	51.50	5
15137A	72.70	51.70	70.82	1.71	51.00	63.00	5
15149A	58.50	87.20	59.02	19.71	49.10	109.10	5
15150A	58.50	87.20	59.02	19.71	49.10	109.10	5
15177A	217.50	170.70	216.62	2.17	117.00	293.00	5
15178A	15.72	15.00	14.80	1.90	11.80	19.00	5
15179A	200.67	118.70	200.67	13.57	16.10	357.40	5
15180A	15.52	15.00	15.52	45.76	16.10	37.10	5
15181A	117.35	121.60	117.44	14.29	139.50	154.90	5
15182A	181.75	110.50	175.25	13.74	9.90	54.90	5
15183A	28.93	28.60	28.93	24.57	1.10	141.00	5
15184A	28.93	28.60	28.93	24.57	1.10	141.00	5

VALUES RECORDED \*\*

ALC: DC OCC: NABRAB: QUARTER: 4 DATE: 22-MAY- TIME: 16:09:43 REPT.ID: VALIDATI PA 6

BACKSHOP DWELL SUMMARY

ITEM	VELOCITY	STANDARD DEVIATION	SIMULATED MINIMUM BACKSHOP HOURS	SIMULATED MAXIMUM BACKSHOP HOURS	NUMBER OF SAMPLES
1113A	192.00	0.00	96.00	192.00	195
1117A	96.00	0.00	96.00	96.00	63
1121A	96.00	0.00	96.00	96.00	63
1125A	96.00	0.00	96.00	96.00	67
1130A	168.00	0.00	168.00	168.00	70
1137A	168.00	0.00	168.00	168.00	70
1140A	96.00	0.00	96.00	96.00	157
1150A	125.00	0.00	125.00	125.00	163
1155A	125.00	0.00	125.00	125.00	213
1178A	125.00	0.00	125.00	125.00	56
1185A	96.00	0.00	96.00	96.00	59
1188A	171.56	0.00	171.56	171.56	70
1190A	120.00	0.00	120.00	120.00	71
1195A	120.00	0.00	120.00	120.00	71
1200A	272.47	13.06	272.47	272.47	54
1205A	120.00	0.00	120.00	120.00	73
1210A	96.00	0.00	96.00	96.00	68
1215A	96.00	0.00	96.00	96.00	74

AVERAGE VELOCITY  
 SIMULATED MINIMUM BACKSHOP HOURS  
 SIMULATED MAXIMUM BACKSHOP HOURS  
 NUMBER OF SAMPLES

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW %	BACKSHP HOURS	NO. VALUE
15113A	864.0	1387.0	710.7	53.6%	192.0	14.5%
15113A	792.0	458.4	909.4	68.2%	196.0	10.4%
15126A	792.0	317.4	74.3	18.5%	96.0	20.9%
15136A	816.0	401.8	80.9	18.3%	86.0	30.2%
15140A	744.0	238.5	316.2	16.5%	168.0	41.8%
15150A	744.0	586.1	136.4	23.7%	196.0	15.0%
15175A	840.0	769.0	134.0	29.4%	145.0	17.6%
15188A	840.0	827.7	131.0	19.0%	168.0	21.1%
15188ASUB1	840.0	234.1	125.1	11.2%	60.0	42.8%
15191A	840.0	238.5	129.0	11.7%	96.0	40.3%
15191A	840.0	601.5	194.0	16.6%	171.0	21.4%
15191A	840.0	238.5	129.0	11.7%	150.0	17.1%
15191A	840.0	673.4	48.5	14.1%	272.0	39.0%
15247C	904.0	722.4	108.0	15.0%	190.0	16.6%
15257A	904.0	719.3	107.0	13.3%	148.0	16.1%
15257ASUB1	904.0	219.3	107.0	13.3%	148.0	16.1%

NO. 31 2 10 00 7:10 MURBL 0-1775H HSL 006

PROCESS TIMES SUMMARY

ITEM	HOURS	HOURS	HOURS	RESOURCES	RESOURCES	RESOURCES	PROCESSING	PROCESSING	PROCESSING	HOURS	HOURS	HOURS	BACKSHOP	BACKSHOP
							%	%	%					%
151132A	864.0	1828.3	2592.3	935.4	56.4%	47.4%	32.11%	532.2	192.0	11.6%	192.0	11.6%	11.6%	11.6%
151133A	792.0	1828.3	2592.3	1254.8	68.6%	68.6%	20.31%	422.6	151.0	18.3%	151.0	18.3%	18.3%	18.3%
151134A	792.0	1828.3	2592.3	140.8	23.5%	5.7%	61.6%	359.4	96.0	16.8%	96.0	16.8%	16.8%	16.8%
151135A	792.0	1828.3	2592.3	78.4	21.4%	4.2%	52.4%	191.8	96.0	26.9%	96.0	26.9%	26.9%	26.9%
151136A	792.0	1828.3	2592.3	87.3	24.4%	4.2%	43.5%	194.4	96.0	27.4%	96.0	27.4%	27.4%	27.4%
151137A	816.0	1828.3	2592.3	130.5	24.0%	4.2%	45.0%	231.7	96.0	23.5%	96.0	23.5%	23.5%	23.5%
151138A	744.0	1828.3	2592.3	296.2	40.0%	4.2%	48.0%	297.2	168.0	45.0%	168.0	45.0%	45.0%	45.0%
151139A	456.0	1828.3	2592.3	198.2	29.0%	4.2%	48.0%	320.1	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151140A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151141A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151142A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151143A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151144A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151145A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151146A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151147A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151148A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151149A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151150A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151151A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151152A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151153A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151154A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151155A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151156A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151157A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151158A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151159A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151160A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151161A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151162A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151163A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151164A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151165A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151166A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151167A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151168A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151169A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%
151170A	840.0	1828.3	2592.3	198.2	23.0%	4.2%	32.0%	159.5	145.0	38.0%	145.0	38.0%	38.0%	38.0%

NO VALUES ACCUMULATED  
 984.0  
 246.4  
 15237A SUBI

ALC: D. RCC: MABFAB QUARTER: 4 DATE: 22-N -89 TIME: 17:17:00 REPT. ID: VALIDATI PAGE: 12

WORK IN PROCESS

ITEM	ALLOWABLE QUANTITY	AVERAGE	STD. DEV.	MINIMUM	MAXIMUM	CURRENT	AVERAGE WAITING TIME	AVERAGE QUANTITY WAITING	CURRENT QUANTITY WAITING
15113A	30	30.0	0.0	30	30	30	1798.1	51.9	95
15115A	10	10.0	0.0	10	30	30	1709.3	47.9	103
15119A	16	4.8	2.7	0	12	8	**	WAITED	**
15121A	10	2.8	1.3	0	10	9	**	WAITED	**
15126A	10	1.8	1.4	0	6	4	**	WAITED	**
15130A	16	1.8	1.4	0	6	2	**	WAITED	**
15132A	16	1.2	1.2	0	19	6	**	WAITED	**
15137A	16	2.2	1.5	0	19	6	**	WAITED	**
15140A	10	5.4	3.3	0	14	16	246.9	0.5	12
15145A	10	5.4	3.3	0	14	34	109.1	0.3	1500
15151A	16	1.7	1.1	0	14	14	157.2	0.3	0
15155A	10	1.9	1.1	0	11	9	**	WAITED	**
15178A	16	1.7	1.1	0	17	9	**	WAITED	**
15189A	16	1.7	1.1	0	15	12	**	WAITED	**
15180A	50	1.6	1.2	0	5	9	**	WAITED	**
15187A	50	1.2	1.1	0	5	2	**	WAITED	**
15191A	18	1.0	1.0	0	12	1	**	WAITED	**
15197A	18	1.0	1.0	0	15	1	**	WAITED	**
15200A	10	1.3	1.0	0	7	0	**	WAITED	**
15207A	10	1.0	1.0	0	10	10	242.6	0.6	4
15209A	10	1.0	1.0	0	10	10	189.9	0.7	4
15237A	10	1.0	1.0	0	15	10	**	WAITED	**

SUBI SUBI SUBI SUBI SUBI

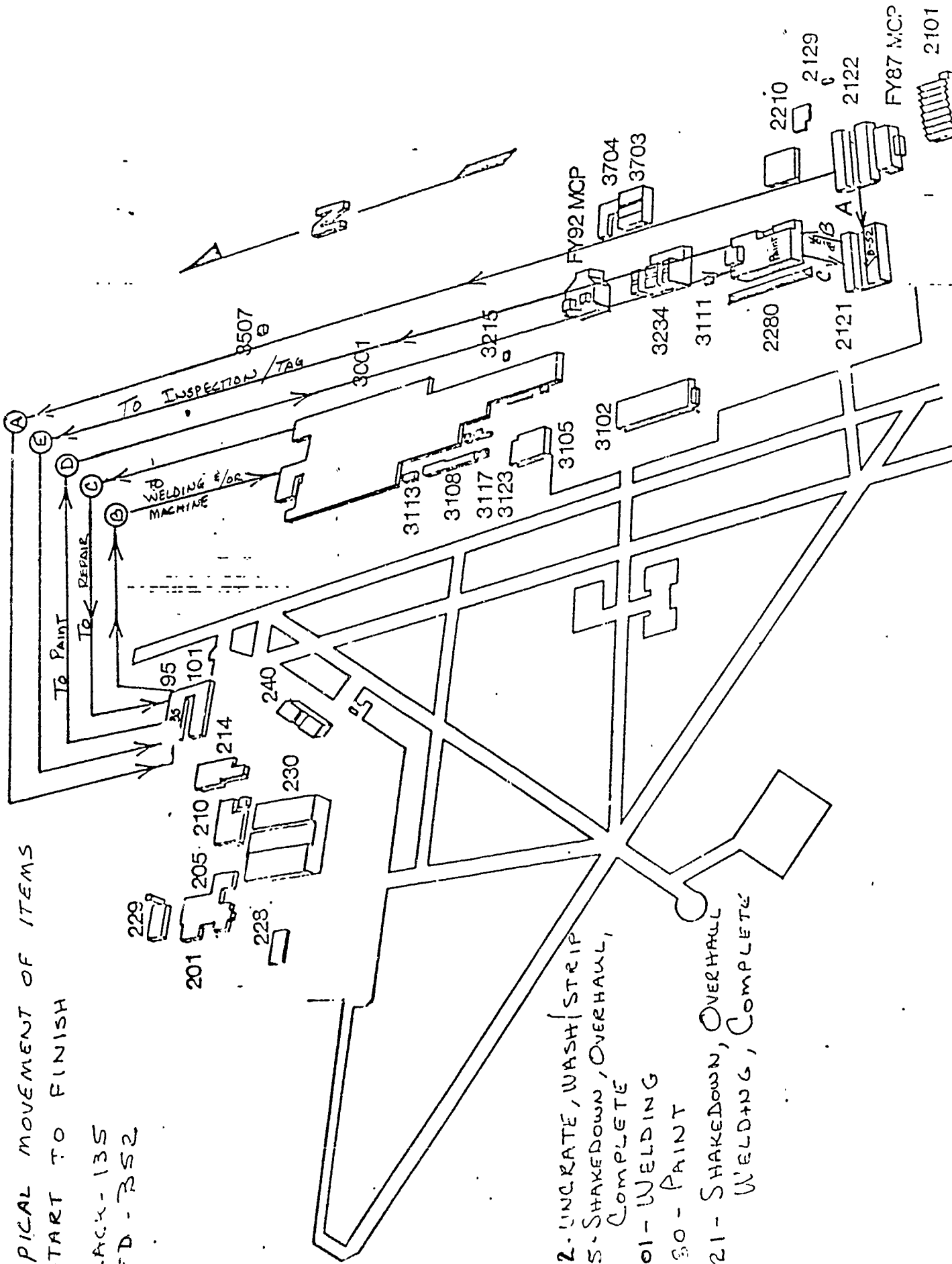


TYPICAL MOVEMENT OF ITEMS

START TO FINISH

BLACK - 135

RED - 352



- 2122 - UNCRATE, WASH STRIP
- 95 - SHAKEDOWN, OVERHAUL, COMPLETE
- 3001 - WELDING
- 2280 - PAINT
- 2121 - SHAKEDOWN, OVERHAUL
- WELDING, COMPLETE

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## **TECHNOLOGY INSERTION**

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### **AGENDA**

#### **RESOURCE CONTROL CENTER (RCC)**

#### **UNIVERSAL DEPOT OPERATIONS SIMULATOR VERSION 2.0**

#### **VALIDATION AND BRAINSTORMING SESSION**

- **INTRODUCTION**
- **RCC REVIEW**
  - **SCHEDULE**
  - **FLOW PROCESS**
  - **SAMPLES OF INPUT FILES AND ASSUMPTIONS**
  - **UDOS 2.0 SIMULATION OVERVIEW**
- **MODEL OBJECTIVES**
- **MODEL VALIDATION CRITERIA**
- **MODEL OUTPUT ANALYSIS**
- **LOAD/TRIAL RUN AT ALC (FIRST RCC ONLY)**
- **BRAINSTORMING SESSION (SEE APPENDIX)**
- **MEETING MINUTES, ACTION ITEMS & CONCLUSIONS**

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07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**

## ***TECHNOLOGY INSERTION***

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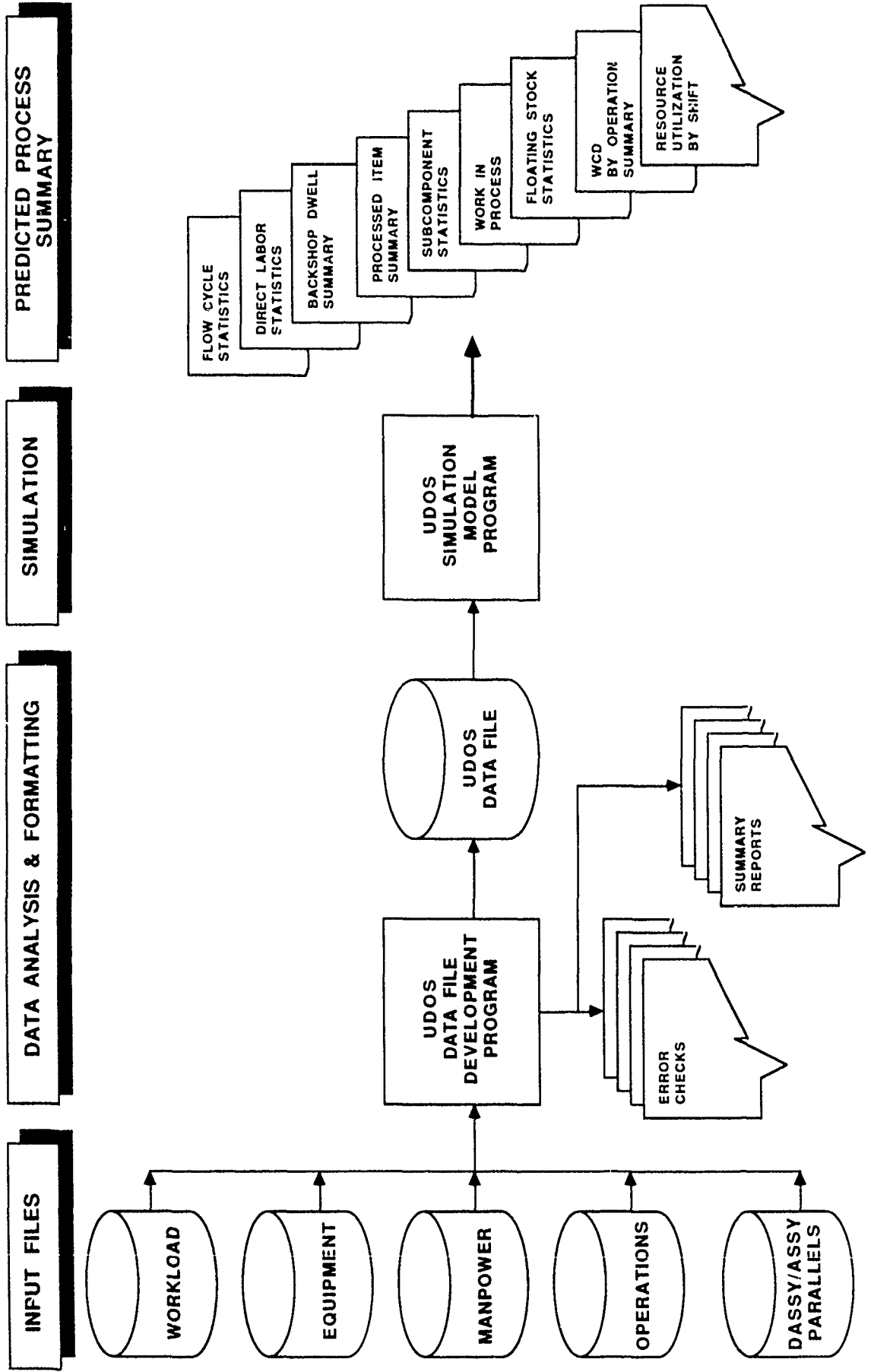
### **MODEL OBJECTIVE**

- VALIDATION WILL BE EVALUATED BY RCC AND RECOMMENDED FOR ACCEPTANCE BY RCC VALIDATION TEAM.
- THE MODEL IS AN APPROXIMATION OF THE "AS IS CONDITION" CAPTURED AT THE TIME OF INTERVIEW.
- INTENDED AS A TOOL FOR ENGINEERING ASSESSMENT OF SHOP OPERATIONS:
  - IMPROVED END ITEM THROUGHPUT.
  - IMPROVED UTILIZATION OF RESOURCES.
  - REDUCTION OF OPERATIONS COST.
- ALLOW EXPERIMENTATION OF CHANGES TO THE "AS IS" CONDITION WITHOUT CAPITOL INVESTMENT.
- THE MODEL WILL:
  - PROVIDE AN APPROXIMATION OF REALITY.
  - ESTABLISH A BASELINE FOR EXPERIMENTATION.
  - PROVIDES A USEFUL TOOL FOR EXPLORING THE EFFECT OF CHANGE WITHOUT DISRUPTION OF OPERATION.

07 JUNE 1989  
L. A. MAVROS

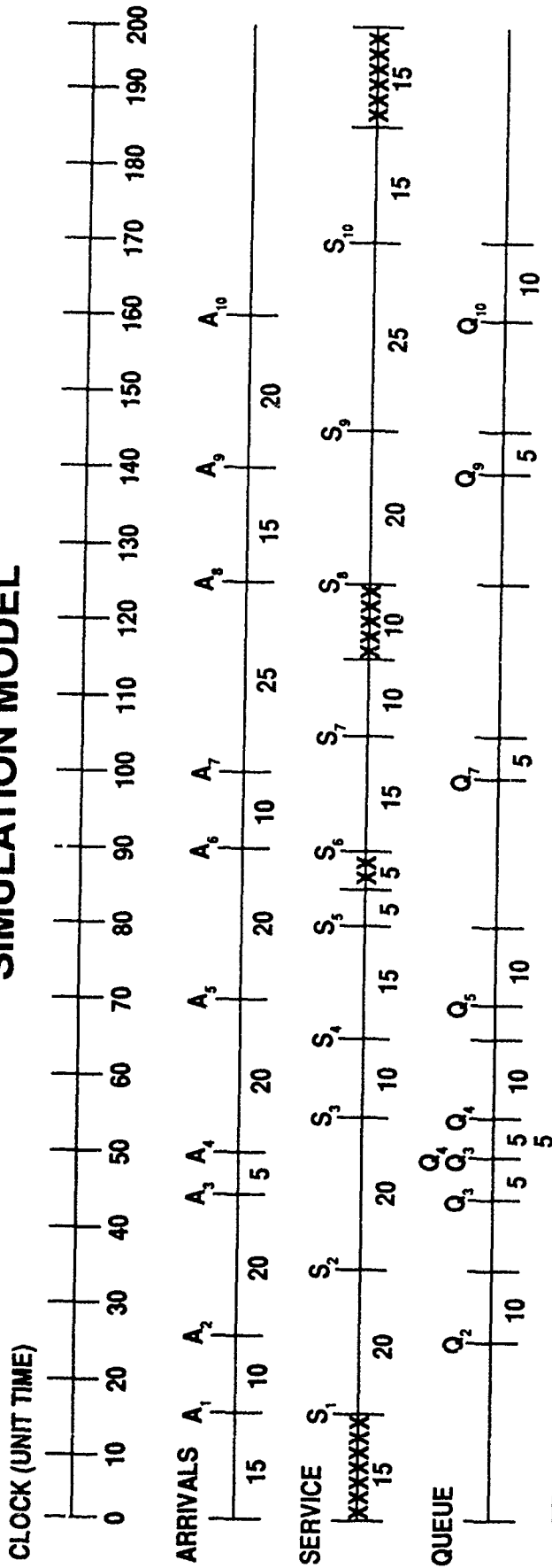
**AFLC/MDMSC**

# UDOS 2.0



# TECHNOLOGY INSERTION

## SIMULATION MODEL



STATISTICS: SERVICE 10 UNITS (THROUGHPUT)  
 TOTAL SERVICE TIME 155 UNIT TIMES  
 AVG. SERVICE TIME 15.5 UNIT TIMES  
 MAX. UNITS IN QUEUE 2  
 TOTAL IN QUEUE TIME 65 UNIT TIMES

AVG. IN QUEUE TIME 9.3 UNIT TIMES  
 AVG. ARRIVAL INTERVAL 16 UNIT TIMES  
 TOTAL IDLE TIME 45 UNIT TIMES  
 % UTILIZATION  $\frac{155}{200} = 77.5\%$

R. BOLANOS  
 16 JUNE 1989

## **TECHNOLOGY INSERTION**

### **MODEL VALIDATION CRITERIA**

- **SIMULATED THROUGHPUT vs AVAILABLE PRODUCTION DATA.**
  - **SCHEDULING**
  - **HISTORY**
- **SIMULATED FLOW DAYS vs BEST AVAILABLE RCC FLOW DAYS.**
  - **WCD HISTORY**
  - **SCHEDULING**
  - **SHOP FLOOR INTERVIEWS**
- **SIMULATED RESOURCE UTILIZATION vs ALC/RCC ASSESSMENT.**
  - **SHOP FLOOR INTERVIEWS**
  - **AREA MANAGER CONTROL DOCUMENTS**

07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**

## **TECHNOLOGY INSERTION**

### **THROUGHPUT VALIDATION CRITERIA**

- A COMPARISON BY PART NUMBER, BETWEEN ~  
SIMULATED THROUGHPUT & PRODUCTION DATA FOR A  
BASE YEAR.
- THE SIMULATED OUTPUT REPRESENTS A REASONABLE  
APPROXIMATION OF THE BASE YEAR PRODUCTION DATA  
USED AS A BASELINE FOR EXPERIMENTATION.

07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**

## **TECHNOLOGY INSERTION**

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### **FLOW DAYS VALIDATION CRITERIA**

- A COMPARISON, BY PART NUMBER, BETWEEN ~  
SIMULATED FLOW DAYS AND BEST AVAILABLE RCC FLOW  
DAYS, SUCH AS
  - HISTORICAL DATA
  - WORK CONTROL DOCUMENT (WCD)
  
- IN THE EVENT HISTORICAL DATA HAS BEEN PURGED OR IS  
NOT ACCURATE, THE VALIDATION TEAM WILL DETERMINE  
THE BEST SOURCE OF DATA THAT REPRESENTS A REASONABLE  
APPROXIMATION.

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07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**



OKLAHOMA CITY AIR LOGISTICS CENTER  
RESOURCE CONTROL CENTER MABPAB  
UNIVERSAL DEPOT OPERATIONS SIMULATOR (UDOS) VERSION 2.0  
VALIDATION CONFERENCE AND BRAINSTORMING SESSION  
AGENDA

MONDAY 22 MAY 1989

8:45 - 9:00 INTRODUCTION: EARL STAMPS - MABEBS  
9:00 - 10:00 MABPAB OVERVIEW: RICARDO BOLANOS  
SCHEDULE  
FLOW PROCESS  
PROCESS PROFILE  
10:00 - 10:15 BREAK  
10:15 - 10:30 MODEL EXPECTATIONS: RICARDO BOLANOS  
10:30 - 12:00 MODEL OUTPUT ANALYSIS: SCOTT VROMAN  
12:00 - 13:00 LUNCH  
13:00 - 16:00 MODEL VALIDATION/ADJUSTMENT RUN AT ST. LOUIS  
16:00 - 16:30 ACTION PLANING

TUESDAY 23 MAY 1989

9:00 - 18:00 DATA OUTPUT ANALYSIS  
& SECOND VALIDATION ADJUSTMENT RUN

WEDENSDAY 24 MAY 1989

9:00 - 10:00 LOAD/TRIAL RUN MABPAB UDOS 2.0 ON OC-ALC  
VAX

10:00 - 12:00 MODEL VALIDATION & CONCLUSIONS

13:00 16:00 BRAINSTORMING / TAGUCHI

OC-MABPAB

5/24/89

- A. REDUCTION ON MAN-POWER due to 80/20 WORKLOAD 'S : 19.5%
  - B. INCREASE ON MAN-POWER due to FY88 EFFICIENCY IS : 11.2%
  - C. REDUCTION ON INTERVIEW TIMES due to BREAKS & PFD OF ~~3~~ 7% IS : 89.13%
- } MAN POWER PROFILE.

$$\left( 8 \text{ hrs/day} - \frac{.33 \text{ min.}}{\text{TWO BREAKS}} \right) \times \underset{\text{PFD}}{.93} = 7.13$$

$$\frac{7.13}{8} = .8913.$$

THEREFORE :

A & B NET REDUCTION ON MAN POWER PROFILE FACTOR IS 8.3%

$$\begin{array}{r} 19.5 \\ - 11.2 \\ \hline 8.3\% \end{array}$$

1 <sup>ST</sup> QTR	5.6	x .917	=	5.135 hrs (5.14)
2 <sup>ND</sup> QTR	5.7	x .917	=	5.23
3 <sup>RD</sup> QTR	5.9	x .917	=	5.41
4 <sup>TH</sup> QTR	5.8	x .917	=	5.32

ON WEEK END or HOLIDAYS

$$(7.13 \text{ hrs} \times .917) = 6.54$$

C. OPERATION PROFILE REDUCTION ON MAN-POWER & EQUIPMENT TIMES

$$\text{I} \quad (5.6 \times .805) \times 1.112 = 5.04$$

$$\text{II} \quad (5.6 \times 1.112) \times .805 = 5.01$$

$$\text{III} \quad 5.6 \times \left( \frac{19.5 - 11.2}{19.5 - 11.2} \right) =$$
$$\times [1 - (19.5 - 11.2)] = 5.135$$

$$\begin{array}{r} 5.6 \\ - (5.6 \times 0.995) \\ + (5.6 \times 0.112) \\ \hline \end{array}$$

$$(10 \times .805) \times 1.112$$

↗ 80/20 WL      ↘ EFF.

$$10 \times 0.917$$

## **7.0 COMPUTER SIMULATION ANALYSIS OF RCC**

The computer simulation analysis for RCC MABPAB was previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

## **8.0 VALIDATION OF SIMULATION ANALYSIS**

The validation of simulation analysis for RCC MABPAB was previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

### MABPAB THROUGHPUT STATISTICAL ANALYSIS

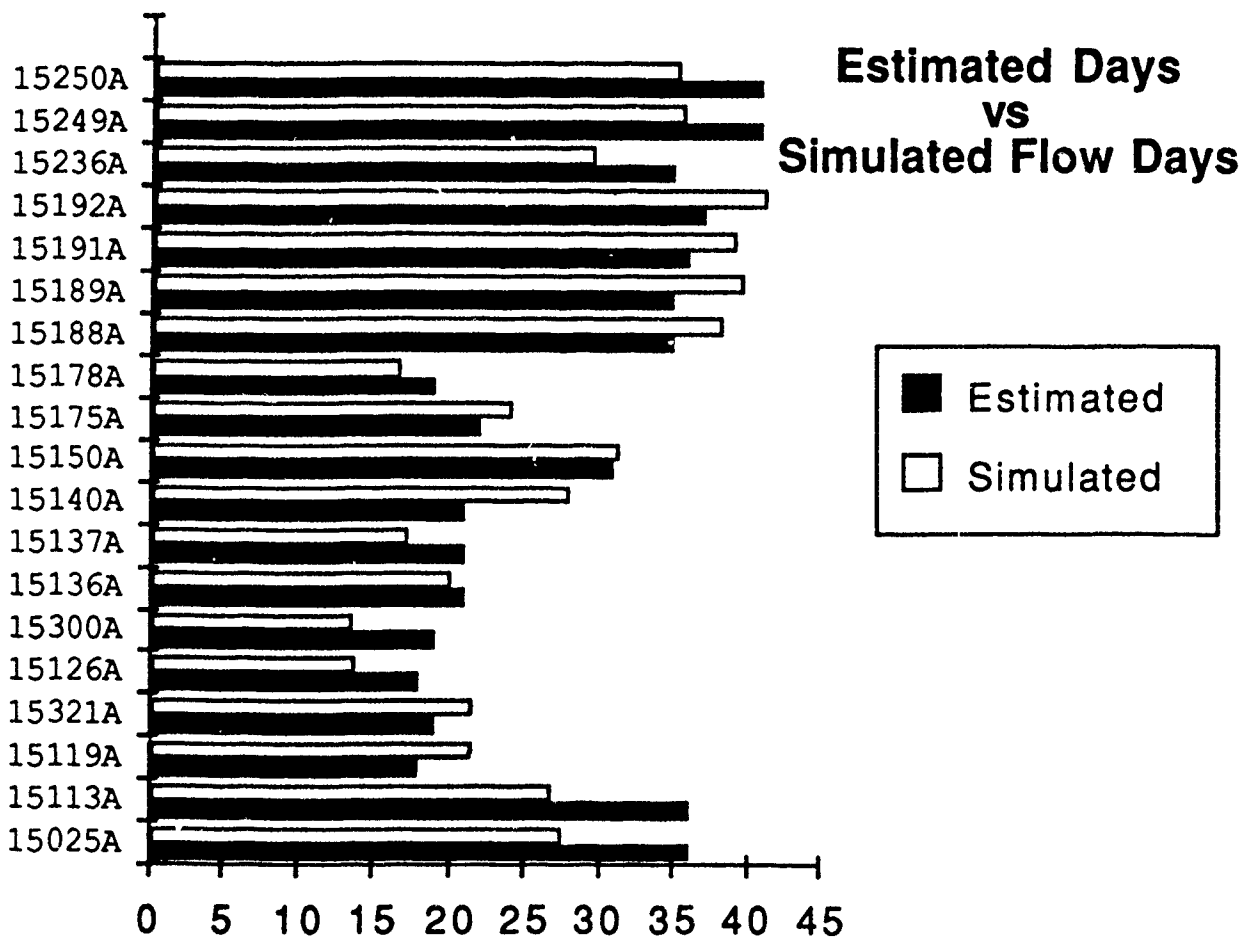
PART CONTROL NUMBER (PCN)	SIMULATED	FY 88 ACTUALS	% VARIANCE (SIM /ACTUALS)
15113A	233	243	-4%
15025A	214	240	-12%
15119A	65	69	-6%
15321A	65	69	-6%
15126A	68	69	-1%
15300A	67	69	-3%
15136A	73	76	-4%
15137A	69	73	-6%
15140A	17	45	-165%
15150A	122	154	-26%
15175A	69	71	-3%
15178A	202	220	-9%
15188A	56	58	-4%
15189A	54	60	-11%
15191A	47	55	-17%
15192A	33	39	-18%
15236A	34	34	0%
15249A	67	74	-10%
15250A	65	74	-14%
<b>SHOP AVERAGE</b>	<b>1620</b>	<b>1792</b>	<b>-11%</b>

### MABPAB FLOW HOURS STATISTICAL ANALYSIS

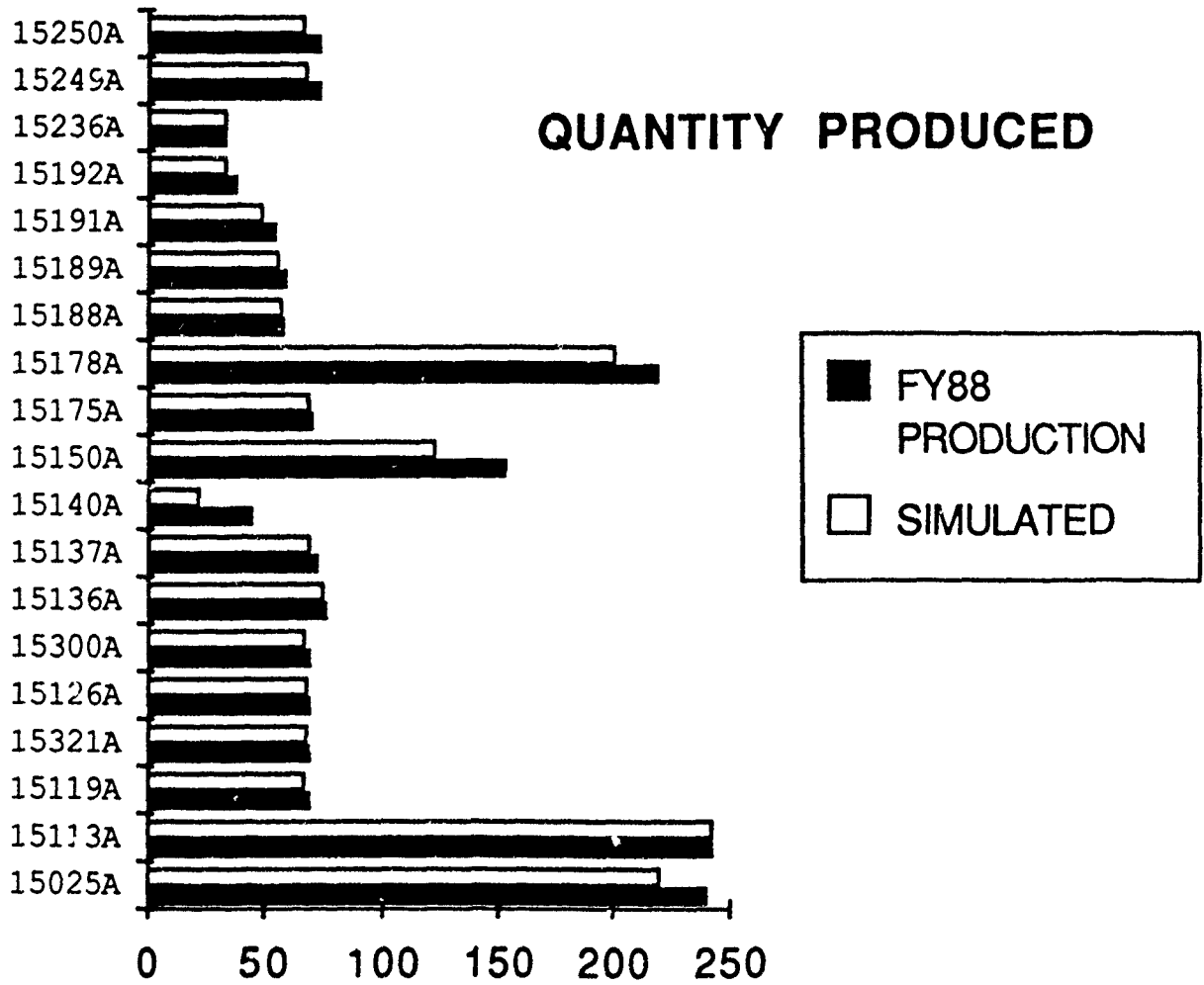
(PCN)	HISTORY	SIMULATED	G-019-C	% VARIANCE (SIM/HIST)	% VARIANCE (SIM/G-019-C)
15113A	1,276	810	864	-58%	-7%
15025A	1,628	848	864	-92%	-2%
15119A	1,178	571	432	-106%	24%
15321A	1,015	562	456	-81%	19%
15126A	892	349	432	-156%	-24%
15300A	376	363	456	-4%	-26%
15136A	767	481	504	-59%	-5%
15137A	441	452	504	2%	-12%
15140A	1,235	688	504	-80%	27%
15150A	1,453	820	744	-77%	9%
15175A	4,183	717	528	-483%	26%
15178A	360	411	456	12%	-11%
15188A	1011	1,059	840	5%	21%
15189A	873	1,126	840	22%	25%
15191A	1,028	1,050	864	2%	18%
15192A	731	1,155	892	37%	23%
15236A	1,689	777	840	-117%	-8%
15249A	156	963	984	84%	-2%
15250A	833	953	984	13%	-3%
<b>SHOP AVERAGE</b>	<b>21,125</b>	<b>14,155</b>	<b>12,988</b>	<b>-49%</b>	<b>8%</b>

LSC-20455

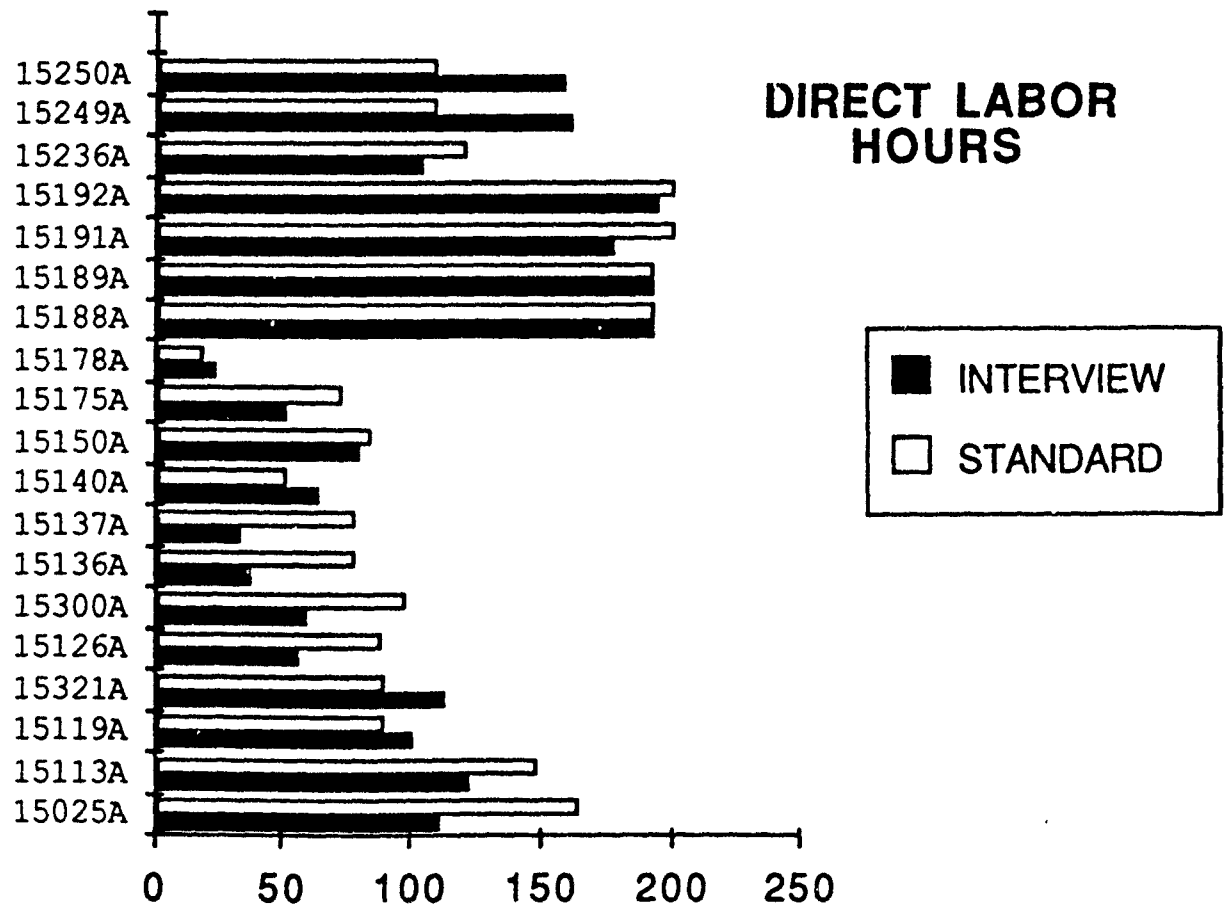


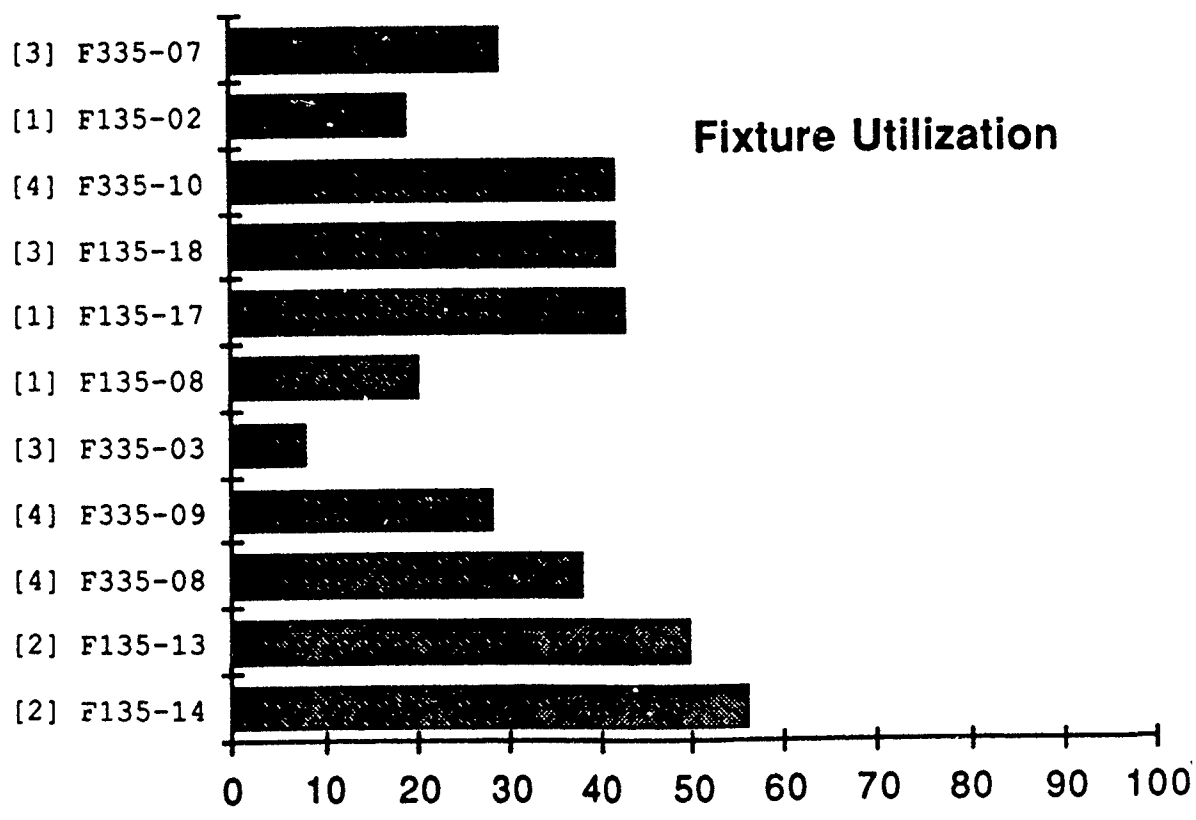


# QUANTITY PRODUCED

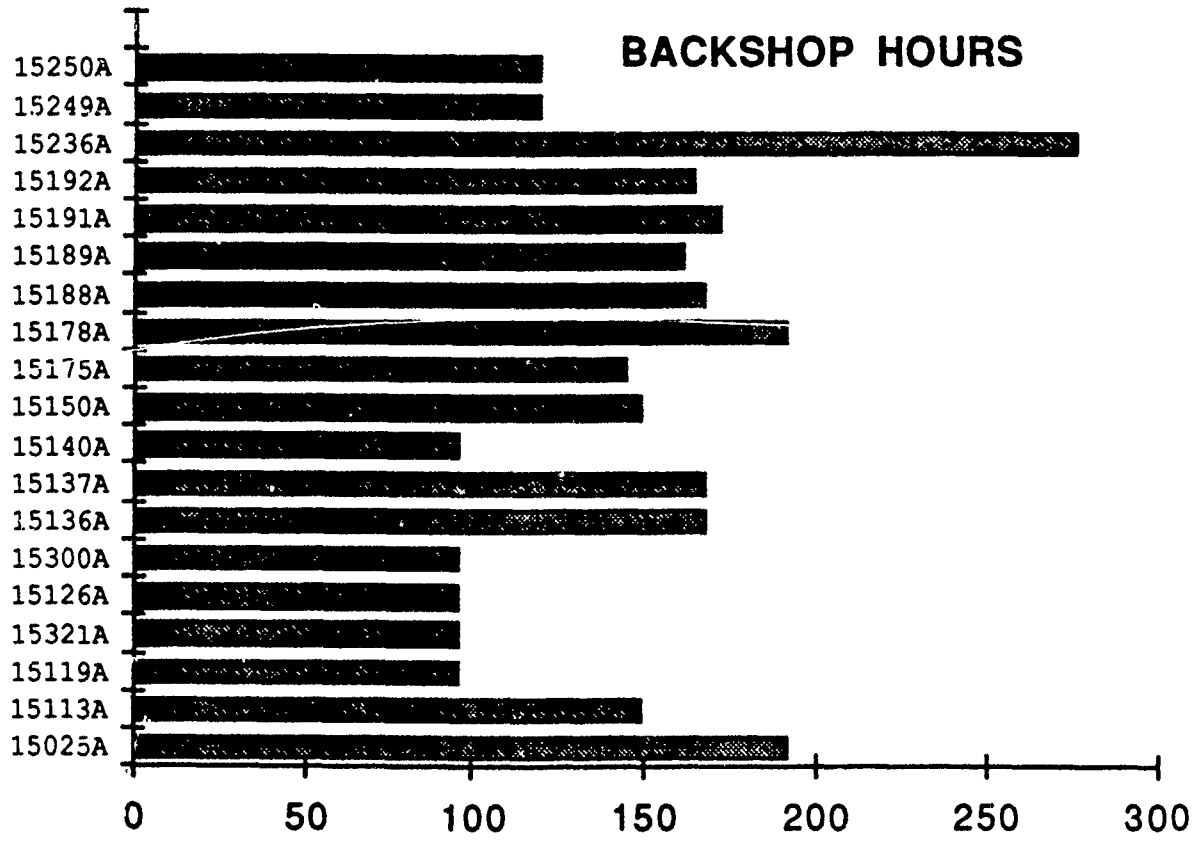


# DIRECT LABOR HOURS

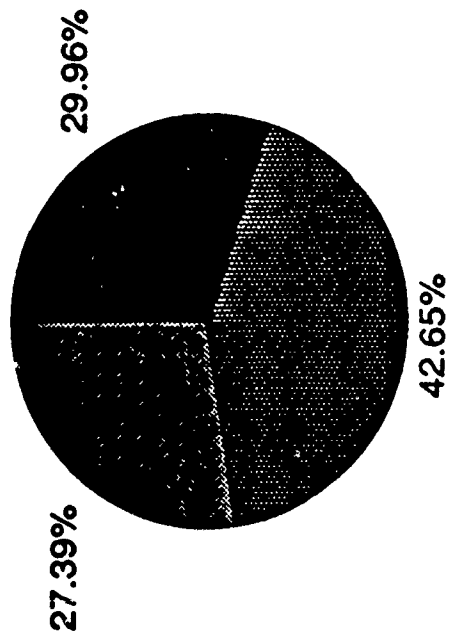




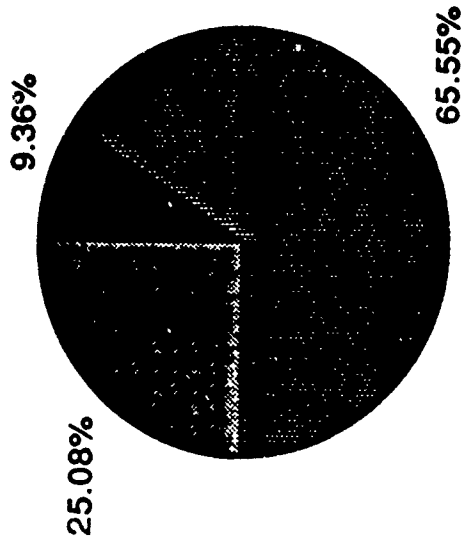
# BACKSHOP HOURS



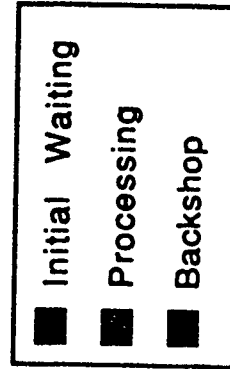
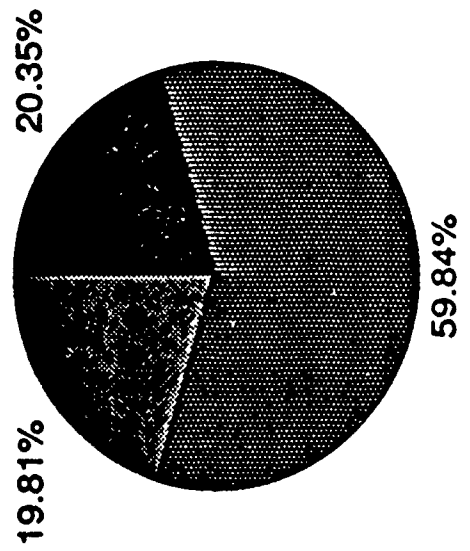
### 15025A PROCESSING SUMMARY



### 15113A PROCESSING SUMMARY

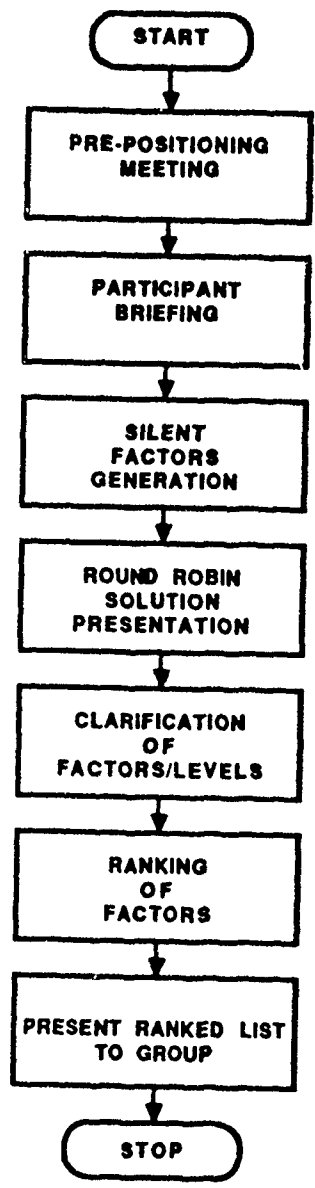


### 15150A PROCESSING SUMMARY



## **9.0 BRAINSTORMING**

The minutes for RCC MABPAB brainstorming were previously submitted under memo number NKE-E016-6955, dated June 5, 1989.



LSC-20462

### TI-ES BRAINSTORMING PROCESS



## 2.7 BRAINSTORMING SESSION

On the afternoon of Wednesday 24 May, a brainstorming session was conducted in accordance with the procedures set forth in enclosure 18. The problem addressed by this brainstorming session, the Taguchi Factors and levels identified during the session are summarized below:

<u>Problem Statement:</u>	How to move MABPAB from its current 100,000 square foot facility into a new 60,000 square foot facility and maintain FY90 workload and surge capacity.
<u>Taguchi Factors:</u>	Manpower (Control Factor) Equipment (Control Factor) Workload (Noise Factor)
<u>Levels:</u>	To be determined at a later date.

Table 2.7-1. Taguchi Factors.

<u>FACTORS</u>	<u>METHOD OF INVESTIGATION</u>
1) REDUCTION OF BREAK AREAS	Quick Fix (QF)
2) INCREASE MANPOWER ON 2ND SHIFT	Model (M)
3) BALANCE MANPOWER REPORTS BETWEEN 1ST & 2ND SHIFT	M
4) INCREASE NUMBER OF HIGHLY UTILIZED FIXTURES	M
5) MATERIAL CONTROL TO REDUCE QUEUES	Focus Study (FS)
6) INCREASE BACK SHOP DWELL TIME	M
7) OPTIMIZE SPACE REQUIREMENTS (COMPRESSED BARE MINIMUM)	FS
8) 3RD SHIFT POSSIBILITY	M
9) INCREASE MANPOWER AVAILABILITY BY X%	M
10) MODEL NEW FACILITY LAYOUT FOR EQUIPMENT	M
11) REDUCE WORK IN PROCESS	M
12) REDUCE DISTANCE TRAVELED INSIDE RCC	QF or FS
13) CONSOLIDATE SUPERVISOR'S OFFICES	M
14) OVERTIME	M
15) ELIMINATE EQUIPMENT & FIXTURES WITH MINIMUM UTILIZATION	M
16) DETERMINE WAR TIME SURGE CAPABILITY	M
17) INCORPORATE BACK SHOP OPERATIONS	M
18) INCREASE WORKLOAD FROM 18.1 TO 18.5 LEVEL INDUCTIONS	M
19) DECREASE WORKLOAD	M
20) CONTINUITY BETWEEN SHIFTS	M
21) ESTABLISH PICK UP CREW ON 3RD SHIFT	M
22) MOBILE TAGING UNIT	QF
23) INCORPORATE STAGING AREA	FS
24) MODEL FIXTURE FORCASTS	M

### **3.0 LIST OF ATTENDEES**

The list of attendees is provided as enclosure 1 to these meeting minutes. Those not in attendance for the entire conference and brainstorming session are so indicated.

### **4.0 CONFERENCE AGENDA**

The modified agenda reflecting actual conference sequence is provided as enclosure 2 to these meeting minutes.

### **5.0 PRESENTATION MATERIALS**

Presentation materials used during the MABPAB UDOS 2.0 Validation Conference are provided as enclosure 3 to these meeting minutes.

### **6.0 VALIDATION FORM**

The Validation Form form signed at the conclusion of the MABPAB UDOS 2.0 Validation Conference is provided as enclosure 4 to these meeting minutes.

### **7.0 ACTION ITEMS**

Action items annotated on the Validation Form referenced in paragraph 6.0 have been recorded of Action Item forms and are included as enclosure 5 of these meeting minutes.

### **8.0 MODEL INPUT/OUTPUT FILE PRINTOUTS**

MABPAB UDOS 2.0 model input files and output files which resulted in validation of the model are provided as enclosures 6 through 17.

Factors

↳ How allocate MABPFB into 60k's 100 K S  
↓  
60k's

- |  |             |                                 |
|--|-------------|---------------------------------|
| 1) <del>Reduction</del> of break areas.  | <u>DONE</u> | Quick fix<br>( <del>M</del> ) F |
| 2) Increase $\frac{MP}{L}$ in 2 <sup>nd</sup> shift  |             | M                               |
| 3) <del>maximize</del> $\frac{MP}{L}$ reports between 1 <sup>st</sup> & 2 <sup>nd</sup> shift          |             | M                               |
| 4) Increase number of <del>utilized</del> fixtures   |             | M                               |
| 5) Material control to reduce queues   |             | IS                              |
| 6) Increase back shop dwell time   |             | M                               |
| 7) Optimize space requirements<br>Completed base $\frac{\text{requirements}}{\text{minimum}}$          |             | FS <sup>local study</sup>       |
| 8) 3 <sup>rd</sup> shift Possibility   |             | M                               |
| 9) Increase $\frac{MP}{L}$ availability by x%  |             | M                               |
| 10) model new facility layout for eqmt   |             | M                               |
| 11) Reduce work in process   |             | M                               |
| 12) Minimize <del>distance</del> <sup>travel</sup> inside RCC  |             | CF or FS                        |
| 13) Consolidate Supv's Ofcs  |             | <del>FS</del> M                 |
| 14) Overtime   |             | M                               |
| 15) Eliminate Eqmt + $\frac{\text{figures}}{\text{at}}$ $\frac{\text{maximum utilization}}{\text{of}}$ |             | M                               |
| 16) <sup>Determine</sup> War Line: Surge <del>Rate</del> Capacity                                      |             | M                               |
| 17) Incorporate back shop Operations   |             | M                               |

same

- 18) Increase workload: <sup>18.1</sup> Decre. Inductions  
<sub>18.5</sub> Increase Inductions M
- 19) Decrease workload M
- 20) Continuity between shifts M
- 21) Establish Pick Up crew on 3<sup>rd</sup> shift M M M
- 22) Mobile Lightening Unit GF
- ~~23) Change Reactor Inductions~~
- 23) Incorporate Staging Area FS
- 24) Model Future Forecasts M

Priority (per Scott)

Identifying the factors

similarities  
2, 3, 20, 21

Continuity of shifts  
Incr Util. & fixtures

- New Eqmt Profile → levels
- manpower → levels
- Workload → levels

# of fixtures)

- Now we have the same number of manhours only distributed across different shifts -
- Need to include increased manhours such as weekends -
- This could be the same as adding people -

- Validation -

~~34 hrs~~

One week - 7 days

40 hours

$$\left( \frac{56}{40} = 1.4 \right) \quad \frac{48}{40} = 1.2$$

$$\{ 1.204 \} \quad \text{1.08}$$

Examine People distribution  
 by shift, staffing level and  
 Equipment (no. of fixtures) versus  
 FY 90 and surge workload.  
 This examination is limited to  
 Part no. 15025A and 15133A  
 (left and right hand side coul)  
 at MABFAB, Tinker AFB.

High Equip, High workload -  
 → 60% above  
 Work load 1.6  
 - 2 shift - 7 days  
14% down from 72 hours a  
week → when in a surge  
mode -

People =  
 60 hours - 9  
 72 hours - 9

split people between shifts -  
 and work overtime -  
 $\frac{1}{3} \rightarrow 27 \text{ people}$   
 $2.1 \times 40 = \text{every one works}$

People - more

- Baseline  
- Baseline + 60%

200 - Baseline - Effective hours  
320 - surge

- Need to have increase in  
workload / person  
also additional people (?)



MEMO


19 June 1989  
TI-89-FJL-0199

Subject: TECHNOLOGY INSERTION-ENGINEERING SERVICES (TI-ES) TASK ORDER  
NO. 1 PRELIMINARY EXPERIMENTATION RESULTS FOR OC-ALC (RCC MABPAB)

To: R. G. Bolanos, R. Donnelly Jr., C. J. Gonzales, B. Kirk,  
L. A. Mavros, M. S. McCoy, File

Encl: (1) Transmittal Letter NKE-E016-6971, dated 15 June 1989  
(2) Task Order No. 1 Process Characterization, OC-ALC, RCC  
MABPAB Sheetmetal Backshop

1. Enclosures (1) and (2) are provided as internal distribution.
2. If you have any questions or comments, contact R. G. Bolanos at Ext. 925-5840, or the writer.

  
F. J. Lauber  
T. I. Program Administration  
E510/0922272, Sta. 925-5406

FJL:ksf

0048P/5

**MCDONNELL DOUGLAS**

McDonnell Douglas  
Missile Systems Company

15 June 1989  
NKE-E016-6971

CORRESPONDENCE  
ACTION  
ITEM  
RESPONSE

YES  NO

*L.A. MAVROS*  
L.A. MAVROS

*R. Donnelly*  
R. DONNELLY JR.

Subject: Contract F33600-88-D-0567, Technology Insertion Engineering Services, Process Characterization at OC-ALC (RCC MABPAB)

To: Department of the Air Force  
Attention: Ms J. Hoyt (PMRP)  
Contracting Officer  
Building 1, Area C  
Wright Patterson Air Force Base, Ohio 45433-5320

Reference: (a) Task Order No. 1, Cure Notice MOA, dated 17 March 1989

Enclosure: (1) Task Order No. 1, Process Characterization: OC-AL RCC MABPAB - Sheetmetal Backshop

1. As required by Paragraph (1) of Reference (a), McDonnell Douglas Missile Systems Company (MDMSC) expedited process characterization of the subject RCC. Data collection, model validation, and experimentation has been completed and, accordingly, MDMSC herein submits Enclosure (1). MDMSC will include the applicable Quick Fix Plans and focus study recommendations in the Block 1 Contract Summary Report.

2. Please address any questions or requests for additional information to the undersigned at (314) 233-8724.

*O.W. Engelbart*  
D. W. Engelbart  
Senior Contracts Administrator  
Advanced Programs

EC: Department of the Air Force  
HQ AFLC/MAQF  
Attn: Doxie Cripe  
Wright Patterson AFB, OH 45433-5320

IC: *G. Eisenhart*  
F. Lauber (Bldg. 92 Dist)  
Contract Files  
D. Engelbart  
Master Files

AFTER FINAL  
SIGNATURE  
RETURN TO:

LETTER

ENCLOSURE

SEE  NEXT TO LADDER SIGNATURE  
IN APPROPRIATE BOX  
IF COPY IS DESIRED

RAH-96/5  
MDE 14-27-1 (REV 22 AUG 88)

**MASTER FILE**

P.O. Box 516, Saint Louis, MO 63166-0516 (314) 232-0232 TELEX 44-857

**TECHNOLOGY INSERTION ENGINEERING SERVICES  
PROCESS CHARACTERIZATION**

**(TASK ORDER NO. 1)  
OC/ALC RCC MABPAB  
Sheetmetal Backshop  
15 JUNE 1989  
(PRELIMINARY)**

**CONTRACT NO. F33600-88-D-0567**

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

**Enclosure (1)**

**OC/ALC MABPAB  
Sheetmetal Repair Shop**

**Results**

The expedited MABPAB experimentation required by the MOA was completed June 15, 1989 on schedule. Preliminary Taguchi results indicated that moving MABPAB from approximately a 100,000 sq. ft. to a 65,000 sq. ft. will require certain considerations if the projected FY-90 workload is to be met.

A 65,000 sq. ft. facility, one shift will produce 66.5% of the FY-90 projected workload. Addition of a second shift will increase the FY-90 thruput to approx. 94%. The addition of assembly fixtures for 15249 & 15250(outboard left hand and right hand aileron assembly) will increase the thruput for one shift from 66.5% to 78.3%. If additional assembly fixtures are added, increased floor space is required.

**Surge Requirement**

Surge requirement was calculated on 1.6 of the FY-90 projected workload. It is assumed that during war time conditions 3 shifts will be used raising the thruput to 93.35%. If the additional assembly fixtures are installed the projected surge thruput will increase to 98.5%. However it should be noted that additional floor space is required.

Additional analysis of the Taguchi results will be made and if warranted a focus study will be recommended.

**MDMSC recommends the following:**

- Maintain the three existing aileron assembly fixtures.
- Increase floor space to accommodate the three aileron fixtures.
- Add a second shift as required.
- Consider a stand alone sheet metal shop by the addition of paint, welding and sand blasting capabilities.

Enclosure (1)

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP      6/15/89

END-ITEM	FY90 INDUCTIONS	BASE SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	182	40	22.0%
15250A	195	47	24.1%
15119A	170	65	38.2%
15321A	161	74	46.0%
15175A	151	82	54.3%
15126A	175	111	63.4%
15300A	184	117	63.6%
15140A	106	72	67.9%
15136A	212	164	77.4%
15137A	201	180	89.6%
15113A	134	124	92.5%
15025A	136	131	96.3%
15150A	146	141	96.6%
15189A	19	19	100.0%
15236A	23	23	100.0%
15192A	12	12	100.0%
15191A	16	16	100.0%
15178A	177	177	100.0%
	=====	=====	=====
	2400	1595	66.5%

40 HOUR WEEK , ONE SHIFT

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP      6/15/89

END-ITEM	FY90 INDUCTIONS	BASE #5 SIMULATION	THROUGHPU
15188A	0	0	N/A
15237A	0	0	N/A
15249A	182	112	61.5%
15250A	195	142	72.8%
15113A	134	129	96.3%
15126A	175	170	97.1%
15119A	170	166	97.6%
15175A	151	148	98.0%
15025A	136	134	98.5%
15136A	212	209	98.6%
15150A	146	145	99.3%
15189A	19	19	100.0%
15236A	23	23	100.0%
15300A	184	184	100.0%
15192A	12	12	100.0%
15137A	201	201	100.0%
15321A	161	161	100.0%
15140A	106	106	100.0%
15191A	16	16	100.0%
15178A	177	177	100.0%
	2400	2254	93.9%

2 SHIFTS, <sup>6</sup>/~~7~~ DAYS A WEEK

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP

6/15/89

END-ITEM	SURGE INDUCTIONS	BASE #9 SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	297	173	58.2%
15250A	309	213	68.9%
15175A	261	242	92.7%
15189A	31	29	93.5%
15236A	47	44	93.6%
15150A	254	247	97.2%
15140A	178	176	98.9%
15025A	224	222	99.1%
15136A	358	355	99.2%
15126A	279	277	99.3%
15113A	219	218	99.5%
15300A	287	286	99.7%
15137A	327	326	99.7%
15178A	286	286	100.0%
15191A	24	24	100.0%
15119A	277	277	100.0%
15321A	249	249	100.0%
15192A	18	18	100.0%
	3925	3662	93.3%

3 SHIFTS, 7 DAYS A WEEK

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP 6/15/89

END-ITEM	SURGE INDUCTION	BASE #9 SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	297	283	95.3%BASE ++
15250A	309	309	100.0%BASE ++
15175A	261	242	92.7%
15189A	31	29	93.5%
15236A	47	44	93.6%
15150A	254	247	97.2%
15140A	178	176	98.9%
15025A	224	222	99.1%
15136A	358	355	99.2%
15126A	279	277	99.3%
15113A	219	218	99.5%
15300A	287	286	99.7%
15137A	327	326	99.7%
15178A	286	286	100.0%
15191A	24	24	100.0%
15119A	277	277	100.0%
15321A	249	249	100.0%
15192A	18	18	100.0%
=====			
	3925	3868	98.5%

3 SHIFTS, 7 DAYS A WEEK PLUS ADDITIONAL AILERON FIXTURES



OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP      6/15/89

END-ITEM	FY90	BASE #5	THROUGHPUT
	INDUCTION	SIMULATION	
15188A	0	0	N/A
15237A	0	0	N/A
15249A	182	116	63.7%BASE ++
15250A	195	146	74.9%BASE ++
15113A	134	129	96.3%
15126A	175	170	97.1%
15119A	170	166	97.6%
15175A	151	148	98.0%
15025A	136	134	98.5%
15136A	212	209	98.6%
15150A	146	145	99.3%
15189A	19	19	100.0%
15236A	23	23	100.0%
15300A	184	184	100.0%
15192A	12	12	100.0%
15137A	201	201	100.0%
15321A	161	161	100.0%
15140A	106	106	100.0%
15191A	16	16	100.0%
15178A	177	177	100.0%
	----- 2400	----- 2262	----- 94.3%

2 SHIFTS, 5 DAYS A WEEK PLUS ADDITIONAL AILERON FIXTURES

## MABPAB TAGUCHI EXPERIMENTAL RESULTS - FY 90 SURGE

PART CONTROL NUMBER (PCN)	FY 90 INDUCTIONS	RUN #1	RUN #2	RUN #3	RUN #4	RUN #5	RUN #6	RUN #7	RUN #8	RUN #9
15113	219	189	218	219	219	218	219	219	217	218
15025	224	150	208	213	224	222	222	222	222	222
15119	277	51	143	200	259	213	259	275	274	277
15321	249	71	112	183	234	144	256	249	248	249
15126	279	116	225	279	276	277	277	275	277	277
15300	287	112	234	287	288	286	286	287	286	286
15136	358	161	355	355	353	354	354	358	355	355
15137	327	186	327	327	324	324	325	327	326	326
15140	178	71	173	173	173	174	176	174	177	176
15150	254	185	229	226	231	243	243	240	245	247
15175	261	82	157	187	217	213	232	231	248	242
15178	286	286	286	286	286	286	286	286	286	286
15188	0	0	0	0	0	0	0	0	0	0
15189	31	30	29	30	30	29	29	29	29	29
15191	24	24	24	24	24	24	24	24	24	24
15192	18	18	18	18	18	18	18	18	18	18
15236	47	44	45	45	44	45	45	45	45	44
15249	297	27	56	91	121	116	143	147	283	173
15250	309	33	79	110	158	147	179	196	316	213
THROUGHPUT	3,925	1,836 46.8 %	2,918 74.3 %	3,253 82.9 %	3,479 88.6 %	3,333 84.9 %	3,573 91.0 %	3,602 91.8 %	3,876 98.8 %	3,662 93.3 %

LSC-20460

## MABPAB TAGUCHI EXPERIMENTAL RESULTS - FY 90

PART CONTROL NUMBER (PCN)	FY 90 INDUCTIONS	RUN #1	RUN #2	RUN #3	RUN #4	RUN #5	RUN #6	RUN #7	RUN #8	RUN #9
15113	134	124	127	127	128	129	129	130	131	130
15025	136	131	136	135	135	134	133	133	134	134
15119	170	65	128	172	168	166	167	166	171	171
15321	161	74	130	161	161	161	161	161	161	161
15126	175	111	170	169	170	170	170	170	170	170
15300	184	117	184	184	184	184	184	184	184	184
15136	212	164	209	208	211	209	210	208	211	211
15137	201	180	199	199	200	201	201	201	200	200
15140	106	72	104	105	105	106	106	106	106	107
15150	146	141	142	141	145	145	144	144	145	145
15175	151	82	135	144	145	148	149	146	149	150
15178	177	177	177	177	177	177	177	177	177	177
15188	0	0	0	0	0	0	0	0	0	0
15189	19	19	19	18	18	19	19	19	19	19
15191	16	16	16	16	16	16	16	16	16	16
15192	12	12	12	12	12	12	12	12	12	12
15236	23	23	23	23	23	23	23	23	23	23
15249	182	40	73	89	116	112	143	144	177	178
15250	195	47	90	111	146	142	183	179	198	198
THROUGHPUT	2,400	1,595 66.5 %	2,074 86.4 %	2,190 91.3 %	2,260 94.2 %	2,254 93.9 %	2,327 97.0 %	2,319 96.6 %	2,384 99.3 %	2,386 99.4 %

LSC-20459

JUNE 2, 1989

WORKLOAD / EXPERIMENTATION:

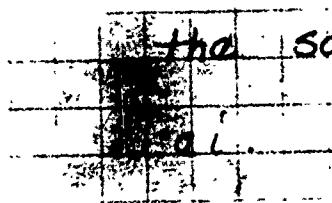
ON JUNE 1<sup>ST</sup> WE HAD A TELE-CONFERENCE WITH EARL STAMPS & STAFF TO STRUCTURE THE ORTHOGONAL ARRAY FOR MODEL EXPERIMENTATION USING TAGUCHI CONCEPT.

- ISSUES :
- MANPOWER DISTRIBUTION
  - FY90 WORKLOAD
  - FY90 SURGE.

• MAN POWER :

NOW WE HAVE THE SAME NUMBER OF MANHOURS ONLY DISTRIBUTED ACROSS DIFFERENT SHIFT.

NEED TO INCLUDE INCREASED MANHOURS SUCH AS WEEKENDS



THIS COULD BE THE SAME AS ADDING PEOPLE.

40 HOURS BASE

$$\frac{48}{40} = 1.2$$

$$\frac{56}{40} = 1.4$$

EFFICIENCY (90%) 1.08

1.204

- WORKLOAD DRIVES RESOURCE NEEDS

- ON SURGE CONDITION

60% INCREASE OR WORKLOAD FACTOR OF 1.6  
2 SHIFT 7/DAYS 12 HOURS/SHIFT.

- HOWEVER EFFICIENCY FACTOR ARE :

60 HOURS/WK  $\rightarrow$  90%

72 HOURS/WK  $\rightarrow$  86%

- SPLIT PEOPLE BETWEEN SHIFT

† WORK OVERTIME.

May 31 / JUNE

	WORKLOAD FY-90				MAX WIP	
	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>r</sup>	4 <sup>th</sup>		
15025A	25	39	35	37	15	
15113A	28	35	34	37	15	
15119A	44	42	43	41	3	12
15321A	43	38	41	39	3	12
15126A	45	43	44	43	4	16
15300A	49	44	46	45	4	16
15136A	55	51	54	52	4	16
15137A	52	49	50	50	4	16
15140A	23	27	27	29	8	12
15150A	31	40	34	41	18	
15175A	18	39	38	56	3	12
15178A	41	46	45	45	5	15
15188A	-	-	-	-	-	
15189A	4	4	5	6	4	
15191A	4	4	4	4	4	
15192A	3	3	3	3	4	
15236A	5	9	9	6	4	
15249A	41	49	48	44	4	12
15250A	50	46	50	49	5	15

# TECHNOLOGY INSERTION

## MABPAB FY-90 WORKLOAD

END ITEM	QUARTER				MAX WIP
	1st	2nd	3rd	4th	
15025A	25	39	35	37	15
15113A	28	35	34	37	15
15119A	44	42	43	41	12
15321A	43	38	41	39	12
15126A	45	43	44	43	16
15300A	49	44	46	45	16
15136A	55	51	54	52	16
15137A	52	49	50	50	16
15140A	23	27	27	29	12
15150A	31	40	34	41	18
15175A	18	39	38	56	12
15178A	41	46	45	45	15
15189A	4	4	5	6	4
15191A	4	4	4	4	4
15192A	3	3	3	3	4
15236A	5	9	9	6	4
15249A	41	49	48	44	12
15250A	50	46	50	49	15

E. STAMP  
07 JUNE 1989

AFLC/MDMSC

**TECHNOLOGY INSERTION**

**MABPAB FY-90 MANPOWER**

SKILL CODE	QUANTITY QUARTER				FACTOR QUARTER			
	1st	2nd	3rd	4th	1st	2nd	3rd	4th
AS	13	18	16	17	5.0	5.3	6.1	5.9
BS	14	16	15	16	5.0	5.3	6.1	5.9
CS	10	16	16	12	5.0	5.3	6.1	5.9
DS	7	9	8	8	5.0	5.3	6.1	5.9
ES	75	72	72	71	5.0	5.3	6.1	5.9
FS	78	78	78	80	5.0	5.3	6.1	5.9

**E. STAMP**

**07 JUNE 1989**

**AFLC/MDMSC**



**TECHNOLOGY INSERTION**

**MABPAB Equipment Profile (Benches)**

CODE	QUANTITY	END ITEM
25	13	15025A
113	13	15113A
119	3	15119A/15321A
126	3	15126A/15300A
136	6	15136A/15137A
140	7	15140A
150	18	15150A
175	3	15175A
178	5	15178A
188153	6	15188A/15189A
188154	6	15191A/15192A
236	4	15236A
249	7	15249A/15250A

**E. STAMP**

**07 JUNE 1989**

**AFLC/MDMSC**

**TECHNOLOGY INSERTION**

**MABPAB Equipment Profile (Fixtures)**

<b>CODE</b>	<b>QUANTITY</b>	<b>END ITEM</b>
F335-03	2	15136A/15137A
F135-02	1	15191A/15192A
F335-07	1	15249A/15250A
F335-08	3	15119A/15321A
F335-09	3	15126A/15300A
F135-08	1	15140A
F135-18	3	15175A
F135-13	2	15113A
F135-14	2	15025A
F335-10	3	15188A5061/15189A5061
F135-17	1	15150A

**E. STAMP**  
**07 JUNE 1989**

**AFLC/MDMSC**

**TECHNOLOGY INSERTION**

**MABPAB SHEET METAL  
TAGUCHI ORTHOGONAL ARRAY**

RUN #	MANPOWER	FACTOR	EQUIPMENT	WORKLOAD	
				FY 90	FLOW TIMES
					SURGE
1	1	1	1		
2	1	2	2		
3	1	3	3		
4	2	1	3		
5	2	2	1		
6	2	3	2		
7	3	1	2		
8	3	2	3		
9	3	3	1		

E. STAMP

07 JUNE 1989

**AFLC/MDMSC**

# TECHNOLOGY INSERTION

## MABPAB SHEET METAL TAGUCHI ORTHOGONAL ARRAY

RUN #	MANPOWER			OVERTIME			EQUIPMENT	FY 90	WORKLOAD	
	1	2	3	SAT	SUN	FLOW TIMES			SURGE	
1	ALL						BASE	66.5		
2	ALL			YES			BASE +	86.4		
3	ALL			YES	YES		BASE ++	94.3		
4	50%	50%					BASE ++	94.2		
5	50%	50%		YES			BASE	93.9		
6	50%	50%		YES	YES		BASE +	97.0		
7	1/3	1/3	1/3				BASE +	96.6		
8	1/3	1/3	1/3	YES			BASE ++	99.3		
9	1/3	1/3	1/3	YES	YES		BASE	99.4		

E. STAMP  
07 JUNE 1989

AFLC/MDMSC

**TECHNOLOGY INSERTION**

**MABPAB Equipment Quantities**

<b>CODE</b>	<b>BASE +</b>	<b>BASE ++</b>
119	4	6
126	4	6
136	8	10
249	9	11
F135-8	2	3
F135-18	4	5
F335-09	4	5

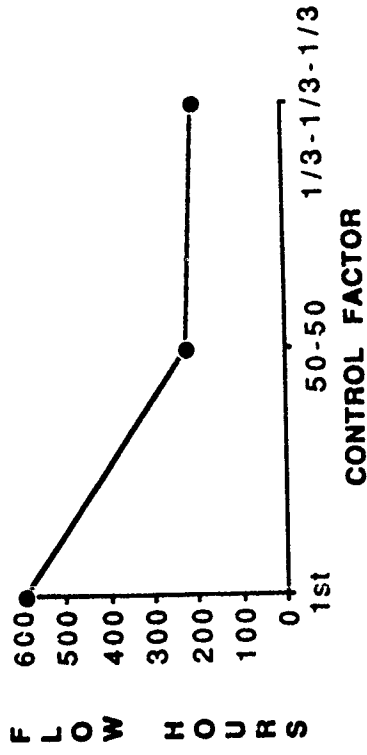
**E. STAMP**  
**07 JUNE 1989**

**AFLC/MDMSC**

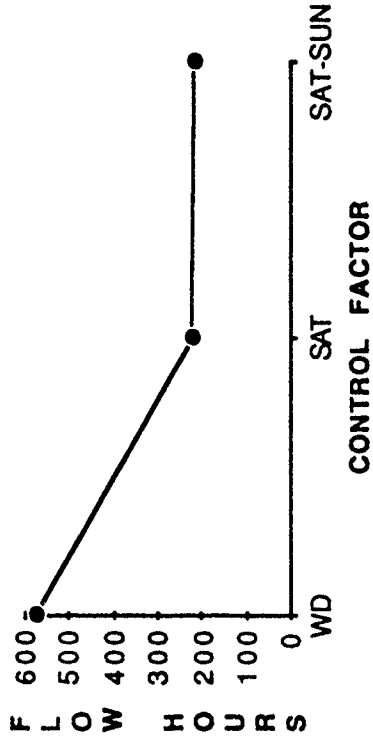
# TECHNOLOGY INSERTION

MABPAB EXPERIMENTATION RESULTS  
 FY 90 WORKLOAD  
 15126A/15300A

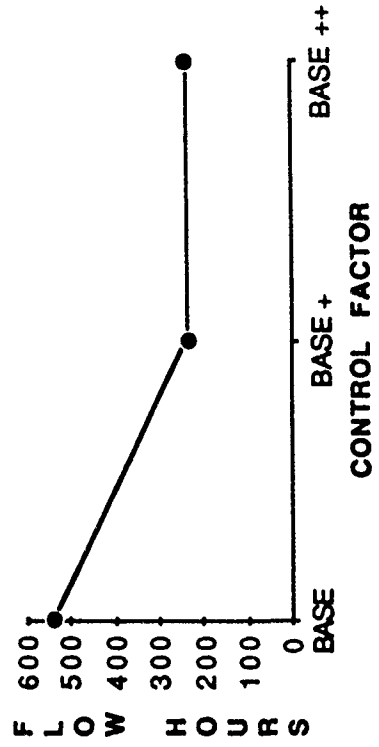
## MANPOWER



## FACTOR



## EQUIPMENT



E. STAMPS  
 07 JUNE 1989

AFLC/MDMSC

EXPERIMENT DATA CALCULATION  
FLOW HOURS

R U N #	ITEM #		=	AVERAGE
	15126A	15300A		
1	1176	1291	=	1233.5
2	271	288	=	279.5
3	257	268	=	262.5
4	263	272	=	267.5
5	203	208	=	202.5
6	201	205	=	203.0
7	221	234	=	227.5
8	188	190	=	189.0
9	185	187	=	186.0

MABPAB EXPERIMENT DATA CALCULATIONS

MP1			
1233.5+279.5+262.5	=		591.8
MP2			
267.5+202.5+203	=		224.3
MP3			
227.5+189+186	=		200.8
F1			
1233.5+267.5+227.5	=		576.2
F2			
279.5+202.5+189	=		223.7
F3			
262.5+203+186	=		217.2
EQ1			
1233.5+202.5+186	=		540.7
EQ2			
279.5+203+227.5	=		236.7
EQ3			
262.5+267.5+189	=		239.7

CC: OC RCC: MASPAB QUARTER: 4 DATE: 3-JUN-89 TIME: 17:59:00 KEPI.ID: EAP W7

ITEM INDUCTIONS

ITEM	1ST QTR	2ND QTR	3RD QTR	4TH QTR	YTD	(MISTR)
115A	35	39	34	37	134	(MISTR)
119A	40	43	35	37	136	(MISTR)
121A	40	43	41	41	171	(MISTR)
126A	40	44	44	43	175	(MISTR)
136A	40	44	46	45	184	(MISTR)
137A	40	44	46	45	184	(MISTR)
140A	40	44	46	45	184	(MISTR)
155A	40	44	46	45	184	(MISTR)
178A	40	44	46	45	184	(MISTR)
189A	40	44	46	45	184	(MISTR)
189ASUB1	40	44	46	45	184	(MISTR)
191A	40	44	46	45	184	(MISTR)
191ASUB1	40	44	46	45	184	(MISTR)
192A	40	44	46	45	184	(MISTR)
192ASUB1	40	44	46	45	184	(MISTR)
193A	40	44	46	45	184	(MISTR)
193ASUB1	40	44	46	45	184	(MISTR)
195A	40	44	46	45	184	(MISTR)
195ASUB1	40	44	46	45	184	(MISTR)
197A	40	44	46	45	184	(MISTR)
197ASUB1	40	44	46	45	184	(MISTR)
200A	40	44	46	45	184	(MISTR)
200ASUB1	40	44	46	45	184	(MISTR)
202A	40	44	46	45	184	(MISTR)
202ASUB1	40	44	46	45	184	(MISTR)
203A	40	44	46	45	184	(MISTR)
203ASUB1	40	44	46	45	184	(MISTR)
205A	40	44	46	45	184	(MISTR)
205ASUB1	40	44	46	45	184	(MISTR)
207A	40	44	46	45	184	(MISTR)
207ASUB1	40	44	46	45	184	(MISTR)
209A	40	44	46	45	184	(MISTR)
209ASUB1	40	44	46	45	184	(MISTR)
211A	40	44	46	45	184	(MISTR)
211ASUB1	40	44	46	45	184	(MISTR)
213A	40	44	46	45	184	(MISTR)
213ASUB1	40	44	46	45	184	(MISTR)
215A	40	44	46	45	184	(MISTR)
215ASUB1	40	44	46	45	184	(MISTR)
217A	40	44	46	45	184	(MISTR)
217ASUB1	40	44	46	45	184	(MISTR)
219A	40	44	46	45	184	(MISTR)
219ASUB1	40	44	46	45	184	(MISTR)
221A	40	44	46	45	184	(MISTR)
221ASUB1	40	44	46	45	184	(MISTR)
223A	40	44	46	45	184	(MISTR)
223ASUB1	40	44	46	45	184	(MISTR)
225A	40	44	46	45	184	(MISTR)
225ASUB1	40	44	46	45	184	(MISTR)
227A	40	44	46	45	184	(MISTR)
227ASUB1	40	44	46	45	184	(MISTR)
TOTAL ITEM INDUCTIONS	577	628	631	634	2470	



ALC: OC RCC: MABPAB QUARTER: 4 DATE: 13-JUN-89 TIME: 20:05:11 REPT.ID: EXP #1 PAGE  
 PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
151123A	864.0	994.8	93.1	709.6	192.0	124
151125A	464.0	824.7	127.8	545.5	196.0	131
151127A	456.0	1761.6	129.8	446.8	96.0	74
151130A	456.0	1254.5	94.5	426.8	96.0	111
151133A	504.0	1869.7	41.5	219.2	96.0	164
151137A	504.0	789.4	37.4	279.2	168.0	180
151140A	504.0	1436.6	91.4	427.2	168.0	172
151150A	544.0	1028.4	151.8	425.6	150.0	141
151175A	456.0	1465.0	69.8	414.7	145.0	180
151188A	840.0	991.8	36.8	203.2	192.0	19
151188ASUB1	0.0	NO	RECORDED	790.0	165.5	19
151189A	864.0	275.6	33.4	146.4	96.0	19
151191A	892.0	967.0	46.0	752.3	168.0	17
151192ASUB1	0.0	NO	RECORDED	863.7	166.0	13
151192ASUB1	0.0	NO	RECORDED	116.4	120.0	12
151193A	840.0	784.4	19.6	436.0	279.0	24
151223A	984.0	2807.9	76.7	911.9	120.0	40
151237A	0.0	NO	RECORDED	908.6	148.0	47
151253A	0.0	NO	RECORDED	175.0	0.0	23

PERCENTAGES: 71.3% 65.1% 28.0% 18.0% 19.3% 18.4% 19.3% 19.3% 31.3% 39.6% 43.8% 79.7% 53.1% 77.8% 81.3% 46.4% 55.6% 32.5% 31.3% 73.8%

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESSING FLOW %	HOURS	BACKSHOP HOURS	BACKSHOP %	NUMBER SAMPLES
113AA	864.0	99.3	14.9	42.4	70.4%	192.0	27.5%	27.5%	17
113AA	864.0	697.3	27.5	41.9	47.9%	150.6	26.7%	26.7%	1268
113AA	455.0	812.0	42.0	51.8	68.7%	196.0	11.8%	11.8%	1320
113AA	455.0	812.0	42.0	51.8	36.4%	96.0	11.8%	11.8%	1170
113AA	455.0	812.0	42.0	51.8	55.4%	96.0	33.9%	33.9%	1869
113AA	504.0	350.6	55.4	107.8	54.6%	168.0	47.9%	47.9%	2099
113AA	504.0	407.4	13.9	178.2	73.6%	196.0	23.9%	23.9%	1042
113AA	574.0	552.2	66.6	309.6	59.7%	145.0	27.8%	27.8%	1425
113AA	528.0	552.2	4.5	161.9	45.2%	192.0	53.6%	53.6%	1178
113AA	840.0	730.4	NO VALUES RECORDED	563.9	77.2%	164.2	22.5%	22.5%	19
113AA	0.0	21.0	NO VALUES RECORDED	123.8	55.8%	96.0	43.4%	43.4%	19
113AA	864.0	202.9	1.4	19.4	74.0%	176.0	25.1%	25.1%	173
113AA	892.0	766.2	6.2	595.4	78.0%	166.0	21.8%	21.8%	118
113AA	0.0	226.2	2.9	107.3	45.7%	120.0	53.0%	53.0%	124
113AA	0.0	617.9	3.8	341.9	55.4%	274.0	44.4%	44.4%	124
113AA	840.0	17.7	NO VALUES RECORDED	614.6	41.7%	120.0	8.1%	8.1%	73
113AA	984.0	1456.3	739.0	590.3	40.5%	120.0	8.2%	8.2%	203
113AA	984.0	189.8	746.0	141.7	74.5%	48.0	25.3%	25.3%	23

ALC: OC KCC: MABPAB QUARTER: 4 DATE: 12-JUN-89 TIME: 17:47:58 REPT.ID: BURGE W1 .MUL  
 PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
1125A	864.0	695.1	18.0	485.1	192.0	127
1125A	432.0	484.6	82.6	383.1	150.4	135
1125A	432.0	477.3	18.0	295.8	96.0	169
1125A	432.0	267.2	13.3	157.9	96.0	186
1137A	504.0	380.7	14.3	208.2	96.0	209
1140A	504.0	450.8	34.0	179.8	168.0	105
1155A	504.0	457.6	30.8	300.7	196.0	144
1178A	528.0	460.6	18.3	303.5	192.0	178
1188A	840.0	731.4	14.0	565.1	164.0	18
1188A	0.0	201.7	1.8	104.0	96.0	19
1191A	892.0	755.2	6.4	551.8	173.6	17
1192A	0.0	211.5	2.2	88.0	120.0	12
1192A	0.0	226.1	4.6	102.0	120.0	12
1237A	840.0	617.1	1.8	343.4	272.0	24
1237A	984.0	1183.4	472.1	591.2	120.0	89
1237A	0.0	1184.6	468.7	596.0	148.0	113
1237A	0.0	1194.2	0.0	146.1	0.0	123

VALUES RECORDED \*\*  
 VALUES RECORDED \*\*  
 VALUES RECORDED \*\*

ALC: OC RCC: MABPAB QUARTER: 4 DATE: 13-JUN-89 TIME: 19:43:17 KEPI-ID: LAI

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
113A	864.0	630.2	46.5	62.2%	192.8	30.5%	128
115A	432.0	476.3	32.2	8.3%	151.0	35.5%	135
117A	432.0	372.4	46.1	11.4%	96.0	23.5%	168
119A	432.0	267.9	41.4	15.3%	96.0	23.5%	170
120A	456.0	269.2	47.9	12.8%	96.0	23.5%	186
123A	504.0	362.5	44.0	16.5%	168.0	42.8%	210
124A	504.0	347.5	44.0	15.7%	168.0	42.8%	205
125A	744.0	475.1	44.0	9.2%	147.0	27.6%	145
127A	528.0	432.1	35.8	19.4%	145.0	31.6%	145
128A	840.0	652.7	53.6	66.9%	162.7	24.9%	18
129A	0.0	52.7	3.6	44.5%	96.0	54.1%	19
130A	84.0	217.5	4.8	11.8%	167.0	25.3%	17
131A	84.0	656.8	49.7	4.5%	160.0	24.4%	138
132A	0.0	207.8	22.0	13.6%	120.0	57.8%	24
133A	840.0	251.9	22.6	10.1%	279.0	44.2%	24
134A	984.0	907.5	31.9	35.9%	120.0	13.3%	116
135A	984.0	163.3	20.3	35.9%	148.0	29.4%	123
136A	0.0	16.2	1.6	3.9%	0.0	0.0%	0

VALUES RECORDED \*\*  
 VALUES RECORDED \*\*  
 VALUES RECORDED \*\*

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ALC: OC RCC: MABPAB QUARTER: 4 DATE: 3-JUN-84 TIME: 12:48:54 REPI: UML VJ  
 PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
113A	864.0	473.1	3.8	277.3	192.0	129
115011A	864.0	374.6	6.1	218.8	149.0	134
115111A	432.0	320.9	58.7	179.3	96.0	166
115211A	432.0	207.6	7.1	99.4	96.0	170
115311A	432.0	223.3	10.3	101.5	96.0	189
115411A	504.0	296.4	3.4	152.1	168.0	201
115511A	504.0	286.7	18.4	125.1	196.0	106
115611A	744.0	368.5	9.9	212.3	149.6	145
115711A	528.0	310.2	17.0	202.3	142.0	178
115811A	840.0	498.5	VALUES RECORDED	330.0	165.6	20
115911A	0.0	180.7	VALUES RECORDED	83.5	96.0	20
116011A	892.0	520.5	2.7	301.1	174.3	207
116111A	0.0	182.4	4.1	352.6	120.0	113
116211A	0.0	179.4	3.7	58.6	276.5	182
116311A	840.0	509.8	2.9	231.4	120.0	123
116411A	984.0	920.6	VALUES RECORDED	321.3	120.0	142
116511A	984.0	140.6	467.7	322.5	148.0	123
116611A	0.0	114.0	0.1	92.5	34.9	123

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PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
113A	864.0	476.9	3.6	281.8	192.9	129
112A	864.0	328.9	4.3	176.6	150.0	167
111A	432.0	200.8	18.5	169.4	96.0	164
1126A	432.0	202.8	4.1	99.4	96.0	189
1137A	432.0	271.9	2.2	101.7	168.0	210
1137A	504.0	295.6	2.1	155.5	168.0	206
1140A	504.0	274.4	3.8	174.3	149.2	144
1150A	744.0	368.0	4.4	213.5	145.0	149
1157A	456.0	310.7	2.1	116.6	192.0	178
1157A	840.0	502.4	NO VALUES RECORDED	333.2	166.8	20
1188A	0.0	NO VALUES RECORDED	2.4	84.0	96.0	20
1189A	864.0	489.2	3.1	312.9	173.3	17
1191A	864.0	504.6	2.3	337.9	164.0	13
1192A	0.0	183.9	0.9	60.6	120.0	18
1192A	840.0	514.7	3.8	239.5	273.4	23
1193A	864.0	729.3	1.3	320.0	120.0	143
1193A	984.0	725.2	283.2	94.1	148.0	183
1193A	0.0	142.1	0.0	66.2	33.8	23

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ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
15113A	864.0	54.7	37.8	285.0	192.0	133
15113A	864.0	59.5	30.1	214.4	149.4	133
15113A	456.0	30.1	40.6	166.6	96.0	176
15113A	456.0	22.4	22.7	104.8	96.0	176
15113A	456.0	23.4	33.8	104.9	96.0	186
15113A	456.0	33.8	39.4	166.6	166.0	201
15113A	456.0	20.1	20.7	126.7	145.0	144
15113A	456.0	33.8	34.0	190.2	145.0	144
15113A	456.0	33.6	35.2	116.1	192.0	178
15113A	840.0	52.8	52.8	312.1	163.2	20
15113A	0.0	190.3	13.8	81.0	96.0	19
15113A	89.0	53.2	31.7	340.2	174.6	113
15113A	0.0	183.9	19.2	49.6	120.0	123
15113A	840.0	56.1	48.8	241.3	271.3	123
15113A	984.0	73.4	66.9	318.3	120.0	149
15113A	0.0	145.2	28.2	385.0	148.0	123

VALUES RECORDED 0%  
 VALUES RECORDED 0%  
 VALUES RECORDED 0%  
 VALUES RECORDED 0%

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING HOURS	PROCESsing %	HOURS	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
113A	864.0	409.3	3.5	212.9	52.1%	192.0	0.4	47.0%	131
15019A	432.0	235.3	4.7	164.2	51.2%	136.0	0.0	40.8%	134
15021A	432.0	235.3	4.7	130.7	36.1%	118.0	0.0	41.2%	170
15022A	456.0	190.0	5.6	86.2	19.1%	86.0	0.0	51.5%	189
15023A	504.0	311.4	5.3	136.0	45.6%	168.0	0.0	53.9%	211
15024A	504.0	231.4	5.4	111.4	39.7%	168.0	0.0	59.4%	207
15025A	574.0	321.7	5.5	133.2	55.2%	196.6	0.0	41.1%	145
15026A	528.0	319.0	5.3	169.7	55.3%	145.0	0.0	45.7%	178
15027A	840.0	450.4	15.4	270.7	60.1%	164.4	0.0	36.5%	20
15028A	0.0	176.2	15.4	77.0	43.8%	96.0	0.0	54.5%	20
15029A	864.0	422.8	9.7	247.2	58.8%	160.0	0.0	39.3%	18
15030A	0.0	176.9	5.7	257.2	60.8%	120.0	0.0	37.8%	18
15031A	0.0	177.6	4.2	49.4	29.6%	120.0	0.0	68.0%	23
15032A	940.0	477.6	3.9	205.5	43.1%	268.2	0.0	56.2%	23
15033A	984.0	359.3	10.4	230.7	63.9%	120.0	0.0	33.2%	177
15034A	984.0	359.3	9.8	229.6	63.9%	120.0	0.0	33.4%	198
15035A	0.0	125.1	0.4	77.7	61.5%	48.0	0.0	38.2%	23

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PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
1013A	864.0	405.7	3.1	210.6	192.0	47.3%	190
1129A	422.0	314.6	16.8	165.0	149.0	46.2%	134
11321A	456.0	242.9	4.3	129.6	96.0	39.6%	164
11310A	456.0	186.9	4.3	86.5	96.0	31.4%	170
113137A	504.0	306.4	2.1	136.0	168.0	54.8%	189
1131140A	504.0	281.1	2.3	111.0	168.0	59.8%	200
1131150A	544.0	239.5	4.4	139.3	196.8	59.1%	145
1131178A	538.0	318.0	4.6	168.3	155.0	46.8%	150
1131188A	456.0	298.8	2.0	104.8	192.0	64.3%	178
1131189A	840.0	434.3	2.0	267.4	164.4	37.9%	20
1131189A SUB1	0.0	NO VALUES RECORDED	2.0	0.0	0.0	0.0%	0
1131189A SUB1	0.0	NO VALUES RECORDED	0.6	76.4	96.0	55.5%	20
1131191A	892.0	172.0	2.1	232.3	168.0	41.7%	128
1131191A SUB1	0.0	NO VALUES RECORDED	0.6	250.2	160.0	38.3%	128
1131192A	0.0	170.8	0.6	49.6	120.0	70.3%	123
1131192A SUB1	0.0	NO VALUES RECORDED	0.4	201.2	280.7	58.0%	23
1131237A	840.0	483.8	1.9	201.9	120.0	20.4%	178
1131237A	984.0	596.1	37.9	239.6	120.0	20.1%	123
1131237A SUB1	0.0	NO VALUES RECORDED	0.0	77.3	48.0	38.3%	23



ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
113A	864.0	127.6	417.0	718.6	192.0	189
115A	864.0	1566.0	848.6	566.7	196.0	150
117A	432.0	3705.5	3148.4	466.0	96.0	151
126A	432.0	2867.5	443.1	426.1	96.0	116
139A	456.0	2476.1	2059.6	223.7	96.0	111
140A	504.0	1748.1	1157.6	228.5	168.0	146
150A	504.0	1538.6	1143.6	250.4	168.0	146
155A	744.0	1476.1	777.4	431.0	148.0	185
178A	528.0	738.0	777.4	416.4	145.0	286
187A	840.0	NO VALUES	1931.1	214.9	192.0	30
188ASUB1	0.0	NO VALUES	647.0	830.8	162.4	28
189ASUB1	864.0	279.3	39.4	143.9	96.0	27
191A	892.0	1683.7	619.6	894.8	168.9	195
192ASUB1	0.0	1710.5	634.7	839.7	162.0	125
192ASUB1	0.0	2655.9	34.4	105.6	120.0	144
1936A	840.0	804.9	44.4	100.9	279.8	44
2337A	984.0	NO VALUES	96.0	428.9	120.0	27
249A	984.0	5571.9	4839.9	962.0	120.0	33
250ASUB1	0.0	245.6	4846.2	183.4	148.0	45

PROCESSING FLOW %  
 BACKSHOP %

WAITING FOR RESOURCES %

HISTOR. FLOW HOURS

SIMULATED FLOW HOURS

NUMBER OF SAMPLES

DC RCC: MABPAB QUARTER: 4 DATE: 13-JUN-89 TIME: 06:47:37

DIRECT LABOR STATISTICS

ITEM	EXPECTED HOURS	STANDARD HOURS	SIMULATED AVERAGE LABOR HOURS	STANDARD DEVIATION	SIMULATED MINIMUM HOURS	SIMULATED MAXIMUM HOURS	NUMBER OF SAMPLES
13AA	123.49	147.70	122.68	5.78	102.61	137.92	18
13AA	119.62	163.80	117.99	10.76	71.62	178.62	208
13AA	113.93	189.70	117.99	1.62	75.13	178.62	11
13AA	116.40	90.20	114.04	4.08	108.43	163.13	22
13AA	67.66	88.30	57.88	4.16	47.90	66.59	25
13AA	34.80	79.20	34.06	5.16	28.08	46.79	33
13AA	61.00	71.70	65.13	6.02	43.57	77.54	33
13AA	24.26	55.90	24.20	12.99	43.49	109.25	1
13AA	193.59	193.90	193.42	2.39	16.15	27.80	257
13AA	14.88	193.90	196.16	48.12	121.66	288.33	29
13AA	14.88	15.00	14.17	48.39	9.93	51.28	30
13AA	178.33	201.80	175.16	19.88	87.44	255.40	27
13AA	174.70	201.30	174.69	37.49	139.75	271.40	22
13AA	14.55	15.00	13.51	12.62	10.35	48.33	145
13AA	102.55	128.60	106.51	11.47	74.60	127.19	145
13AA	161.92	128.60	164.76	19.97	119.52	197.96	56
13AA	154.00	110.50	160.49	20.16	115.08	197.96	46
13AA	124.00	111.60	124.02	5.21	10.78	130.84	46

VALUES RECORDED \*\*  
 VALUES RECORDED \*\*  
 VALUES RECORDED \*\*

DC RCC: MABPAB QUARTER: 4 DATE: 13-JUN-89 TIME: 11:58:31 REPT. 1M: 3000  
 ACCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
113A	864.0	735.5	51.5	492.1	192.0	219
113A	384.0	801.7	255.1	395.0	151.2	213
113A	456.0	1094.6	697.4	311.3	96.0	200
113A	456.0	1159.9	767.4	296.5	96.0	182
113A	456.0	1159.9	397.1	158.3	96.0	297
113A	504.0	630.2	375.9	179.6	96.0	328
113A	504.0	368.1	18.6	195.7	96.0	177
113A	504.0	400.1	28.9	277.5	96.0	126
113A	528.0	677.4	149.5	306.1	145.0	187
113A	456.0	387.2	319.1	166.2	192.0	191
113A	840.0	*NO	VALUES RECORDED *	586.4	165.6	30
113A	0.0	770.5	18.6	76.1	21.5	30
113A	0.0	*NO	VALUES RECORDED **	115.8	96.0	28
113A	864.0	220.5	8.7	52.9	43.5	27
113A	892.0	752.2	32.3	584.5	170.4	19
113A	0.0	221.8	17.3	98.2	120.0	18
113A	0.0	230.4	3.8	106.1	281.1	15
113A	840.0	632.2	4.1	344.1	44.5	145
113A	984.0	*NO	VALUES RECORDED **	583.4	120.0	91
113A	984.0	2376.5	1657.5	599.1	148.0	146
113A	0.0	188.1	1657.5	140.0	25.5	146
113A	0.0	188.1	60.0	74.5	25.5	146

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESsing FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER SAMPLES
13AA	864.0	60.7	66.4	402.5	60.9%	192.0	29.1%	225
13BA	864.0	528.0	81.4	297.3	56.7%	150.2	28.6%	225
13CA	432.0	370.0	43.4	245.3	29.7%	96.0	10.7%	225
13DA	432.0	275.0	55.5	134.9	26.0%	96.0	10.8%	225
13EA	450.0	427.2	55.2	134.3	47.0%	96.0	33.4%	225
13FA	504.0	421.0	72.9	174.3	40.3%	168.0	38.4%	225
13GA	504.0	366.6	80.1	136.1	41.5%	166.0	37.6%	225
13HA	744.0	522.0	179.3	295.1	56.2%	150.3	28.5%	123
13IA	528.0	417.5	179.3	246.2	48.0%	192.0	46.0%	222
13JA	840.0	697.5	NO VALUES RECORDED	468.2	67.1%	164.0	23.5%	30
13KA	0.0	228.7	55.3	103.1	45.1%	96.0	42.0%	28
13LA	864.0	892.0	97.0	428.8	64.7%	169.2	25.6%	286
13MA	0.0	692.4	77.4	477.7	33.2%	120.0	51.2%	126
13NA	0.0	230.6	66.9	73.7	31.9%	276.0	44.3%	144
13OA	840.0	623.6	NO VALUES RECORDED	271.0	43.5%	120.0	6.5%	121
13PA	984.0	1842.1	338.7	464.5	25.8%	120.0	6.6%	158
13QA	984.0	1157.4	121.5	497.9	62.2%	148.0	30.5%	146

SUB1  
SUB1  
SUB1  
SUB1  
SUB1

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESSING FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
113A	864.0	484.8	9.7	283.1	58.4%	192.8	39.6%	18
1129A	864.0	398.4	8.4	220.9	55.3%	149.6	37.0%	22
1131A	456.0	150.4	1.8	185.3	19.3%	96.0	10.4%	14
1100A	456.0	150.4	4.7	103.4	11.8%	96.0	10.7%	17
1137A	456.0	250.4	6.2	107.9	43.2%	96.0	40.4%	28
1140A	504.0	334.5	1.4	127.6	44.5%	168.0	38.9%	34
1150A	504.0	334.5	6.6	127.9	40.5%	168.0	38.9%	34
1175A	744.0	382.4	1.6	171.3	51.4%	96.0	28.5%	17
1178A	744.0	412.6	1.0	200.4	56.5%	145.0	39.1%	24
1189A	840.0	512.6	13.3	117.6	37.6%	192.0	61.4%	22
1189ASUB1	840.0	538.2	NO VALUES	349.6	65.0%	163.9	30.4%	29
1189ASUB1	0.0	NO VALUES	4.7	81.2	44.8%	96.0	53.0%	30
1192A	892.0	1506.3	10.1	324.5	64.1%	175.0	33.9%	26
1192ASUB1	0.0	1531.5	2.8	344.6	64.8%	165.0	31.1%	19
1192ASUB1	0.0	188.2	3.2	64.2	34.3%	120.0	64.8%	25
11335A	840.0	518.2	1.4	232.6	44.9%	273.1	52.7%	14
11335A	984.0	NO VALUES	1.7	328.3	17.6%	120.0	6.4%	11
113357ASUB1	984.0	1819.1	1365.0	93.4	65.9%	48.0	33.9%	46

DC RCC: MABPAB QUARTER: 4 DATE: 14-JUN-89 TIME: 06:26:24 REPT. ID: J0000  
 SUCCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
113A	864.0	481.1	9.0	279.9	192.0	19
113AA	864.0	380.4	10.1	218.3	151.0	22
113A	432.0	782.0	512.9	178.1	96.0	25
113AA	432.0	209.7	10.9	199.7	96.0	22
113A	432.0	299.3	4.1	102.8	168.0	33
113AA	432.0	374.6	4.4	127.2	168.0	32
113A	432.0	405.4	9.4	215.9	149.3	17
113AA	432.0	312.4	9.8	200.6	145.0	22
113A	840.0	512.5	NO VALUES RECORDED	346.0	163.9	29
113AA	840.0	183.6	NO VALUES RECORDED	85.7	96.0	31
113A	840.0	485.9	1.9	307.3	175.7	19
113AA	840.0	507.9	1.9	343.9	161.0	25
113A	840.0	176.8	1.4	54.8	120.0	18
113AA	840.0	151.7	1.5	63.4	281.1	15
113A	984.0	1480.5	NO VALUES RECORDED	325.7	120.0	143
113AA	984.0	1040.9	69.9	327.5	120.0	179
113A	984.0	1144.6	0.0	96.6	48.0	146

SUB1  
 SUB1  
 SUB1  
 SUB1  
 SUB1





ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESSING FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
113A	64:00	429:5	10:7	217:7	51:8%	0:0	45:7%	172
119A	43:00	358:1	23:9	138:3	39:7%	0:0	37:1%	224
121A	45:00	269:1	23:5	137:1	51:4%	0:0	35:8%	227
126A	45:00	207:3	27:5	90:1	43:0%	0:0	44:2%	227
133A	45:00	226:8	16:6	93:2	41:2%	0:0	51:7%	228
137A	50:00	296:5	16:4	111:0	37:0%	0:0	49:8%	235
140A	50:00	234:6	25:2	114:0	49:1%	0:0	43:1%	275
157A	54:00	328:2	15:2	172:5	53:5%	0:0	44:1%	248
178A	55:00	201:8	1:0	168:6	83:1%	0:0	63:7%	287
188A	840:0	508:5	NO VALUES RECORDED	280:5	55:2%	168:0	33:0%	29
189A	0:00	190:5	NO VALUES RECORDED	79:6	41:8%	96:0	50:4%	31
191A	89:00	458:0	49:6	242:6	52:7%	166:4	36:7%	269
192A	0:00	519:1	71:0	279:0	54:0%	160:0	31:4%	123
192A	0:00	181:2	18:8	59:1	27:3%	120:0	66:9%	145
197A	840:0	498:0	NO VALUES RECORDED	199:8	40:1%	273:6	54:9%	14
233A	98:00	710:6	38:1	236:3	33:4%	120:0	16:2%	393
237A	0:00	129:1	2:2	79:1	61:2%	48:0	37:1%	46

1189A SUB1  
 1189A SUB1  
 1192A SUB1  
 1192A SUB1  
 1197A  
 1197A SUB1  
 1197A SUB1

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING HOURS	PROCESSING FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
13A	864.0	407.1	4.2	210.8	51.8%	192.0	47.2%	218
1125A	892.0	421.3	4.0	165.5	18.9%	186.0	47.0%	222
1121A	436.0	412.0	195.2	135.0	31.0%	96.0	22.3%	255
1206A	456.0	193.8	10.2	87.9	19.3%	96.0	51.5%	277
11337A	504.0	208.4	10.6	136.8	45.3%	168.0	54.5%	285
1140A	504.0	246.4	3.2	111.2	44.4%	168.0	59.0%	326
11517A	544.0	286.3	17.4	139.2	39.4%	196.8	59.7%	1767
115175A	528.0	350.9	38.5	167.4	52.0%	148.8	45.7%	1247
115178A	456.0	399.2	2.1	105.2	27.7%	192.0	64.2%	242
115188A	840.0	**NO VALUES RECORDED**	2.0	260.5	60.9%	164.7	38.5%	29
115188A	0.0	**NO VALUES RECORDED**	2.0	77.1	44.1%	96.0	55.0%	31
115189A	892.0	1408.8	1.5	233.8	57.1%	172.9	42.3%	269
115191A	892.0	418.0	2.0	256.6	61.4%	159.2	38.9%	125
115192A	0.0	175.3	0.7	53.2	30.7%	120.0	68.2%	138
115192A	0.0	175.3	0.7	53.2	30.7%	120.0	68.2%	138
115236A	840.0	486.0	0.6	203.2	41.8%	280.9	57.8%	44
115237A	984.0	**NO VALUES RECORDED**	1.9	228.9	18.6%	120.0	9.7%	173
115249A	984.0	1235.1	882.7	227.4	18.4%	120.0	9.7%	246
115250A	0.0	128.3	0.0	80.2	62.5%	48.0	37.4%	46
115257A	0.0	128.3	0.0	80.2	62.5%	48.0	37.4%	46

Ricardo

DDB

**TABLE OF CALCULATIONS**

Omega Transform FY-90		
Run No.	Thruput (%)	db
1	66.5	2.9778
2	86.4	8.0297
3	91.3	10.2095
4	94.2	12.1062
5	93.9	11.8734
6	97.0	15.0965
7	96.6	14.5350
8	99.3	21.5185
9	99.4	22.1924

**Manpower Distribution**

1st shift

$$\frac{2.9778 + 8.0297 + 10.2095}{3} = 7.0723 \quad 83.6\%$$

50%/50%

$$\frac{12.1062 + 11.8734 + 15.0965}{3} = 13.0254 \quad 95.25\%$$

3rd

$$\frac{14.5350 + 21.5185 + 22.1924}{3} = 19.4153 \quad 98.87\%$$

Overtime

40 hrs

$$\frac{2.9778 + 12.1062 + 21.5185}{3} = 9.873 \quad 90.66\%$$

SAT

$$\frac{8.0297 + 11.8734 + 14.535}{3} = 13.8072 \quad 96.00\%$$

SAT & SUN

$$\frac{10.2095 + 15.0965 + 22.1924}{3} = 15.8328 \quad 97.46\%$$

**Equipment Base**

Base

$$\frac{2.9778 + 11.8734 + 22.1924}{3} = 12.3478 \quad 94.50\%$$

Base +

$$\frac{8.0297 + 15.0965 + 14.535}{3} = 12.5537 \quad 94.74\%$$

Base + +

$$\frac{10.2095 + 12.1062 + 21.5185}{3} = 14.6114 \quad 96.66\%$$

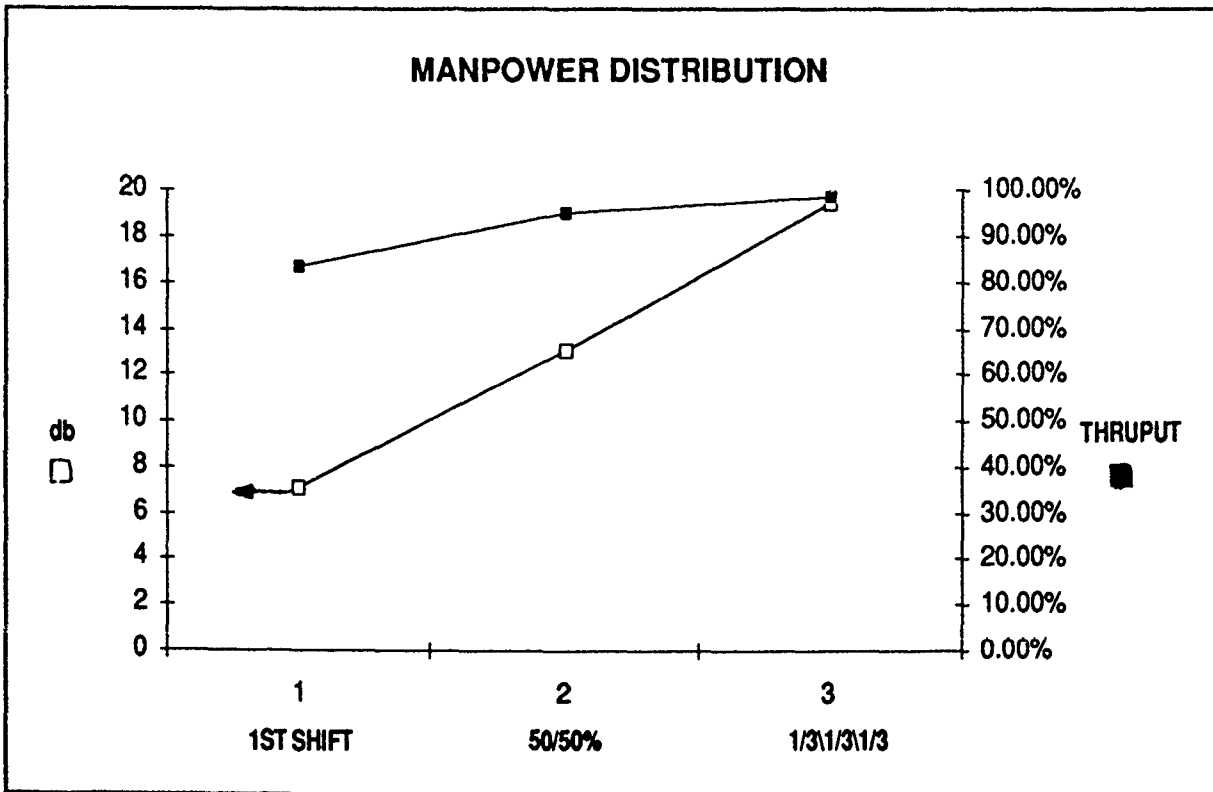
Average = 13.1710    95.4031%

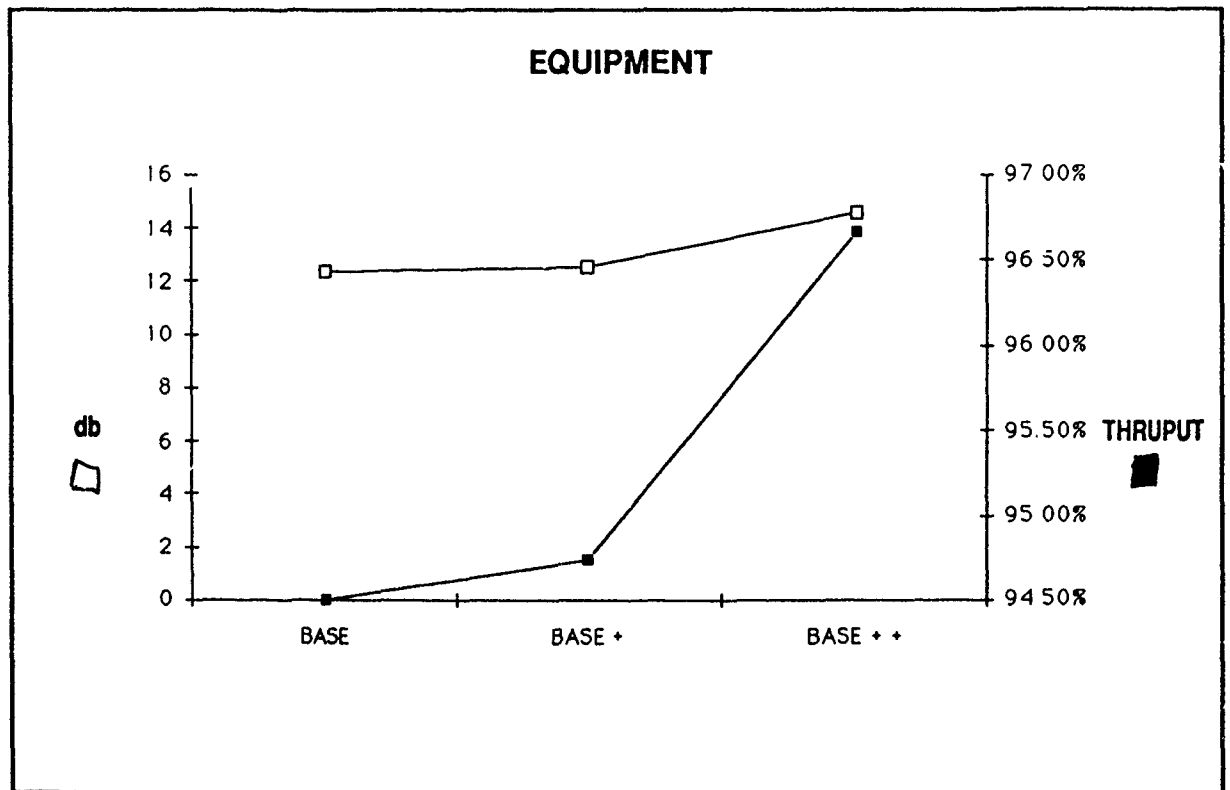
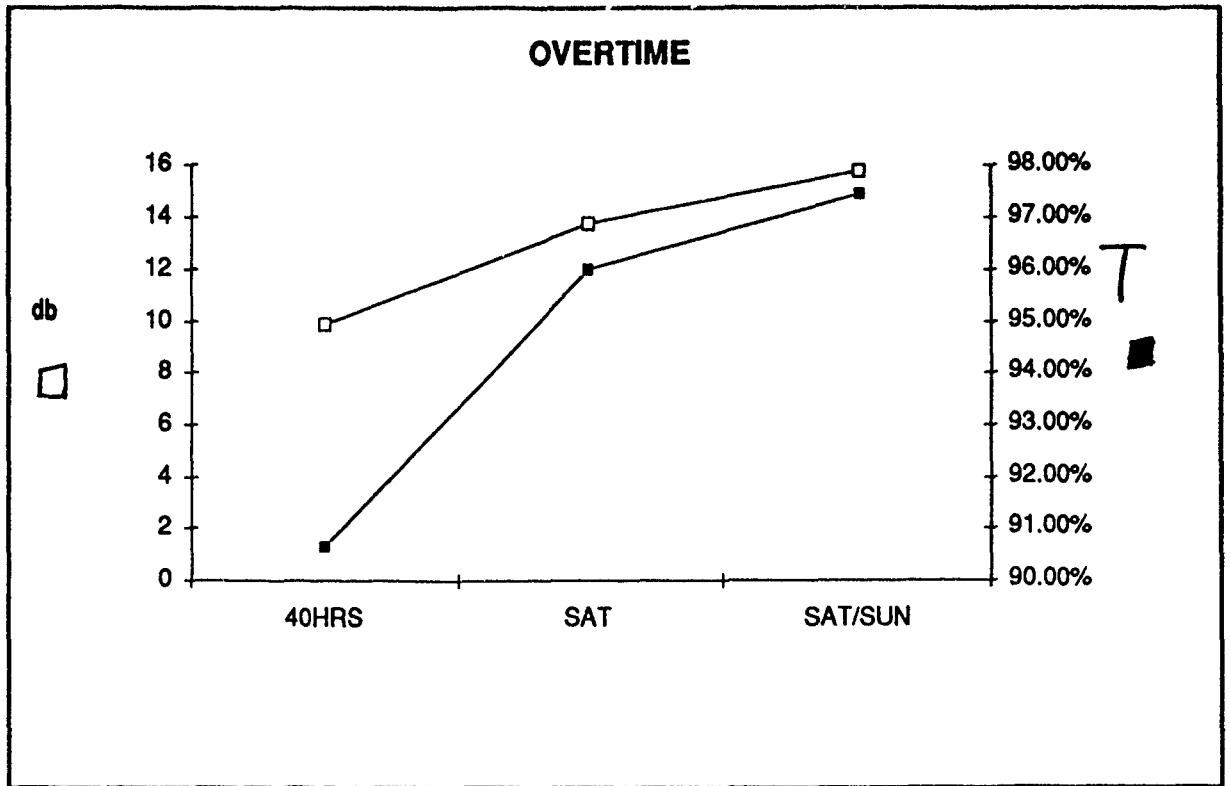
Now for just 2nd shift

$$13.1710 + (12.3479 + 13.1710) + (9.873 - 13.1710) + (13.1710 - 13.0254) = 9.1955 \quad 89.26\%$$

2nd shift + SAT

$$13.1710 + (13.0254 - 13.1710) + (13.8072 - 13.1710) + (13.1710 - 12.4379) = 12.8355, \quad 95.06\%$$





**Omega Transform FY-90**

Run No.	Thruput (%)	db
1	46.8	-0.5567
2	74.3	4.6106
3	82.9	6.8556
4	88.6	8.9053
5	84.9	7.4993
6	91.0	10.0480
7	91.8	10.4903
8	98.8	19.1558
9	93.3	11.4381

**Manpower Distribution**

1st shift

$$\frac{-0.5567 + 4.6106 + 6.8556}{3} = 3.6365 \quad 69.79\%$$

50%/50%

$$\frac{8.9053 + 7.4993 + 10.0480}{3} = 8.8175 \quad 88.4\%$$

3rd

$$\frac{10.4903 + 19.1558 + 11.4381}{3} = 13.6947 \quad 95.9\%$$

**Overtime**

40 hrs

$$\frac{-0.5567 + 8.9053 + 10.4903}{3} = 6.2796 \quad 80.9\%$$

SAT

$$\frac{4.6106 + 7.4993 + 19.1558}{3} = 10.4219 \quad 91.68\%$$

SAT & SUN

$$\frac{6.8556 + 10.0480 + 11.4381}{3} = 9.4472 \quad 89.8\%$$

**Equipment Base**

Base

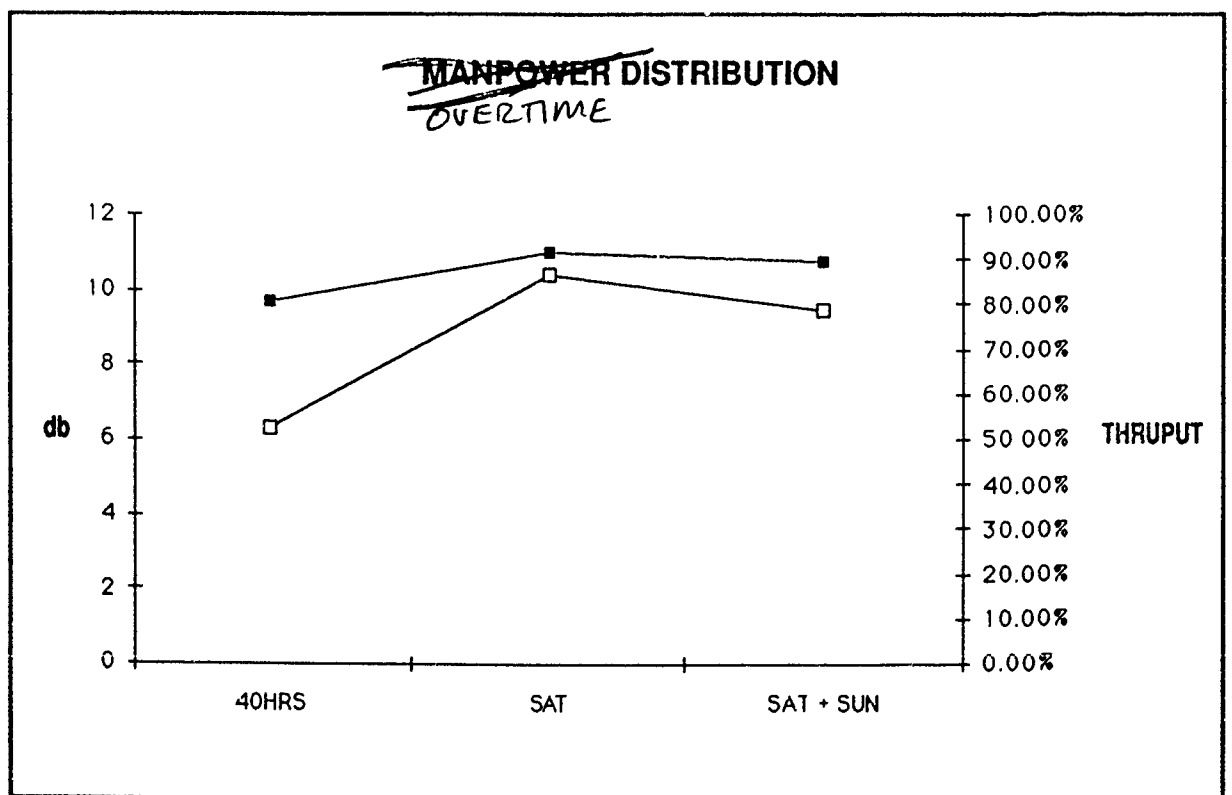
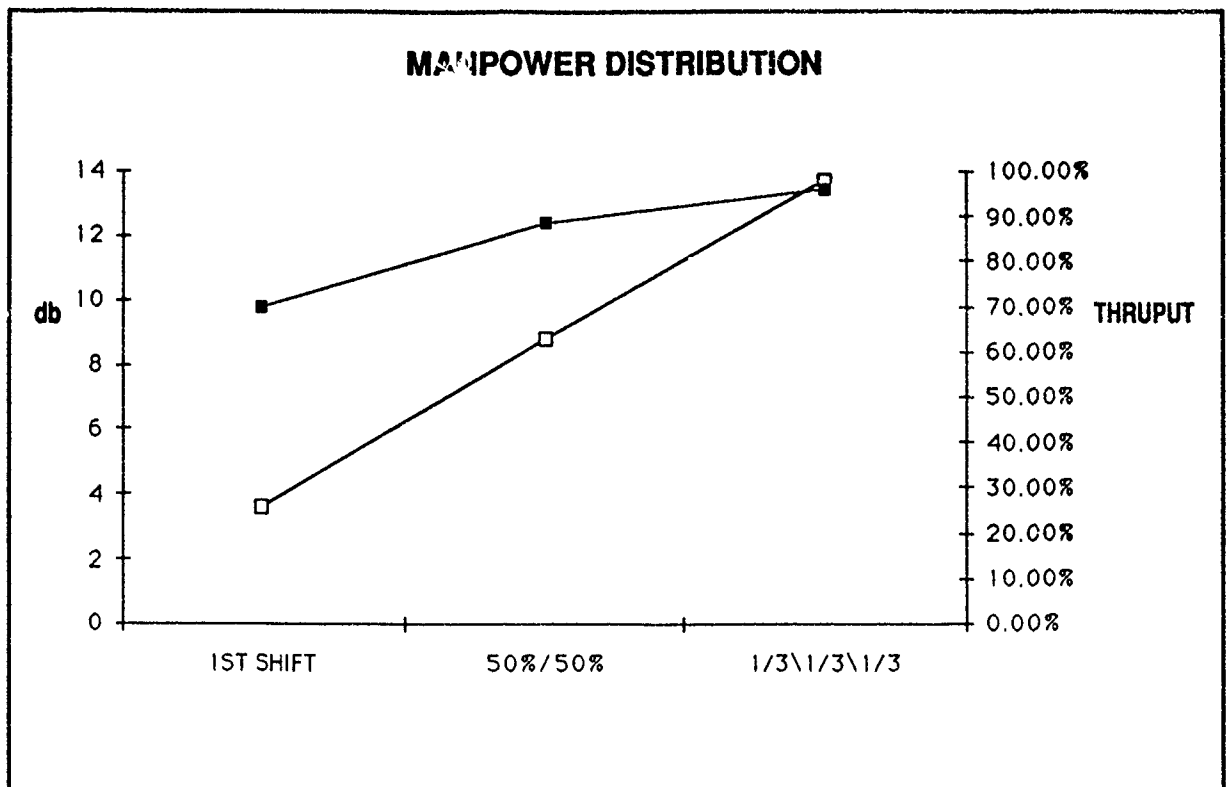
$$\frac{-0.5567 + 7.4993 + 11.4381}{3} = 6.1269 \quad 80.39\%$$

Base +

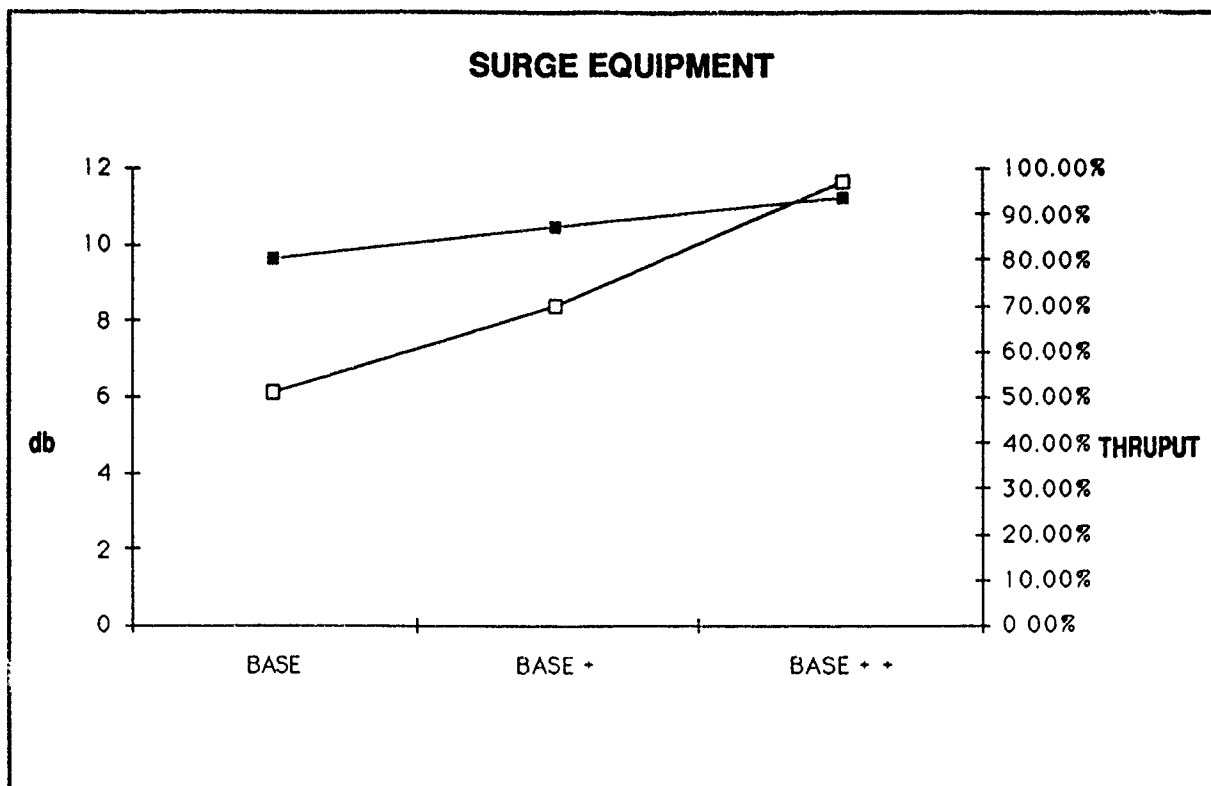
$$\frac{4.6106 + 10.0480 + 10.4903}{3} = 8.383 \quad 87.33\%$$

Base + +

$$\frac{6.8556 + 8.9053 + 19.1558}{3} = 11.6389 \quad 93.58\%$$







**SUMMARY:**

"BEST " WE CAN DO IS 1/3, SAT. AND ONLY BASE BECAUSE OF SPACE LIMITATIONS

**AVERAGE = 8.7163**

$$\text{PREDICTED} = 8.8163 + \{13.6947 - 8.7163\} \{10.4219 - 8.7163\} + \{6.1268 - 8.7163\}$$

$$12.8109 \sim 95.0\%$$

# EXPERIMENT DATA Calculation

## Flow Hours

	15126A	15300A	$\bar{x}$
1	1176	1291	1233.5
2	271	288	279.5
3	257	268	262.5
4	263	272	267.5
5	203	208	202.5
6	201	205	203.0
7	221	234	227.5
8	188	190	189.0
9	185	187	186.0

# MABPAB EXPERIMENT DATA CALCULATIONS

M<sub>R</sub> Power 1

$$1233.5 + 279.5 + 262.5 = 591.8$$

MRT 2

$$267.5 + 202.5 + 203 = 224.3$$

MP 3

$$227.5 + 189 + 186 = 200.8$$

---

F 1

$$1233.5 + 267.5 + 227.5 = 576.2$$

F 2  $279.5 + 202.5 + 189 = 223.7$

F 3  $262.5 + 203 + 186 = \underline{217.2}$

---

Eq 1

$$1233.5 + 202.5 + 186 = 540.7$$

Eq 2

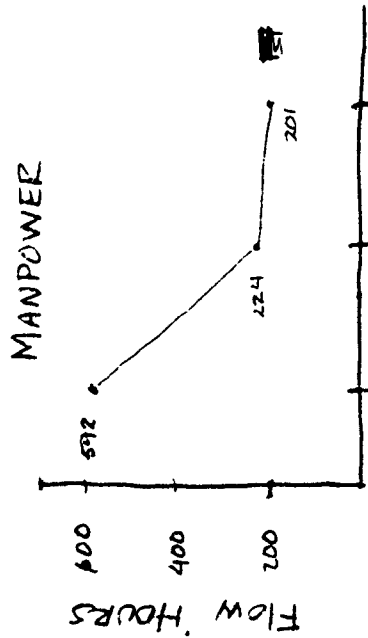
$$279.5 + 203 + 227.5 = 236.7$$

Eq 3

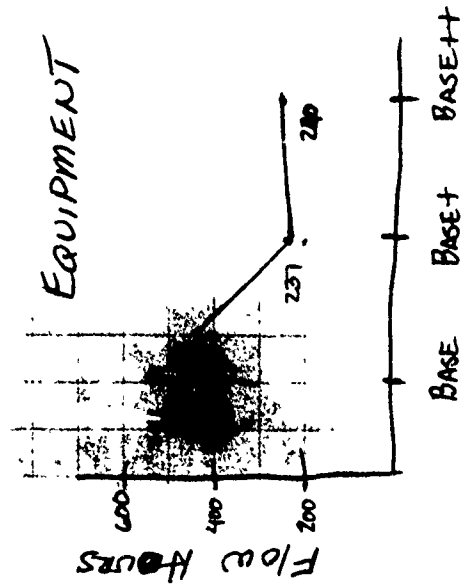
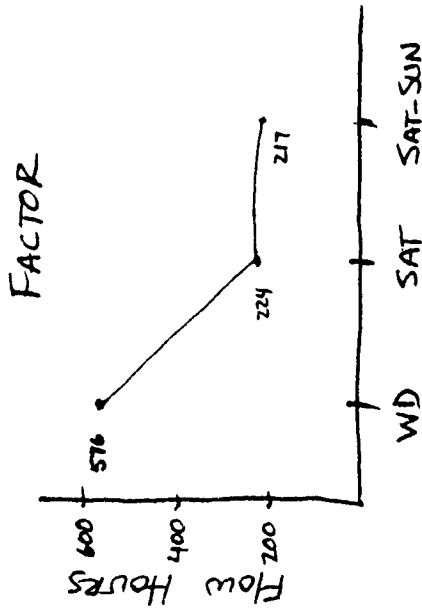
$$262.5 + 267.5 + 189 = \underline{239.7}$$

# MADFLD EXPERIMENTATION RESULTS

FY 90 WORKLOAD  
15126A / 15300A



1st 50-50 1/3 1/3 1/3



Part No. 023A

FY90

①

Manpower Dist.

96.3%  
Throughput at  
level 1

All Day shift

$$= (824 + 567 + 560) / 3 = 650.3$$

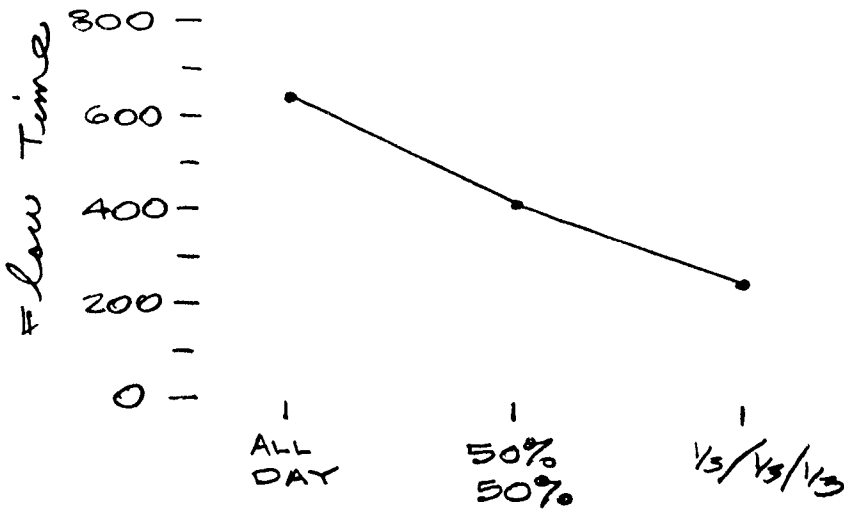
Any  
change  
moves  
to 100%

50%/50%

$$= (476 + 375 + 371) / 3 = 407.3$$

1/3/1/3/1/3

$$= (394 + 324 + 319) / 3 = 259.2$$



Overtime

40 hrs

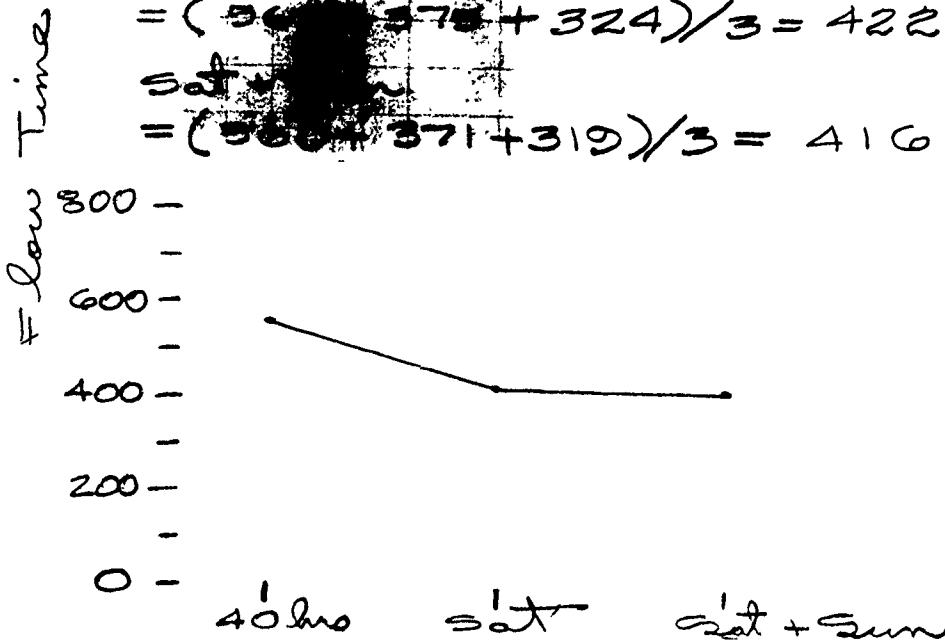
$$= (824 + 476 + 394) / 3 = 564.7$$

Sat

$$= (567 + 375 + 324) / 3 = 422$$

Sat + Sun

$$= (560 + 371 + 319) / 3 = 416.7$$



Part No. 113A

FY 90

2

92.5% Throughput at level 1

Manpower Dist.

All Day shift

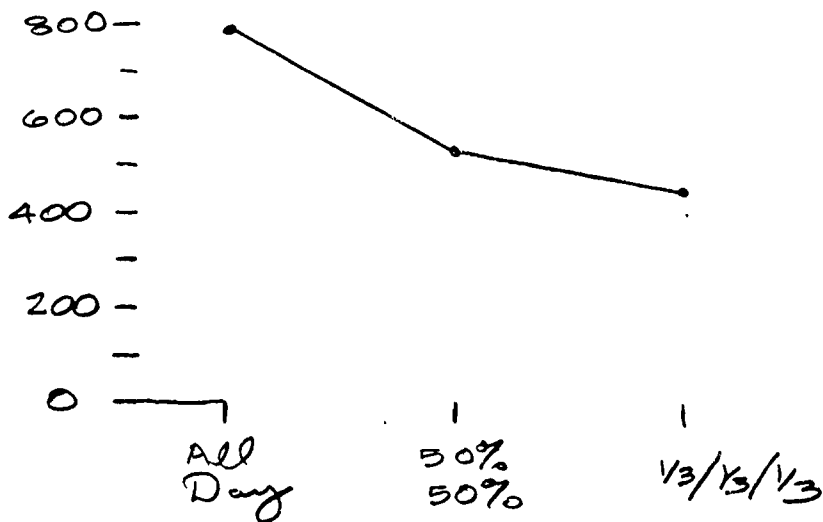
$$= (995 + 699 + 695) / 3 = 796.3$$

50%/50%

$$= (630 + 473 + 477) / 3 = 526.7$$

1/3/1/3/1/3

$$= (515 + 408 + 406) / 3 = 443$$



Overtime

40 hrs

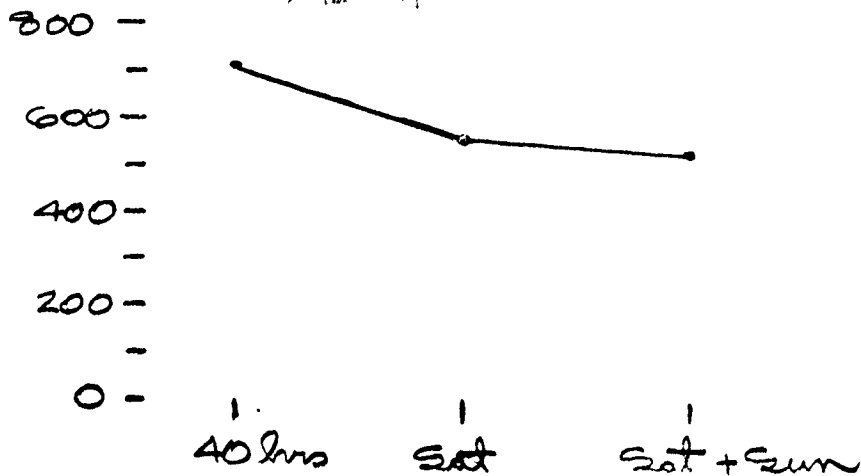
$$= (995 + 630 + 515) / 3 = 713.3$$

Sat.

$$= (699 + 473 + 515) / 3 = 562.3$$

Sat + Sun

$$= (699 + 477 + 406) / 3 = 526.0$$



Part No. 113A FY 90  
 Use Omega transform on  
 Thruput

$$\text{Omega transform} = -10 \log_{10} \left( \frac{1}{P} - 1 \right)$$

Run no.	Thruput (%)	Transform (db)
1	92.5	10.9108
2	94.8	12.6080
3	94.8	12.6080
4	95.5	13.2679
5	96.3	14.1542
6	96.3	14.1542
7	97.0	15.0965
8	97.8	16.4792
9	97.0	15.0965

Manpower Dist.  
 All Day Shift

$$= (10.9108 + 12.6080 + 12.6080) / 3$$

$$= 12.0423$$

50%/50%

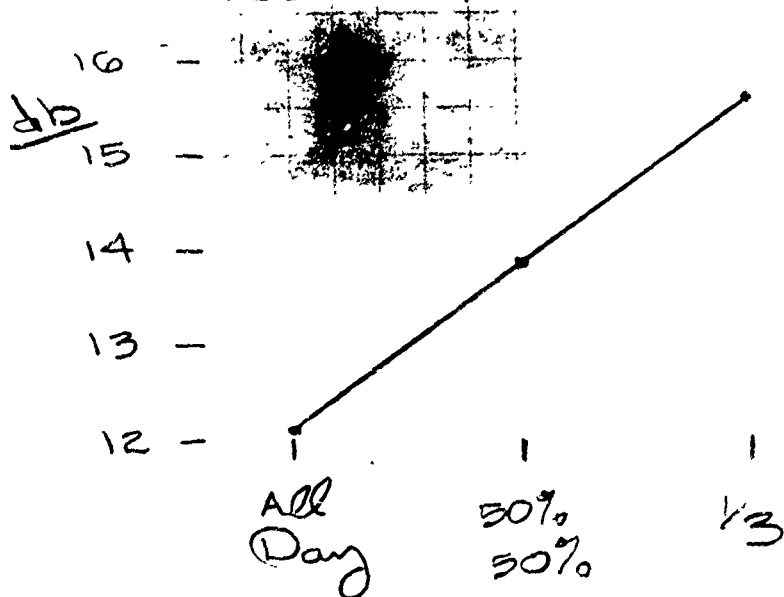
$$= (13.2679 + 14.1542 + 14.1542) / 3$$

$$= 13.8588$$

1/3 / 1/3 / 1/3

$$= (15.0965 + 16.4792 + 15.0965) / 3$$

$$= 15.5574$$



Overtime

40 hrs

$$= (10.9108 + 13.2679 + 15.0965) / 3$$

$$= 13.0917$$

Sat.

$$= (12.6080 + 14.1542 + 16.4792) / 3$$

$$= 14.4138$$

Sat + Sun

$$= (12.608 + 14.1542 + 15.0965) / 3$$

$$\frac{db}{16} = 13.9529$$

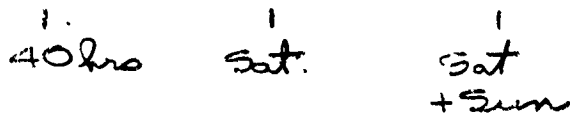
16 -

15 -

14 -

13 -

12 -



Best condition is  $\frac{1}{3} / \frac{1}{3} / \frac{1}{3}$   
and Sat. which is run no.  
8.

$$\text{Prediction} = 13.8195 + (14.4138 - 13.8195) \\ + (15.5574 - 13.8195)$$

$$= 16.1517$$

which translates to 97.6%  
throughput. Run no. 8 provided  
97.8% throughput



Part no. 119A

FY90

3

Manpower Dist.

All Day Shift

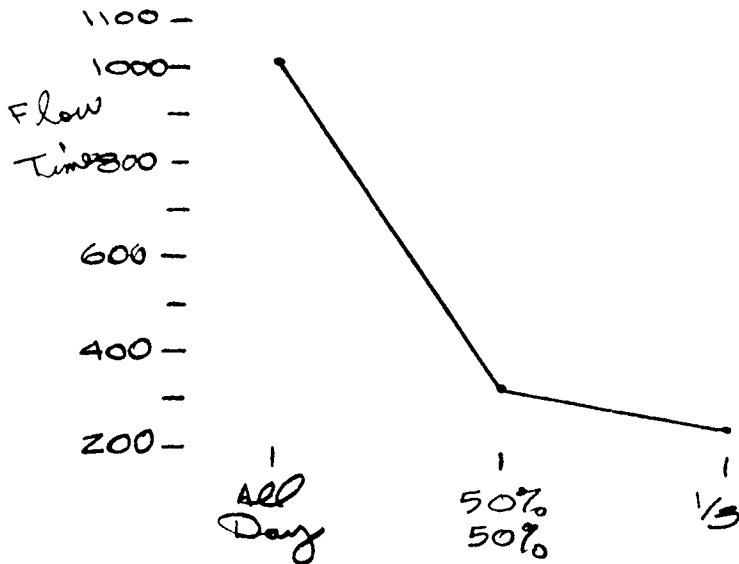
$$= (1765 + 821 + 485) / 3 = 1023.7$$

50%/50%

$$= (376 + 331 + 288) / 3 = 331.7$$

1/3/1/3/1/3

$$= (305 + 235 + 245) / 3 = 261.7$$



Overtime

40 hrs

$$= (1765 + 376 + 305) / 3 = 815.3$$

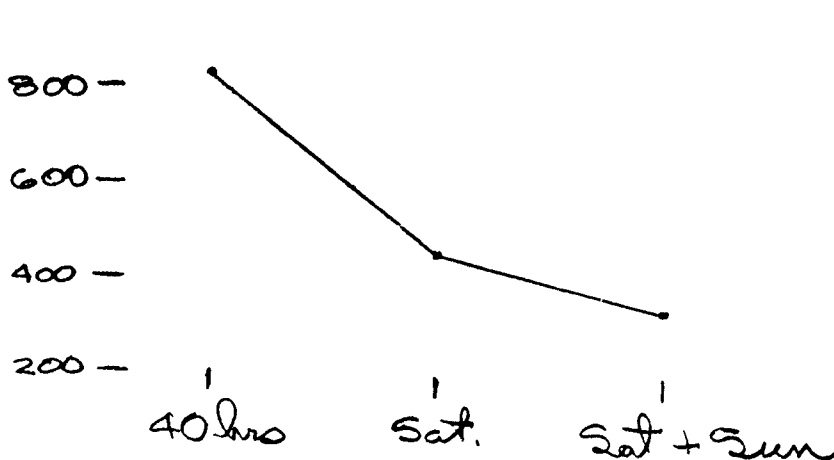
Sat

$$= (821 + 331 + 235) / 3 = 462.3$$

Sat + Sun

$$= (485 + 288 + 245) / 3 = 339.3$$

Flow Times



Part no. 119A

FY 90

6

Equip.

Base

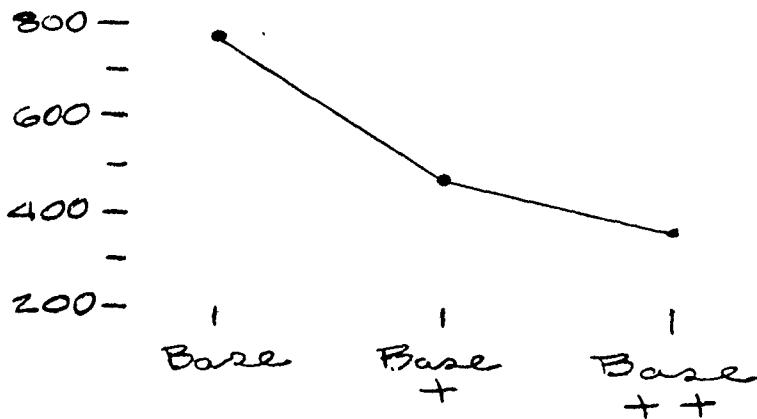
$$= (-176 + 331 + 245) / 3 = 780.3$$

Base +

$$= (821 + 288 + 305) / 3 = 471.3$$

Base ++

$$= (485 + 376 + 235) / 3 = 365.3$$



Omega Transform

Run No.	Throughput	(db)
1	38.2 %	-2.0892
2	75.3	4.8410
3	100 % 99.0	19.9564
4	98.8	19.1558
5	97.6	16.0924
6	98.2	17.3684
7	97.6	16.0924
8	100	19.9564
9	100	19.9564

Manpower Dist.

All day shift

$$= (-2.0892 + 4.8410 + 19.9564) / 3$$

$$= 7.5694$$

50%/50%

$$= (19.1558 + 16.0924 + 17.3684) / 3$$

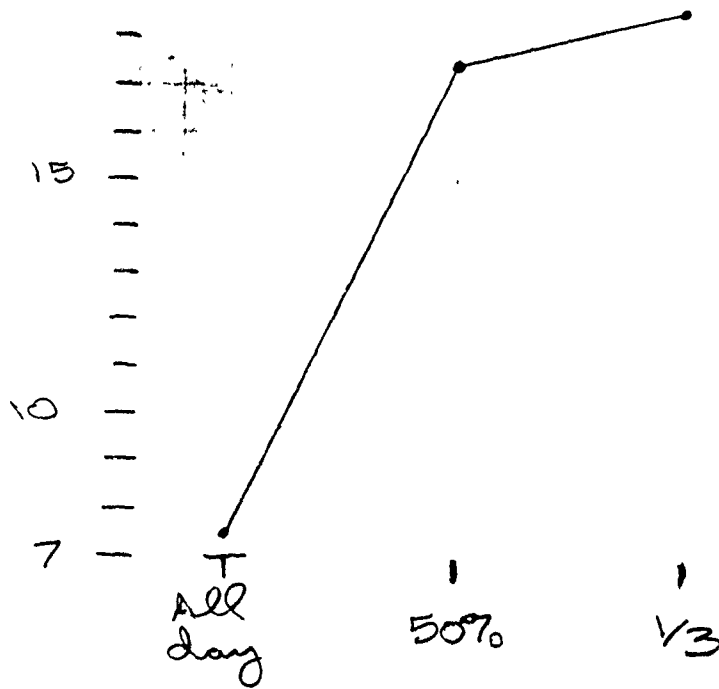
$$= 17.5389$$

$$Y_3 = (16.0924 + 19.9564 + 19.9564) / 3 = 18.6684$$

Part no. 119A  
db 19.0

FY 90

(7)



Overtime  
40 hrs.

$$= (-2.0892 + 19.1558 + 16.0924) / 3 = 11.053$$

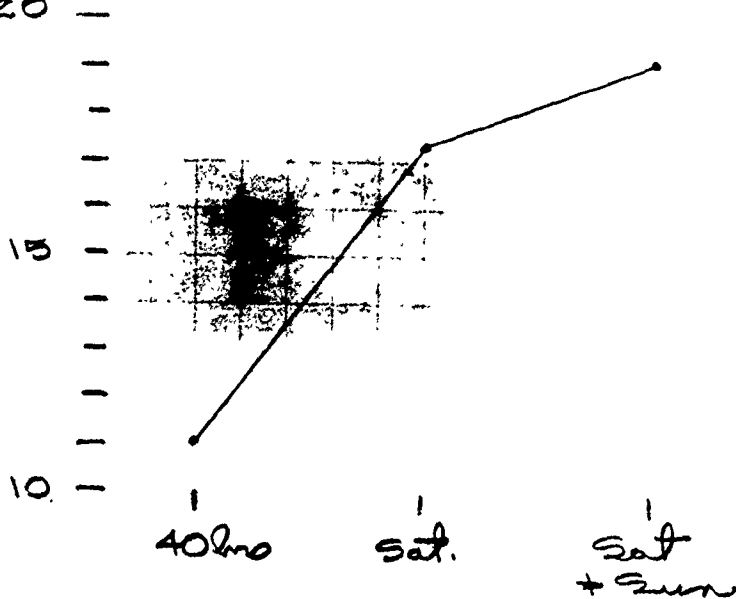
Sat.

$$= (4.8410 + 16.0924 + 19.9564) / 3 = 17.3143$$

Sat + Sun.

$$= (19.9564 + 17.3684 + 19.9564) / 3 = 19.0937$$

db/20



Part no. 119A FY90

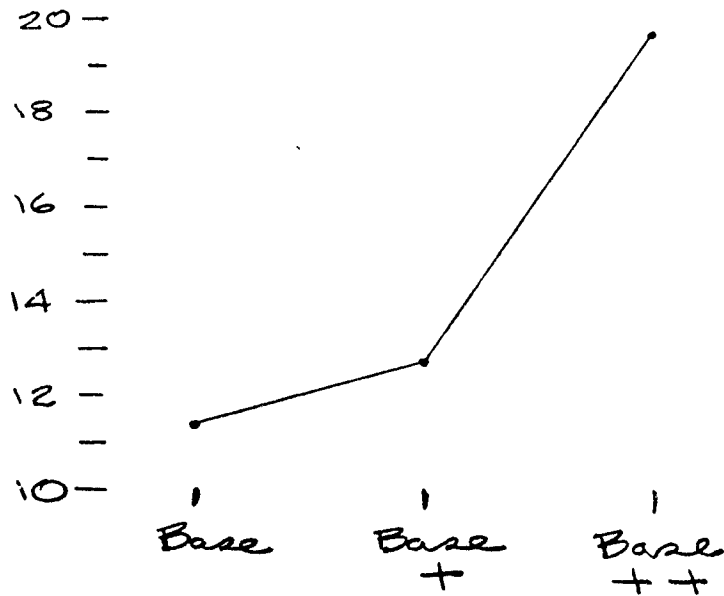
⑧

Equip.

$$\text{Base} = (-2.0892 + 16.0924 + 19.9564) / 3 = 11.3199$$

$$\text{Base} + = (4.8410 + 17.3684 + 16.0924) / 3 = 12.7673$$

$$\text{Base} ++ = (19.9564 + 19.1558 + 19.9564) / 3 = 19.6895$$



Best condition is  $\frac{1}{3} / \frac{1}{3} / \frac{1}{3}$ , Sat + Sun,  
Base ++

$$\begin{aligned} \text{Prediction} &= 14.5922 + (19.6895 - 14.5922) \\ &+ (19.0937 - 14.5922) + (18.6684 - 14.5922) \\ &= 28.2672 \text{ which translates} \\ &\text{to } \underline{99.8\% \text{ throughput}} \end{aligned}$$

Now this best condition is too expensive, then consider 50/50, Sat., and Base ++.

$$\begin{aligned} \text{Prediction} &= 14.5922 + (19.6895 - 14.5922) \\ &+ (17.3143 - 14.5922) + (17.5389 - 14.5922) \\ &= 25.3583 \text{ which translates} \\ &\text{to } \underline{99.7\% \text{ throughput}} \end{aligned}$$

Also consider only 50/50 or Sat / Base ++

Part No. 321A  
Mangrove Dist.

FY 90

②

All Day shift

$$= (1522 + 812 + 478) / 3 = 937.3$$

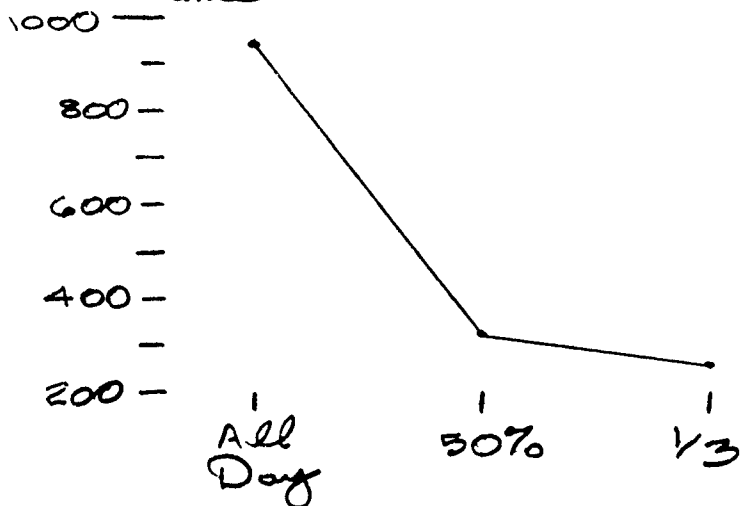
50%/50%

$$= (372 + 328 + 283) / 3 = 327.7$$

1/3/1/3

$$= (311 + 233 + 242) / 3 = 262$$

Flow Time



Overtime

40 hrs

$$= (1522 + 372 + 311) / 3 = 735$$

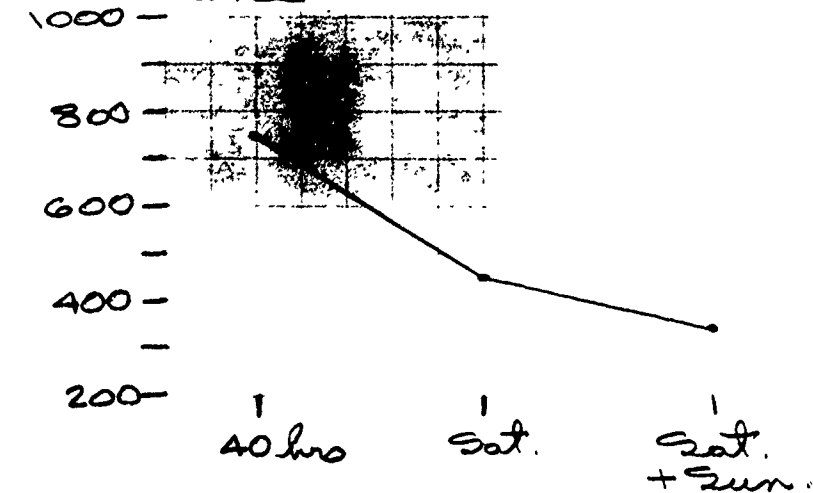
Sat.

$$= (812 + 328 + 233) / 3 = 457.7$$

Sat + Sun

$$= (478 + 283 + 242) / 3 = 334.3$$

Flow Time



Part No. 321A

FY 90

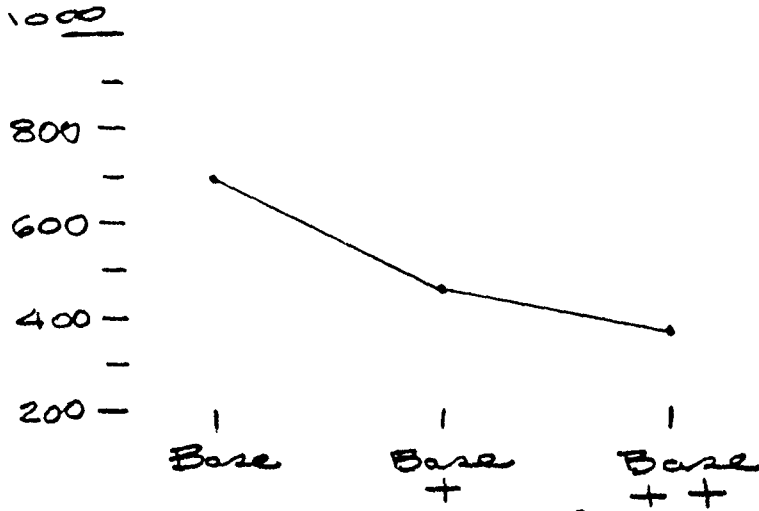
10

Equip.

$$\text{Base} = (1522 + 328 + 242) / 3 = 697.3$$

$$\text{Base} + = (812 + 283 + 311) / 3 = 468.7$$

$$\text{Base} + + = (478 + 372 + 233) / 3 = 361$$



Run No.	Omega Transform Thruput	db
1	46 %	-0.6964
2	80 %	6.0206
3	100 %	19.9564
4	100	19.9564
5	100	19.9564
6	100	19.9564
7	100	19.9564
8	100	19.9564
9	100	19.9564

Manager Dist.  
All shift

$$= (-0.6964 + 6.0206 + 19.9564) / 3 = 8.4269$$

50%

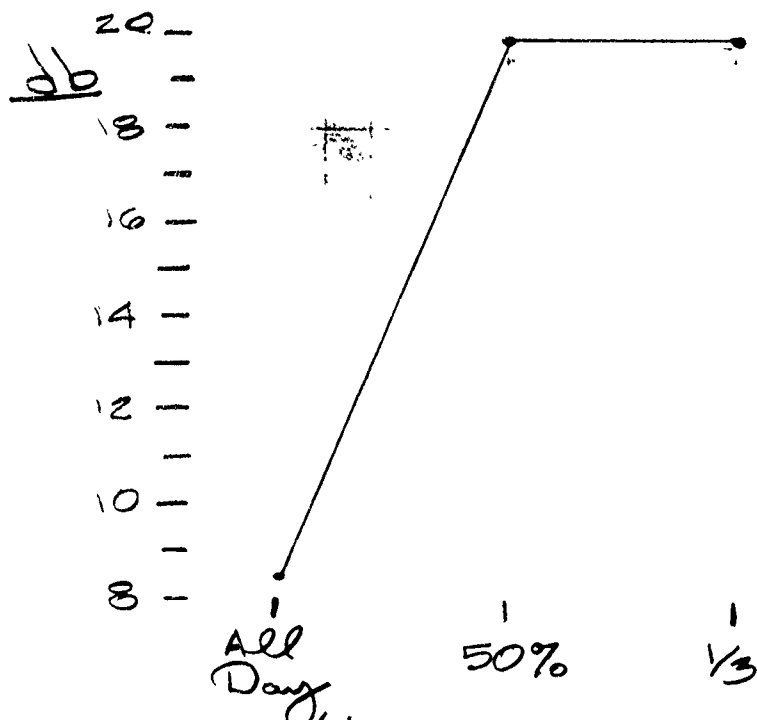
$$= 19.9564$$

$$\sqrt{3} = 19.9564$$

Part No. 321A

FY90

(11)

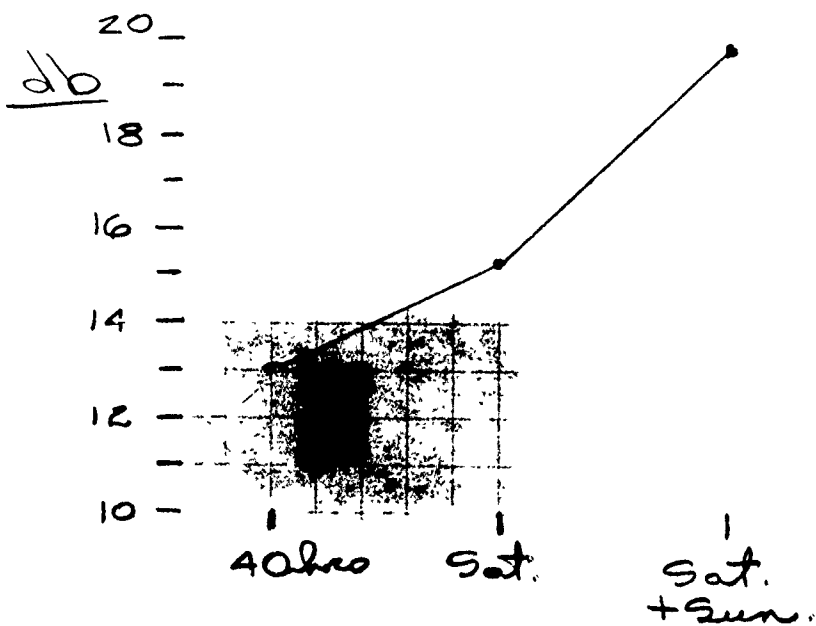


Overtime

$$40\text{hrs} = (-.6964 + 19.9564 + 19.9564) / 3 = 13.0721$$

$$\text{Sat.} = (6.0206 + 19.9564 + 19.9564) / 3 = 15.3111$$

$$\text{Sat.} + \text{Sun.} = (19.9564)$$

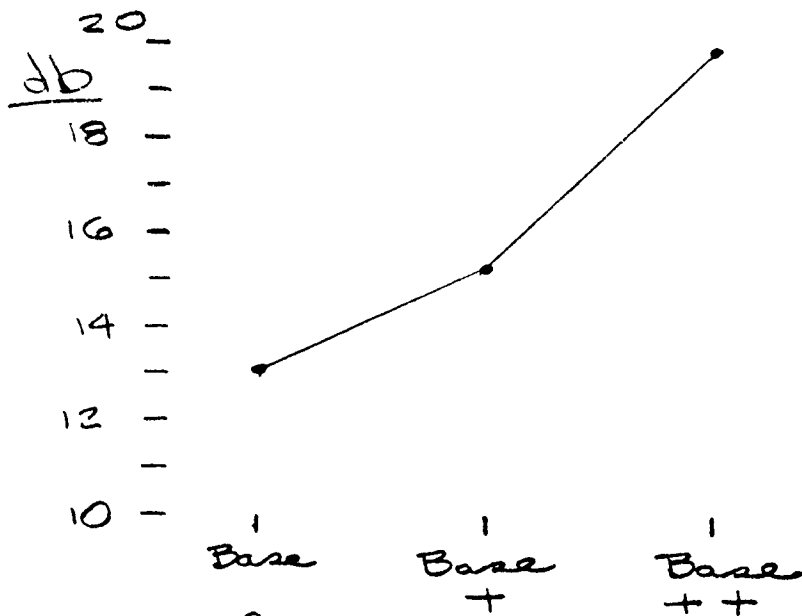


Equip.

$$\text{Base} = (-.6964 + 19.9564 + 19.9564) / 3 = 13.0721$$

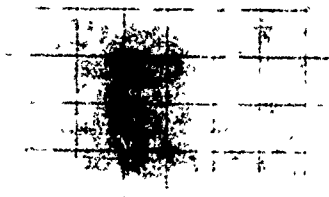
$$\text{Base} + = (6.0206 + 19.9564 + 19.9564) / 3 = 15.3111$$

$$\text{Base} ++ = (19.9564$$



In this case, 50%/50%, Sat + Sun.,  
Base ++ is the best condition

Prediction =  $16.1132 + (19.9564 - 16.1132)$   
(so only need one factor - which is  
50%/50% to achieve 99%)





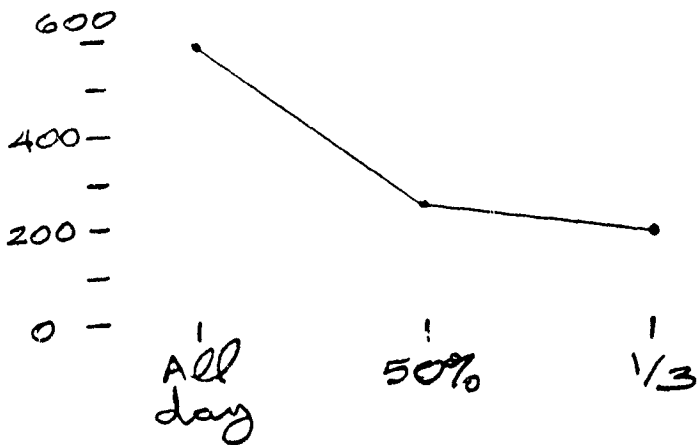
Part no. 126A  
 Manpower Dist.  
 All Day shift

FY 90

$$= (1254 + 268 + 257) / 3 = 593$$

$$50\% = (262 + 203 + 200) / 3 = 221.7$$

$$1/3 = (221 + 188 + 185) / 3 = 198$$

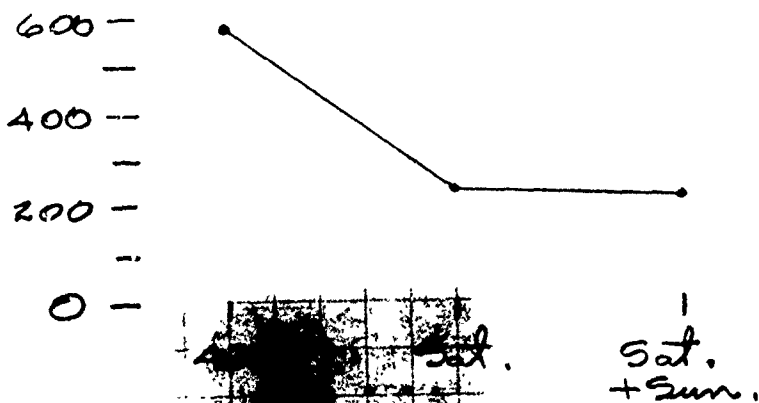


Overtime

$$40\text{hr} = (1254 + 262 + 221) / 3 = 579$$

$$\text{Sat.} = (268 + 203 + 188) / 3 = 219.7$$

$$\text{Sat.} + \text{Sun.} = (257 + 200 + 185) / 3 = 214.0$$



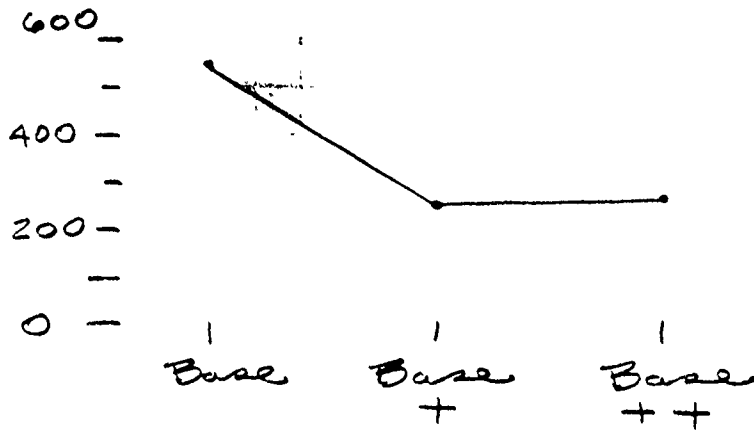
Equip.

$$\text{Base} = (1254 + 203 + 185) / 3 = 547.3$$

$$\text{Base} + = (268 + 200 + 221) / 3 = 229.7$$

$$\text{Base} + + = (257 + 262 + 188) / 3 = 235.7$$

Flow Time



Omega Transform

Run no.	Thruput	db
1	63.4	2.3861
2	97.1	15.2482
3	96.6	14.5350
4	97.1	15.2482
5		
6		
7		
8		
9	97.1	15.2482

Vertical arrows indicate a relationship between the throughput values of runs 5-9 and runs 2-4.

Manpower Dist.

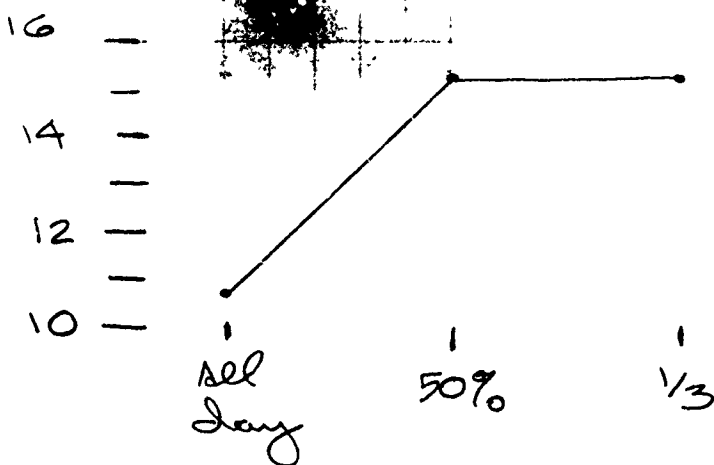
All day shift

$$= (2.3861 + 15.2482 + 14.5350) / 3 = 10.7231$$

50%

$$= (15.2482$$

$$/ 3 = 5.0827$$



Part no. 126A

FY 90

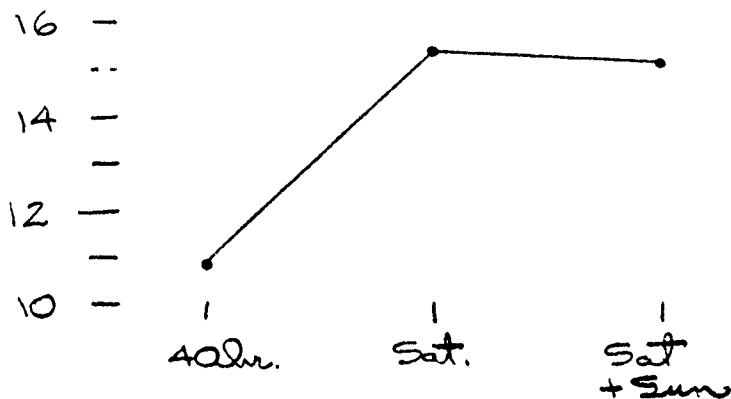
15

Overtime

$$40 \text{ hr.} = (2.3861 + 15.2482 + 15.2482) / 3 = 10.9608$$

$$\text{Sat} = (15.2482)$$

$$\text{Sat} + \text{Sun} = (14.5350 + 15.2482 + 15.2482) / 3 = 15.0105$$



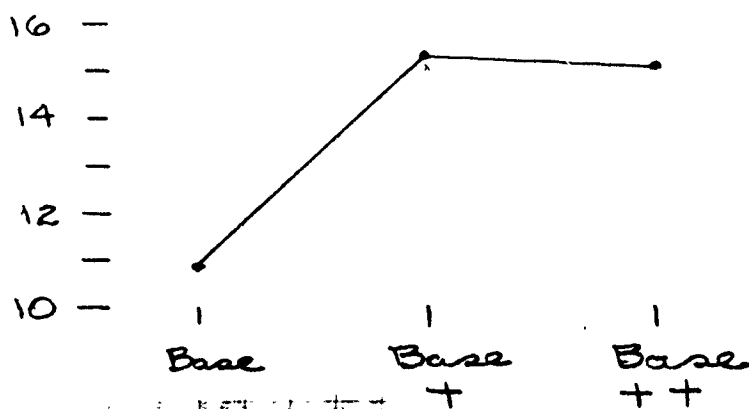
Equip.

$$\text{Base} = (2.3861 + 15.2482 + 15.2482) / 3 = 10.9608$$

$$\text{Base} + = (15.2482)$$

$$\text{Base} ++ = (14.535 + 15.2482 + 15.2482) / 3 =$$

15.0105



So, ~~Base +~~ Sat. 50%

$$\begin{aligned} \text{Predicted} &= 13.7398 + (15.2482 - 13.7398) \\ &+ (15.2482 - 13.7398) + (15.2482 - 13.7398) \\ &= 18.2649 \approx \underline{\underline{98.5\%}} \end{aligned}$$

300A

FY 90

Manpower Dist.  
All day shift

$$= (1220 + 283 + 267) / 3 = 590$$

50/50 ..

$$= (268 + 208 + 203) / 3 = 226.3$$

1/3

$$= (234 + 190 + 187) / 3 = 203.7$$

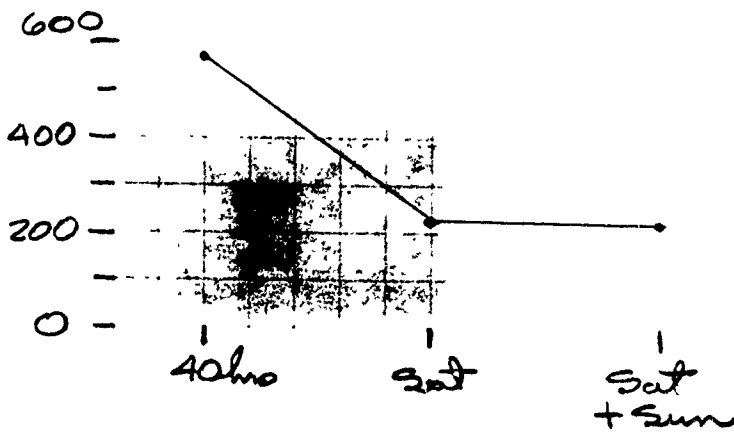


Overtime

$$40hrs = (1220 + 268 + 234) / 3 = 574$$

$$Sat. = (283 + 208 + 190) / 3 = 227$$

$$Sat + Sun = (267 + 203 + 187) / 3 = 219$$

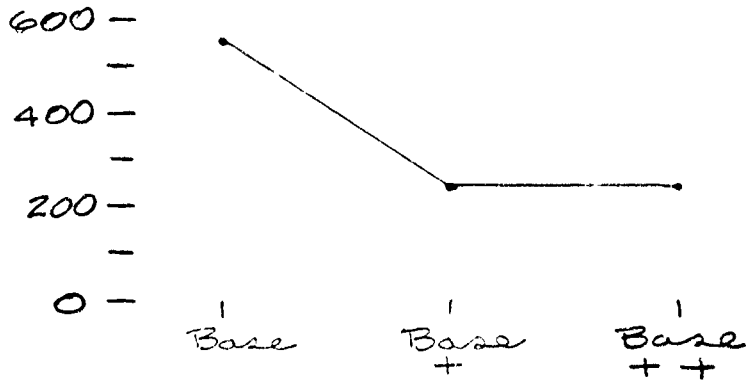


Equip.

$$\text{Base} = (1220 + 208 + 187) / 3 = 538.3$$

$$\text{Base} + = (283 + 203 + 234) / 3 = 240$$

$$\text{Base} ++ = (267 + 268 + 190) / 3 = 241.7$$



Any shift gives 100%  
 Base throughput = 63.6%



136A

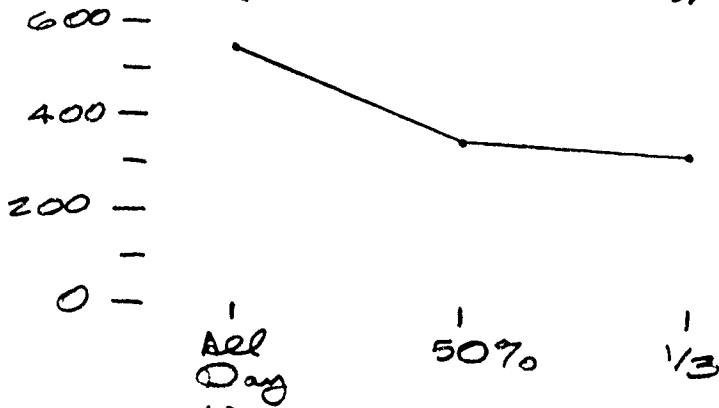
FY90

Manpower Dist.  
All Day shift

$$= (862 + 382 + 380) / 3 = 541.3$$

$$50\% = (393 + 323 + 322) / 3 = 346$$

$$1/3 = (365 + 312 + 306) / 3 = 327$$

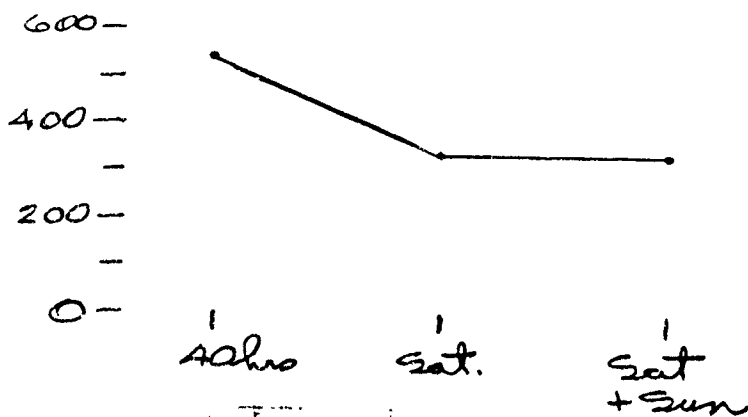


Overtime

$$40hrs = (862 + 393 + 363) / 3 = 539.3$$

$$Sat. = (382 + 323 + 312) / 3 = 339$$

$$Sat. + Sun. = (380 + 322 + 306) / 3 = 336$$

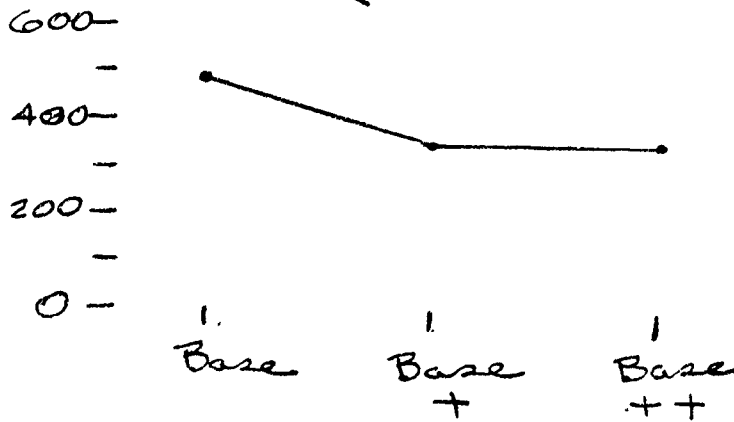


Equip

$$Base = (302 + 323 + 306) / 3 = 497$$

$$Base + = (382 + 322 + 363) / 3 = 355.7$$

$$Base ++ = (380 + 393 + 312) / 3 = 361.7$$



136A

FY 90

19

Omega Transform

$-10 \log_{10} (\frac{1}{F} - 1)$

Run No.	Thruput	db
1	77.4	5.3463
2	98.6	18.4775
3	98.1	17.1292
4	99.5	22.9885
5	98.6	18.4775
6	99.1	20.4183
7	98.1	17.1292
8	99.5	22.9885
9	99.5	22.9885

Manpower Dist.

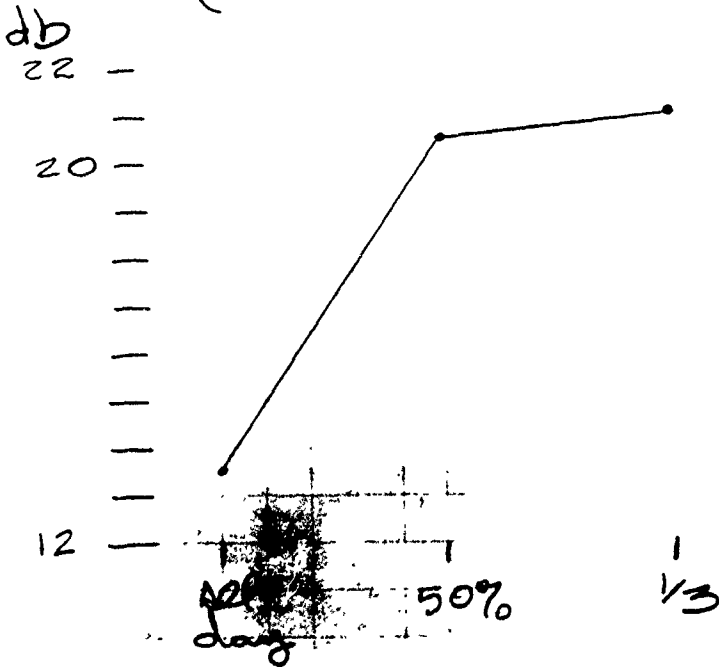
All day

$= (5.3463 + 18.4775 + 17.1292) / 3 = 13.651$

50%

$= (22.9885 + 18.4775 + 20.4183) / 3 = 20.6281$

$1/3 = (17.1292 + 22.9885 + 22.9885) / 3 = 21.0351$



Overtime

40hrs

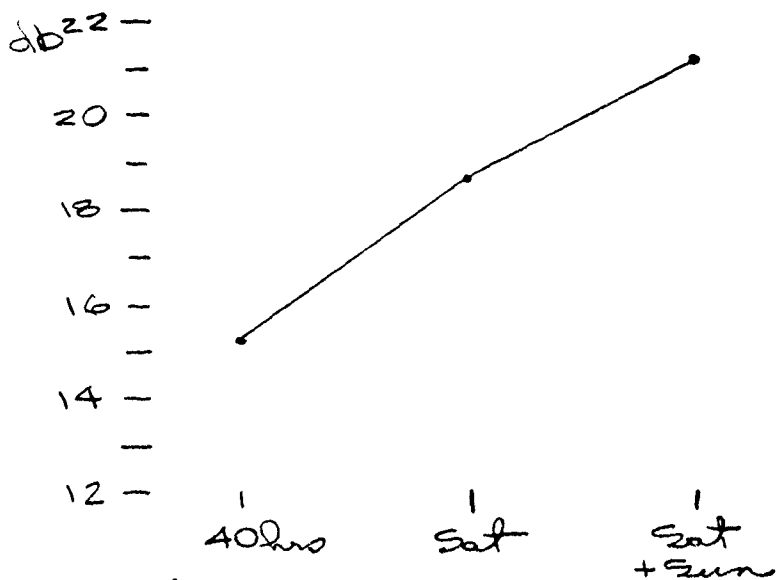
= (5.3463 + 22.9885 + 17.1292) / 3 = 15.1547

Sat

= (18.4775 + 20.4183 + 17.1292) / 3 = 18.675

Sat + Sun

= (17.1292 + 22.9885 + 22.9885) / 3 = 21.0354

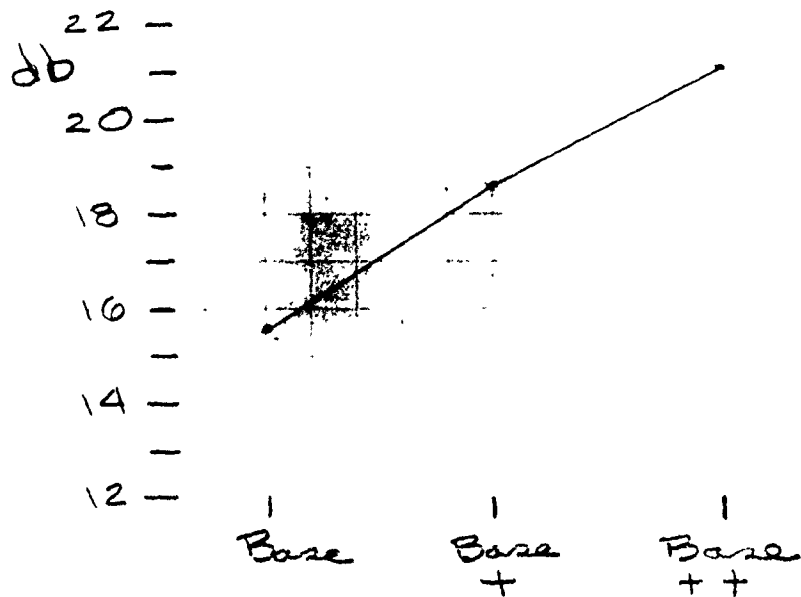


Equip.

Base = (5.3463 + 18.4775 + 22.9885) / 3 = 15.6041

Base + = (18.4775 + 20.4183 + 17.1292) / 3 = 18.675

Base ++ = (17.1292 + 22.9885 + 22.9885) / 3 = 21.0354



Average = 18.4382

so with just 50%, 99.1%

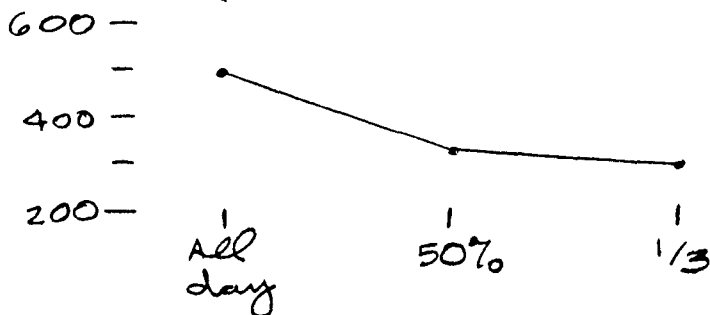


Manpower Dist.  
All day shift

$$= (790 + 351 + 351) / 3 = 497.3$$

$$50\% = (363 + 296 + 296) / 3 = 318.3$$

$$1/3 = (314 + 284 + 281) / 3 = 293$$

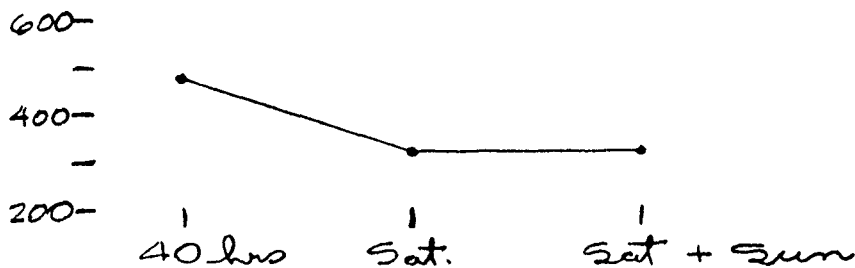


Overtime

$$40 \text{ hrs} = (790 + 363 + 314) / 3 = 489$$

$$\text{Sat.} = (351 + 296 + 284) / 3 = 310.3$$

$$\text{Sat} + \text{Sun} = (351 + 296 + 281) / 3 = 309.3$$

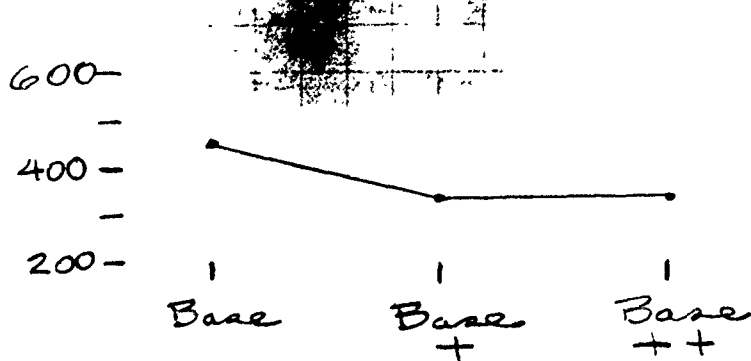


Equip.

$$\text{Base} = (790 + 296 + 281) / 3 = 455.7$$

$$\text{Base} + = (351 + 296 + 314) / 3 = 320.3$$

$$\text{Base} + + = (351 + 296 + 284) / 3 = 332.7$$



Any shift moves to 99%  
Base = 39.6%

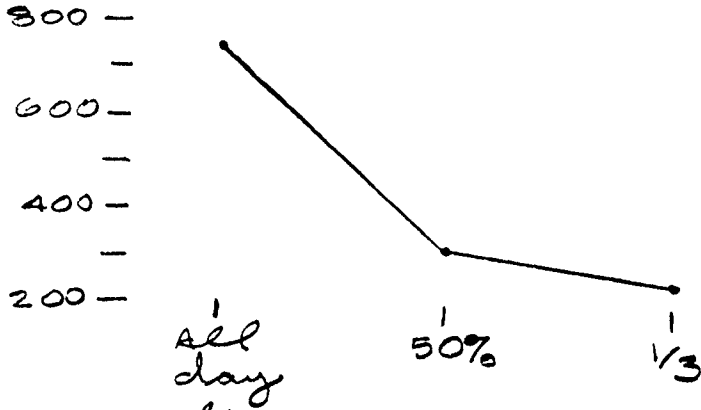
Manpower Dist.  
All day shift

$= (1436 + 408 + 401) / 3 = 748.3$

50%

$= (374 + 286 + 274) / 3 = 311.3$

$1/3 = (288 + 232 + 239) / 3 = 253$

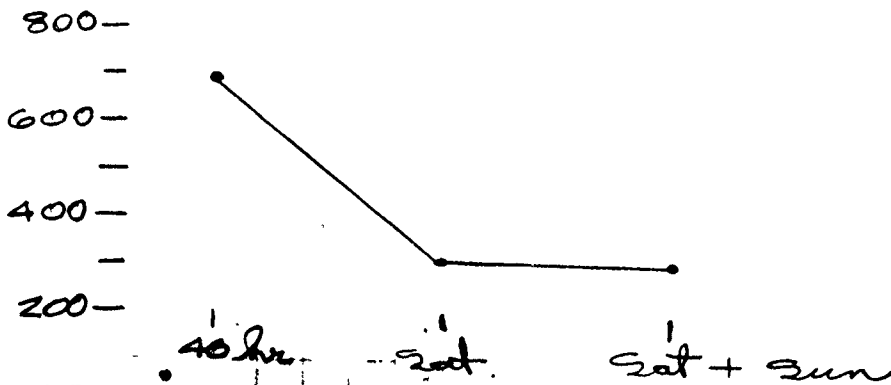


Overtime

40hr. =  $(1436 + 374 + 288) / 3 = 699.3$

Sat. =  $(408 + 286 + 232) / 3 = 308.7$

Sat. + Sun =  $(401 + 274 + 239) / 3 = 304.7$

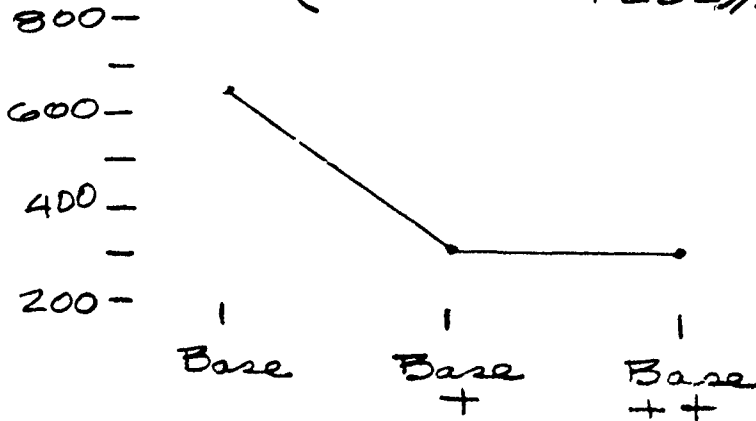


Equip.

Base =  $(226 + 286 + 239) / 3 = 653.7$

Base + =  $(408 + 274 + 288) / 3 = 323.3$

Base ++ =  $(401 + 374 + 232) / 3 = 335.7$



Base 67.9  
 Day shift  
 provides  
 at least  
98.1%

Manpower Dist.  
All day shift

$(329 + 536 + 557) / 3 = 640.7$

$50\% (475 + 369 + 368) / 3 = 404$

$1/3 (402 + 324 + 326) / 3 = 350.7$

Overtime

$40\text{hrs} = (329 + 475 + 402) / 3 = 568.7$

$\text{Sat.} = (536 + 369 + 324) / 3 = 409.7$

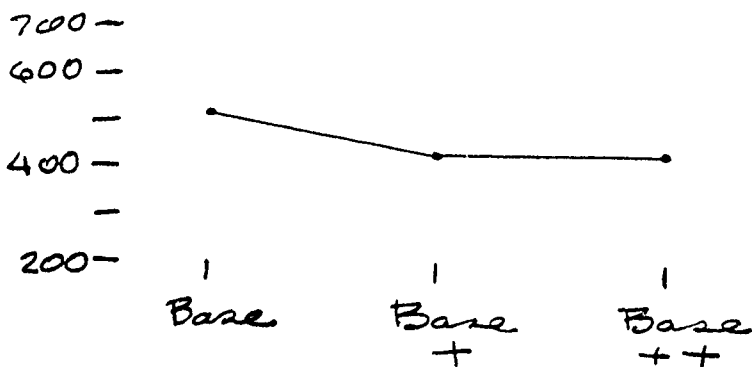
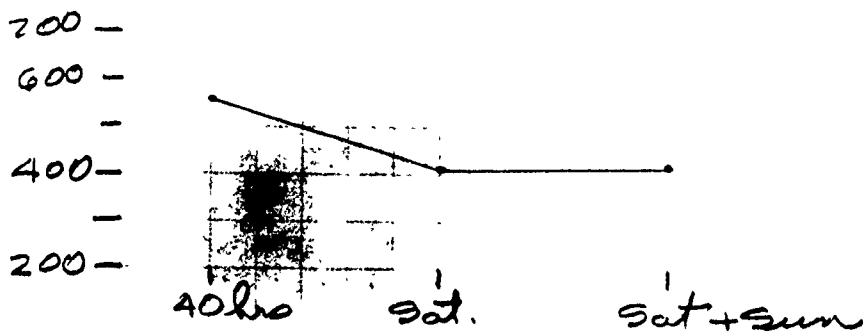
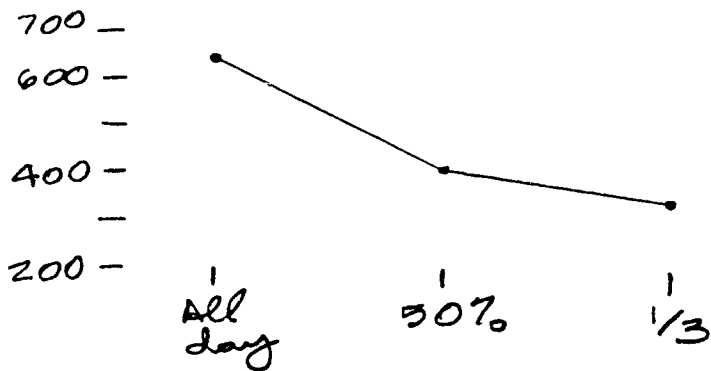
$\text{Sat} + \text{Sun} = (557 + 368 + 326) / 3 = 417$

Equip.

$\text{Base} = (329 + 369 + 326) / 3 = 508$

$\text{Base} + = (536 + 368 + 402) / 3 = 435.3$

$\text{Base} ++ = (557 + 475 + 324) / 3 = 452.0$



## Omega Transform

Run no.	Throughput	db
1	96.6	14.5350
2	97.3	15.5675
3	96.6	14.5350
4	99.3	21.5185
5	99.3	21.5185
6	98.6	18.4775
7	98.6	18.4775
8	99.3	21.5185
9	99.3	21.5185

## Manpower Dist.

All day shift

$$(14.5350 + 15.5675 + 14.5350) / 3 = 14.8792$$

$$50\% (21.5185 + 21.5185 + 18.4775) / 3 = 20.5048$$

$$1/3 (18.4775 + 21.5185 + 21.5185) / 3 = 20.5048$$

## Overtime

$$40 hrs (14.5350 + 21.5185 + 18.4775) / 3 = 18.177$$

$$Sat (15.5675 + 21.5185 + 21.5185) / 3 = 19.5348$$

$$Sat + Sun (14.5350 + 18.4775 + 21.5185) / 3 = 18.177$$

## Equip.

$$Base = (14.5350 + 21.5185 + 21.5185) / 3 = 19.1907$$

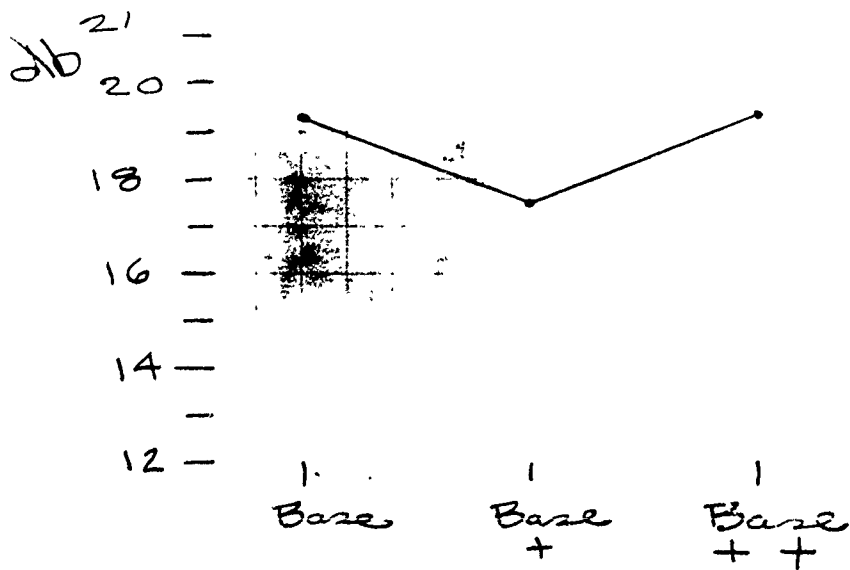
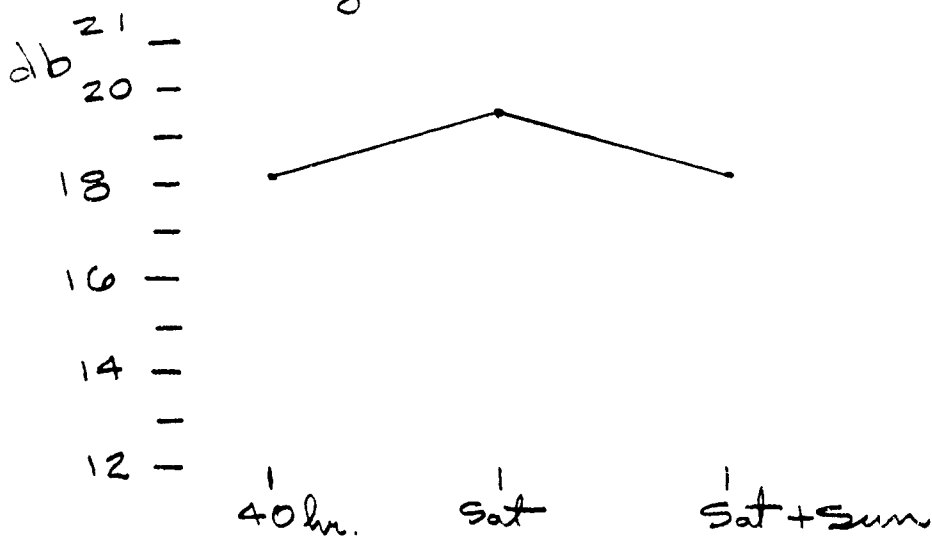
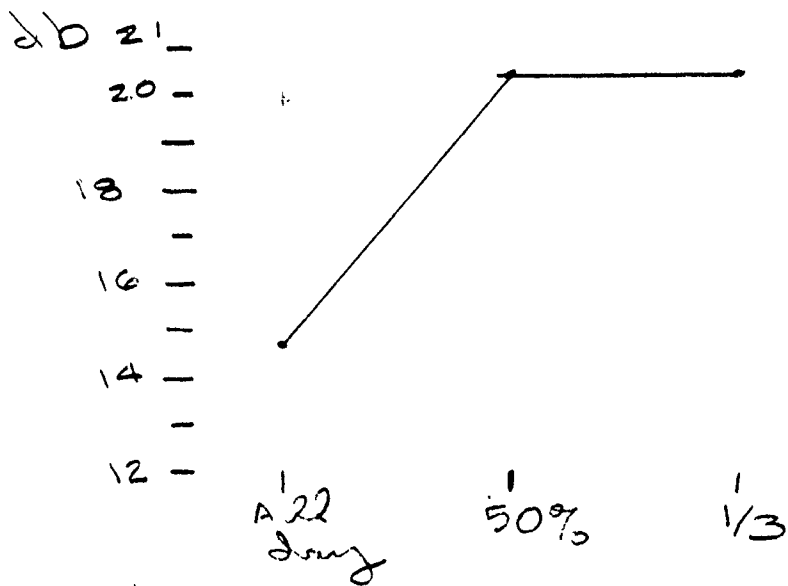
$$Base + Sat = (15.5675 + 18.4775 + 18.4775) / 3 = 17.5075$$

$$Base + Sun = (14.5350 + 21.5185 + 21.5185) / 3 = 19.1907$$

$$Average = 18.6296$$

150A

FY90



Manpower Dist.

All day shift

(1016 + 521 + 467) / 3 = 668

50%

(432 + 365 + 350) / 3 = 382.3

1/3 (386 + 317 + 318) / 3 = 340.3

Overtime

40hr. (1016 + 432 + 386) / 3 = 611.3

Sat. (521 + 365 + 317) / 3 = 401

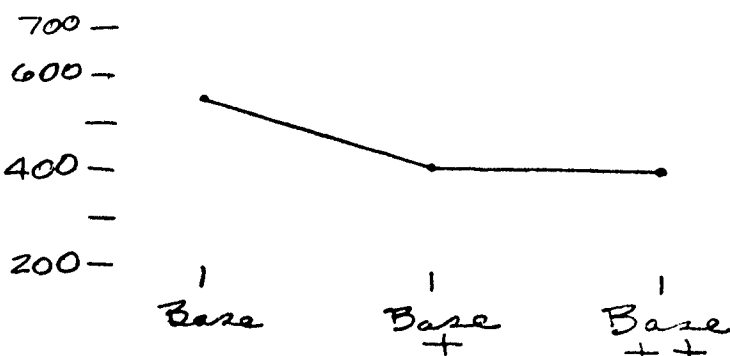
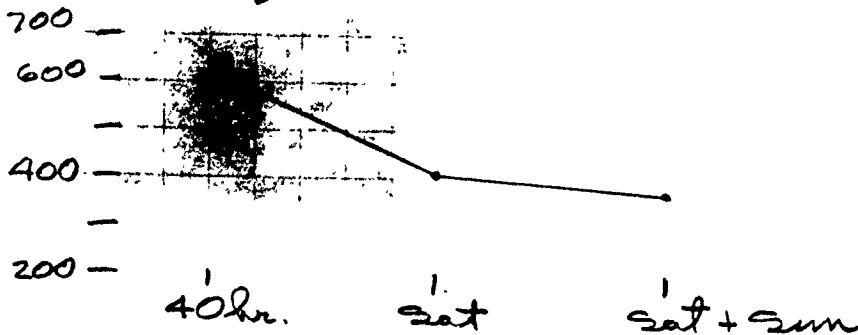
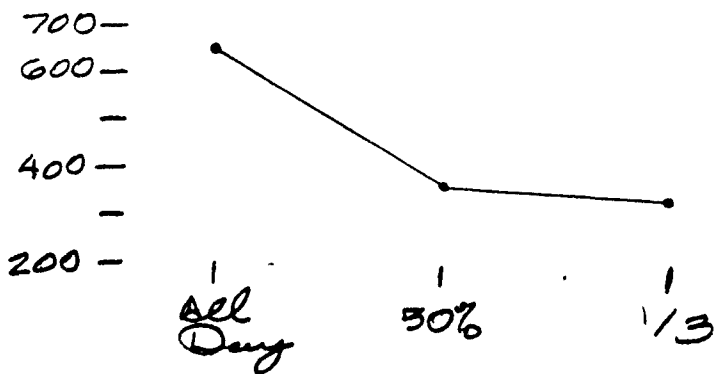
Sat + Sun (467 + 350 + 318) / 3 = 378.3

Equip.

Base (1016 + 365 + 318) / 3 = 566.3

Base + (521 + 350 + 386) / 3 = 419

Base ++ (467 + 432 + 317) / 3 = 405.3



## Omega Transform

Run No.	Throughput	db
1	54.3	.7488
2	89.4	9.2603
3	95.4	13.1679
4	96.0	13.8021
5	98.0	16.9020
6	98.7	18.8037
7	96.7	14.6691
8	98.7	18.8037
9	99.3	21.5185

## Manpower Dist.

All day

$$(.7488 + 9.2603 + 13.1679) / 3 = 7.7257$$

50%

$$(13.8021 + 16.9020 + 18.8037) / 3 = 16.5026$$

1/3

$$(14.6691 + 18.8037 + 21.5185) / 3 = 18.3304$$

## Overtime

$$40 \text{ hr. } (.7488 + 13.8021 + 14.6691) / 3 = 9.74$$

$$\text{Sat } (9.2603 + 16.9020 + 18.8037) / 3 = 14.9387$$

$$\text{Sat + Sun } (13.1679 + 18.8037 + 21.5185) / 3 = 17.8300$$

## Equip.

$$\text{Base } (.7488 + 16.9020 + 21.5185) / 3 = 13.0564$$

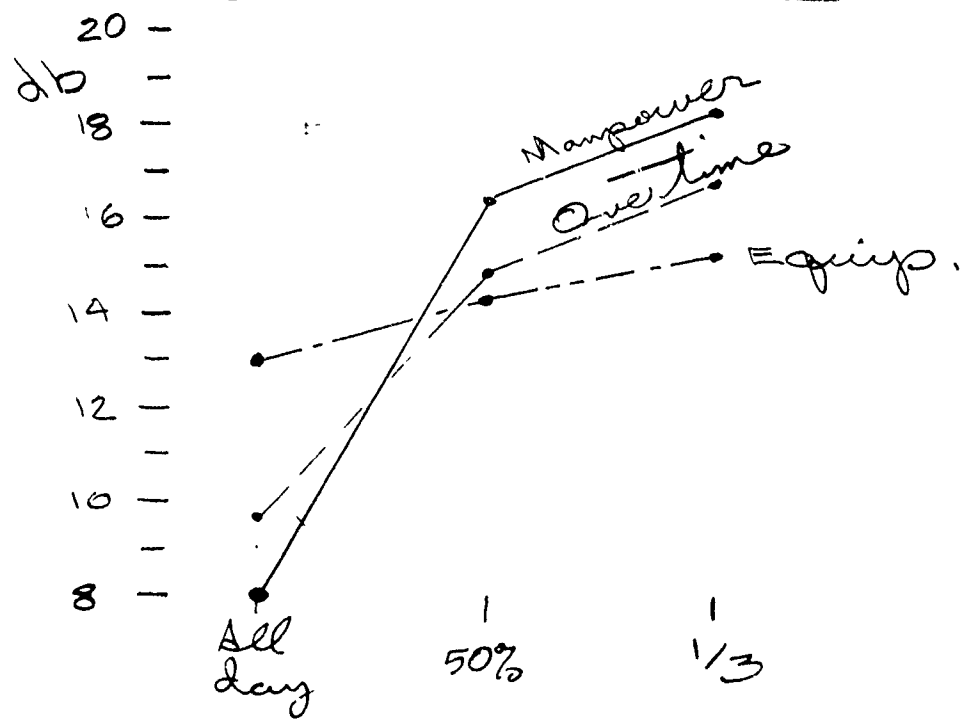
$$\text{Base + } (9.2603 + 18.8037 + 14.6691) / 3 = 14.2444$$

$$\text{Base + + } (13.1679 + 13.8021 + 18.8037) / 3 = 15.2579$$

$$\text{Average} = 14.1862$$

175 A

FY 90





249A

FY90

Manpower Dist.

All day

$$(2808 + 1474 + 1183) / 3 = 1821.7$$

50%

$$(903 + 920 + 729) / 3 = 850.7$$

$$1/3 (735 + 361 + 588) / 3 = 561.3$$

Overtime

$$40 \text{ hr } (2808 + 903 + 735) / 3 = 1482$$

$$\text{Sat } (1474 + 920 + 361) / 3 = 918.3$$

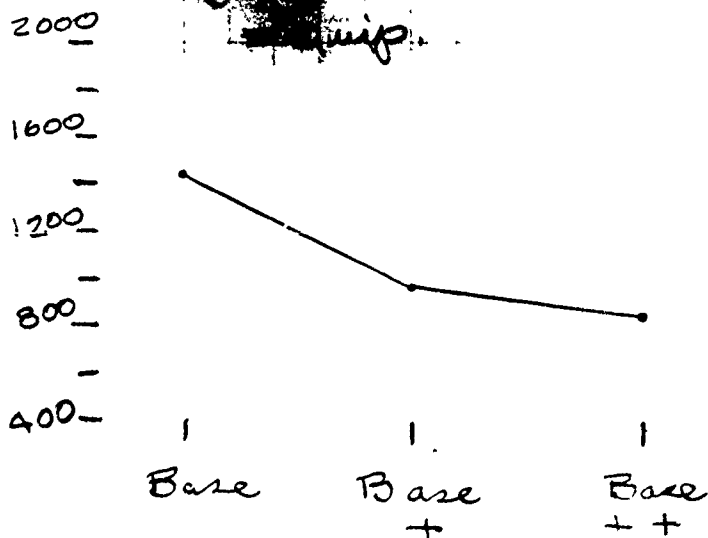
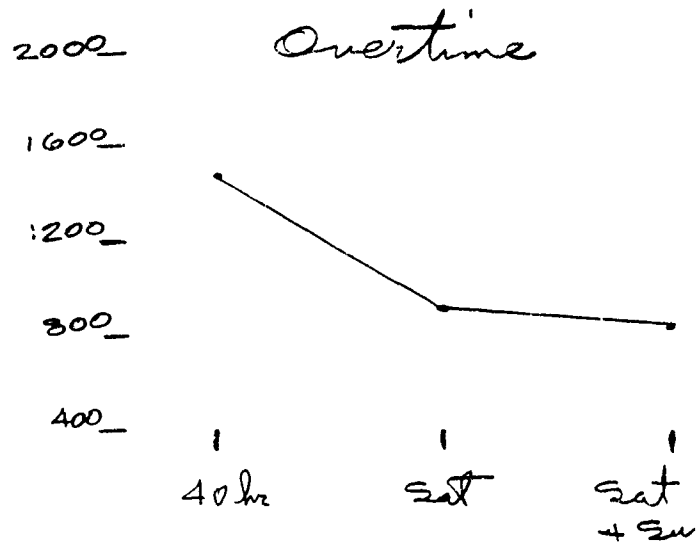
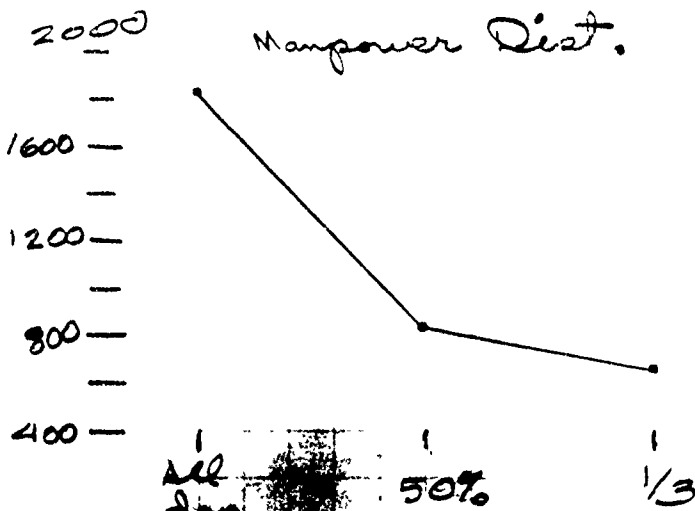
$$\text{Sat + Sun } (1183 + 729 + 588) / 3 = 833.3$$

Equip.

$$\text{Base } (2808 + 920 + 588) / 3 = 1438.7$$

$$\text{Base } + (1474 + 729 + 735) / 3 = 979.3$$

$$\text{Base } + + (1183 + 903 + 361) / 3 = 815.7$$



(912) 926-2693

## Omega Transform

Run no.

Thruput

db

1	22	-5.4967
2	40.1	-1.7428
3	48.9	-.1911
4	63.7	2.4423
5	61.5	2.0341
6	78.6	5.6501
7	79.1	5.7803
8	97.2	15.4051
9	97.8	16.4792

Manpower Dist.

All day shift

$$(-5.4967 - 1.7428 - .1911) / 3 = -2.4769$$

50%

$$(2.4423 + 2.0341 + 5.6501) / 3 = 3.3755$$

$$1/3(5.7803 + 15.4051 + 16.4792) / 3 = 12.5549$$

overtime

$$40hr (-5.4967 + 2.4423 + 5.7803) / 3 = .9086$$

$$sat (-1.7428 + 2.0341 + 15.4051) / 3 = 15.6964$$

$$sat + sun. (-.1911 + 5.6501 + 16.4792) / 3 = 21.9382$$

Equip.

$$Base (2.4423 + 2.0341 + 16.4792) / 3 = 4.5389$$

$$Base + (-1.7428 + 5.6501 + 5.7803) / 3 = 3.2292$$

$$Base ++ (15.4051 + 2.4423 - .1911) / 3 = 17.6563$$

Average 4.4845

Manpower Dist.

All day  $(2902 + 1456 + 1185) / 3 = 1847.7$

50%  $(908 + 911 + 725) / 3 = 848$

1/3  $(739 + 359 + 596) / 3 = 564.7$

Overtime

40hr  $(2902 + 908 + 739) / 3 = 1516.3$

Sat  $(1456 + 911 + 359) / 3 = 908.7$

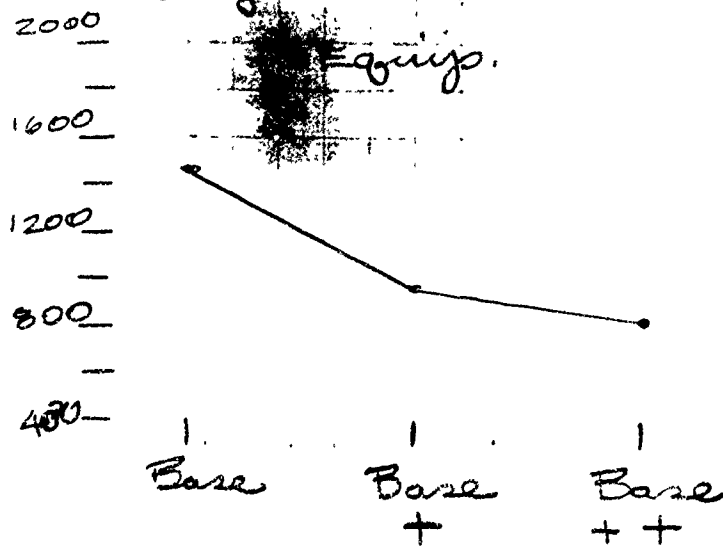
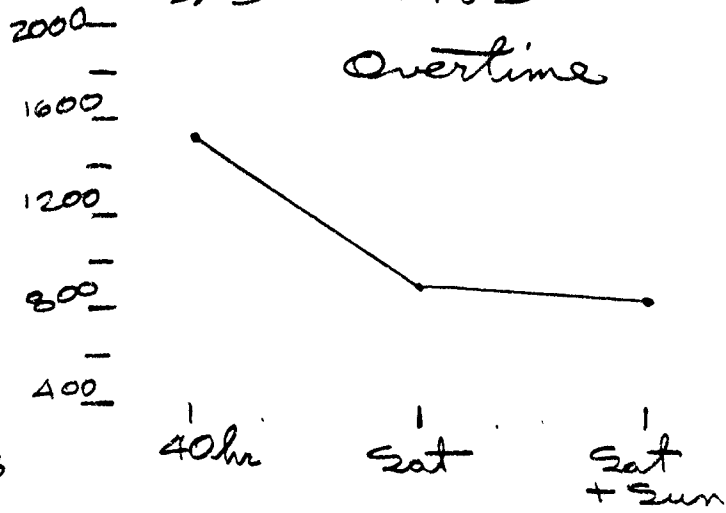
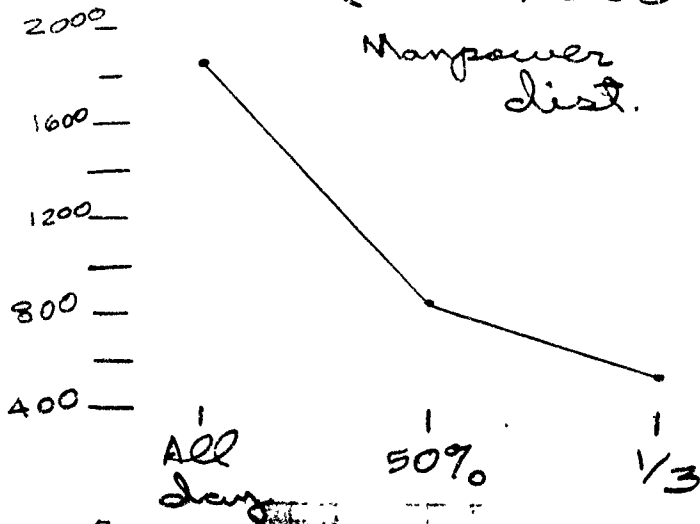
Sat + Sun  $(1185 + 725 + 596) / 3 = 835.3$

Equip.

Base  $(2902 + 911 + 596) / 3 = 1469.7$

Base +  $(1456 + 725 + 739) / 3 = 973.3$

Base ++  $(1185 + 908 + 359) / 3 = 817.3$



250A

FY 90

(32)

Omega

Run No.	Throughput	db
1	24.1	-4.9822
2	46.2	-.6614
3	56.9	1.2063
4	74.9	4.7480
5	72.8	4.2756
6	93.8	11.7981
7	91.8	10.4903
8	100 (99)	19.9564
9	100 (99)	19.9564

Manpower Dist.

All day shift

$$(-4.9822 + (-.6614) + 1.2063) / 3 = -1.4791$$

50%

$$(4.7480 + 4.2756 + 11.7981) / 3 = 6.9406$$

$$1/3 (10.4903 + 19.9564 + 19.9564) / 3 = 16.8010$$

Overtime

$$40hr (-4.9822 + 4.7480 + 10.4903) / 3 = 3.4187$$

$$Sat (-.6614 + 4.2756 + 19.9564) / 3 = 7.8569$$

$$Sat + Sun (1.2063 + 11.7981 + 19.9564) / 3 = 10.9869$$

Equip

$$Base (-4.9822 + 4.2756 + 19.9564) / 3 = 6.4166$$

$$Base + (-.6614 + 11.7981 + 10.4903) / 3 = 7.209$$

$$Base ++ (1.2063 + 4.7480 + 19.9564) / 3 = 8.6369$$

Average 7.4208

→ 97.2    1/3, sat. (++)  
100%    1/3, sat    ++

~~177~~

137  
148

119

99.7    50, sat, Base ++

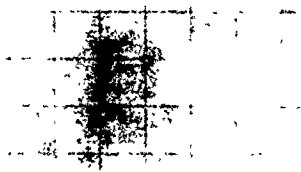
99    50, —,

321

168

103  
85

86.2%



SURGE INDUCTIONS	BASE SIMULATION	THROUGHPUT
224	150	67.0%
219	189	86.3%
277	51	18.4%
249	71	28.5%
279	116	41.6%
287	112	39.0%
358	161	45.0%
327	186	56.9%
178	71	39.9%
254	185	72.8%
261	82	31.4%
286	286	100.0%
0	0	N/A
31	30	96.8%
24	27	112.5%
18	19	105.6%
47	44	93.6%
0	0	N/A
297	27	9.1%
309	33	10.7%
=====	=====	=====
3925	1840	46.9%

DC/MC MAPAD  
SHEETMETAL REPAIR SHOP  
JUNE 15, 1989

F190		BASE		SURGE		BASE	
EMP-ITEM	INDUCTIONS	SIMULATION	THROUGHPUT	EMP-ITEM	INDUCTIONS	SIMULATION	THROUGHPUT
15188A	0	0	M/A	15188A	0	0	M/A
15237A	6	0	M/A	15237A	0	0	M/A
15249A	187	40	22.02	15249A	297	27	9.12
15250A	195	47	24.12	15250A	309	33	10.72
15119A	179	65	38.22	15119A	277	51	18.42
15321A	161	74	46.02	15321A	249	71	28.32
15175A	131	82	54.32	15175A	261	82	31.42
15128A	175	111	63.42	15380A	287	112	39.02
15309A	184	117	63.52	15146A	178	71	39.92
15140A	196	72	67.92	15126A	279	116	41.62
15136A	212	164	77.42	15136A	358	161	45.02
15137A	201	180	89.62	15137A	327	186	56.92
15113A	134	124	92.52	15025A	224	130	67.02
15025A	136	131	96.32	15159A	254	185	72.82
15159A	146	141	96.62	15113A	219	189	86.32
15189A	19	19	100.02	15236A	47	48	55.52
15236A	23	23	106.02	15189A	31	30	96.82
15192A	12	12	100.02	15192A	18	18	100.82
15191A	16	16	100.02	15191A	24	24	100.32
15178A	177	177	100.02	15178A	286	286	100.02
2400	1595		66.52	3925	1836		46.82

78.3 { 2242  
250  
862 { 119  
321

ABBATANA

OC/ALC MABPAB  
 SHEETMETAL REPAIR SHOP 6/15/89

END-ITEM	SURGE INDUCTIONS	BASE SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	297	27	9.1%
15250A	309	33	10.7%
15119A	277	51	18.4%
15321A	249	71	28.5%
15175A	261	82	31.4%
15300A	287	112	39.0%
15140A	178	71	39.9%
15126A	279	116	41.6%
15136A	358	161	45.0%
15137A	327	186	56.9%
15025A	224	150	67.0%
15150A	254	185	72.8%
15113A	219	189	86.3%
15236A	47	44	93.6%
15189A	31	30	96.8%
15192A	18	18	100.0%
15191A	24	24	100.0%
15178A	286	286	100.0%
=====	=====	=====	=====
	3925	1836	46.8%



DC/ALC MABPAB  
SHEETMETAL REPAIR SHOP

6/15/89

END-ITEM	SURGE INDUCTIONS	STD HRS	WORKLOAD W/AVG	%
15025A	224	163.49	36622	10.2%
15250A	309	110.99	34296	9.5%
15249A	297	110.53	32827	9.1%
15113A	219	147.72	32351	9.0%
15136A	358	79.18	28346	7.9%
15300A	287	98.31	28215	7.8%
15137A	327	79.18	25892	7.2%
15119A	277	89.76	24864	6.9%
15126A	279	88.73	24756	6.9%
15321A	249	90.24	22470	6.2%
15150A	254	85.15	21628	6.0%
15175A	261	73.86	19277	5.3%
15140A	178	51.65	9194	2.5%
15236A	47	121.58	5714	1.6%
15178A	286	18.97	5425	1.5%
15189A	31	120.73	3743	1.0%
15191A	24	118.72	2849	0.8%
15192A	18	118.72	2137	0.6%
15188A	0	120.73	0	0.0%
15237A	0	28.6	0	0.0%
			=====	
			360606	100.0%

SET WITH INDEPENDENT FIXTURES ①

RUN NO.	PART NO. 15025A	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE	INDUCTION
1	F B	1500	150		224
2	s B+	850	208		224
3	ss B++	802/	213		
4	F B++	520	225		
5	s B	308	222		
6	ss B+	300	222		
7	F B+	425	222		
8	s B++	347	222		
9	ss B	321	222		

RUN NO.	PART NO. 15113A	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE	INDUCTION
1		1328	189		219
2		738	218		219
3		736	219		
4		660	220		
5		485	218		
6		481	219		
7		534	219		
8		420	217		
9		407	218		

2

SET

RUN NO.	PART NO. 15119A	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE	INDUCTION
1		3705	51		277
2		1544	143		277
3		1095	200		
4		826	259		
5		963	213		
6		802	259		
7		759	276		
8		258	274		
9		412	279		

RUN NO.	PART NO. 15321A	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE	INDUCTION
1		2866	71		249
2		1891	112		249
3		1160	183		
4		901	234		
5		1504	144		
6		782	256		
7		1002	210		
8		267	248		
9		422	255		

SET

(3)

RUN NO.	PART NO. 15126A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1	2417	118A	116		279
2			225		279
3	6150		282		
4	276		276		
5	236		277		
6	203		277		
7	258		275		
8	210		277		
9	187		277		

RUN NO.	PART NO. 15300A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1	2377		112		287
2	118A		234		287
3	630		297		
4	285		288		
5	250		286		
6	210		286		
7	266		288		
8	217		286		
9	194		286		

SET

(4)

RUN NO.	PART NO. 15136A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1		1746	161		358
2		689	355		358
3		328	356		
4		437	353		
5		344	354		
6		324	354		
7		431	358		
8		327	355		
9		308	355		

RUN NO.	PART NO. 15137A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1		1538	186		327
2		658	328		327
3		368	328		
4		422	324		
5		315	324		
6		299	325		
7		407	330		
8		296	326		
9		284	326		

INDEPENDENT

(5)

RUN NO.	PART NO. 15140A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1		2771	71		178
2		457	173		178
3		400	173		
4		361	173		
5		335	174		
6		275	176		
7		296	174		
8		235	177		
9		246	176		

INDEP.

RUN NO.	PART NO. 15150A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1		1476	185		254
2		662	229		254
3		677	226		
4		527	231		
5		382	243		
6		375	243		
7		422	240		
8		346	245		
9		325	247		

INDEF.

6

PART NO. 15175A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1	2339	82	261
2	911	157	261
3	766	187	
4	512	217	
5	482	213	
6	405	232	
7	446	231	
8	329	248	
9	351	242	

INDEF.

PART NO. 15178A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1	738	286	286
2	388	289	286
3	387	291	
4	417	293	
5	313	288	
6	312	287	
7	351	290	
8	301	287	
9	299	287	

SET

(7)

PART NO. 15188A (?)

NOTE POSSIBLE ERRC. 2  
WORKLOAD SURGE

FLOW TIME

NO. OF PARTS

INDUCTION  
O.P.

RUN NO.

1			
2			
3			
4			
5			
6			
7			
8			
9			

PART NO. 15189A

WORKLOAD

SURGE

NO. OF PARTS

INDUCTION

RUN NO.

1	1640	30	31
2	764	29	
3	771	30	31
4	628	30	
5	538	29	
6	513	29	
7	584	29	
8	509	29	
9	428	29	



8

SET

RUN NO.	PART NO. 15101A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1	10083	767	27		24
2		756	27		24
3		661	26		
4		507	26		
5		486	27		
6		583	26		
7		459	26		
8		409	26		

RUN NO.	PART NO. 15102A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1	1712	802	19		18
2		762	19		18
3		692	19		
4		532	19		
5		508	19		
6		618	19		
7		510	19		
8		418	19		

69

RUN NO.	PART NO. 15236A	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1		305	44	47
2		633	45	47
3		632	45	
4		624	44	
5		518	45	
6		518	45	
7		588	45	
8		498	45	
9		486	44	

RUN NO.	PART NO. 15237A	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1				0(?)
2				
3				
4				
5				
6				
7				
8				
9				

SET

RUN NO.	PART NO. 15243A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1		5572	27		297
2		3093	58		297
3		2361	91		
4		1843	121		
5		1870	116		
6		1482	143		
7		1520	147		
8		740	283		
9		1231	173		

RUN NO.	PART NO. 15250A	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1		5891	33		309
2		2956	79		309
3		2377	110		
4		1805	158		
5		1819	147		
6		1489	179		
7		1438	196		
8		711	316		
9		1235	213		

SET WITH INDEPENDENT FIXTURES

①

PART NO. 15025A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	FY90	INDUCTION
1	824	131			136
2	567	136			136
3	560	135			136
4	476	135			136
5	375	134			136
6	377	133			136
7	394	133			136
8	324	134			136
9	319	134			136

PART NO. 15113A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	FY90	INDUCTION
1	995	124	92.5%		134
2	699	127	94.8%		134
3	695	127	94.8%		134
4	630	128	95.5%		134
5	473	129	96.3%		134
6	477	129			134
7	515	130	97.0%		134
8	408	131	97.8%		134
9	406	130	97.0%		134

SET

PART NO. 15119A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	1765	65	38.2	170
2	821	128	75.3	170
3	485	172	100%	170
4	376	168	98.8	120
5	331	166	97.6	170
6	288	167	98.2	170
7	305	166	97.6	170
8	235	171	100	170
9	245	171	100	170

PART NO. 15321A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	1522	74	46%	161
2	812	130	80.7	161
3	478	163	100	161
4	322	163	100	161
5	328	161	100	161
6	283	164	100	161
7	311	166	100	161
8	233	164	100	161
9	242	164	100	161

SET

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15126A	1254	111	63.4%	175
2		268	120	97.1%	175
3		257	169	96.6%	175
4		262	170	97.1	175
5		203	120		175
6		200	170		175
7		221	170		175
8		188	170		175
9		185	170	97.1	175

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15300A	1220	117	63.6%	184
2		283	186	100%	184
3		267	186		184
4		268	186		184
5		208	189		184
6		203	189		184
7		234	186		184
8		190	189		184
9		187	189		184

SET

RUN NO.	PART NO. 15136A	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1		862	164	77.4	212
2		382	209	98.6	212
3		380	208	98.1	212
4		393	211	99.5	212
5		323	209	98.6	212
6		322	210	99.1	212
7		363	208	98.1	212
8		312	211	99.5	212
9		306	211	99.5	212

RUN NO.	PART NO. 15137A	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1		790	180	89.6	201
2		351	199	99.0	201
3		351	199	99.0	201
4		363	200	99.5	201
5		296	201	100%	201
6		296	201	100%	201
7		314	201	100%	201
8		284	200	99.5	201
9		281	200	99.5	201

INDEF.

RUN NO.	PART NO. 15140A	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1		1436	72	67.9	106
2		408	104	98.1	106
3		401	105	99.1	106
4		324	105	99.1	106
5		286	106	100%	106
6		274	106		106
7		288	106		106
8		232	107		106
9		239	107	100%	106

INDEF.

RUN NO.	PART NO. 15150A	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1		829	141	96.6%	146
2		536	142	97.3	146
3		557	141	96.6%	146
4		475	145	99.3	146
5		369	145	99.3	146
6		368	144	98.6	146
7		402	144	98.6	146
8		324	145	99.3	146
9		326	145	99.3	146



INDEX.

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15175A	1016	82	54.3	151
2		521	135	82.4	151
3		467	144	95.4	151
4		432	145	96.0	151
5		365	148	98.0	151
6		350	149	98.7	151
7		386	146	96.7	151
8		317	149	98.7	151
9		318	150	99.3	151

INDEX.

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15178A	465	180	177	177
2		358	178	177	177
3		361	178	177	177
4		382	179	177	177
5		311	178	177	177
6		311	178	177	177
7		336	178	177	177
8		299	178	177	177
9		299	178	177	177

100%

RUN NO.	PART NO.	15188A	WORKLOAD
	FLOW TIME	NO. OF PARTS	INDUCTION
1	0	0	0
2	0	0	0
3	0	0	0
4	0	0	0
5	0	0	0
6	0	0	0
7	0	0	0
8	0	0	0
9	0	0	0

RUN NO.	PART NO.	15189A	WORKLOAD
	FLOW TIME	NO. OF PARTS	INDUCTION
1	992	19	19
2	730	19	19
3	731	19	19
4	653	18	19
5	498	20	19
6	502	20	19
7	528	20	19
8	450	20	19
9	434	20	19

100%

SET

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15191A	967	17		16
2		703	17		16
3		732	17		16
4		660	17		16
5		429	17		16
6		489	17		16
7		531	17		16
8		417	18		16
9		403	18		16

100%

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15192A	1062	13		12
2		764	13		12
3		755	12		12
4		657	13		12
5		520	13		12
6		505	13		12
7		532	13		12
8		423	12		12
9		414	12		12

100%

PART NO. 15236A

WORKLOAD

RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	784	24	23
2	618	24	23
3	617	24	23
4	632	24	23
5	510	23	23
6	515	23	23
7	561	23	23
8	478	23	23
9	484	23	23

100%

PART NO. 15237A

WORKLOAD

RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	0	0	0
2	0	0	0
3	0	0	0
4	0	0	0
5	0	0	0
6	0	0	0
7	0	0	0
8	0	0	0
9	0	0	0

SET

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15249A	2808	40	22%	182
2		1474	73	40.1	182
3		1183	89	48.9	182
4		903	116	63.7	182
5		920	112	61.5	182
6		729	143	78.6	182
7		735	144	79.1	182
8		361	177	97.2	182
9		588	178	97.8	182

RUN NO.	PART NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	INDUCTION
1	15250A	2902	47	24.1	195
2		1456	90	46.2	195
3		1185	111	56.9	195
4		908	146	74.9	195
5		911	142	72.8	195
6		725	183	93.8	195
7		739	179	91.8	195
8		359	198	100%	195
9		596	198	100%	195

## OC-ALC/MABPAB SHEET METAL SHOP DRAFT RECOMMENDATIONS

RECOMMENDATION TYPE	POTENTIAL BENEFIT(S)
FOCUS STUDY	QUEUE REDUCTION BY IMPLEMENTING A MATERIAL CONTROL (PULL-APPROACH).
QUICK FIX	IMPROVE SPACE UTILIZATION BY CONSOLIDATING SUPERVISORS' OFFICES.
FOCUS STUDY	IMPLEMENT A "STAND-ALONE" SHEET METAL CONCEPT BY INCORPORATING BACKSHOP OPERATIONS.
QUICK FIX	REDUCTION OF TRAVEL TIME & DISTANCE ON END ITEMS BY IMPLEMENTING A MOBILE TAGGING UNIT.
FOCUS STUDY	INCREASE PAINTING CAPACITY BY DEVELOPING A VERTICAL-PAINTING PROCESS.
QUICK FIX	INCREASE STORAGE CAPACITY BY USING VERTICAL SPACE.
QUICK FIX	IMPROVE FLOW DAYS BY IMPLEMENTING COLOR TAGGING PARTS.
QUICK FIX	<p><u>TOOLING</u></p> <ul style="list-style-type: none"> <li>• IMPROVE ACCURACY &amp; MINIMIZE TIME FOR WEIGHT &amp; BALANCE OPERATION ON FLIGHT CONTROL USING AN ELECTRONIC DEVICE.</li> </ul> <p>CO<sub>2</sub> SANDING VS. BRUSH SANDING.</p>

# # 1 - PRIORITY

2.1 FOCUS STUDY - OPPORTUNITY TO PROVIDE THE OPTIMUM LAYOUT FOR SHEET METAL OPERATIONS IN BLDG. # 2101  
AT OC

2.1.1 DESCRIPTION OF CURRENT OPERATION  
OPERATIONS ARE NOW LOCATED IN BLDG #95 WHICH IS TO BE VACATED BY SEPT. '89. SHEET METAL REFURBISHING IS PERFORMED ON COWLING, FLAPS, FLIGHT CONTROLS, DOORS AND MISC. STRUCTURES.

2.1.2 OVERALL ASSESSMENT OF CURRENT OPERATION  
CURRENT OPERATIONS ARE CONGESTED AND THE FLOW OF PARTS DOES NOT CONFORM TO ANY TYPE OF SYSTEMATIC PROGRESSION.

2.1.2.1 CURRENT PROCESS PROBLEMS  
MATERIAL HANDLING - EXCESSIVE  
TOOLING LAYOUTS CAUSES OPERATION INTERFERENCES  
WORK STATION LAYOUTS - NOT EFFICIENT  
STAGING AREAS NOT IN LINE OF FLOW.  
AIR AND UTILITIES LOCATIONS - IN ADEQUATE

2.1.2.2 SHOP ORGANIZATION

TOTAL REORGANIZATION OF OFFICE SUPPORT, RECEIVING STORES, SHIPPING AND OPERATIONS

2.1.3 RATIONALE LEADING TO CHANGE  
OBSERVATIONS INDICATE POOR FLOW, CONGESTED AREAS, EXCESSIVE MATERIAL HANDLING THAT CAN BE RESOLVED WITH THE APPLICATION OF GENERAL I.E. PLANT LAYOUT PRINCIPLES

2.1.3.1 SUPPORTING DATA -PROFILES -MODEL -GENERAL KNOWLEDGE

2.1.4 DESCRIPTION OF NEW PROCESS

(SEE ATTACHMENT)

- PRODUCTIVITY IMPROVEMENTS

A 15 TO 20% INCREASE IN PRODUCTIVITY IS ANTICIPATED

- RESOURCE UTILIZATION

MORE EFFICIENT FLOOR SPACE UTILIZATION BY REDUCING THE PRESENT 105,000 SQ.FT. TO 61,000 SQ.FT.

- FLEXIBILITY

CONSOLIDATED AREAS WILL ACCOMMODATE THE VARIATIONS IN PRODUCTION REQUIREMENTS

(BLDG #95 - RELOCATION)

2.1.4 DESCRIPTION OF NEW PROCESS

AN ORGANIZED I E EFFORT WILL BE DIRECTED TOWARD THE ESTABLISHMENT OF THE OPTIMUM LAYOUT FOR SHEET METAL OPERATIONS IN BLDG. #2102 BY:

- DEVELOPING A DETAILED PRODUCT FLOW ANALYSIS
- PROVIDING COMPLETE OPERATIONAL ANALYSES FOR ALL TASKS
- RE-DESIGN OF WORK STATION LAYOUTS
- TOOLING EVALUATIONS & LAYOUTS
- PROPER LOCATIONS OF AIR & UTILITIES.
- DESIGNATED STORES AREAS
  - " IN PROCESS STORAGES AREAS
  - " STAGING AREAS
- EVALUATION & RECOMMENDATION OF MORE EFFICIENT MATERIAL HANDLING EQUIPMENT
- CONSOLIDATED RECEIVING AREA
- CONSOLIDATED SHIPPING AREA
- ESTABLISHMENT AND LOCATION OF AN INCOMING RECEIVING INSPECTION AREA FOR VENDOR PARTS



2.1.5. BENEFITS/TRADE-OFFS

MORE EFFICIENT OPERATIONS AND A 40% REDUCTION  
IN REQUIRED FLOOR SPACE.  
- DOLLAR SAVINGS

COST BENEFIT ANALYSIS

IT IS ANTICIPATED A 15% REDUCTION  
IN LABOR REQUIREMENTS WILL BE REALIZED.

- INTANGIBLE SAVINGS

MORE ORGANIZED OPERATIONS  
BETTER SCHEDULING OVERVIEW  
MORE ON TIME DELIVERIES

2.1.6 IMPLEMENTATION COST/SCHEDULE

I.E. REQUIREMENT IS 3000 MAN HOURS

NOTES IF IMPLEMENTATION ASSISTANCE IS REQUIRED AN ADDITIONAL  
1000 I.E. MAN HOURS WOULD BE REQUIRED.

- IMPACT

MINIMAL - BY IMPLEMENTING A SEQUENTIAL SCHEDULE  
OF SEGMENTED MOVES.

2.1.7 SAFETY IMPROVEMENTS

ELIMINATION OF MATERIAL HANDLING HAZARDS.

2.1.8 ENVIRONMENTAL HAZARDS/IMPROVEMENTS

ENVIRONMENTALLY CONTROLLED PAINT OPERATION

2.1.9 RELIABILITY / MAINTAINABILITY CHARACTERISTICS

NON/APPLICABLE

2.1.10 HUMAN FACTORS DESIGN CRITERIA

LESS FATIGUE THROUGH BETTER WORK PLACE  
LAYOUT & MORE EFFECTIVE MATERIAL HANDLING.

ALC	RCC	TYPE	POTENTIAL BENEFIT(S)
OC	MABPAB	FS	QUEUE REDUCTION by implementing A MATERIAL CONTROL (pull-approach)
OC	MABPAB	QF	Improve space utilization by consolidating SUPERVISORS OFFICE
OC	MABPAB	FS	Implement A "STAND-ALONE" SHEET METAL CONCEPT by incorporating back shop operations
OC	MABPAB	QF	REDUCTION OF TRAVEL TIME + DISTANCE ON END ITEMS by implementing A MOBILE-TAGGING UNIT.
OC	MABPAB	FS	INCREASE PAINTING CAPABILITY by developing A VERTICAL-PAINTING PROCESS.
OC	MABPAB	QF	INCREASE STORAGE CAPACITY USING VERTICAL SPACE.
OC	MABPAB	QF	IMPROVE FLOW DAYS by implementing COLOR TAGGING PARTS.
OC	MABPAB	QF	<p>"Tooling"</p> <ul style="list-style-type: none"> <li>• IMPROVE ACCURACY + MINIMIZE TIME OF WEIGHT + BALANCE OPERATION ON FLIGHT CONTROL USING AN ELECTRONIC DEVICE.</li> <li>• CO<sub>2</sub> SANDING VS. BRUSH SANDING</li> </ul>

R. Bofanes



DEPARTMENT OF THE AIR FORCE  
HEADQUARTERS OKLAHOMA CITY AIR LOGISTICS CENTER (AFLC)  
TINKER AIR FORCE BASE OKLAHOMA 73145



REPLY TO  
ATTN OF:

MAW (TI)

19 Jan 89

SUBJECT:

RCC Workload Data To Support Technology Insertion (TI)

TO:

MABE

*Control*

1. McDonnell Douglas has requested that the attached ~~part~~ numbers for each identified RCC be reviewed to verify that they do in fact account for 80 percent of the workload for that RCC. It has also been requested that the columns on the attached forms be filled-in to reflect the workload for FY88 per quarter.

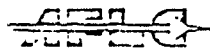
2. This information needs to be provided ASAP so that it may be telefaxed to McDonnell Douglas in St. Louis.

GENE W. LEITERMAN  
OC-ALC TI Program Manager

1 Atch  
Listing

*BS  
m  
20/1*

OPERATING BRANCH	
SEARCH	<u>1-23</u>
ASST	INFO
<input type="checkbox"/>	MADCS
<input checked="" type="checkbox"/>	MADCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MAJCS
<input type="checkbox"/>	MABE STAFF



COMBAT STRENGTH THROUGH LOGISTICS

MABPAB	FY 88 UNLOAD BY QUARTER *					
	MABPAB	1st	2nd	3rd	4th	
	LABOR	# UNITS	# UNITS	# UNITS	# UNITS	
1 15103	163.5	56	55	54	75	
2 15117	155.7	60	60	53	70	
3 15120	92.4	25	25	27	66	
4 15137	193.9	13	15	15	17	
5 15173	193.9	13	13	15	17	
6 15174	201.8	11	11	16	17	
7 15130	110.5	13	18	23	20	
8 15249	110.5	13	14	25	20	
9 15192	201.8	6	6	10	17	
10 15100	98.3	13	16	20	20	
11 15136	79.2	13	17	23	22	
12 15101	90.2	13	16	20	20	
13 15176	89.7	13	16	20	20	
14 15119	89.8	13	16	20	20	
15 15137	79.2	13	16	22	21	
16 15175	74.9	25	12	8	26	
17 15179	24.0	36	50	59	75	
18 15276	149.6	6	10	9	9	
19 15140	58.7	1	0	4	40	

\* IAW A-GØ19C-CAA-CA-MCE  
 DATED 16 JUN 1988



DEPARTMENT OF THE AIR FORCE  
HEADQUARTERS AIR FORCE LOGISTICS COMMAND  
WRIGHT-PATTERSON AIR FORCE BASE, OHIO 45433 5001

*TI Library  
file*

21 OCT 1988

REPLY TO  
ATTN OF MAQF

SUBJECT Surge Factors for Technology Insertion (TI) Program

TO Mr Dave Szukalski  
McDonnell Douglas Corp  
St Louis MO 63166-0516

1. The weapon systems surge factors to be used in the TI program are provided in attachment 1. For some weapon system subsystems you may need to contact the TI center representative to obtain a further surge factor breakdown.
2. If additional information is required, please contact myself or Trixie Brown at 513-257-7277.

*Doxie L. Cripe*  
DOXIE L. CRIFE  
Chief, Facilities & Equipment Div

1 Atch  
Surge Factors

cc: TI Working Group Members  
WPCC/PMRP (Don Peterson)

UNITED STATES AIR FORCE



SEPTEMBER 18, 1947

19 OCT 1988

	FY 89	FY90
MDS	SURGE %	SURGE %
A-7D	37	99
A-7K	68	66
TOTAL	86	96
A-10A	39	24
B-1B	3	-5
B-52G	134	186
B-52H	128	-10
TOTAL	132	115
C-5A	656	695
C-5B	549	488
TOTAL	612	597
C-7	0	0
C-9A	-11	45
C-9C	0	0
TOTAL	-10	42
C-12A	0	0
C-12F	-96	124
C-12J	0	0
TOTAL	-82	104
C-18A	0	0
C-20A	0	0
C-20B	0	0
C-20C	0	0
TOTAL	0	0
C-21A	-96	69

page 1 of 6

C-22A	0	0
C-22B		0
TOTAL	0	0
C-23A	-100	218
C-47A	0	0
C-130A	-61	-18
C-130B	218	187
C-130E	123	133
C-130H	146	209
TOTAL	93	159
C-131D	0	0
C-131E	0	0
TOTAL	0	0
C-135A	0	0
C-135B	0	0
C-135C	0	0
C-135E	0	0
TOTAL	0	0
C-137B	0	0
C-137C	0	0
TOTAL	0	0
C-140A	51	29
C-141A	0	0
C-141B	249	247
TOTAL	248	246
E-3A		99
E-3B	122	122
E-3C	124	124
TOTAL	122	110

E-4B	0	0
F-5A		0
F-4C	-53	0
F-4D	45	-43
F-4E	84	60
F-4G	81	81
TOTAL	64	39
F-5E	0	0
F-5F	0	0
TOTAL	0	0
F-15A	89	63
F-15B	24	29
F-15C	61	62
F-15D	55	66
F-15E	0	69
TOTAL	65	61
F-16A	68	41
F-16B	20	31
F-16C	48	28
F-16D	56	22
TOTAL	55	30
F-111A	67	55
F-111D	66	65
F-111E	59	76
F-111F	86	80
TOTAL	78	71
AC-130A	202	237
AC-130B	231	257
AC-130U		0
TOTAL	220	238
CH-003E	17	0
CH-003A	162	0



ED-018R	0	0
FC-130E	250	241
ED-130H	320	244
TOTAL	290	245
EC-135A	37	0
EC-135C	1	0
EC-135E	0	0
EC-135G	56	0
EC-135H	225	225
EC-135J	159	159
EC-135K	147	104
EC-135L	46	0
EC-135P	225	225
EC-135Y	0	188
TOTAL	55	50
EF-111A	196	176
FB-111A	0	-61
HC-130H	120	162
HC-130N	125	116
HC-130P	119	110
TOTAL	123	119
HH-001H	-44	-15
HH-003E	48	72
HH-053B	0	0
HH-53C	0	0
KC-10A	-44	484
KC-135A	251	220
KC-135E	288	279

WC-135B	-7	-7
NKC-135A	0	0
NPC-135E	0	0
TOTAL	0	0

KC-135Q	408	400
KC-135R	234	277
TOTAL	268	265
LC-130H	23	-7
MC-130E	120	127
MC-130H	153	108
TOTAL	126	120
MH-053H	0	0
MH-053J	0	107
TOTAL	0	101
MH-606		69
NA-037E	0	0
NC-170H	0	0
OA 10A		16
OA-37B	81	52
OV-10A	113	117
TOTAL	77	117
RC-135E	44	44
RC-135U	38	38
RC-135V	44	44
RC-135W	74	74
RC-135X	0	0
TOTAL	50	50
RF-004C	114	114
UH-001N		-10
UH-060A	73	78
WC-130B	0	0
WC-130E	32	32
WC-130H	188	188
TOTAL	81	81

page 6 of 6

MODEL EXPERIMENTATION

## PROBLEM APPROACH

1. FLOW TIME IS THE QUALITY CHARACTERISTIC WE ARE TRYING TO IMPROVE (MINIMIZE).
2. BRAIN STORM FOR PHYSICAL FACTORS THAT EFFECT FLOW TIME. APPLY NO CONSTRAINTS-PREPARE LIST.
3. APPLY 1<sup>st</sup> BOUNDARY CONDITION. IS THE FACTOR TRIVIAL IN AN ENGINEERING SENSE? REDUCE LIST.
4. APPLY 2<sup>nd</sup> BOUNDARY CONDITION. IS THE FACTOR AVAILABLE IN THE SIMULATION? REDUCE LIST.
5. DIVIDE REMAINING FACTORS INTO CONTROL FACTORS AND NOISE FACTORS.
6. DISCUSS/IDENTIFY INTERACTIONS AND LEVELS FOR:  
A. CONTROL FACTORS  
B. NOISE FACTORS
7. DEFINE DEGREES OF FREEDOM AND REQUIRED LINEAR GRAPHS FOR:  
A. CONTROL FACTORS  
B. NOISE FACTORS
8. SELECT PROPER ORTHOGONAL ARRAY AND ASSIGN COLUMNS FOR:  
A. CONTROL FACTORS  
B. NOISE FACTORS
9. COORDINATE THE RESULTING TEST MATRIX WITH SOUTHWEST RESEARCH.

PROBLEM APPROACH (CONT.)

10. EXECUTE MODEL THROUGH THE TEST MATRIX.
11. INTERPRET RESULTS.
12. CONFIRM PREDICTIONS BY RUNNING MODEL WITH THE SELECTED VALUES.

WARNER ROBINS  
GYRO OVERHAUL FACILITY  
BRAINSTORMING RESULTS

Quality Characteristic                      Minimize FLOW TIME  
(includes  
Throughput)

Control Factors:

1. PEOPLE/SKILL LEVEL  
    includes People, Skill, Training, Cross  
    Training, Grade Structure.
2. EQUIPMENT  
    includes Equipment, Tools.
3. FLOATING STOCK  
    includes Materials.
4. CALIBRATION/MAINTENANCE OF TEST EQUIPMENT  
    includes MTTF, Down Time.

Noise Factors:

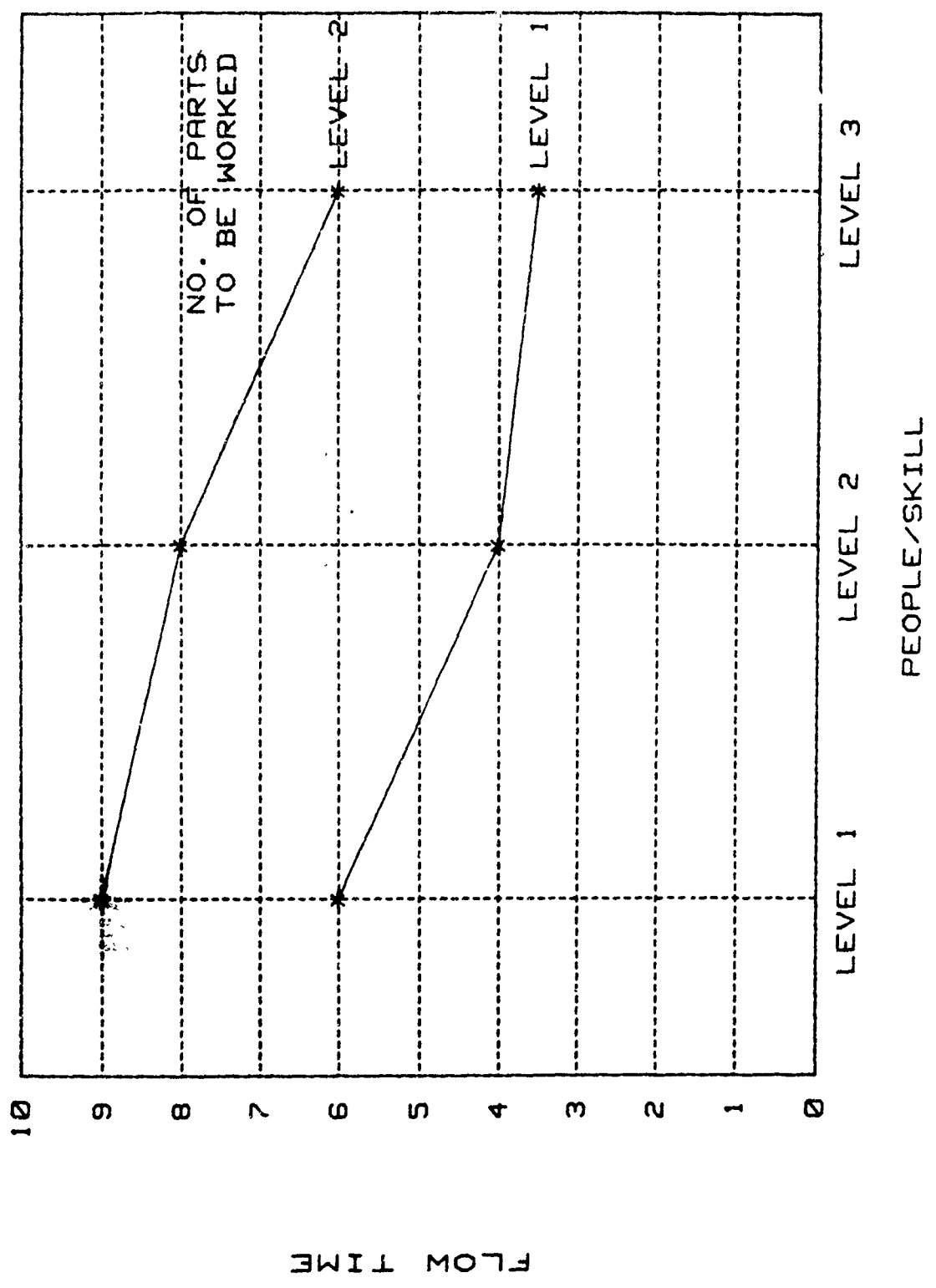
1. NO. OF PARTS TO BE WORKED  
    includes Assets, Workload Fluctuation.
2. RECEIVING/SELL DATES  
    includes Shipping/handling.

WARNER ROBINS  
GYRO OVERHAUL FACILITY  
EXAMPLE

RUN NO.	PEOPLE / SKILL	EQUIPMENT	NO. OF PARTS TO BE WORKED	CALIBRATION / MAINTENANCE / TEST EQUIPMENT	REC./SELL TIME		FLOW TIME		SIGNAL TO NOISE RATIO (db)
					1	2	1	2	
1	1	1	1	1	1	1	2	1	2
2	1	2	2	2	2	1	1	2	2
3	1	3	3	3	3	1	1	2	2
4	2	1	2	3	3	1	1	2	2
5	2	2	3	1	2	1	1	2	2
6	2	3	1	2	2	1	1	2	2
7	3	1	3	2	2	1	1	2	2
8	3	2	1	3	3	1	1	2	2
9	3	3	2	1	2	1	1	2	2



MODEL EXAMPLE (CONT.)



*R. R. Johnson*

OC-ALC/MAB

TECHNOLOGY INSERTION

AND

PRODUCTION PROCESS REVIEW

MAB TECHNOLOGY INSERTION TEAM

POINT OF CONTACT

EARL STAMPS	MABEFS	65267
-------------	--------	-------

PLANNING

LARRY MULLINAX	MABEFS	65261
ROGER WADDELL	MABEFS	65265

PRODUCTION

JANIS WOOD	MABPAB (-135)	63595
TERRY BREWER	MABPAB (-135)	63595
IDA M. GRAVES	MABPFF (B52)	63860 ✓
DONNA MASON	MABPFF (B52)	63860

SCHEDULING

DARRELL TANNER	MABSFS (B52)	62969
PAT HANCOCK	MABSFS	67235

ENGINEERING

DON HRNCIR	MABEE (FACILITIES)	67757
PHIL KUERNER	MABEP (TOOLING)	65986

QUALITY

TED KAYES	MAQBF (-135)	62390
JACKIE LENDERMAN	MAQBBA (B52)	67322

**AIRCRAFT SECTION**  
 Col Larry C. Souder 63476  
 Thomas C. Jones

Operations Office  
 Dona Burdick 67

Productivity Office  
 Cari Gardner  
 Judie Linville 65561

**ENGINEERING/PLANNING BRANCH**  
 Charles Sandine 55457  
 Maj Hudson

MABEA  
 B-1B PIng/Res Std Sec  
 Terry Bates 67863

MABEB  
 B-52 PIng/Res Std Sec  
 C. Schlenker (Actg)  
 63082

MABEC  
 -135/E-3 PIng Res Std  
 Sec  
 Allen Michael 62117

MABEE  
 Engineering Serv Sec  
 Johnnie Williamson  
 67757

MABEL  
 Long Range Bomber  
 PIng/Res Std Section  
 Steve Jones 67863

MABEP  
 Production Engr Sec  
 John Pate 65986

**2871 TEST SQUADRON**  
 LTC Larry Lopez 67719

*Bill Correia* →

**PRODUCTION BRANCH**  
 James Dupy  
 John Sneed  
 Robert Ashton 63353

MABPA  
 -135 Acft Section  
~~Larry Hodge~~  
 Maj Bartels 62118

MABPB  
 B-1B A/C Mod Sec  
 Kenneth Todd  
 Capt Massie 62917

MABPC  
 Services Section  
 Charles Campbell  
 63074

MABPE  
 E-3 Acft Section  
 Wm Correia (Actg)  
 Capt Thurman 65323

MABPF  
 B-52 Acft Mod Sec  
~~Mike Butcher~~  
 Lt Brown 67296

MABPT  
 A/C Training Section  
 Ed Scroggins 65298

**SCHEDULING/INVENTORY CONTROL BRANCH**  
 Donald Staton  
 Maj Stroh 6277

MABSA  
 Rep/Analysis Sec  
 Donna McMurry  
 MABSA 62757

MABSB  
 B-52 Sched Sec  
 Jim Clements  
 67296

MABSC  
 Cargo Sched Sec  
 Don Smith 62119

MABSE  
 E-3 Sector  
 Bill Lemieux

MABSL  
 B-1B Section  
 Ron Larrison

MABSS  
 A/C Ctrl Serv Sec  
 M. Mitchell  
 6230

\* NO. 1000

Activity Checklist

MABPAB - EARL STAMPS (unit Chief)  
 SHEET METAL C-135  
 R. Bolanos / T. Hall

#	Priority	Activity	D = Delegated for Action	
			Delegated to	Start Date
1	100%	ENVELOP SIZE/NO. SUFF.	R.B.	4/7
2	80%	ITEM CHECK LIST	R.B.	4/7
3	80%	ITEM SUMMARY	R.B.	4/7
4	80%	RCC CHECK LIST	R.B.	4/7
5	95%	OPERATION - MATCH w/Elect. Process - Equipment - TSP Times - MAND. Flow Time (week) - SKILL LEVEL (min. Req.)	T.H.	4/3
6	100%	MANPOWER - qty - HES - Alt. Skill Code	E.S./T.D.	4/7
7	100%	WORKLOAD - Electronic Stock - Act. Press by Qty - MAX W.I.P - STD HRS	L.M.	4/7
8	90%	EQUIPMENT - Press Paint - BOARD in - Issues by Other - ALTERNATIVE	L.M.	4/6
9	100%	DISASSEMBLE/ASSEMBLE	R.B.	4/7
10	100%	PARALLEL	R.B.	4/7
11	16%	IN DATES	E.S.	4/7
12	16%	OUT DATES	E.S.	4/7
13		IE ASSESSMENT	RB/TH	4/3

- TEAM EFFORT
- CLIENT OWNERSHIP
- ROAD MAP
- CLEAR COMMUNICATION

THE TEAM:  
 EARL STAMPS (ALC/Plng Unit. Chief)  
 LARRY MULLINAX (ALC/Sr. Plng Eng.)  
 Jim DOTSON (ALC/Plng Eng.)  
 Tim HALL (MDMSC/CPI)  
 RICARDO BOLANOS (MDMSC/PROJ. LEADER)

**1989 Project Overview-Day**  
**MABP AB - EARL STAMPS (RMS UNIT Chief)**  
**SHEET METAL C-135**  
**R. BOLANOS / T. HALL**

January

Week	M	T	W	T	F	S	S
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April

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4:20 Passover

May

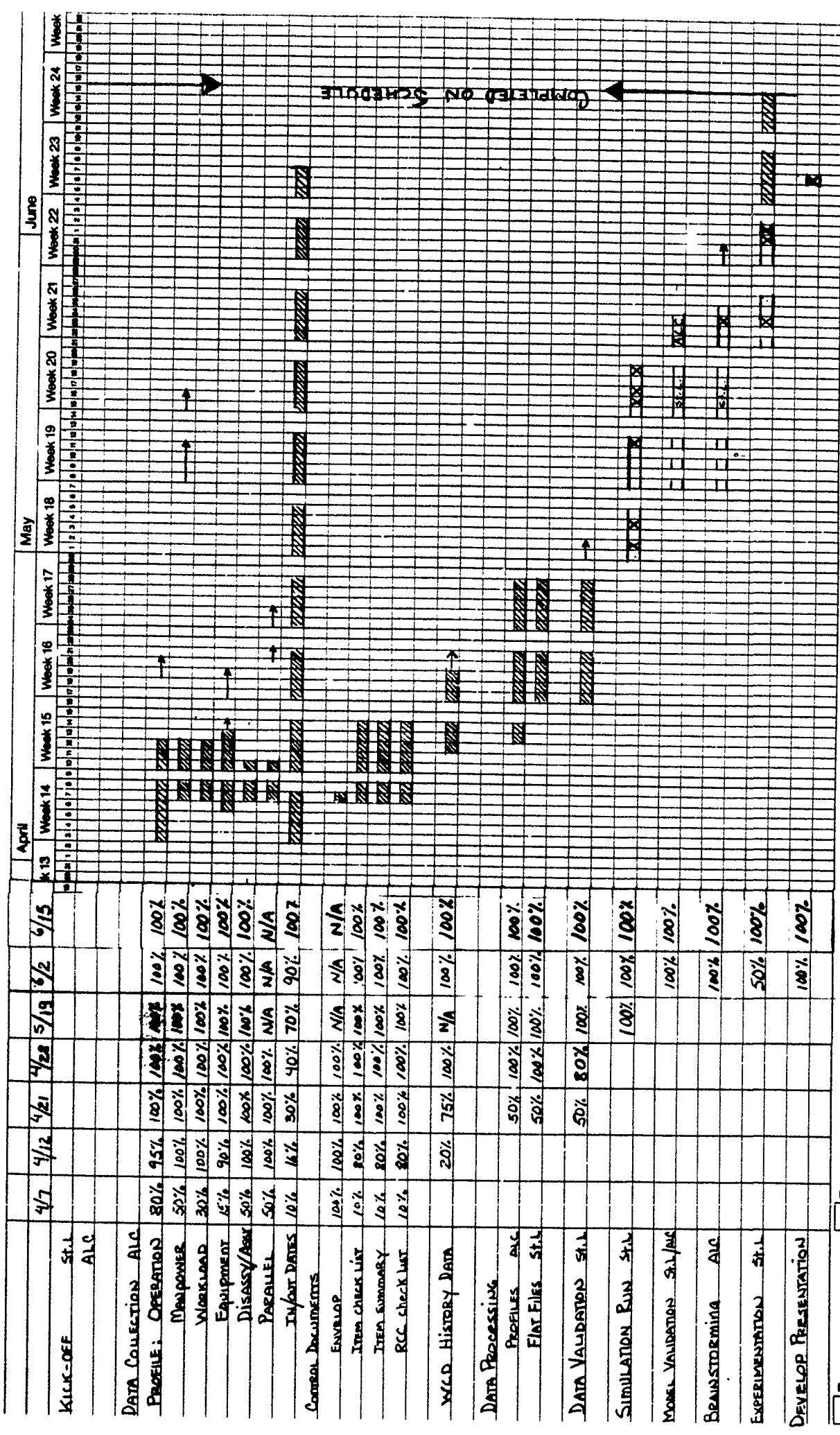
Week	M	T	W	T	F	S	S
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5:14 Mother's Day  
 5:21 Armed Forces Day  
 5:26 Memorial Day

June

Week	M	T	W	T	F	S	S
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6:14 Flag Day  
 6:18 Father's Day



COMPLETED ON SCHEDULE

Flag Day  
Father's Day

July  
7 4 Independence Day

August  
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31

September  
9 4 Labor Day  
9 20 Rosh Hashanah

October  
10 9 Columbus Day / Yom Kippur  
10 24 United Nations Day  
10 31 Halloween

July							August							September							October									
Week 24	Week 25	Week 26	Week 27	Week 28	Week 29	Week 30	Week 31	Week 32	Week 33	Week 34	Week 35	Week 36	Week 37	Week 38	Week 39	Week 40	Week 41	Week 42	Week 43											
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31

COMPLETED ON SCHEDULE

11

October	M	T	W	T	F	S	S
Week 39	1	2	3	4	5	6	7
Week 40	8	9	10	11	12	13	14
Week 41	15	16	17	18	19	20	21
Week 42	22	23	24	25	26	27	28
Week 43	29	30	31				

10, 6 Columbus Day / Yom Kippur  
10, 24 Uniformed Services of America Day  
10, 31 Halloween

November	M	T	W	T	F	S	S
Week 44	1	2	3	4	5	6	7
Week 45	8	9	10	11	12	13	14
Week 46	15	16	17	18	19	20	21
Week 47	22	23	24	25	26	27	28
Week 48	29	30					

11, 7 Election Day  
11, 11 Veterans Day  
11, 23 Thanksgiving Day

December	M	T	W	T	F	S	S
Week 49	1	2	3	4	5	6	7
Week 50	8	9	10	11	12	13	14
Week 51	15	16	17	18	19	20	21
Week 52	22	23	24	25	26	27	28
Week 53	29	30	31				

12, 23 Hanukkah  
12, 24 Christmas

		October							November							December						
Week	Day	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55				
1	Mon	1	8	15	22	29	5	12	19	26	3	10	17	24	31	7	14	21				
2	Tue	2	9	16	23	30	6	13	20	27	4	11	18	25		8	15	22				
3	Wed	3	10	17	24	31	7	14	21	28	5	12	19	26	1	9	16	23				
4	Thu	4	11	18	25		8	15	22	29	6	13	20	27	2	10	17	24				
5	Fri	5	12	19	26	1	9	16	23	30	7	14	21	28	3	11	18	25				
6	Sat	6	13	20	27	2	10	17	24	31	8	15	22	29	4	12	19	26				
7	Sun	7	14	21	28	3	11	18	25		9	16	23	30	5	13	20	27				
8	Mon	8	15	22	29	4	12	19	26	1	10	17	24	31	6	14	21	28				
9	Tue	9	16	23	30	5	13	20	27	2	11	18	25		7	15	22	29				
10	Wed	10	17	24	31	6	14	21	28	3	12	19	26	1	8	16	23	30				
11	Thu	11	18	25		7	15	22	29	4	13	20	27	2	9	17	24	31				
12	Fri	12	19	26	1	8	16	23	30	5	14	21	28	3	10	18	25					
13	Sat	13	20	27	2	9	17	24	31	6	15	22	29	4	11	19	26	30				
14	Sun	14	21	28	3	10	18	25		7	16	23	30	5	12	20	27	31				
15	Mon	15	22	29	4	11	19	26	1	8	17	24	31	6	13	21	28					
16	Tue	16	23	30	5	12	20	27	2	9	18	25		7	14	22	29	31				
17	Wed	17	24	31	6	13	21	28	3	10	19	26	1	8	15	23	30					
18	Thu	18	25		7	14	22	29	4	11	20	27	2	9	16	24	31	30				
19	Fri	19	26	1	8	15	23	30	5	12	21	28	3	10	17	25		29				
20	Sat	20	27	2	9	16	24	31	6	13	22	29	4	11	18	26	30	28				
21	Sun	21	28	3	10	17	25		7	14	23	30	5	12	19	27	29	27				
22	Mon	22	29	4	11	18	26	1	8	15	24	31	6	13	20	28	26	26				
23	Tue	23	30	5	12	19	27	2	9	16	25		7	14	21	29	25	25				
24	Wed	24	31	6	13	20	28	3	10	17	26	1	8	15	22	28	24	24				
25	Thu	25		7	14	21	29	4	11	18	27	2	9	16	23	29	23	23				
26	Fri	26	1	8	15	22	30	5	12	19	28	3	10	17	24	30	22	22				
27	Sat	27	2	9	16	23	31	6	13	20	29	4	11	18	25	31	21	21				
28	Sun	28	3	10	17	24		7	14	21	30	5	12	19	26		20	20				
29	Mon	29	4	11	18	25	1	8	15	22	31	6	13	20	27	1	19	19				
30	Tue	30	5	12	19	26	2	9	16	23		7	14	21	28	2	20	20				
31	Wed	31	6	13	20	27	3	10	17	24	1	8	15	22	29	3	21	21				
32	Thu		7	14	21	28	4	11	18	25	2	9	16	23	30	4	22	22				
33	Fri		8	15	22	29	5	12	19	26	3	10	17	24	31	5	23	23				
34	Sat		9	16	23	30	6	13	20	27	4	11	18	25		6	24	24				
35	Sun		10	17	24	31	7	14	21	28	5	12	19	26	1	7	25	25				
36	Mon		11	18	25		8	15	22	29	6	13	20	27	2	8	26	26				
37	Tue		12	19	26	1	9	16	23	30	7	14	21	28	3	9	27	27				
38	Wed		13	20	27	2	10	17	24	31	8	15	22	29	4	10	28	28				
39	Thu		14	21	28	3	11	18	25		9	16	23	30	5	11	29	29				
40	Fri		15	22	29	4	12	19	26	1	10	17	24	31	6	12	30	30				
41	Sat		16	23	30	5	13	20	27	2	11	18	25		7	31	31	31				
42	Sun		17	24	31	6	14	21	28	3	12	19	26	1	8							
43	Mon		18	25		7	15	22	29	4	13	20	27	2	9							
44	Tue		19	26	1	8	16	23	30	5	14	21	28	3	10							
45	Wed		20	27	2	9	17	24	31	6	15	22	29	4	11							
46	Thu		21	28	3	10	18	25		7	16	23	30	5	12							
47	Fri		22	29	4	11	19	26	1	8	17	24	31	6	13							
48	Sat		23	30	5	12	20	27	2	9	18	25		7	14							
49	Sun		24	31	6	13	21	28	3	10	19	26	1	8	15							
50	Mon		25		7	14	22	29	4	11	20	27	2	9	16							
51	Tue		26	1	8	15	23	30	5	12	21	28	3	10	17							
52	Wed		27	2	9	16	24	31	6	13	22	29	4	11	18							
53	Thu		28	3	10	17	25		7	14	23	30	5	12	19							
54	Fri		29	4	11	18	26	1	8	15	24	31	6	13	20							
55	Sat		30	5	12	19	27	2	9	16	25		7	14	21							
56	Sun		31	6	13	20	28	3	10	17	26	1	8	15	22							



OC PL PAB

Activity Checklists:

#	Date	Prio- rity	Activity	Delegated to	Start Date	Due Date
1	100% ✓	✓	ENVELOP SIZE/NO. CUFF.	R.B.	4/7	4/7
2	✓	✓	ITEM CHECK LIST	R.B.	4/7	4/14
3	✓	✓	ITEM SUMMARY	R.B.	4/7	4/14
4	✓	✓	RCC CHECK LIST	R.B.	4/7	4/14
5	80% ✓	✓	OPERATION - MATCH w/Flow Process - EQUIPMENT - TSP Times - MAND. Flow Time (hrs) - SKILL LEVEL (Min, Req)	T.H.	4/3	4/12
6	50% ✓	✓	MANPOWER - RTY - HRS - Alt. Skill Core	E.S./T.D.	4/7	4/12
7	30% ✓	✓	WORKLOAD - Flowing Stock - Act. Prod by Air - Max WIP - STD. HRS	L.M.	4/7	4/12
8	15% ✓	✓	EQUIPMENT - Prev. Maint - Breakdown - % used by Other - ALTERNATIVE	L.M.	4/6	4/13
9	50% ✓	✓	DISASSEMBLE/ASSEMBLE	R.B.	4/7	4/10
10	50% ✓	✓	PARALLEL	R.B.	4/7	4/10
11	✓	✓	IN DATES	E.S.	4/7	6/7
12	✓	✓	OUT DATES	E.S.	4/7	6/7
13			IE ASSESSMENT	R.B./T.H.	4/3	ON GOING

EARL'S Wish List.  
 DECREASE - Flow Time  
 - SPACE Req.  
 - Labor Hr.  
 IMPROVE Cntl/Org. STRUC.  
 INCREASE OUTPUT (EFF)

Thursday  
 13  
 April 1989

Daily Plan

Week 15 103/262

Month	Week	MTWTFSS
March	1	2 3 4 5
6	7 8 9 10 11 12	13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31
April	1	2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31
May	1	2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31

Schedule	Contact	OK
8: MODEL PRESENTATION TO AB WORK CENTER TEAM		
9: TOUR MABPAB Bldg 95		
10: TOUR MABPFF Bldg 2121		
11: TOUR NEW Bldg FOR MABPAB		
12:		
1:		
2: DIVISION MAB Tom Jones BRANCH MABE Charue Sandhu		
3:		
4:		
5:		

Activities Checklist

OC MABPAB

EARL'S Wish List.  
 DECREASE - Flow Time  
 - SPACE Req.  
 - LABOR Hr.  
 IMPROVE CTR/ORG. STRUC.  
 INCREASE OUTPUT (EFF)

Task #	Date	Priority	Activity	D = Delegated for Action		Start Date	Due Date
				Delegated to	OK		
1	100%	✓	ENVELOP SIZE/NO. S.V.EF.	R.B.	✓	4/7	4/7
2		✓	ITEM CHECK LIST	R.B.	✓	4/7	4/14
3		✓	ITEM SUMMARY	R.B.	✓	4/7	4/14
4		✓	RCC CHECK LIST	R.B.	✓	4/7	4/14
5	80%	✓	OPERATION - MACH. w/ Flow Process - EQUIPMENT - TSP Times - MAND. ELAP. TIME (HRS) - SKILL LEVEL (Min. Req.)	T.H.	✓	4/3	4/12
6	50%	✓	MANPOWER - STD - HRS - Alt. SKILL CAP	E.S./T.D.	✓	4/7	4/12
7	30%	✓	WORKLOAD - FLOWS & STRUC - ACT. PEOP. by GR - MAX W.I.P - STD HRS.	L.M.	✓	4/7	4/12
8	15%	✓	EQUIPMENT - Prev. Maint - BREAKDOWN - CAUSED BY OTHER - ALTERNATIVE	L.M.	✓	4/6	4/13
9	50%	✓	DISASSEMBLE/ASSEMBLE	R.B.	✓	4/7	4/10
10	50%	✓	PARALLEL	R.B.	✓	4/7	4/10
11		✓	IN DATES	E.S.	✓	4/7	6/7
12		✓	OUT DATES	E.S.	✓	4/7	6/7
13			IE ASSESSMENT	R.B./T.H.		4/3	ON GOING

Thursday  
**13**  
 April 1989

Daily Plan

Month	Week	MTWTFSS	Day	Week	MTWTFSS
March	12	1 2 3 4 5 6	1	18	1 2 3 4 5 6
	13	7 8 9 10 11 12	2	19	7 8 9 10 11 12
	14	13 14 15 16 17 18	3	20	13 14 15 16 17 18
	15	19 20 21 22 23 24	4	21	19 20 21 22 23 24
	16	25 26 27 28 29 30	5	22	25 26 27 28 29 30
	17	31	6	23	31

Week 15 103/262

Task #	Schedule	Contact
8:	MODEL PRESENTATION	
9:	TO AB WORK CENTER TEAM	
10:	TOUR MABPAB Bldg 9S	
11:	TOUR MABPFF Bldg 2/24	
12:	TOUR NEW BLDG FOR MABPAB	
1:		
2:	DIVISION MAB Tom Jones	
3:	BRANCH MABE Charles Sengue	
4:		
5:		



DIRECTORATE OF MAINTENANCE

RELOCATION OF  
BUILDING 95 SHEET METAL



## RELOCATION OF B95 SHEET METAL

### BACKGROUND

- SHEET METAL RELOCATED AFTER NOV 84 FIRE
- DS WAREHOUSES AT 98% SATURATION
- CC INSTRUCTED MA TO VACATE B95 BY SEPT 89
- MA DIRECTED ESTABLISHMENT OF FACILITY PLANNING GROUP

1-



FACILITY PLANNING GROUP

PLAN B - RELOCATION OF B95 SHEET METAL

- Ø B3001 HIGHWAY, POST 52 THRU 74
- BLADE AREA MUST VACATE BY JUN 89
- ENGINE LINE MOVE BACK NORTH OF COL 74.

*MA THREW THIS  
PLAN OUT.*



MA RELOCATION OF  
BLDG 95 SHEET METAL

**PROPOSAL: A**

- Ø LOCATION**
  - BLDG 2101
- Ø PLAN**
  - RELOCATE MA ORGANIZATIONS FROM B2101 (MAD, MAE, MAT) TO SEPARATE SMALLER LOCATIONS
  - RELOCATE (MA) GROUND SPACE EQUIPMENT CONTRACTOR
  - RELOCATE BLDG 95 SHEET METAL INTO ~~BLDG 2101~~ SF OF BLDG ~~2101~~



MA RELOCATION OF  
BLDG 95 SHEET METAL

PLAN:

- Ø RELOCATE MA ORGANIZATIONS FROM B2101
- MA GAINS ASSIGNMENT OF BLDG 3771 - 15,000 SF
- MA RELOCATES MAE TO BLDG 3771 - 15,000 SF
- MAD PLANT MANAGEMENT RELOCATES FABRICATION/WELDING SHOP TO BLDG 3773 - 18,000 SF
- MAE PROPULSION DIVISION RELOCATES ENG. RECLAMATION TO BLDG 3703 & 3001 - 21,000 SF TOTAL
- MAT ACCESSORIES DIVISION RELOCATES FOUNDRY TO BLDG 2129 - 2,700 SF

OR 5001



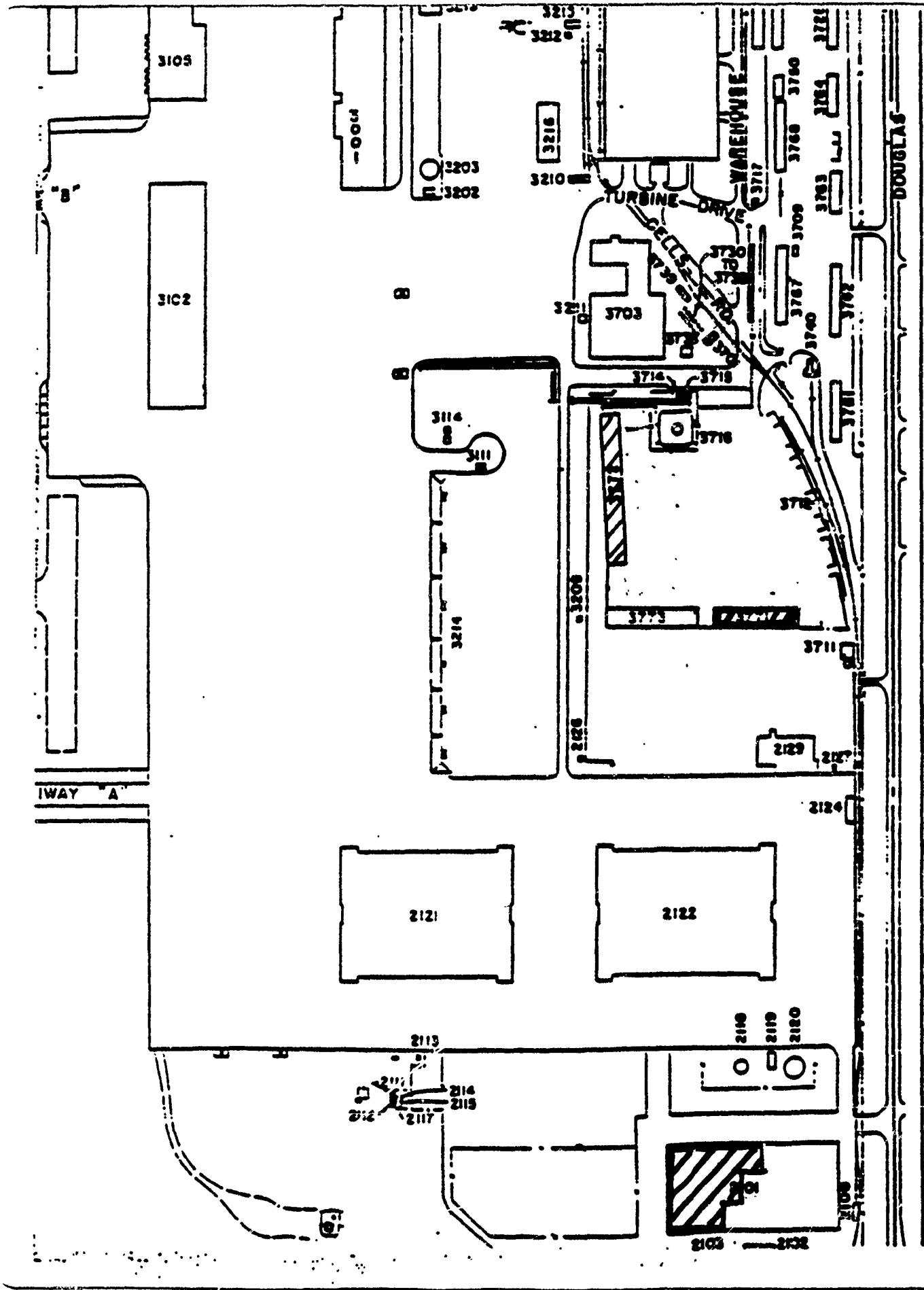
**MA RELOCATION OF  
BLDG 95 SHEET METAL  
CONTINUED**



**PLAN:**

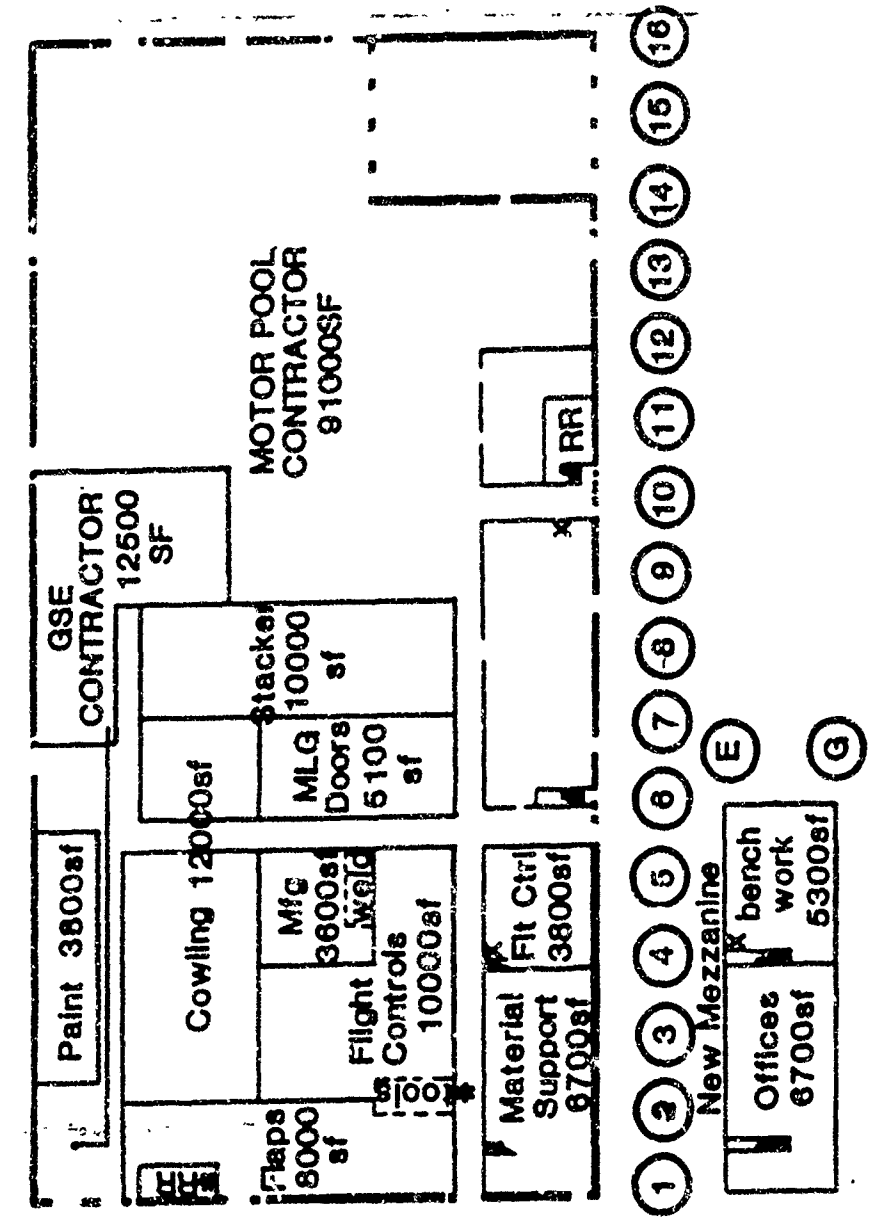
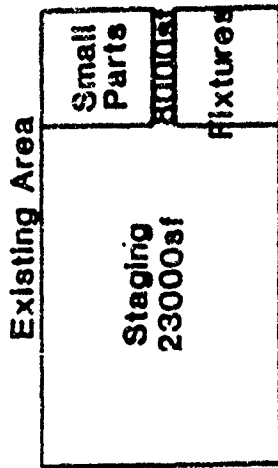
- 0** ~~RELOCATE SHEET METAL~~ INTO  
VACATED SPACE ~~BLDG 95~~ SEP 89 EST.  
COMPLETION DATE
- SELF-HELP AND CONTRACT RELOCATION  
FROM BLDG 95





# PROPOSED AIRCRAFT SHEETMETAL

New Shed  
Supply Pickup 3000sf



SF  
75000  
13500  
2100

Type of Space  
Production  
Aisles

\*Break Areas 2nd fl.  $\phi$

x elevator

BLDG 2101

NO	MILESTONE ACTIVITIES AND EVENTS	PCT PROGRAM ACCOMPLISHED		FY89												DATE REVIEWED	REPORTING AGENCY & PROJECT MONITOR	
		FCST	ACT	O	N	D	J	F	M	A	M	J	J	A	S			
1	MA APPROVAL OF B2101 PLAN AND IMPLEMENTATION (OPR: MA)																	
2	SUBMIT 600P MAT (OPR: MAT)																	
3	SUBMIT 600P MAE (OPR: MAE)																	
4	SUBMIT 600P MAD (OPR: MAD)																	
5	REVIEW DRAWINGS FROM DIVISION(S), ORDER MATERIALS (OPR: MAD)																	
6	MAT SITE PREP OF B3001 (OPR: MAT)																	
7	MAE SITE PREP OF B3767 (OPR: MAE)																	
8	MAD SITE PREP OF B3771/B3773 (OPR: MAD)																	
9	MAT VACATE B2101 TO B2129 (OPR: MAT)																	
10	MAE VACATE B2101 TO B3767 (OPR: MAE)																	
11	MAD VACATE B2101 TO B3771/B3773																	
12	SUBMIT B2101 DESIGN & 600P SERVICE ORDER (OPR: MAB)																	

LEGEND: (Colors indicated for attention attraction) ACTIVITY PLAN EVENT TARGET TARGET SLIPPAGES PERCENTAGE OF ACTIVITY PLAN COMPLETED AS OF DATE DATE COMPLETED

1 (Ref 2) TARGET SLIPPAGES

PERCENTAGE OF ACTIVITY PLAN COMPLETED AS OF DATE

DATE COMPLETED

SUBJECT UNDER REVIEW  
 SHEET METAL RELOCATION CONTINUED

FY89

DATE REVIEWED

REPORTING AGENCY & PROJECT MONIT

NO	MILESTONE ACTIVITIES AND EVENTS	DATE REVIEWED							PCT PROGRAM ACCOMPLISHED	ACT
		O	N	D	J	F	M	A		
13	REVIEW DRAWINGS FROM DIVISION FOR B2101 (OPR: MAD)								△	
14	WRITE SPECIFICATIONS & STATEMENT OF WORK (OPR: MAD)								△	
15	CONTRACT SOLICITATION & AWARD (OPR: MAD)								△	
16	PREP SITE AT B2101 (OPR: MAD/CONTRACTOR)								△	
17	RELOCATE FROM B95 TO B2101 (OPR: MAD)								△	

29 SEPT

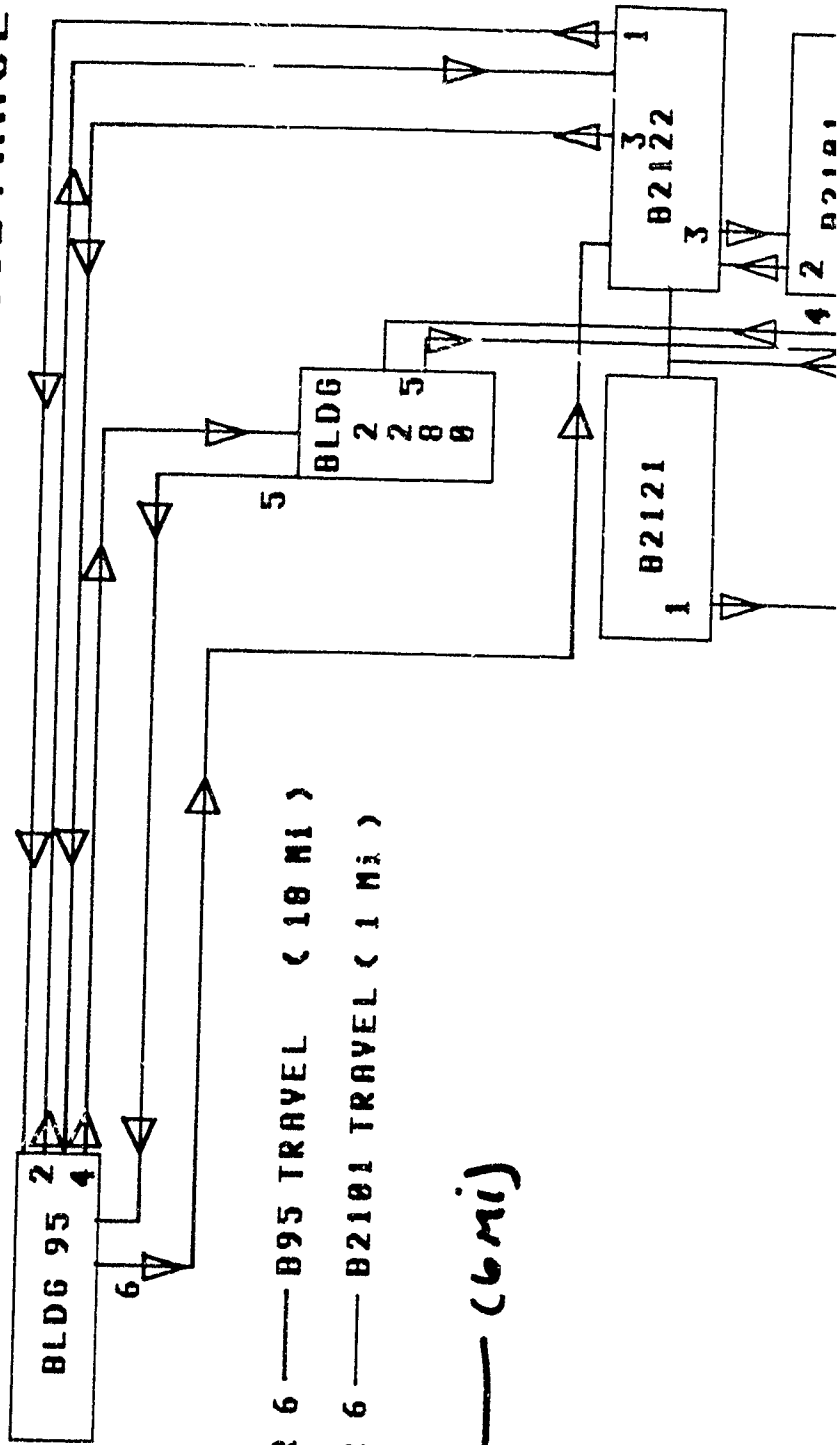
LEGEND: (Colors indicated for attention attraction)   
 [ ] EVENT   
 [ ] TARGET   
 [ ] PERCENTAGE OF ACTIVITY

*Davis Maff*  
*67978*



MA RELOCATION OF  
BLDG 95 SHEET METAL

**LOCATION: B2101 VRS B95 TRAVEL DISTANCES**



1 THUR 6 — B95 TRAVEL ( 10 MI )  
1 THUR 6 — B2101 TRAVEL ( 1 MI )

SS001 — ( 6 mi )

3-31-87 Engineering Notes - Tim Hall - Industrial Eng

Started on site at PE-RHC. Engineers on site today were: Blake Hixson, Henry Johnson, Ricardo Bohner, Sadie MacFarland and myself. We met with Bob Conover, planning chief at MIT, and Earl Stamps, planning chief at utility, and Gene Lichtenman, our AT contacts. A meeting was set up for 2 o'clock Monday afternoon with the same attendees plus some people from scheduling and planning.

We were assigned an office conference room ('The Win. Room') adjacent to Bob Conover's office. Since the rest of the team had spent 4 weeks in St. Louis learning a lot about the process character in another way and this was the first day back since December for us, I had some reading material to review for the rest of the day. Namely, the 'Case Notice' and the 'Case Notice Response' letters were reviewed by myself.

4-3-87 Monday

Chuck Gonzalez was started a two week assignment here today. Ricardo Bohner, Chuck Gonzalez and myself spent most of the morning (the day with) Earl Stamps, planning chief for MIT and Henry Johnson, electrical planner. We discussed how we were planning to approach the MIT's counter action effort. Ricardo informed them that full so there had been a meeting and a study study. The site list was agreed to. The MIT's were requested. The MIT's were requested. The MIT's were requested. The MIT's were requested.

We toured Building 15; Sheetmetal shop. Mullinax led us through the shop.

At 2 PM we had a breakfast meeting of sorts, with the people mentioned in previous notes in attendance. Our people included Chuck McCarty, Blake Hixon, Henry Johnson, Sadie MacFarland, Ricardo Salinas and myself. Blake & Henry sort of worked thru meeting by explaining upon why we are here again. The competition here and interest seem to be good. The main problem seemed to be finding enough room for us to work in. We will be able to use the 'War Room' for 12 weeks. Earl Stamps furnished us one black MCP.

Tuesday 4-4-87

Blonde & ~~myself~~ I went to Jerry's meeting. Today we got started on the paperwork. Blonde recruited a Flow process chart on every PCN, so we sat down in the War Room and started on a Flow process chart for a PCN. Then we decided to enlist the help of AIRBPPB personnel to help us do the charts and to indicate when the WIP is out of sequence.

Most of the afternoon was spent with Larry Mullinax and Michael Tytonic, inhibition planner, working up flow process charts. Earl Stamps reviewed his proposed layout for an hour or two. Mitchell is scheduled to move to bldg 201 on Oct 89.

Wed - 4/4/89

I spent the day filling out flow process charts. Ricardo and the planners started on other forms

Thur - 4/6/89

Started ~~filling~~ putting together a package for one I.C.N. no. 151262. Interviewed mechanic for operation times and equipment involved with each operation. His name was Levi Brown.

Fri - 4/7/89

Started putting up profiles in folders and getting things arranged to meet with all mechanics.

Chuck Gonzalez, Ricardo Brown, Tony Mullins, and ~~myself~~ I met with Earl Stays at 2 for a status of project report. Ricardo presented a list of things to be completed with the target completion date and the assigned responsible person. Earl reacted favorably to our approach and progress.

Sat - 4/8/89

Completed preparations for mechanic interviews. Made folders and completed blank operative profiles where the computer printouts had gaps.



Monday, April 10, 1989 and Tuesday, April 11, 1989

Larry Mullinax and I walked through the ship in bldg 95 and talked to all of the Fleet supervisors who identified their better mechanics for me to interview. I then interviewed the following mechanics associated with each PCN:

<u>Mechanic</u>	<u>Supervisor</u>	<u>PCN</u>
Billy Thompson	Steward	15113A
Eng Mundy	Steward	15025A
John Tutum	Jacobs	15119A
Reford Eric	"	15321A
Pat's Daniels	Brewer	15136A 15137A
Vernon Taylor	Jacobs	15140A
Manuel Florez	Lenox	15150A
Steve Farley	Jacobs	15175A
Jesse Spencer	Jacobs	15175A
Ralph Barrier	W <sup>Jack</sup> imberly	15188A 15189A 15191A 15192A
	↓	
Lydia Fletcher	Jack Wimberly	15188A (Foretop) 15189A 15191A 15192A
	↓	
David King	Lenox	15236A
Vicki Fry	"	15237A
Calvin Hackler	Brewer	15249A
	↓	15250A

During the interviews I obtained the following information: (1) occurrence dates for each operation in the shop; (2) skill level required for each operation.

(3) number of people needed to perform each operation,  
(4) amount of time <sup>required for</sup> each operation required to be performed, (5) percentages of when an operation is difficult or easy, with corresponding times, (6) equipment required during each operation, and (7) the amount of time the equipment is utilized during each operation.

Wed, 4/12/59

Low Maurer (T.O. 1 manager) and Mike McCoy (simulation manager), and <sup>and Guy Felle (marketing mgr)</sup> are here for two days. They spent this morning with Henry Johnson touring his BCCs and this afternoon touring Blake Hiseox's BCCs. Guy Felle returned today. Guy will take over Blake's position as site manager.

I started the process of getting transit times. It took longer than expected because there was clarification needed on just what time to use for transit time and because of the extra time required for the VLPs. Mike McCoy & Chuck Benzales had a discussion on transit times and time backshops and after that things were set. I interviewed Larry Mullinax this afternoon and got all transit times (travel times between backshops) and operation times for operations in backshops.

Thursday 4/13/87

Today was spent in meetings and tours with Lou Maurras, and Mike McLoy, and Harry Steele. At 8 o'clock there was a meeting at Bldg 95 with MABPAB key personnel; Earl Stamps, (MABPAB planning unit chief) Janis Wood, (MABPAB unit chief), several MABPAB Floor supervisors, Larry Sullivan, MABPAB planning & RAB scheduler, a FAB engineer, Lou Maurras, Harry Steele, Mike McLoy, Chuck Gonzales, Ricardo Bolanos, and myself. At this meeting, Earl Stamps gave a pitch on his organization and who we were and what we were doing. Ricardo gave a status of the project report and Mike McLoy gave a summary pitch.

After this meeting, Lou Maurras, Harry Steele, Mike McLoy, Chuck Gonzales, Ricardo Bolanos, Earl Stamps and myself were given a tour of Bldg 95 by Janis Wood. After this tour, Earl Stamps reviewed the proposed layout for his facility at Bldg 201 with Lou Maurras and the rest of us, mainly Mike McLoy, answered questions that Janis Wood had on what the model could do and cannot do.

At about 11:30 - 11:45 AM we like some group that toured Bldg 95) rode over to the other end of the base and toured Bldg 201, where RAB is scheduled to move in Oct.

Between 1 and 3 I tried to work on cleaning up the operation profile. At 3 PM we had a meeting with Col. Sander, MAB chief. Our people included Lou Maurras, Mike McLoy, Harry Steele, Chuck Gonzales, Ricardo Bolanos, Larry Sullivan, and myself. The same presentation given at 8 AM was presented.

at this time. The main benefit of this meeting seemed to be the clarification of what the model cannot do.

Friday 4/14/59

I cleaned up the computer printouts and operation profiles. They are ready for input but Ricardo wants to hold them for our 'I.E. Assessment' next week.

Monday, 4/17/89

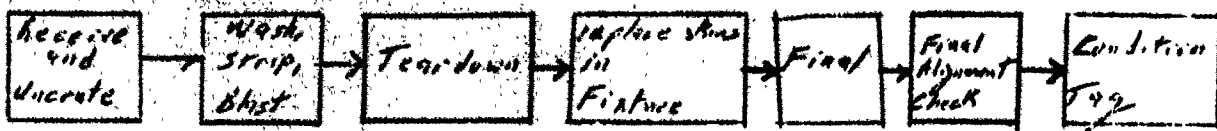
Interviewed Mr. Stewart, supervisor of MRB/MB side cowl shop. He indicated that their main problem was availability of parts. The unavailability of new parts hampers the flow process tremendously, according to him. Key points are as follows:

- ✓ MIEC is required to keep a 15 day supply of parts on hand in the Bldg 95 area, but are often out of critical parts.
- ✓ If MIEC is out, and the part is somewhere else in the base, it takes 3-4 hrs to get the part.
- ✓ If a part has to be ordered it takes months for it to come in.
- ✓ Most of the time parts are 'robbed' from other workings.

A focus study is recommended to develop an inventory system that will consistently keep a 15 day supply on hand. One suggestion was to have the parts in a 'kit' for each cowling, with the unused portion returned to MIEC for incorporation into other kits.

Interviewed Ino Blundy, mechanic on LH side cowling. The side cowl comes in to storage, goes through tear-down, then goes into the fixture for skin repair/replacement, then goes into Final for completion. In Final excess skin is trimmed, some parts such as clips are installed, and all work is completed. After final the cowl goes into the fixture for a final alignment check.

A block diagram of this process is as follows:



Some areas of concern and potential quick fixes are discussed below:

- The Tear-down phase cannot be worked in sequence by the W.C.D
- More light is needed in the Fixture while working up under the feet.
- Rivets - the rivets ~~need~~ have to be kept frozen in order to keep soft. After they thaw, they harden & cannot be buckled. Presently, I'm simply keeps dry ice in a tray of all rivets she needs. So the rivets stay cold until installed. ~~A method~~ A standardized method of doing this should be established. The freezer is too far from the work area @ the present time to run and get whatever rivets are needed.
- Ideas - small freezers in work area
  - sized trays & block of dry ice issued to each mechanic
- The inspection technique is casual inspection. Are there other more comprehensive, objective teching
- Air pressure is a problem - water and oil get in the lines and it often operates at about 60% pressure. Rivets cannot be buckled with partial pressure.
- Human Factors - It gets very hot in the shop in the summer and very cold in the winter. Heater fans should be installed in the walls during the summer to save the money on electricity.

should be installed in the new location, if it is not already planned.

- Process delays - air pressure, parts shortage, heat in summer. Very frequent breaks are necessitated, cold in winter.
- Environmental Assessments/Impacts - There is inadequate ventilation in the shop. During the summer a blue cloud of jet exhaust fumes builds up in the area. (They are <sup>located</sup> close to the end of the runway.) Dust clouds build up also. Again, a ventilation fan is needed to ventilate the area.
- Eqp/Workplace layout - At the present time, it is often difficult to transport a cowl from the storage area to the work area because of obstructions. The new location should be designed to have a clear path from storage to the work areas.

I interviewed Billy Thompson, mech for BH side cowl and gathered the following additional information:

RF/FS  
experimentation

- a third fixture is needed. Two fixtures are currently in place and it is the bottleneck in the process. The model should test for an extra fixture and determine the cost savings. An extra fixture is needed for LH side cowl also. If a part is needed while the cowl is in the fixture, then there is really a process delay.
- They have no accountability between the parts & the mechanic who worked it. They send a part instead of with each part they request.

with the mechanics stamp number on it and a log number of the part itself. They can pinpoint who worked on what part if a part comes back defective. This is very commendable and should be implemented in all of PAB and command wide for that matter.

Going back to my interview with Mr. Steward, he gave me a 'MISTH critical / Super critical' status report that lists parts that they are waiting for. His group (side cowl) had one item on the super critical list (work stoppage) and 12 items on the critical list. He can't finish work because of these items. And it was indicated that this was a typical list.

### Summary

- ✓ Focus Study - develop a system that will consistently maintain a 15 day supply
- ✓ QF - move light on Fixture, underneath cowl
- ✓ RF - standardize procedure for keeping rivets free
- ✓ RF - Human Factors - install ventilating fans to reduce heat and to ventilate jet exhaust fumes and dust out of the shop.
- ✓ QF - add a third Fixture to LH & RH side cowl to ease bottlenecks - use model to experiment



4/18/89 Tuesday

MAT Meeting

Our group had a meeting with MAT area managers. Bob Conover, MAT Planning manager, Gene Lester, AF Contract manager, were among the people leading up the AF at the meeting. Our group numbers nine at the present time including Guy Fallo, Henry Johnson, Blake Hixcox, Silvio ~~McFarland~~, Ricardo Salinas, myself, and three new people ~~that~~ that started yesterday.

Bob Conover started the meeting by summarizing the agenda. Gene Lester then presented a brief history of the Technology Insertion program. Guy Fallo then presented the Forms that we will be asking the AF personnel to complete and the items on the forms were discussed.

I.E. Assessment

I interviewed Jack Wimberly, supervisor of flap ship, and Ralph Barber, mechanic <sup>in</sup> the same area. Again, the main problem to surface was the shortage of parts: parts such as screws & skins, parts that are always used on every part often run out. It was expressed to me as a communication problem between scheduling, <sup>etc.</sup>, planning, production & upper mgmt. Sometimes a contract will expire before another one replaces it.

The inspection technique is visual. Better lighting is needed for finding the cracks, corrosion, etc.

Dust builds up in the summer which along with excessive heat, decreases productivity.

Another problem was discussed was damage to the part in transit. In the floor at the time of the interview, I saw where the leading edge of a flap had been ripped. This damage occurred between the time the part was removed from the line and when it was ~~delivered~~

on the shop floor. A study to determine the frequency and extent of <sup>in</sup> transit damage is recommended.

Summary:

- ✓ Bottlenecks identified as parts shortage - Focus study recommended in 4/17/84 notes.
- ✓ Q/F - better lighting is needed for visual inspection.
- ✓ Q/F - Improve ventilation to reduce heat and to ventilate dust out of the area. Several stationary fans are currently used.
- ✓ Focus Study - determine frequency and extent of in transit damage to parts.

4/19/57 Wednesday -14-

There was an informal meeting @ 7:15 AM between Earl Stamps, Harry Mulline, Ricardo Belances, and myself. Two decisions were made. The equipment in the general machine shop will be selected on the operation profile as well as the equipment profile. These equipment are not used as part of the regular <sup>process</sup> but are used often enough, for manufacturing out-of-stock items, to be profiled. These will be profiled by entering a single line on each profile with an average time that the equipment was used for that part. Three work cells work in this shop.

The second decision was to include work stations, or work benches, on the operation and equipment profile. I made a list of P.C.'s <sup>from</sup> the 30/20 list and interviewed each supervisor to obtain the number of work benches available for each P.C.'s. Then a code no. was assigned for each group of work benches. On the operation profile the code is entered on each operation in P.C.B. when the part is not in the fixture. The equipment profile will reflect the quantity of work benches available.

1989 **1st Overview-Day**  
**MASPER - EARL STRAINS (RMS Unit Cells)**  
**SHEET METAL C-135**  
**R. Bolanos / T. Hall**

4.8. Present

MON	1	2	3	4	5	6	7	8
TUE	1	1	1	1	1	1	1	1
WED	1	1	1	1	1	1	1	1
THUR	1	1	1	1	1	1	1	1
FRI	1	1	1	1	1	1	1	1
SAT	1	1	1	1	1	1	1	1
SUN	1	1	1	1	1	1	1	1

5.14. Member's Day  
 5.21. Annual of 1988 Day  
 5.27. Memorial Day

MON	1	1	1	1	1	1	1	1
TUE	1	1	1	1	1	1	1	1
WED	1	1	1	1	1	1	1	1
THUR	1	1	1	1	1	1	1	1
FRI	1	1	1	1	1	1	1	1
SAT	1	1	1	1	1	1	1	1
SUN	1	1	1	1	1	1	1	1

6.14. Member's Day  
 6.19. Father's Day

MON	1	1	1	1	1	1	1	1
TUE	1	1	1	1	1	1	1	1
WED	1	1	1	1	1	1	1	1
THUR	1	1	1	1	1	1	1	1
FRI	1	1	1	1	1	1	1	1
SAT	1	1	1	1	1	1	1	1
SUN	1	1	1	1	1	1	1	1

	APR				MAY				JUNE				JULY			
	Week 13	Week 14	Week 15	Week 16	Week 17	Week 18	Week 19	Week 20	Week 21	Week 22	Week 23	Week 24	Week 25	Week 26	Week 27	
KICK-OFF	9/7	9/12	9/18	9/25												
DATA COLLECTION AND PREPARE: OPERATIONS	80%	95%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
DISPATCH	50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
WORKLOAD	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
EQUIPMENT	15%	90%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
DISCREPANCY/ISSUE	5%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
PROBLEMS	5%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
TYPOGRAPHY	10%	10%	30%	40%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
CONTROL DOCUMENTS																
ENCLOSURE	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
ITEM CHECK LIST	10%	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
ITEM SUMMARY	10%	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
RCC CHECK LIST	10%	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
WLD HISTORY RUN		20%	75%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
DATA PROCESSING																
PROFILES			50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
FLAT FILES			50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
DATA VALIDATIONS			50%	80%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	
SIMULATION RUN																
MODEL VALIDATIONS																
BEAMFORMING																
EXPERIMENTATION																

OC MABPAB

Activities Checklist

POKER #	Due Date	Priority	Activity	Delegated to	Start Date	Due Date
1	100%	✓	ENVELOP size/ser. conf.	R.B.	4/7	4/7
2	✓	✓	Item check list	R.B.	4/7	4/14
3	✓	✓	Item Summary	R.B.	4/7	4/14
4	✓	✓	RCC Check List	R.B.	4/7	4/14
5	80%	✓	OPERATION - MACH. w/ Elec. Erection - Equipment - TSP Times - MAND. Elec. Test. (New) - STALL LEVER (New Req.)	T.H.	4/3	4/12
6	50%	✓	MANPOWER - qty - Hrs - Alt. Skill Sets	E.S./E.D.	4/7	4/12
7	30%	✓	WORKLOAD - Electric Stock - Act. Pwr. by Gen - Max. v.I.P. - STD. Hrs	L.M.	4/7	4/12
8	15%	✓	EQUIPMENT - Pres. Maint - Breakdown - Lower by Other - Alternative	L.M.	4/6	4/13
9	50%	✓	DISASSEMBLE/ASSEMBLE	R.B.	4/7	4/10
10	50%	✓	PARALLEL	R.B.	4/7	4/10
11	✓	✓	IN DATES	E.S.	4/7	6/7
12	✓	✓	OUT DATES	E.S.	4/7	6/7
13			IE ASSESSMENT	R.B./T.H.	4/3	ON GOING

EARL'S WICH LIST.

DECREASE - Flow Time  
- Spice Req.  
- Labor Hr.

IMPROVE CTR/DOG. STENC.

INCREASE OUTPUT (EFF)

Thursday  
**13**  
April 1988

Daily Plan  
Week 15 103/202

Time	Activity
08:00	08:00-08:30
08:30	08:30-09:00
09:00	09:00-09:30
09:30	09:30-10:00
10:00	10:00-10:30
10:30	10:30-11:00
11:00	11:00-11:30
11:30	11:30-12:00
12:00	12:00-12:30
12:30	12:30-01:00
01:00	01:00-01:30
01:30	01:30-02:00
02:00	02:00-02:30
02:30	02:30-03:00
03:00	03:00-03:30
03:30	03:30-04:00
04:00	04:00-04:30
04:30	04:30-05:00
05:00	05:00-05:30
05:30	05:30-06:00
06:00	06:00-06:30
06:30	06:30-07:00
07:00	07:00-07:30
07:30	07:30-08:00

Activity	Schedule	OK	Contact
8: MODEL PRESENTATION			
9: TO AB YAKS CENTER TEAM			
TOUR MABPAB Bldg 95			
TOUR MABPFF Bldg 2121			
TOUR NEW Bldg for MABPAB			
12: [Blacked out]			
1: [Blacked out]			
2: DIVISION MAB Test Jense			
BRANCH MADE Chassis S...			
3: [Blacked out]			
4: [Blacked out]			
5: [Blacked out]			

		1 <sup>st</sup> DS			2 <sup>nd</sup> DS			3 <sup>rd</sup> DS			4 <sup>th</sup> DS			
MBPFF	ZS	4	3	1	2	2	0	1	1	0	1	1	0	
	AS	26	22	4	19	16	3	11	9	2	14	12	2	
	3S	14	12	2	11	9	2	9	8	1	7	6	1	
	WS	20	17	3	32	27	5	25	21	4	33	28	5	
	YS	<u>39</u>	33	<u>6</u> 16	<u>39</u>	33	<u>6</u> 16	28	24	<u>4</u> 11	19	16	<u>3</u> 11	54
Total		103			103			74			74			

		DS			DS			DS			DS					
MBPAB	AS	27	25	2	12	11	1	8	7	1	14	13	1	56	5	6
	BS	29	27	2	28	26	2	40	37	3	35	32	3	122	10	13
	CS	18	17	1	20	18	2	27	25	2	19	17	2	77	7	8
	DS	35	32	3	18	17	1	6	6	0	4	4	0	59	4	6
	ES	43	40	3	48	44	4	65	60	5	50	46	4	190	16	20
	FS	<u>53</u>	49	4	<u>52</u>	48	4	<u>62</u>	57	5	<u>55</u>	51	4	205	17	22
Total		205			178			208			177			709	59	71
			<u>15</u>			<u>14</u>			<u>16</u>			<u>14</u>				

MBPFF		1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
	5	0	0	0	0
ZS	8	1	0	0	0
	10	2	2	1	1
	5	3	3	1	2
AS	8	5	3	2	3
	10	14	10	6	7
	5	2	1	1	1
3S	8	3	2	2	1
	10	7	6	5	4
	5	3	4	4	5
WS	8	4	6	4	6
	10	10	17	13	17
	5	6	6	4	3
YS	8	7	7	5	3
	10	20	20	15	10
	5	1	1	1	1
GS	8	5	5	3	3
	10	10	10	7	7
		<hr/>	<hr/>	<hr/>	<hr/>
		103	103	74	74

MBPFF

	1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
ZS	09 882.43	02 344.67	01 275.49	01 398.67
	09			
AS	25 8,703.60	18 4,052.00	15 3,015.70	19 4,522.20
	25			
BS	19 3,762.90	11 2,966.90	12 2,397.30	19 2,090.30
	19			
WS	19 4,362.96	28 7,113.59	38 6,966.96	45 10,450.99
YS	38 2,559.00	38 2,559.00	38 7,698.60	20 5,997.30
Totals	22,567.39	22,530.61	20,389.00	23,395.31

MBPAS

AS	10,575.50	4,998.50	2,966.00	8,193.00
	13		09	08
BS	11,135.00	10,702.00	10,582.00	10,483.00
	14		19	
CS			7,127.00	6,100.00
			25	
DS	17,113.20	15,000.00	17,025.00	18,237.10
	21		31	22
ES	21,093.00	18,000.00	16,749.00	15,674.40
	26		30	23
Totals	90,815.70	88,195.50	85,516.80	83,309.10



		1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
15009A	ZS	20.66	30.87	10.87	30.87
15010	ZS	-	-	-	-
15011	ZS	-	-	-	-
15012	ZS	-	-	-	-
15013	ZS	138.46	138.46	69.23	138.46
15014	ZS	501.36	125.34	125.34	125.34
15017	AS	24.00	15.00	12.00	18.00
15020	AS	24.00	15.00	12.00	18.00
15021	AS	46.40	29.00	23.20	38.80
15022	AS	46.40	29.00	23.20	38.80
15023	AS	-	243.00	243.00	243.00
15026	AS	192.00	120.00	96.00	144.00
15027	AS	192.00	120.00	96.00	144.00
15028	AS	192.00	120.00	96.00	144.00
15029	AS	192.00	120.00	96.00	144.00
15030	AS	192.00	120.00	96.00	144.00
15031	AS	192.00	120.00	96.00	144.00
15059	BS	-	-	-	76.10
15070	BS	-	-	-	-
15073	BS	343.20	573.00	573.00	573.00
15074	BS	1,192.00	953.60	953.60	953.60
15075	BS	953.60	573.00	476.70	476.70
15076	BS	573.00	343.20	343.20	-
17297	WS	390.88	243.30	195.44	293.16
17298	WS	390.88	243.30	195.44	293.16
17299	WS	390.88	243.30	195.44	293.16
17300	WS	390.88	243.30	195.44	293.16
17301	WS	390.88	243.30	195.44	293.16
17302	WS	390.88	243.30	195.44	293.16
17303	WS	390.88	243.30	195.44	293.16
62055	AS	315.80	197.35	157.88	236.82
74495	WS	8,554.00	8,558.00	7,698.60	8,987.40
74450 Jo					
74962	AS	4,097.04	2,860.65	2,048.52	3,027.78
Total		22,567.39	20,530.65	20,389.00	23,317.31

	WG 10	1	59	
	WG 8	1	57	92
	WG 5	1	38	
	WG 8	1	09	
	WG 10	1	54	
			83	09
	WG 5	1		
	WG 8	1		
	WG 10	1		
			23	
			201	
RFF	DAYS			
	WG 5	1	17	
	WG 8	1	21	
	WG 10	1	60	
			72	95
	WG 5	1		
	WG 8	1	31	
	WG 10	1	60	
			13	15
			85	
	WG 5	1		
	WG 8	1		
	WG 10	1		
			94	

F988

	<del>OCT</del>	MABAB	MABPF	
1ST QTR	OCT	235	103	1ST QTR
2ND QTR	JAN	178	103	2ND QTR
	<del>MAR</del>	<del>167</del>	<del>74</del>	
3RD QTR	MAY	208	74	<del>208-74</del> 3RD QTR
	<del>JUN</del>	<del>174</del>	<del>74</del>	
4TH QTR	AUG	177	74	177-74 4TH QTR

IdH

1ST	5.6	5.5	
2 <del>1st</del>	5.7	5.7	
3 Rd	5.9	5.8	
4th	5.8	4.6	?

Current = 70 of 5i - 8i - 10i



		Days		
MBPAB Assigned TECHNICAL	WG-5	35	.22	
	WG 8	29	.19	
	WG 10	<u>93</u>	.59	
		157		.92
Swing				
	WG 5	5	.38	
	WG 8	1	.08	
	WG 10	<u>7</u>	.54	
		13		.08
<hr/>				
		170		
	WS	4		
	No tech	<u>25</u>		
		201		

		Days		
IPFF	WG 5	12	.17	
	WG 8	15	.21	
	WG 10	<u>45</u>	.62	
		72		.85
Swing				
	WG 5	1	.07	
	WG 8	4	.31	
	WG 10	<u>8</u>	.62	
		13		.15
		<u>85</u>		
	WS	5		
	No tech	<u>4</u>		
		94		

FY89 DATA

ACT FY88

NAME: \_\_\_\_\_ ALC: OC DATE: \_\_\_\_\_ RCC: MABPAB 0:46 FRIDAY, MARCH 24, 1989 SHEET \_\_\_\_\_ OF \_\_\_\_\_ 1

*Do not use*

SK CODE	DESCRIPTN	QTR	WORK WEEK 1	WORK WEEK 2	WORK WEEK 3	QUANTITY AVAILABLE			HOLIDAY	AVAILABLE HRS (PER SHIFT)	WEEK END	HOLIDAY
						1	2	3				
AS		1	40						6.1			3
AS		2	39						6.2			2
AS		3	37						6.1			1
AS		4	37						6.1			2
BS		1	40						6.1			3
BS		2	40						6.2			2
BS		3	37						6.1			1
BS		4	37						6.1			2
CS		1	21						6.1			3
CS		2	22						6.2			2
CS		3	21						6.1			1
CS		4	22						6.1			2
DS		1	43						6.1			3
DS		2	44						6.2			2
DS		3	44						6.1			1
DS		4	44						6.1			2
ES		1	67						6.1			3

FY88-1 277  
 FY88-2 275  
 -3 273  
 -4 276  
 (FY89)  
 that

SK CODE	DESCRIPTN	QTR	QUANTITY AVAILABLE			HOLIDAY	AVAILABLE HRS. (PER SHIFT)					
			WEEK 1	WEEK 2	WEEK 3		WEEK 1	WEEK 2	WEEK 3			
ES	2	66	.	.	.	.	6.2	.	.	.	.	.
ES	3	69	.	.	.	.	6.1	.	.	.	.	.
ES	4	70	.	.	.	.	6.1	.	.	.	.	.
FS	1	66	.	.	.	.	6.1	.	.	.	.	.
FS	2	64	.	.	.	.	6.2	.	.	.	.	.
FS	3	65	.	.	.	.	6.1	.	.	.	.	.
FS	4	66	.	.	.	.	6.1	.	.	.	.	.

//p1

WORK ORDERS

1-1071-  
117

MABPAB NAME BLDG 95 POST LOCATION SPECIFIC PROBLEM ORGN CODE

Problem	Post	Reported by	Date/Time	Work Order #	Completed
47222 D. Dillon 43201 G. Ison 43519 HUNT SL. 47222 HARBAUGH					
Overhead door	15	Wimberley	15 Nov 88	W 7158	✓ JW
Leak in steam line	17D 19D	Hensley	25 Nov 88	W 8095	✓ JH
Heaters would work	31D 25C	Lenox	28 Nov 88	W 8110	
Leak in steam line	17D	Hensley	2 Dec 88	W 8577	✓ JH
Personnel door between 988		Johnson	2 Dec 88	W 8644	
Overhead light in ip. <sup>CE</sup>	1125	McBride	5 Dec 88 / 0845	W 8715	✓ NMCB
Restroom Commode	NW Corner	Bayler	6 Dec 88	W 8883	✓ WLB
Partially Elevator	23K	Johnson	8 Dec 88	343-55	
Urinal would flush	19C	Hensley	13 Dec 88	W 89603	✓ JH
Heater in SE <sup>ladies</sup> restroom		Lenox	28 Dec 88 / 1320	W 9646	Contractor's contact by Civil Eng. to fix up to right line
plug-ins bad insulation	29H	Lenox	29 Dec 88 / 1040	W 9736	
No cover over thermostat	29E	Lenox	29 Dec 88 / 1040	W 9737	✓ JH
Called animal Center 1435 18 talked to the Jenkins / was at the	13H	McBride	30 Dec 88 / 1200	re work	
LOOSE BOARDS IN ROOF TRUSSES	21D 31C	GREENWOOD	4 JAN 9:45	W 1072	
SMALL DOOR DOOR BROKEN	23C	HENSLEY	5 JAN 1520	W 1225	OK W JH
Lock doesn't work Door SE Corner		Lenox	11 Jan 0705	W 1708	✓ JH
LEAK IN STEAM PIPE (PAPER TOWEL DISP)	19D	HENSLEY	17 JAN 0805	W 2132	
LEAK IN RESTROOM	19C	HENSLEY	17 JAN 0805	W 2133	
To Remove Oil	13H	Johnson	20 JAN 0905	W 2546	
Breaker won't stay on	27C	Lenox	24 Jan 0630	W 2778	NOT Breaker box - Reset box / changing S
air Comp down		MILBY	1 Feb 0627		
Personnel door		Johnson	1 Feb 0940	W 3617	
Restroom	I13 I10	Johnson	3 Feb 0850	W 3933	
Leak in	J-11	Johnson	3 Feb 10:00	W 3940	
Auto 105	WIN 105	Brown	5 Feb 1500	W 4171	
Leak in	17D	BROWN	7 Feb 1500	W 4058-82	

WORK ORDERS

4311

MABPAB NAME BLDG 95 POST LOCATION SPECIFIC PROBLEM ORGN CODE 320

Problem	Post	Reported by	Date/Time	Work Order #	Completed
Elc. box/no cover	13C	Lenox	10 Feb 89 12:00 <sup>pm</sup>	W4868	✓ Wd
Elet Braker Switch	15	Brown Jerry	14 Feb 89 07:15	W 5091	CANX
Leak in Roof	25N 21N 12J	13N Johnson	14 FEB 89 <sup>13:10</sup>	W5191	
Heat Pump Noisy	11-12	MUSTIN	15 Feb 89 17:30	W 5392	
Leak in S... ..	31N	JENNISON	27 Feb 89 14:00	W 6201	
S... ..	13A	...	...	W 6408	2 March 89 8 8:15
Personnel Door won't lock	27B	Lenox	2 Mar 89 12:00	W6523 Pri: Urgent	
Men's Comm stopped up	19C	Jacobs	10 Mar 89 9:56	W7383	11 MAR 89 YH
Rel. dat. to...		...	17 MAR 89 14:00	W 7136	
...		...	17 DEC 89 14:30	W 8136	
...		...	...	W 8752	
...		...	...	W 9676	
STEEL PIPE	11D	Jacobs	3 APR 89 13:52	W 9676	
MEN'S RESTROOM	19C	HENSLEY	7 APR 89 01:05	X 0072	c/w
COMMODE STOPPED UP	31D 95	HENSLEY	10 APR 89 09:05	X 220	
TURN ON HEAT					



B FALLO  
R. BOLANI

MABPAB FIXTURES

TI DELVP. CODES  
FLIGHT CONTROLS

<u>EQUIP CODE NO.</u>	<u>NAME</u>	<u>PART. NO.</u>	<u>QTY.</u>	<u>APPLICATI</u>
F 335-01	FILLET FLAP	SC65-1062T1		E3A/135
" 02	RUDDER	590CJ1130	1	E3A/135
FE3A 01	INBD FLAP	SC65-1063T1	1	E3A
" 02	L' RH ELEVATOR	SC5-96190T1		E3A
F135- 01	RH/RH ELEVATOR	590CJ1120	1	135
F 335-03	INBD AILERON	590CJ1010	3	E3A/135
" " 04	OTBD MAIN FLAP	590CJ1030	1	E3A/135
F 135-02	INBD MAIN FLAP	590CJ1030	1	135
F 335-05	OTBD SPOILER	590CJ1060	1	E3A/135
" 07	OTBD AILERON	590C1000	3	E3A/135
F-335 10	Fore Flap Holding	801092.	4	
" 11	<u>DOORS</u>			
F 335-08	OTBD MLG	590CJ1110	4	E3A/135
" 09	INBD MFG	590CJ1100	4	E3a/135
	<u>MISC</u>			
F 135-03	Hog Nose Fairing	65-10607-46	1	135
" 04	OTBD ENG STRUT	590CJ1150	1	135
" 05	INBD ENG STRUT	590CJ1140	1	135
" 06	BOTTOM PANEL TF33 P9	FAJ64-8327-621	1	135
" 07	TAIL CONE	7627259	1	135
" 08	KNEE CAP FAIRING	TJ5-85654	1	135
" 09	BOOM POD FAIRING		1	135
" 10	NOSE WHEEL FAIRING	2FAJ5-73139-1	1	135
" 11	NOSE WHEEL FAIRING	FRJ5-73139-1	1	135
" 12	NOSE WHEEL FAIRING	FAJ5-73139-1	1	135
" 18	BOOM TAIL CONE	600CJ809	3	135
	<u>COWLING</u>			
F33A-03	RH SIDE COWL	SC65-2540	1	E3A
" 04	LH SIDE COWL	SC65-2549T1	1	E3A
F135-13	RH SIDE COWL J57	3AJ5-85638	2.	135
" 14	LH SIDE COWL J57	3AJ5-85637	2	135
" 15	RH SIDE COWL TF33P5	005-64-8327-488	1	135
" 16	L'H SIDE COWL TF33P5	005-64-8327-487	1	135
FE3A- 05	NOSE COWL	204-70099-3ASMJ	1	E3A
" 06	NOSE COWL	204-70099-TRMJ	1	E3A
F135 -17	NOSE COWL J57	AJ5-85655	1	135

TI DEVL. CODES

B-52  
MABPFF FIXTURES

<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>PART NO.</u>	<u>QTY</u>
FB 52-01	ELEV/RUDDER BALANCE	RP046	1
02	BOMB BAY DOOR (LARGE)	FME35-30600-3	2
03	BOMB BAY DOOR (LARGE)	FME35-30600-1	2
04	BOMB BAY DCOR (LARGE)	FME35-30600-2	2
05	BOMB BAY DOOR (SMALL)	AJ5-48467-3	1
06	BOMB BAY DOOR (SMALL)	AJ5-46867-4	2
07	BOMB BAY DOOR (SMALL)	AJ5-46868-28	1
08	BOMB BAY DOOR (SMALL)	AJ5-46868-27	1
FB 52-09	BOMB BAY DOOR (SMALL)	AJ5-46867-3	1

MABPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
E 135-01	Bending MACHINE (HAND)	416	1
" 02	LARGE BAND SAWS		2
" 03	ROTEX PUNCH PRESS		1
" 04	DRILL' (FLOOR MODEL)	1200-118	1
" 05	GRINDER FLOOR MODEL, (2WHEEL ELECT)		1
" 06	PRESS BRAKE (CHICAGO STEEL CO.)	80023	1
" 07	POWER SQUARING MACHINE	002741	1
" 08	PRESS BRAKE	4560G	1
" 09	SMALL METAL SHEAR	241-C	1
" 10	SMALL DRILL PRESS		1
" 11	GRINDER 1WHEEL,(FLOOR MODEL)	WF6566	1
" 12	PUNCH PRESS	P41P	1
" 13	SANDER (BELT) FLOOR MOD.		1
" 15	BENDING MACHINE (HAND)	BB-316	1

B-52

MABPFF EQUIPMENT

<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>MODEL #TYPE</u>	<u>QTY.</u>
EB 52-01	DOUBLE SANDER DISK (FLOOR MODEL)		1
02	DRILL PRESS (FLOOR MODEL)		4
03	GRINDING MACHINE	WISSOTA E8M	1
04	WELDER	MILLER 330ST	1
05	BRAKE, MECH		1
06	BRAKE, MECH FORMING ROLLER	0617	2
07	BRAKE, HAND	NATIONAL	2
08	METAL STREACHER (FLOOR MOD)		1
09	PRESS ARBOR	FAMCO	2
10	PUNCH, MECH	ROTEX	1
11	POWER SHEAR	MASPERI CM500A	1
12	DIMPLER	300	1
13	BRAKE PRESS	65M75	1
14	DOALL SAW	3613-2	1

SKILL CODES

MABPAB

_____	*AS	LEFT HAND SIDE COWL
_____	*BS	RIGHT HAND SIDE COWL
_____	*CS	NOSE COWL
_____	*DS	FLAPS
_____	*ES	FLIGHT CONTROLS
_____	*FS	MISC

MABPFF

_____	*AS	SPOILERS, HATCHES, TIP GREAR, POP-UP
_____	*WS	ANTENNA, SUPPLY B/B DOORS
_____	*YS	FLAPS, RUDDERS, ELEVATORS.
_____	*3S	NOSE COWL, SIDE COWL
_____		PDM

MABPCA

_____	*WL	EQUIPMENT CLEANERS
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MABPCB

_____	*B3	PAINTERS
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MABPCD

_____	*MQ	MOVERS
_____	*CQ	CRANE OPERATORS
_____	*EQ	CHECKERS

AA

SYSTEMS (ELECTRIC)

<u>IC#</u>	<u>No.</u>	<u>IC No. Assignment</u>
15175A	3	<del>175-1, 175-2, 175-3</del>
15175B	5	<del>175-4, 175-5, 175-6, 175-7, 175-8</del>
15175C - 15175D		<del>175-9, 175-10, 175-11, 175-12</del>
15175E - 15175F	12	<del>175-13, 175-14, 175-15, 175-16, 175-17, 175-18, 175-19, 175-20, 175-21, 175-22</del>
15175G - 15175H		<del>175-23, 175-24, 175-25, 175-26, 175-27, 175-28, 175-29, 175-30</del>
15175I - 15175J		<del>175-31, 175-32, 175-33, 175-34, 175-35, 175-36, 175-37, 175-38, 175-39, 175-40</del>
15175K - 15175L		<del>175-41, 175-42, 175-43, 175-44, 175-45, 175-46, 175-47, 175-48, 175-49, 175-50</del>
15175M - 15175N		<del>175-51, 175-52, 175-53, 175-54, 175-55, 175-56, 175-57, 175-58, 175-59, 175-60</del>
15175O - 15175P		<del>175-61, 175-62, 175-63, 175-64, 175-65, 175-66, 175-67, 175-68, 175-69, 175-70</del>
15175Q - 15175R		<del>175-71, 175-72, 175-73, 175-74, 175-75, 175-76, 175-77, 175-78, 175-79, 175-80</del>
15175S - 15175T		<del>175-81, 175-82, 175-83, 175-84, 175-85, 175-86, 175-87, 175-88, 175-89, 175-90</del>
15175U - 15175V		<del>175-91, 175-92, 175-93, 175-94, 175-95, 175-96, 175-97, 175-98, 175-99, 175-100</del>
15236A	4	<del>236-1, 236-2, 236-3, 236-4</del>
15237A		
15249A	5	<del>249-1, 249-2, 249-3, 249-4, 249-5</del>
15250A		<del>250-1, 250-2, 250-3, 250-4, 250-5</del>

For files

11.11.55

P. H.                      10

Code No. Assignment

<del>25-6</del>	<del>25-7</del>
<del>25-8</del>	<del>25-9</del>
<del>25-10</del>	

15112A                      16

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<del>113-6</del>	<del>113-7</del>	<del>113-8</del>	<del>113-9</del>	<del>113-10</del>
<del>113-11</del>	<del>113-12</del>	<del>113-13</del>	<del>113-14</del>	<del>113-15</del>

15112A                      4

~~113-1, 113-2, 113-3, 113-4~~

15120A & 15300A                      4

~~120-1, 120-2, 120-3, 120-4~~

15130A & 15137A                      4

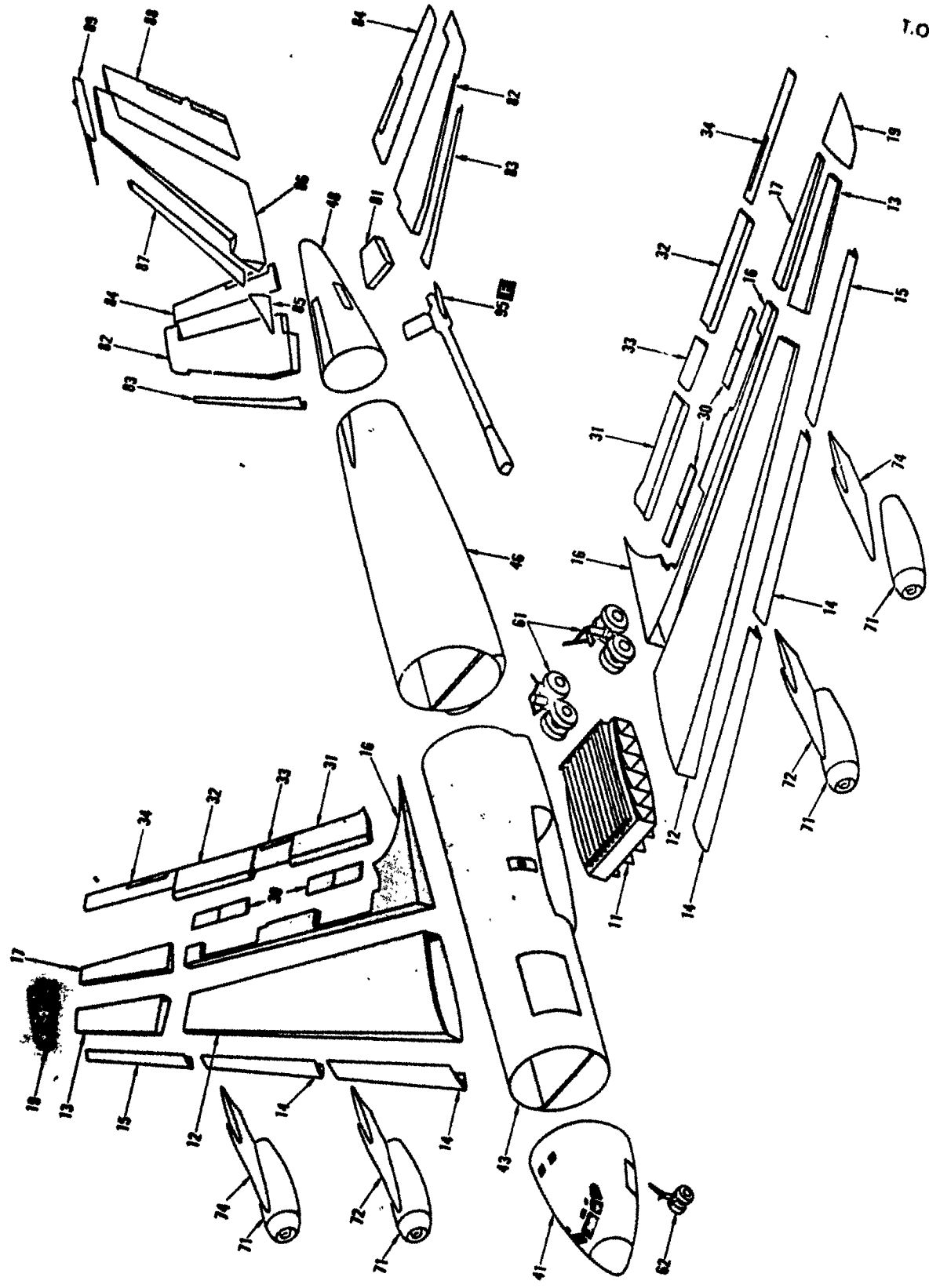
~~130-1, 130-2, 130-3, 130-4~~

15140A                      5

~~140-1, 140-2, 140-3, 140-4, 140-5~~

15150A                      16

<del>150-1</del>	<del>150-2</del>	<del>150-3</del>	<del>150-4</del>	<del>150-5</del>	<del>150-6</del>	<del>150-7</del>	<del>150-8</del>	<del>150-9</del>	<del>150-10</del>	<del>150-11</del>	<del>150-12</del>	<del>150-13</del>	<del>150-14</del>	<del>150-15</del>	<del>150-16</del>
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**J57-43 OR J57-59 TURBOJET ENGINES**  
Figure 1-3. Major Structural Group Breakdown (Sheet 1 of 4)



AIRCRAFT SECTION NO.	DRAWING TITLE	DWG NO.
11	WING CENTER SECTION ASSY	5-73111
12	INBOARD WING ASSY	5-89312
13	OUTBOARD WING ASSY	5-89300
14	INBOARD WING LE INSTL	5-73114
15	OUTBOARD WING LE INSTL	5-73115
16	INBOARD WING TE INSTL	5-73116
17	OUTBOARD WING TE INSTL	5-73117
19	WINGTIP INSTL	5-73119
30	WING SPOILER INSTL	5-73130
31	INBOARD FLAP INSTL	5-73131
32	OUTBOARD FLAP INSTL	5-73132
33	INBOARD AILERON INSTL	5-73133
34	OUTBOARD AILERON INSTL	5-73134
41	BODY INSTL - SECTION 41	5-71741
43	BODY INSTL - SECTION 43	5-71743
46	BODY INSTL - SECTION 46	5-71746
48	BODY INSTL - SECTION 48	5-71748
61	MAIN LANDING GEAR INSTL	5-83045
	MAIN LANDING GEAR INSTL <b>F</b>	458-56100
62	NOSE LANDING GEAR INSTL	5-83046
71	COWL INSTL <b>A</b>	50-3371
	COWL INSTL <b>B</b>	65-10609
	COWL INSTL <b>C</b>	65C18556
	COWL INSTL <b>D</b>	65C18603
	COWL INSTL <b>E</b>	458-56021

AIRCRAFT SECTION NO.	DRAWING TITLE	DWG NO.
72	INBOARD STRUT INSTL <b>A</b>	5-85613
	INBOARD STRUT INSTL <b>B</b>	65-18892
	INBOARD STRUT INSTL <b>B D</b>	35-35325
	INBOARD STRUT INSTL <b>C E</b>	65C18500
74	OUTBOARD STRUT INSTL <b>A</b>	5-85614
	OUTBOARD STRUT INSTL <b>B</b>	65-18893
	OUTBOARD STRUT INSTL <b>B D</b>	35-35326
	OUTBOARD STRUT INSTL <b>C E</b>	65C18500
81	STABILIZER CENTER SECTION INSTL	5-71781
82	STABILIZER INSTL <b>A</b>	5-71782
	STABILIZER INSTL <b>B D</b> (EXTENDED)	69-12778
	STABILIZER INSTL (EXTENDED) <b>B C D E</b>	35-35322
83	STABILIZER LE INSTL <b>A</b>	5-71783
	STABILIZER LE INSTL (EXTENDED) <b>B C D E</b>	65-16737
84	ELEVATOR BALANCE ASSY	5-71784
85	DORSAL FIN INSTL	5-71785
86	VERTICAL TAIL INSTL	65-8624
78	RUDDER BALANCE ASSY	50-9788
88	RUDDER ASSY	65-3495
89	FIN TIP ASSY	50-11379
95	RUDDER ASSY <b>F</b>	5-96159

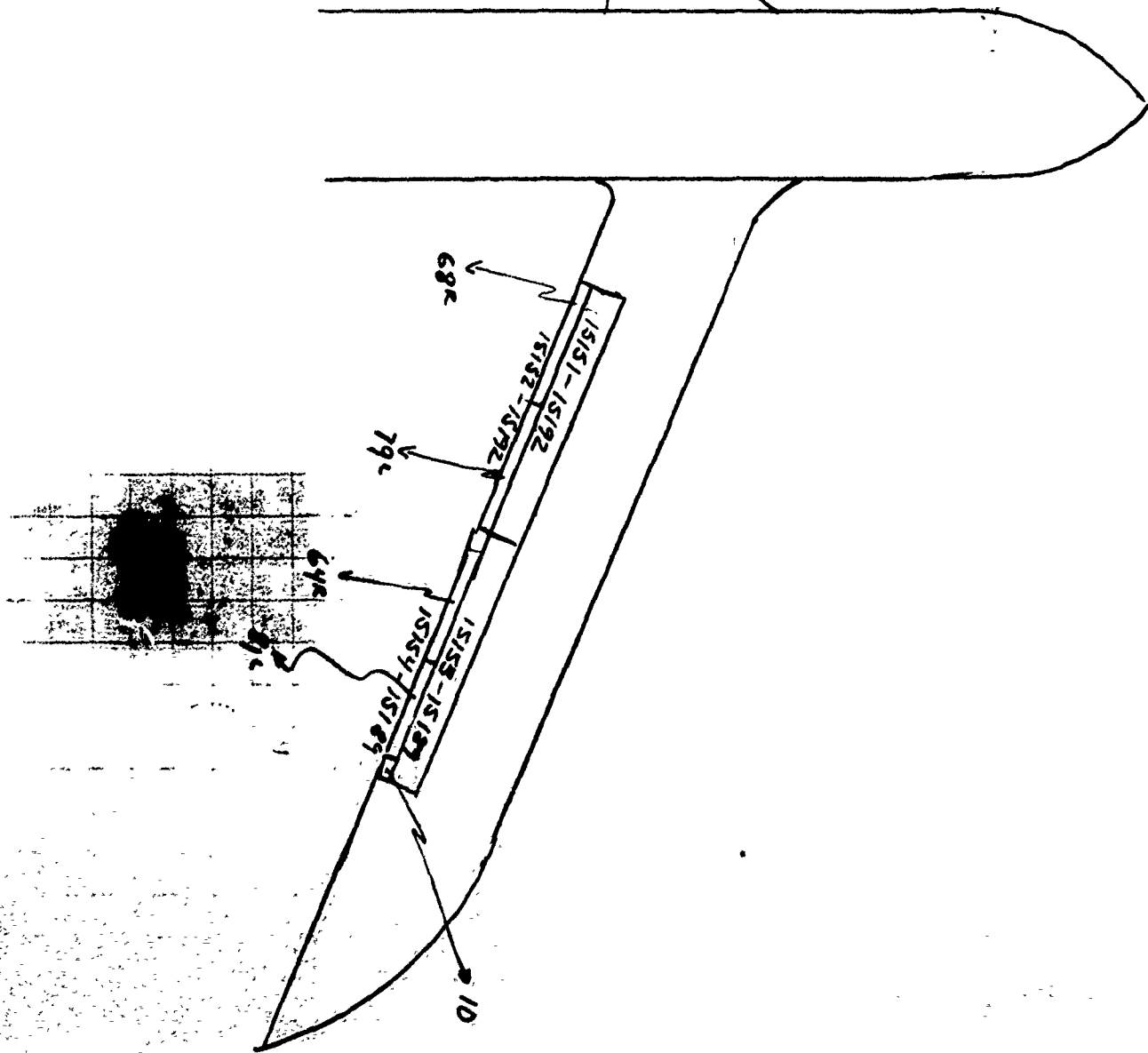
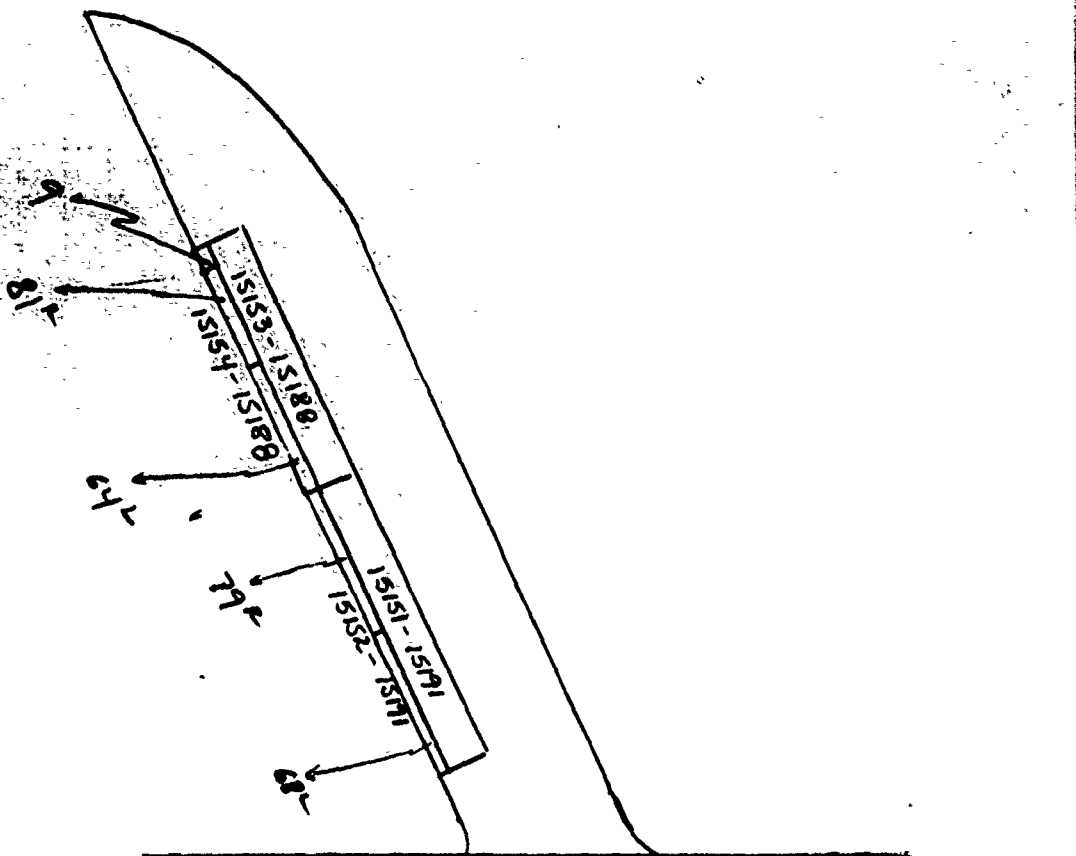
**NOTE**

- A** J67-43 OR J67-59 TURBOJET ENGINES.
- B** TF33-P-6, TF33-P-6, OR TF33-PW-102 TURBOFAN ENGINES.
- C** F108-CF-100 TURBOFAN ENGINES.
- D** AIRCRAFT AFTER T.O. 1C-135-1135.
- E** AIRCRAFT AFTER T.O. 1C-135(K)A-1112.
- F** AIRCRAFT WITH AIR REFUELING BOOM.

Figure 1-3. Major Structural Group Breakdown (Sheet 4 of 4)







SHOP FLOW DAY STANDARD

Reference AFLCR 66-11

CONTROL NO. \_\_\_\_\_

DATE \_\_\_\_\_

$$\text{Shop Flow Days (Std. calendar days)} = \frac{A((B / C) + D + E)}{F}$$

Where :

A = CONVERSION FACTOR, Changing workdays to calendar days.

5 day week = 1.46

6 day week = 1.21

7 day week = 1.03

A = \_\_\_\_\_

B = END ITEM STD HRS, expressed in hours, to two decimal places.

Note 1. When an operation with a labor standard takes place concurrent to a process support or unique process support operation (factors D or E below), use only the longer time.

Note 2. If the same operation is performed on the same part at the same time by multiple workers, divide the total standard time by the number of workers.

B = \_\_\_\_\_

C = RCC CONSTANT, Direct labor hours, expressed as a percentage of total hours available. Subtract indirect labor factors for duty codes .24, .25, .26, and .29 from 1.00. Reference G037G-EHI-MI-MEH. Round off answer to four decimal places.

C = \_\_\_\_\_

D = PROCESS SUPPORT, expressed in hours, to two decimal places.

An average time value for each end item, for transportation time between RCCs, packing, unpacking, and awaiting Maintenance time.

D = \_\_\_\_\_

E = UNIQUE PROCESS SUPPORT, expressed in hours, to two decimal places. An average time value for each end item, for processes, such as plating, heat treating, welding, painting, etc. E = \_\_\_\_\_

F = SHIFT HOURS, expressed in whole hours. Normally 8 hours in peacetime. Peacetime process or test times that exceed 8 hours are an exception (e.g. plating, heat treating, etc.). If the number of shifts are temporarily changed (3 months or less), the number of flow days should not be modified.

F = \_\_\_\_\_

$$\text{Flow days} = \frac{A((B / C) + D + E)}{F}$$

FD = \_\_\_\_\_

28 Feb 89

Al,

Attached is the shop rate information that you asked me to provide. I've also included a list of the routing symbols and their associated unit names. Note that on the computer output routing symbols are reduced from the normal MABPAB to MBPAB.

You also asked that I determine the amount of maskant utilized per year. Personnel in the MIC report that a quantity of forty gallons per month or four hundred and eighty per year is utilized.



GENE W. LEITERMAN  
OC-ALC TI Program Manager

FY 89  
 DC-ALC  
 RCC RATES

DATE : 13-Mar-89  
 FILE : OCRATE

RCC	DIRECT LABOR	DIRECT MAT'L	OTHER DIRECT	OVHD IND MAT'L	OVHD OTHER	G & A	TOTAL	LESS DIR MAT'L
MARPAB	19.86	14.61	0.00	5.34	11.01	5.34	56.16	41.55
MABPFF	19.65	3.46	0.00	1.67	9.05	5.34	39.17	35.71
MAEPSG	16.79	0.00	0.00	2.92	11.11	5.19	36.01	36.01
MATPAA	17.40	58.69	0.00	1.33	11.81	5.19	94.42	35.73
MATPAB	18.08	122.09	0.00	2.34	13.19	5.19	160.89	38.80
MATPAT	19.71	0.00	0.00	1.23	16.55	5.19	42.68	42.68
MATPCA	18.17	39.11	0.00	2.94	14.53	5.19	79.94	40.83
MATPCB	16.96	81.85	0.00	1.87	14.59	5.19	120.46	38.61
MATPCC	17.87	49.10	0.00	1.28	9.92	5.19	83.36	34.26
MATPCD	17.86	45.43	0.00	1.60	15.75	5.19	85.83	40.40
MATPCM	17.16	0.00	0.00	1.19	13.51	5.19	37.05	37.05
MATPFA	18.33	11.92	0.00	1.36	13.92	5.19	50.72	38.80
MATFFE	18.31	12.21	0.00	1.27	11.85	5.19	48.83	36.62
MATPFF	18.42	19.74	0.00	1.26	18.44	5.19	63.05	43.31
MATPHA	18.78	53.16	0.00	1.84	13.35	5.19	92.32	39.16
MATPHB	18.69	100.30	0.00	1.84	12.65	5.19	138.67	38.37
MATPHE	17.51	0.00	0.00	1.84	13.38	5.19	37.92	37.92
MATPIA	18.13	35.55	0.00	2.61	14.99	5.19	76.47	40.92
MATPIN	18.90	5.79	0.00	3.08	16.15	5.19	49.11	43.32
MATPIN	21.17	1.30	0.00	2.44	23.07	5.19	53.17	51.87
MATPIW	19.28	39.86	0.00	3.47	14.19	5.19	81.99	42.13

OC-ALC  
RCC CODES

MBPAB	Sheetmetal Backshop Unit
MBPFF	MISTR Sheetmetal Unit
MTPAA	Cabin Pressure Regulator & Valve Unit
MTPAB	Turbine Powered Access & Missile Maint Unit
MTPAT	Air Accessories Testing Unit
MTPCA	Electrical Accessories Unit
MTPCB	Accessories Unit
MTPCC	Electro-Mechanical Accessories Unit
MTPCD	Governor, Misc Eng Access Overhaul & Test Unit
MTPCM	Machine Unit
MTPFA	Automatic Pilot Unit
MTFFE	Engine Instrument Unit
MTPFF	Flight Control Unit
MTPHA	General Transmission Overhaul Unit
MTPHB	Specialized Transmission Overhaul Unit
MTPHE	Machine Shop Unit
MTPIA	Sheetmetal Unit
MTPIM	Machine Shop Unit
MTPIN	Numeric Control Unit
MTPIW	General Welding Unit
MEPSG	Plating Unit





MABFABWL-PP  
REQ. MLW

OC TINKER, AFB OKLAHOMA CITY, OK.

4/28/1989  
RCC = MABPAB

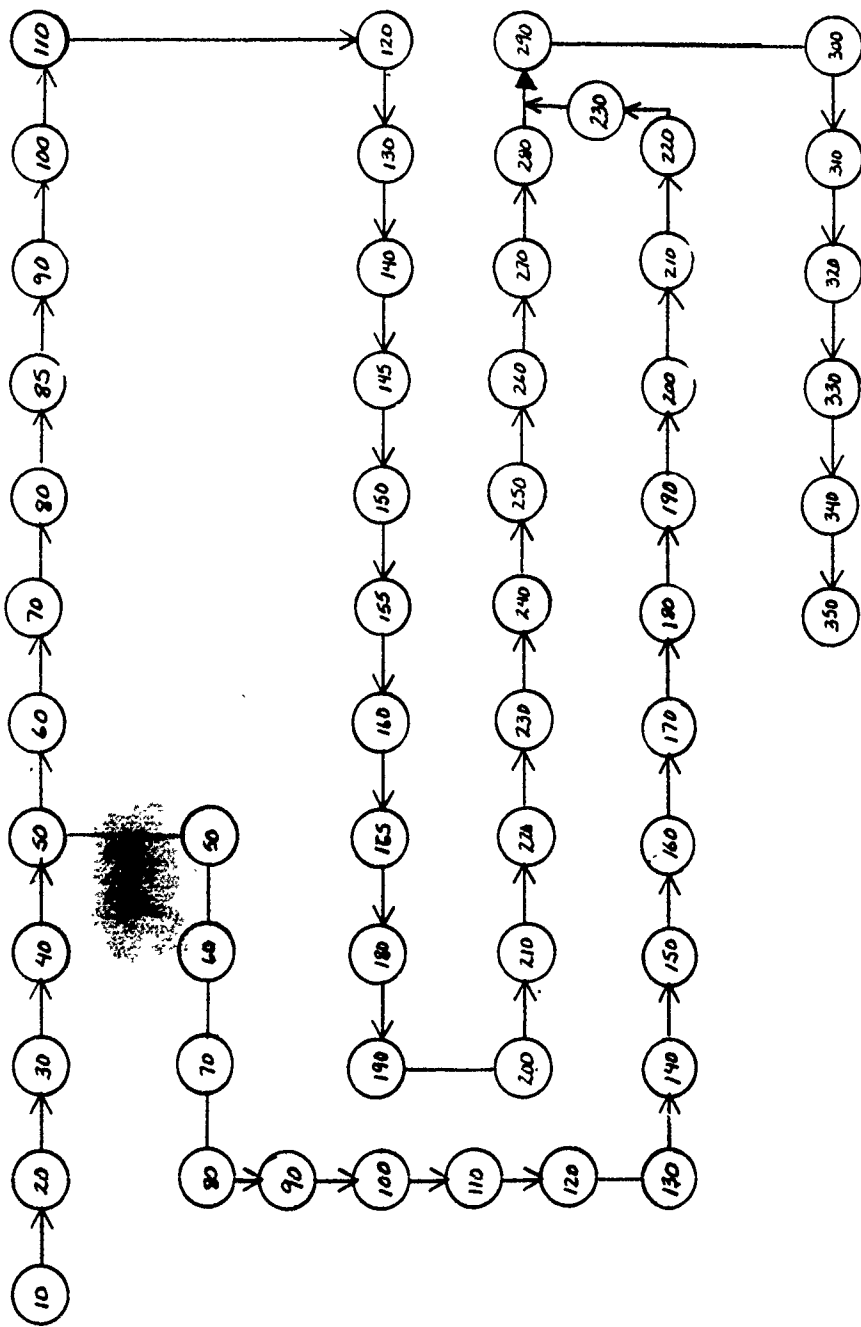
ITEM NUMBER	AIRCRAFT	WCD	W	T	FLT	STK	Q1	Q2	Q3	Q4	UN	EN	MAX	STD	80/20
	MODEL												WIP	HOURS	WT
15025A	C-135	15025A	4	4			56	55	54	75			30	163.5	19.8
15113A	C-135	15113A	4	4			60	60	53	70			44	147.7	18.1
15119A	C-135	15119A	4	4			13	16	20	20			8	89.8	3.1
15321A	C-135	15179A	4	4			13	16	20	20			8	90.2	3.1
15126A	C-135	15126A	4	4			13	16	20	20			10	88.7	3.1
15300A	C-135	15124AA	4	4			13	16	20	20			10	98.3	3.4
15136A	C-135	15136A	4	4			13	18	23	22			8	79.2	3.0
15137A	C-135	15136AA	4	4			13	16	23	21			8	79.2	2.9
15140A	C-135	15140A	4	4			1	0	4	40			16	51.7	1.2
15150A	C-135	15150A	4	4			25	25	28	66			34	85.2	6.6
15175A	C-135	15175A	4	4			25	12	8	26			4	73.9	2.7
15178A	C-135	15178A	4	4			36	50	59	75			14	19.0	2.1
15188A	C-135	15153A	4	4			13	13	15	17			16	120.7	3.5
15189A	C-135	15153AA	4	4			13	15	15	17			16	120.7	3.7
15188ASUB1	C-135	15154A	4	4	2								50	15.0	1.8
15189ASUB1	C-135	15154AA	4	4	2								50	15.0	1.8
15191A	C-135	15151A	4	4			11	11	16	17			14	118.7	3.3
15192A	C-135	15151AA	4	4			6	6	10	17			16	118.7	2.3
15191ASUB1	C-135	15152A	4	4	2								50	15.0	1.7
15192ASUB1	C-135	15152AA	4	4	2								50	15.0	1.2
15236A	C-135	15236A	4	4			6	10	9	9			8	121.6	2.1
15237A	C-135	15237A	4	4			8	8	8	8			2	28.6	0.5
15249A	C-135	15249A	4	4			13	18	23	20			6	110.5	4.1
15250A	C-135	15249AA	4	4			13	18	23	20			6	111.0	4.2
15237ASUB1	C-135	15236B	4	4									2	28.6	0.5

OC - MABPAB

PCN	WCD
*****	*****
15025A	15025A
15113A	15113A
15119A	15119A
15126A	15126A
15136A	15136A
15137A	15136AA
15140A	15140A
15150A	15150A
15175A	15175A
15178A	15178A
15188A	15153A
15188ASUB1	15154A
15189ASUB1	15154AA
15189A	15153AA
15191A	15151A
15191ASUB1	15152A
15192A	15151AA
15192ASUB1	15152AA
15236A	15236A
15237ASUB1	15236B
15237A	15237A
15249A	15249A
15250A	15249AA
15300A	15126AA
15321A	15119AA

MABPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
E 135-01	Bending MACHINE (HAND)	416	1
" 02	LARGE BAND SAWS		2
" 03	ROTEX PUNCH PRESS		1
" 04	DRILL (FLOOR MODEL)	1200-118	1
" 05	GRINDER FLOOR MODEL, (2WHEEL ELECT)		1
" 06	PRESS BRAKE (CHICAGO STIFFL CO.)	80823	1
" 07	POWER SQUARING MACHINE	002741	1
" 08	PRESS BRAKE	4560G	1
" 09	SMALL METAL SHEAR	241-C	1
" 10	SMALL DRILL PRESS		1
" 11	GRINDER 1WHEEL, (FLOOR MODEL)	WF6566	1
" 12	PUNCH PRESS	P41P	1
" 13	SANDER (BELT) FLOOR MOD.		1
" 15	BENDING MACHINE (HAND)	BB-316	1
" 16	DIMPLING MACHINE	AT25655	1
17	PORTABLE ELEVATOR	1518-R5	1
18	AIR HOIST 1 Ton	S2T18-205	1
19	AIR HOIST 1 Ton	S2T18-205	1
20	ELECTRONIC PROG	SQ 200	1
21	METAL FORMER	381D	1
22	METAL SHEAR (HAND)	107-12-78	1
23	SHRINKING/STRETCHING MACHINE	8028	1
24	ARBOR (HAND)	0685	1



MABFABEQ.PP  
REQ. MLW OC

TINKER, AFB OKLAHOMA CITY, OK.

4/28/1989  
RCC = MABFAB

EQUIP CODE	EQUIP DESCR	QUANT AVAIL		PREV FRQ S	MAINT TIME	UNSCHE D TBF	MTRR	%	ENVELOPE ALT	
		S1	S2						MIN	MAX
E135-01	BENDMACH	1	1	90	0.20			43		
E135-02	BAND SAW	1	1	120	0.50			43		
E135-02	BAND SAW				0.50			43		
E135-03	PUNCHPRES	1	1	90	1.50			43		
E135-03	PUNCHPRES				0.50			43		
E135-04	DRILL/FM	1	1	90	0.50			43		
E135-05	GRINDER/F	1	1	180	0.50			43		
E135-05	GRINDER/F				0.50			43		
E135-06	PRESSBRK	1	1	90	0.50			43		
E135-06	PRESSBRK				0.50			43		
E135-07	POWER SQ	1	1	60	0.30			43		
E135-07	POWER SQ				0.50			43		
E135-07	POWER SQ				1.00			43		
E135-07	POWER SQ				0.50			43		
E135-08	PRESSBRK	1	1	120	1.00			43		
E135-09	METALSHEA	1	1	90	0.20			43		
E135-10	SMDRILPRE	1	1	120	0.50			43		
E135-12	PUNCHPR/S	1	1	120	0.50			43		
E135-12	PUNCHPRES				0.20			43		
E135-13	SANDER/FM	1	1	90	1.00			43		
E135-15	BENDMACH	1	1	180	1.00			43		
E135-16	DIMPACH	1	1	90	0.20			43		
E135-16	DIMPACH				1.00			43		
E135-16	DIMPACH				0.50			43		
E135-17	PORTELEVA	1	1	30	0.50			43		
E135-17	PORTELEVA				1.00			43		
E135-17	PORTELEVA				1.50			43		
E135-18	AIRHOIST	1	1	1	0.10			43		
E135-19	AIRHOIST	1	1	1	0.10			43		
E135-20	ELEC PROG	1	1	365	1.00			43		
E135-21	METAL FOR	1	1	90	0.20			43		
E135-22	METALSHEA	1	1	90	0.20			43		
E135-23	SHRINKMAC	1	1	90	0.20			43		
E135-24	ARBOR	1	1	90	0.20			43		
F335-01	FILLEFLA	1	1	365	32.00			43		
F335-02	RUDDER	1	1	365	32.00			43		
FE3A-01	INBD FLAP	1	1	365	32.00			43		
FE3A-02	RL/H ELEV	1	1	365	32.00			43		
F135-01	RL/H ELEV	1	1	365	32.00			43		
F335-03	INBD AILE	3	3	365	32.00			43		
F335-04	OTBDMNFLA	1	1	365	32.00			43		

F335-05	DSPAIL	1	365	1	32.00
F335-07	WIND AILE	3	365	1	32.00
F335-08	OT MLG	4	365	1	32.00
F335-09	INBD MLG	4	365	1	32.00
F135-03	HOBNOSE	1	365	1	32.00
F135-04	OTBDENGSST	1	365	1	32.00
F135-05	INBDENGSST	1	365	1	32.00
F135-06	BOT/PANEL	1	365	1	32.00
F135-07	TAIL CONE	1	365	1	32.00
F135-08	KNEE FAIR	1	365	1	32.00
F135-09	BOMPODFAI	1	365	1	32.00
F135-10	N/WFAIRIN	1	365	1	32.00
F135-11	N/WFAIRIN	1	365	1	32.00
F135-12	N/WFAIRIN	1	365	1	32.00
F135-18	BOMTA/CON	3	365	1	32.00
FE3A-03	RHSIDECOW	1	365	1	32.00
FE3A-04	LHSIDECOW	1	365	1	32.00
F135-13	RHSIDECOW	2	365	1	56.00
F135-14	LHSIDECOW	2	365	1	56.00
F135-15	RHSIDECOW	1	365	1	32.00
F135-16	LHSIDECOW	1	365	1	32.00
FE3A-05	NOSE COWL	1	365	1	32.00
FE3A-06	NOSE COWL	1	365	1	32.00
F135-17	NOSE COWL	1	365	1	32.00
25	BENCH	10			
113	BENCH	16			
119	BENCH	4			
126	BENCH	4			
136	BENCH	4			
140	BENCH	5			
150	BENCH	16			
175	BENCH	3			
178	BENCH	5			
188153	BENCH	12			
188154	BENCH	6			
236	BENCH	4			
237	BENCH	1			
249	BENCH	5			

MABPABDA.PP  
REQ. MLW

OC

DISASSEMBLY/ASSEMBLY PROFILE  
TURNER, AFB OKLAHOMA CITY, OK.

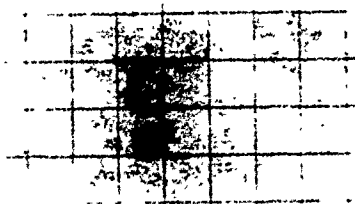
4/28/1989  
RCC = MABPAB

* * * TOP ASSEMBLY * * *	WCD	ITEM NUMBER	WDATE	REM	OPN	INS	OPN	ITEM NUMBER	SUBASSEMBLY	WCD	WDATE	ITEM NUMBER	WDATE	ITEM NUMBER
15188A	15153A	15188ASUB1	88055	20	310	310	15188ASUB1	15154A	15154A	88055	88055	15188ASUB1	88055	15188ASUB1
15189A	15153AA	15189ASUB1	88055	20	310	310	15189ASUB1	15154AA	15154AA	88055	88055	15189ASUB1	88055	15189ASUB1
15191A	15151A	15191ASUB1	88055	20	310	310	15191ASUB1	15152A	15152A	88055	88055	15191ASUB1	88055	15191ASUB1
15192A	15151AA	15192ASUB1	88055	20	310	310	15192ASUB1	15152AA	15152AA	88055	88055	15192ASUB1	88055	15192ASUB1
15236A	15236A	15237ASUB1	88055	50	290	290	15237ASUB1	15236B	15236B	88069	88069	15237ASUB1	88069	15237ASUB1



"SEE WCD / FLOW PROCESS

CHART DOCUMENTATION BOOK



# Power Plant

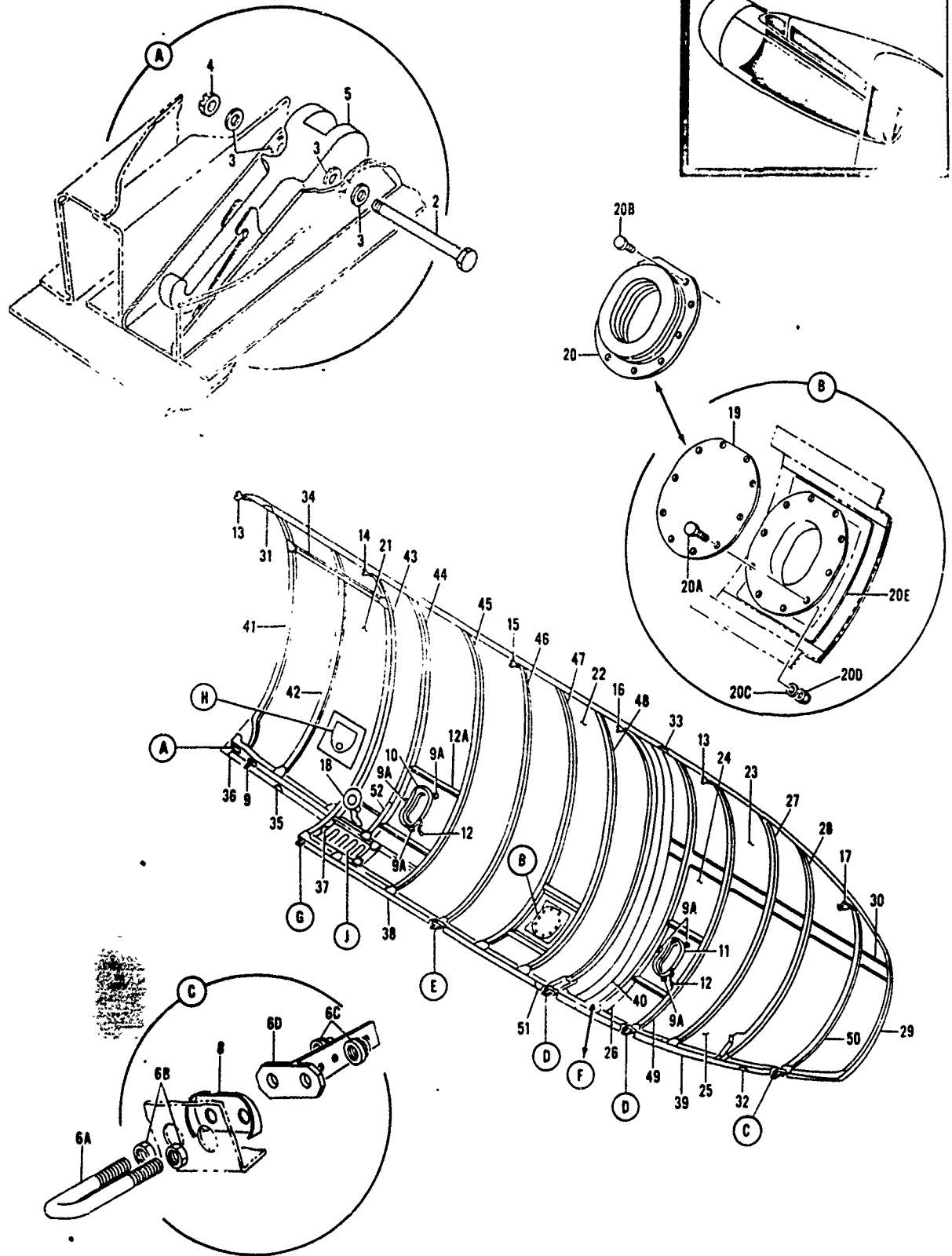


Figure 1102. Engine Nacelle Right-Hand Side Cowl Panel Assembly (Sheet 1 of 2)  
2-2890 Change 80

FLOW PROCESS CHART

MABPAB

SUBJECT SIDE COWL PANEL - RH

DATE 4/4/89

PCN: 15113A WCD: 15113A WCD DATE: 88054

CHART BEGINS OPERATION 10 Rec + UNCRATE

1 of 3

CHART ENDS " 940 CONDITION TAG PREPARED BY: R. Bolanos

+	SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
10	● ◊ D □ ▽	RECEIVE & UNCRATE 2122 MABPCD	210	REP. FRAME #4
	○ ◊ D □ ▽	DELAY	220	" " #5
	○ ◊ D □ ▽	MOVE TO WASH	230	" " #6
20	● ◊ D □ ▽	WASH MABPCA	240	" " #7
30	● ◊ D □ ▽	STRIP	250	" " #8
40	● ◊ D □ ▽	BLAST	260	" " #9
	○ ◊ D □ ▽	DELAY	270	" " #10
	○ ◊ D □ ▽	MOVE TO SHEET METAL 95 MABPAB	280	" " #11
	○ ◊ D □ ▽	DELAY	290	" " #12
50	○ ◊ D ■ ▽	VISUAL INSPECT	300	ASSEMBLE 60-4921 to 631
	○ ◊ D □ ▽	DELAY	310	REP FRAME #13
65	● ◊ D □ ▽	TEARDOWN DISASS	320	" #14
70	● ◊ D □ ▽	REMOVE CORROSION	330	" #15
	○ ◊ D □ ▽	MOVE TO WELDING 3001 MATP IW	340	REP. ANGLES
	○ ◊ D □ ▽	DELAY	350	BELLOW SEALS
75	● ◊ D □ ▽	WELD	360	" "
	○ ◊ D □ ▽	MOVE TO SHEET METAL 95 MABPAB	370	DRILL 1,2,3,4,5,
	○ ◊ D □ ▽	DELAY	380	REP. SKINS 1,2,3,4,5
80	● ◊ D □ ▽	ASSEMBLE DOUBLER & PLATE	390	PLACE COWLING ON FIXTURE
100	● ◊ D □ ▽	REPAIR LONGERONS 46 50% OF RIVETS	400	CLEAN & APPLY CORROSION PROTECTIVE
110	● ◊ D □ ▽	" " " 84 50% of RIVETS	410	REP. LONGERON 81
120	● ◊ D □ ▽	" " " 47 50% of RIVETS	420	REPAIR & ASSEMBLE #11 FRO
	● ◊ D □ ▽	ASSEMBLE 75 to 99	430	POSITION #12 FRAME
140	● ◊ D □ ▽	REPAIR LONGERONS 99	440	" #13 " ASSY. 2
150	● ◊ D □ ▽	ASSEMBLE 75 to 91	450	" #14 "
160	● ◊ D □ ▽	REPAIR LONGERON 91	455	" #15 "
170	● ◊ D □ ▽	" " " 62	460	REMOVE/REPLACE 15
180	● ◊ D □ ▽	" " " FRAME #1	470	Position #16
190	● ◊ D □ ▽	" " " #2	480	" #17
200	● ◊ D □ ▽	" " " #3		

STEP 90 DELETED ON WCD/08ASS

FLOW PROCESS CHART

MABPAB

SUBJECT SIDE COUL PANEL RH

DATE 4/4/89

PCN: 15113A WCD: 15113A WCDDATE: AB054

CHART BEGINS \_\_\_\_\_

2 of 3

CHART ENDS \_\_\_\_\_

PREPARED BY: R. Beldas

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
490 ● ◊ D □ ▽	POSITION # 18	650 ● ◊ D □ ▽	FINAL INSTALL #28 DOUBLER 100% OF RIVETS
500 ● ◊ D □ ▽	REMOVE + REPLACE #19	655 ● ◊ D □ ▽	" " 99 LONGERON
505 ● ◊ D □ ▽	POSITION #19	660 ● ◊ D □ ▽	FIN. INSTALL #88 DOUBLER
510 ● ◊ D □ ▽	POSITION # 20	665 ● ◊ D □ ▽	" 91
515 ● ◊ D □ ▽	" " 21	670 ● ◊ D □ ▽	" #62 LONGERON
520 ● ◊ D □ ▽	REM + REPLACE 21 of FRAME 39 ASSY	675 ● ◊ D □ ▽	" #2 FRAME
525 ● ◊ D □ ▽	POSITION #22	680 ● ◊ D □ ▽	" #3 FRAME
530 ● ◊ D □ ▽	#23	685 ● ◊ D □ ▽	" #4 FRAME
540 ● ◊ D □ ▽	# 24	690 ● ◊ D □ ▽	" #5 FRAME
545 ● ◊ D □ ▽	REMOVE/REPLACE #24	700 ● ◊ D □ ▽	" #6 FRAME
550 ● ◊ D □ ▽	# 25	705 ● ◊ D □ ▽	" #7 FRAME
560 ● ◊ D □ ▽	REPLACE # 1 SKIN	710 ● ◊ D □ ▽	" #8 FRAME
565 ● ◊ D □ ▽	" #2 SKIN	715 ● ◊ D □ ▽	" #9 FRAME
570 ● ◊ D □ ▽	" #3 SKIN	720 ● ◊ D □ ▽	" #10 "
575 ● ◊ D □ ▽	" #4 SKIN	725 ● ◊ D □ ▽	" #11 "
580 ● ◊ D □ ▽	" #5 SKIN	730 ● ◊ D □ ▽	" #12 "
585 ● ◊ D □ ▽	SPLICE # 26	735 ● ◊ D □ ▽	" #13 "
590 ● ◊ D □ ▽	BELLOWS	740 ● ◊ D □ ▽	" #14 "
595 ● ◊ D □ ▽	DOUBLER (REP/RPL)	745 ● ◊ D □ ▽	" #15 "
600 ● ◊ D □ ▽	LOUVER	750 ● ◊ D □ ▽	REP/RPL FIREDOOR PAN 53
605 ● ◊ D □ ▽	STARTER CARTRIDGE DOOR (REPAIR/REPLACE)	755 ● ◊ D □ ▽	INS. ALL FIRE EXTINGUISHER DOOR
610 ● ◊ D □ ▽	REPLACE T ANGLES	760 ● ◊ D □ ▽	R/R FIREDOOR PAN 52
615 ● ◊ D □ ▽	REMOVE COUL FROM FIXTURE	765 ● ◊ D □ ▽	INSTALL FIRE EXTINGUISHER DOOR
620 ● ◊ D □ ▽	FINAL ASSEMBLY (NO TIME USE)	767 ○ ◊ D □ ▽	INSPECT
625 ● ◊ D □ ▽	INSTALL LONGERON #1 100% of RIVETS	770 ● ◊ D □ ▽	R/R SPRING CLIPS
630 ● ◊ D □ ▽	" " 37	775 ● ◊ D □ ▽	INSTALL VENT ASSY
635 ● ◊ D □ ▽	" " 48	780 ● ◊ D □ ▽	INSTALL C/E SPEED DRIVER
640 ● ◊ D □ ▽	" " 34	785 ● ◊ D □ ▽	INSTALL STARTER CARTRIDGE
645 ● ◊ D □ ▽	" " 47	790 ● ◊ D □ ▽	INSTALL STAINLESS STEEL PLATES

FLOW PROCESS CHART

SUBJECT SIDE COWL PANEL R H

DATE 4/4/68

PCN: 15113A WCD: 15113A WCD DATE: 88055

CHART BEGINS \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: R. Bolanos 3 of

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
775 ● ◊ D □ ▽	INSTALL CAP COVER	940 ● ◊ D □ ▽	COMPLETE CONSTRUCTION
800 ● ◊ D □ ▽	INSTALL DRAIN CAP	○ ◊ D □ ▽	TRG
805 ● ◊ D □ ▽	INSTALL 3umpers	○ ◊ D □ ▽	
810 ● ◊ D □ ▽	" OIL BREATHER	○ ◊ D □ ▽	
815 ● ◊ D □ ▽	" PLATE 56	○ ◊ D □ ▽	
820 ● ◊ D □ ▽	" " 72	○ ◊ D □ ▽	
825 ● ◊ D □ ▽	" SKIN #1	○ ◊ D □ ▽	
830 ● ◊ D □ ▽	" " 2	○ ◊ D □ ▽	
835 ● ◊ D □ ▽	" " 3	○ ◊ D □ ▽	
840 ● ◊ D □ ▽	" " 4	○ ◊ D □ ▽	
845 ● ◊ D □ ▽	" " 5	○ ◊ D □ ▽	
850 ● ◊ D □ ▽	" LACHES	○ ◊ D □ ▽	
855 ● ◊ D □ ▽	" HINGES #1 HOOK	○ ◊ D □ ▽	
860 ● ◊ D □ ▽	" " #2 "	○ ◊ D □ ▽	
865 ● ◊ D □ ▽	" " #3 "	○ ◊ D □ ▽	
870 ● ◊ D □ ▽	" " #4 "	○ ◊ D □ ▽	
875 ● ◊ D □ ▽	" " #5 "	○ ◊ D □ ▽	
880 ● ◊ D □ ▽	" " SPEAR	○ ◊ D □ ▽	
890 ● ◊ D □ ▽	DRILL ALL DRAIN HOLE	○ ◊ D □ ▽	
895 ● ◊ D □ ▽	INSTALL CLIPS AS REQ	○ ◊ D □ ▽	
900 ● ◊ D □ ▽	INSPECT COWLING	○ ◊ D □ ▽	
905 ● ◊ D □ ▽	SHAVE ALL HIGH RIVETS	○ ◊ D □ ▽	
910 ○ ◊ D □ ▽	INSPECT COWLING ALIGNMENT ON FIXTURE	○ ◊ D □ ▽	
915 ● ◊ D □ ▽	TRIM SKIN	○ ◊ D □ ▽	
920 ● ◊ D □ ▽	INSTALL ALIGNMENT PLATES & PINS	○ ◊ D □ ▽	
○ ● D □ ▽	MOVE TO PAINT 2280 MABPCB	○ ◊ D □ ▽	
930 ● ◊ D □ ▽	FINAL WASH & TREAT FOR CORROSION	○ ◊ D □ ▽	
935 ● ◊ D □ ▽	PAINT INTERIOR/EXT. INSTALL STANCHIONS	○ ◊ D □ ▽	
○ ● D □ ▽	MOVE TO SHEET METAL 95 MABPOB	○ ◊ D □ ▽	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSY							
			1	2	3	4	5	6	7	
1101-	<b>5-85637</b> -15025A	PANEL ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE (FOR. . . NHA SEE FIG. 1100)							REF	A
	35-32371-1	PANEL ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE (FOR. . . NHA SEE FIG. 1100)							REF	A
1	99836	. PIN, COWL FASTNR (61864) (BACP18A5) . . . . .							1	A
2	98265-2-.170	. STUD, COWL FASTNR (61864) (BACS21B5FH17) . . . . .							1	A
3	99947P.130	. SPRING, COWL FASTNR, FLTG (61864) (BACS20A5P) . . . . .							1	A
4	MS20253-2-475	. PIN . . . . .							1	A
5	5-85637-114	. HINGE, CONTINUOUS HALF, LEFT HAND SIDE COWL, ENGINE NACELLE (ALTERED FROM MS20257H5-550)							1	A
6	5-85637-115	. HINGE, CONTINUOUS HALF, LEFT HAND SIDE COWL, ENGINE NACELLE (ALTERED FROM MS20257H5-600)							1	A
7	5-85637-112	. DOOR ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE							1	A
8	90-7988	. SEAL, MOLDED RUBBER, ENGINE OIL TANK OIL SCUPPER. . . . . (SPEC MIL-R-6855 CLASS I GRADE 40, 40 DUROMETER)							1	A
8A	5-85637-82	. DUCT ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE							1	A
9	NAS1103-23W	. BOLT (FOR REPLACEMENT ORDER NAS1103-23) . . . . .							1	A
10	NAS1103-24W	. BOLT (FOR REPLACEMENT ORDER NAS1103-24) . . . . .							1	A
11	NAS1103-22W	. BOLT (FOR REPLACEMENT ORDER NAS1103-22) . . . . .							3	A
12	NAS1103-21W	. BOLT (FOR REPLACEMENT ORDER NAS1103-21) . . . . .							1	A
13	AN960D10L	. WASHER. . . . .							24	A
14	AN320-3	. NUT . . . . .							6	A
15	H28-3	. LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . . (83014) (ALTERNATE 24L1-3 (71286)) (BOEING SPEC 10-2731-4)							1	A
16	H28-2	. LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . . (83014) (ALTERNATE 24L1-2 (71286)) (BOEING SPEC 10-2731-2)							2	A
17	H28-1	. LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . . (83014) (ALTERNATE 24L1 (71286)) (BOEING SPEC 10-2731-1)							2	A
18	H40-1	. LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . . (83014) (ALTERNATE 26L1 (71286)) (BOEING SPEC 10-2731-3)							1	A
19	60-4019	. PIN, SHEAR, ENGINE NACELLE COWL PANEL (WHEN EXHAUSTED . USE 66-4025)							1	A
19	66-4025	. PIN, SHEAR, ENGINE NACELLE COWL PANEL . . . . . (ATTACHING PARTS)							1	A
	NAS679A4W	. NUT . . . . .							1	A
20	3-74649	. PIN, SHEAR, COWL. . . . .							2	A
20A	3-74649	. PIN, SHEAR, COWL. . . . .							2	A
20B	66-18062-1	. PIN, ALIGNING, ENGINE NACELLE COWL PANEL. . . . . (ATTACHING PARTS)							2	A
	AN960D416	. WASHER. . . . .							4	A
	NAS679A4W	. NUT . . . . .							4	A
21	5-96762	. HOOK, HINGE, NACELLE COWLING. . . . .							2	A
22	5-96766	. HOOK, HINGE, NACELLE COWLING. . . . .							1	A
23	5-96766-1	. HOOK, HINGE, NACELLE COWLING. . . . .							1	A
24	5-96766-2	. HOOK, HINGE, NACELLE COWLING. . . . . (ATTACHING PARTS)							1	A
	AN5-10A	. BOLT (ALTERNATE BACB30NE5-9). . . . .							4	A
	NAS1105-9W	. BOLT (ALTERNATE NAS1105-9). . . . .							1	A
	AN960-516L	. WASHER. . . . .							10	A
	MS21042L5	. NUT (REPLACES NAS679A5) . . . . .							5	A
	AN3-7A	. BOLT (FOR REPLACEMENT ORDER BACB30NF3-8). . . . .							5	A
	AN960-10L	. WASHER. . . . .							5	A
	NAS679A3W	. NUT . . . . .							5	A
24A	AN7510F2	. NAMEPLATE . . . . .							1	A
25	5-96719	. HINGE, SPEAR, ENGINE NACELLE COWL PANEL (FOR I/W INFO . SEE 5-96719-2)							1	A
25	5-96719-2	. HINGE SPEAR, ENGINE NACELLE COWL PANEL. . . . . (ATTACHING PARTS)							1	A
	AN4-10A	. BOLT (ALTERNATE BACB30NE4-9). . . . .							1	A
	AN960-416	. WASHER. . . . .							1	A
	AN960-416L	. WASHER. . . . .							1	A
	MS21042-4	. NUT (REPLACES AN363-428). . . . .							1	A
	AN3-7A	. BOLT (FOR REPLACEMENT ORDER BACB30NF3-8). . . . .							1	A
	AN960-10	. WASHER. . . . .							1	A
	AN960-10L	. WASHER. . . . .							1	A
	NAS679A3W	. NUT . . . . .							1	A

### Power Plant

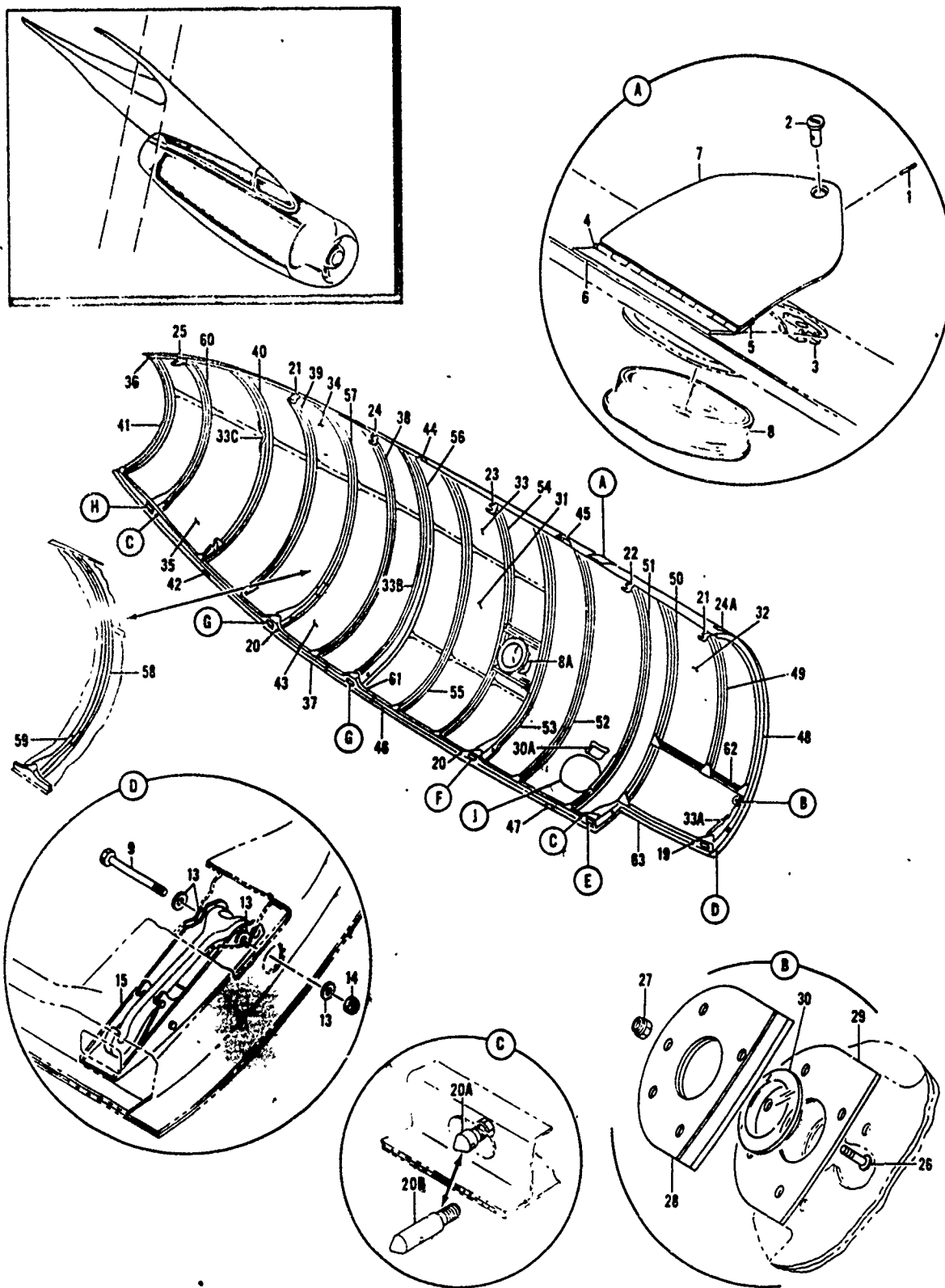


Figure 1101. Engine Nacelle Left Hand Side Cowling Panel Assembly (Sheet 1 of 2)

### Power Plant

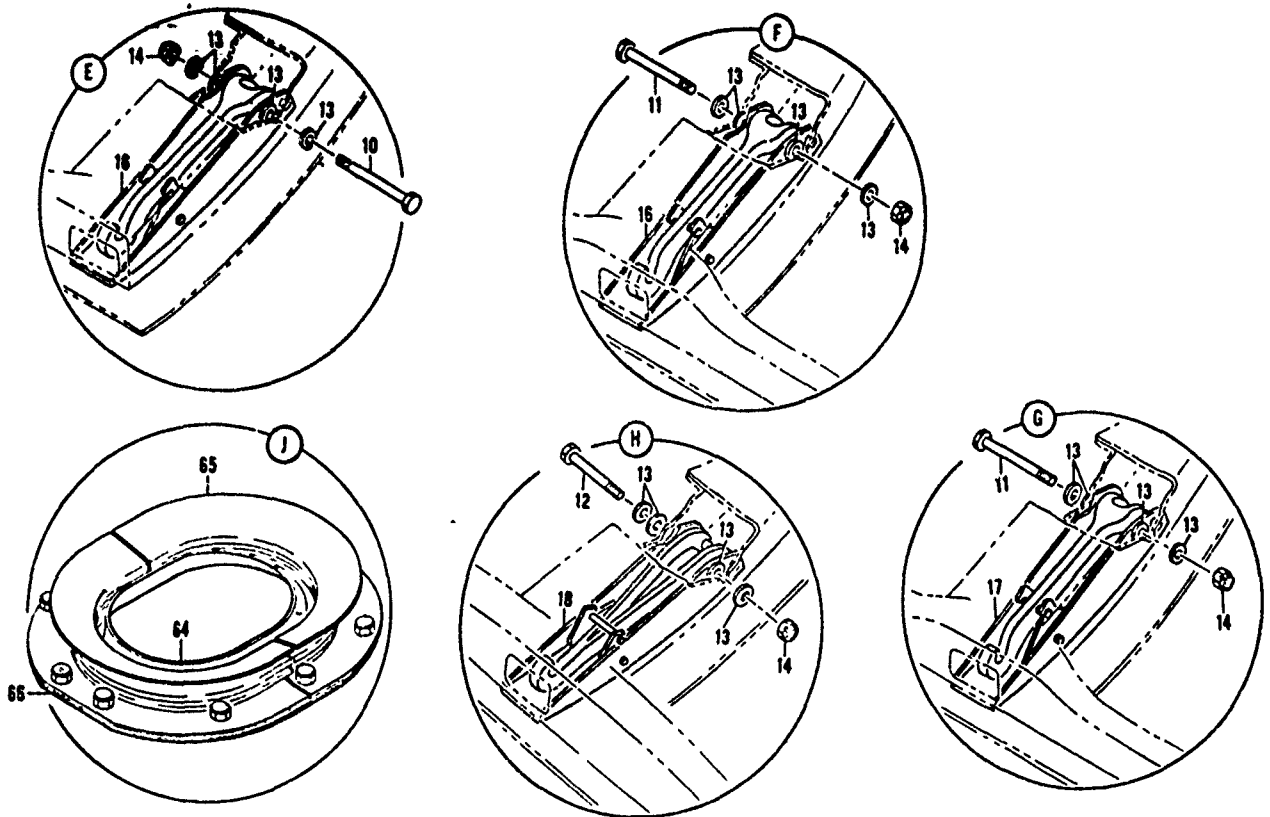


Figure 1101. Engine Nacelle Left Hand Side Cowl Panel Assembly (Sheet 2 of 2)

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
1101-										
26	NAS514P1032-8	.	.	.	.	.	.	.	5	A
27	NAS679A3W	.	.	.	.	.	.	.	5	A
28	5-85637-126	.	.	.	.	.	.	.	1	A
29	5-85637-128	.	.	.	.	.	.	.	1	A
30	66-3355	.	.	.	.	.	.	.	1	A
30A	BACH10L1DWY	.	.	.	.	.	.	.	1	B
31	5-85637-6	.	.	.	.	.	.	.	1	A
32	5-85637-1	.	.	.	.	.	.	.	1	A
33	5-85637-2	.	.	.	.	.	.	.	1	A
33A	5-85637-120	.	.	.	.	.	.	.	1	A
33B	5-85637-91	.	.	.	.	.	.	.	1	A
33C	60-4921	.	.	.	.	.	.	.	1	A
	5-85637-68	.	.	.	.	.	.	.	1	A
	5-85637-136	.	.	.	.	.	.	.	1	A
34	5-85637-4	.	.	.	.	.	.	.	1	A
35	5-85637-5	.	.	.	.	.	.	.	1	A



FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	5	6	7			
1101-										
36	5-85637-8	. .	LONGERON, UPPER AFT, LEFT HAND SIDE COWL PANEL, . . .					1	A	
			ENGINE NACELLE							
37	5-85637-10	. .	LONGERON, LOWER AFT, LEFT HAND SIDE COWL PANEL, . . .					1	A	
			ENGINE NACELLE							
38	5-85637-20	. .	FRAME, PANEL STATION 180.00, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							
39	5-85637-22	. .	FRAME, PANEL STATION 200.00, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							
40	5-85637-23	. .	FRAME, PANEL STATION 210.00, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							
41	5-85637-25	. .	FRAME, PANEL STATION 235.00, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							
42	5-85637-37	. .	DOUBLER, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .					1	A	
43	5-85637-3	. .	SKIN, LOWER AFT, LEFT HAND SIDE COWL PANEL, ENGINE. . .					1	A	
			NACELLE							
	5-85637-98	. .	LONGERON ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . .					1	A	
			NACELLE							
44	5-85637-7	. .	LONGERON, UPPER FORWARD, LEFT HAND SIDE COWL PANEL, .					1	A	
			ENGINE NACELLE							
45	5-85637-27	. .	DOUBLER, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .					1	A	
	5-85637-100	. .	LONGERON ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . .					1	A	
			NACELLE							
46	5-85637-9	. .	LONGERON, LOWER FORWARD, LEFT HAND SIDE COWL PANEL. .					1	A	
			ENGINE NACELLE							
47	5-85637-33	. .	DOUBLER, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .					1	A	
	5-85637-59	. .	FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .					1	A	
			NACELLE							
48	5-85637-11	. .	FRAME, PANEL STATION 89.50, LEFT HAND SIDE COWL, . . .					1	A	
			ENGINE NACELLE							
49	5-85637-12	. .	FRAME, PANEL STATION 100.43, LEFT HAND SIDE COWL, . . .					1	A	
			ENGINE NACELLE							
	5-85637-60	. .	FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .					1	A	
			NACELLE							
50	5-85637-13	. .	FRAME, PANEL STATION 112.50, LEFT HAND SIDE COWL. . .					1	A	
			ENGINE NACELLE							
	5-85637-81	. .	FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .					1	A	
			NACELLE							
51	5-85637-14	. .	FRAME, PANEL STATION 120.00, LEFT HAND SIDE COWL. . .					1	A	
			ENGINE NACELLE							
52	5-85637-15	. .	FRAME, PANEL STATION 131.50, LEFT HAND SIDE COWL. . . .					1	A	
			ENGINE NACELLE							
	5-85637-61	. .	FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .					1	A	
			NACELLE							
53	5-85637-16	. .	FRAME, PANEL STATION 142.80, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							
54	5-85637-17	. .	FRAME, PANEL STATION 152.75, LEFT HAND SIDE COWL, . . .					1	A	
			ENGINE NACELLE							
55	5-85637-18	. .	FRAME, PANEL STATION 161.50, LEFT HAND SIDE COWL, . . .					1	A	
			ENGINE NACELLE							
	5-85637-62	. .	FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .					1	A	
			NACELLE							
56	5-85637-19	. .	FRAME, PANEL STATION 171.20, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							
	5-85637-63	. .	FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .					1	A	
			NACELLE							
57	5-87637-21	. .	FRAME PANEL STATION 190.00 LEFT HAND SIDE COWL, . . .					1	A	
			ENGINE NACELLE							
58	5-85637-81	. .	FRAME, PANEL STATION 190.00, LEFT HAND SIDE COWL, . .					1	A	
			ENGINE NACELLE							

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON COU
1101-59	5-85637-815	. . FRAME, PANEL STATION 190.00, LEFT HAND SIDE COWL, . . ENGINE NACELLE								1	A
	5-85637-64	. FRAME ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE . . . . (WHEN EXHAUSTED USE 5-85637-137)								1	A
	5-85637-137	. FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . . . NACELLE								1	A
60	5-85637-134	. . FRAME, PANEL STATION 225.00, LEFT HAND SIDE COWL, . . ENGINE NACELLE								1	A
	5-85637-113	. SEGMENT ASSY, LONGERON, LEFT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
61	5-85637-32	. . SEGMENT, LONGERON, LEFT HAND SIDE COWL PANEL, . . . . ENGINE NACELLE								1	A
62	5-85637-89	. LONGERON, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE. .								1	A
	5-85637-99	. LONGERON ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . . . NACELLE								1	A
63	5-85637-88	. . LONGERON, PANEL, LEFT HAND SIDE COWL, ENGINE. . . . . NACELLE								1	A
64	90-3343-2	. DUCT, FUEL AIR STARTER EXHAUST. . . . . (ATTACHING PARTS)								1	A
	NAS514P1032-6	. SCREW . . . . .								10	A
	MS21042L3	. NUT . . . . .								10	A
65	1200874-10	. SEAL ASSY, FUEL AIR STARTER EXHAUST BELLOWS (98769) . . (BAC SPEC NO. 10-2748-11) (OPTIONAL 65-32834-1)								1	A
66	69-22576-1	. SEAL, STARTER EXHAUST EXIT GASKET . . . . .								1	A
		A 2201 THRU 2299, 3001 THRU 3015 B 2201 THRU 2299									
		ALSO SEE FIGURE 1132									

FLOW PROCESS CHART

SUBJECT Left Hand Side Cowl

DATE 4/4/89

PCN: 15025A WCD: 15025A WCDDATE: 88054

CHART BEGINS Operation 10

CHART ENDS operation 990

PREPARED BY: Tim Hall

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
010 ● ◊ □ ▽	Receive and Unload 2122 MABPDA	250 ● ◊ □ ▽	Repair or replace Frame # 15
○ ◊ □ ▽	Delay	260 ● ◊ □ ▽	Replace clips as required
○ ◊ □ ▽	Move to MABPCA	○ ◊ □ ▽	Delay
○ ◊ □ ▽	2122 MABPCA	○ ◊ □ ▽	Move to 3001
○ ◊ □ ▽	Delay	○ ◊ □ ▽	3001 MATPIW
020 ● ◊ □ ▽	Wash interior & exterior	○ ◊ □ ▽	Delay
030 ● ◊ □ ▽	Strip all paint	○ ◊ □ ▽	Weld as required
040 ● ◊ □ ▽	Abrasive blast	○ ◊ □ ▽	Delay
○ ◊ □ ▽	Delay	○ ◊ □ ▽	Move to Bldg 95
○ ◊ □ ▽	Move to Bldg 95	○ ◊ □ ▽	95 MABPAB
○ ◊ □ ▽	Delay	○ ◊ □ ▽	Delay
050 ○ ◊ □ ▽	Visual inspection	280 ● ◊ □ ▽	Repair or replace Longeron (-8)
065 ● ◊ □ ▽	Teardown	290 ● ◊ □ ▽	Install Spring Clip 60-2966-40
070 ● ◊ □ ▽	Remove & Treat Corrosion	300 ● ◊ □ ▽	Repair or replace Longeron
080 ● ◊ □ ▽	Remove Hooks & Latches	310 ● ◊ □ ▽	Install Hooks
090 ● ◊ □ ▽	Remove Fuel Starter Exhaust Assy	320 ● ◊ □ ▽	Replace sc91
100 ● ◊ □ ▽	Repair or replace Frame # 2	330 ● ◊ □ ▽	Replace Door Frame (-11)
110 ● ◊ □ ▽	Repair or replace Longeron	340 ● ◊ □ ▽	Repair door assy -112
120 ● ◊ □ ▽	Repair or replace Frame # 3	345 ● ◊ □ ▽	Repair Longeron -10
130 ● ◊ □ ▽	Repair or replace Frame # 4	350 ● ◊ □ ▽	Repair or replace Longeron (-113)
140 ● ◊ □ ▽	Repair or replace Frame # 5	360 ● ◊ □ ▽	Repair or replace Longeron (-100)
150 ● ◊ □ ▽	Repair or replace Frame # 6	370 ● ◊ □ ▽	Repair or replace latches
160 ● ◊ □ ▽	Repair or replace Frame # 7	380 ● ◊ □ ▽	Install Pin plates
170 ● ◊ □ ▽	Repair or replace Frame # 8	390 ● ◊ □ ▽	Remove steel mounting plate (-77)
180 ● ◊ □ ▽	" " " "	400 ● ◊ □ ▽	Repair or replace duct
190 ● ◊ □ ▽	Firewall Assy	410 ● ◊ □ ▽	Replace basket
200 ● ◊ □ ▽	Fireseal	420 ● ◊ □ ▽	Replace seal bellows
210 ● ◊ □ ▽	" " " "	430 ● ◊ □ ▽	Replace vent
220 ● ◊ □ ▽	Frame # 10	440 ● ◊ □ ▽	Replace duct assy
230 ● ◊ □ ▽	Frame # 11	450 ● ◊ □ ▽	Remove # 1 Frame
240 ● ◊ □ ▽	Frame # 12	460 ● ◊ □ ▽	Replace Longeron -99
250 ● ◊ □ ▽	Frame # 13	470 ● ◊ □ ▽	Drill skins out as required
260 ● ◊ □ ▽	Frame # 14		

12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/ROC 15. DATE SCHD 16. DATE COMP  
 15025A | | MBPAB | 89093 |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 35-32371-1 | | | SOW-OC1560FL-82-174  
 | | | DRUG 5-85637  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | T.O. 1-1A 1  
 135 | 1560005205602FL | T.O. 1-1-2  
 | | | T.O. 1C-135(K)A-3-4  
 13. MISC 14. NOUN/END ITEM NOUN | T.O. 1C-135(K)A-3-4  
 | | LEFT HAND SIDE COWL |  
 | | LARRY MULLINAX/MABLBS/65268

15. DISP 16. PDN/STATION/IDP NO. 17. WORK TO BE ACCOMPLISHED 18. METHOD 19. POSITION

2122	010	RECEIVE AND UNCRATE SIDE COWL. NOTE:			
	MBPAB	OBSERVE CAUTION THAT SIDE COWL IS NOT DAMAGED DURING UNCRATING.			
2122	020	WASH INTERIOR AND EXTERIOR PAINT			
	MBPCA	T.O. 1C-135(K)A-3-4 PARA 11-7 AND SOW OC1560-82-174.			
2122	030	STRIP ALL INTERIOR AND EXTERIOR PAINT FROM SIDE COWL PAINT			
	MBPCA	T.O. 1C-135(K)A-3-4 PARA 11-15 & SOW OC1560-82-174.			
2122	040	ABRASIVE BLAST SIDE COWL PAINT T.O. 1C-135(K)A-3-4 SECT 9 AND T.O. 1-1-2.			
95	050	ACCOMPLISH VISUAL INSPECTION PAINT			
	MBPAB	SOW 82-174			
95	065	TEARDOWN			
	MBPAB	NOTE: DEPOT OVERHAUL OF J-57 LEFT HAND SIDE COWL WILL BE DONE IN ACCORDANCE WITH INSTRUCTIONS CONTAINED IN SOW OC1560-82-174 AND 1C-135(K)A-3-4.			
95	070	REMOVE CORROSION AND APPLY CORROSION PROTECTIVE FINISH TO ALL REWORKED SURFACES PAINT T.O. 1C-135(K)A-3-4 AND T.O. 1-1-2			
95	080	REMOVE HOOKS AND LATCHES			
	MBPAB	REQ'D _____ NOT REQ'D _____			
95	090	REMOVE FUEL STARTER EXHAUST ASSY			
	MBPAB	P/N 90-3343-2 REQ'D _____ NOT REQ'D _____			
95	100	FRAME #2 (-12)			
	MBPAB	REPAIR _____ REPLACE _____ NOT REQ'D _____			
95	110	LONGERON (-89)			
	MBPAB	REPAIR _____ REPLACE _____ NOT REQ'D _____			

FLOW PROCESS CHART

SUBJECT Left Hand Side Cowling

DATE 4/4/89

PCN: 1502 SA WCD: 1502 SA WCD DATE: 89081

CHART BEGINS \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: Tim Hall

770 'step deleted'

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
480 ● ◊ ◊ ◊ ▽	Place Cowling in Fixture	760 ● ◊ ◊ ◊ ▽	Attach (-99) longeron to angle of -59 & -60 Frames
490 ● ◊ ◊ ◊ ▽	Replace -99 Longeron	780 ● ◊ ◊ ◊ ▽	Install tabs at end of -100 & -99 longerons
500 ● ◊ ◊ ◊ ▽	Replace #1 Frame, doubler and Hatch Hook	790 ● ◊ ◊ ◊ ▽	Install -825 glide plate to -60 frame
510 ● ◊ ◊ ◊ ▽	Attach -99 longeron to -60 frame	800 ● ◊ ◊ ◊ ▽	Install alignment pins & plates in longerons
520 ● ◊ ◊ ◊ ▽	Repair or replace #1 Hatch	810 ● ◊ ◊ ◊ ▽	Drill rivet patterns in new longerons
521 ● ◊ ◊ ◊ ▽	Replace #1 Hook S-96762	820 ● ◊ ◊ ◊ ▽	Double countersink & install rivets in longerons
530 ● ◊ ◊ ◊ ▽	Replace Hinge Spool S-96719	830 ● ◊ ◊ ◊ ▽	Install tabs at end of -98 longerons
540 ● ◊ ◊ ◊ ▽	Tack Doublers to Longerons	840 ● ◊ ◊ ◊ ▽	Find excess rivet butts on interior of longerons + -58f
550 ● ◊ ◊ ◊ ▽	Locate & tack Fuel air exhaust 983v	850 ● ◊ ◊ ◊ ▽	Install rivets & spacers aft end of longeron
560 ● ◊ ◊ ◊ ▽	Tack -111 duct frame in place	860 ● ◊ ◊ ◊ ▽	Countersink & install rivets in all new skins
570 ● ◊ ◊ ◊ ▽	Remove & replace -1 skin	930 ● ◊ ◊ ◊ ▽	Install bumpers, aft side of -25 frame
580 ● ◊ ◊ ◊ ▽	Trim -1 skin	940 ● ◊ ◊ ◊ ▽	Inspect cowling
590 ● ◊ ◊ ◊ ▽	Remove & replace -6 skin	950 ● ◊ ◊ ◊ ▽	Shave all high rivets in skins
600 ● ◊ ◊ ◊ ▽	Remove & replace -2 skin	960 ● ◊ ◊ ◊ ▽	Place cowling in alignment fixture
610 ● ◊ ◊ ◊ ▽	Remove & replace Vent Louver	○ ◊ ◊ ◊ ▽	Delay
620 ● ◊ ◊ ◊ ▽	Remove & replace -810 Doubler	○ ◊ ◊ ◊ ▽	Move to Bldg 2280 2280 MABPAB
630 ● ◊ ◊ ◊ ▽	Remove & replace -4 skin	○ ◊ ◊ ◊ ▽	Delay
640 ● ◊ ◊ ◊ ▽	Remove & replace -3 skin	970 ● ◊ ◊ ◊ ▽	Final Wash and Treat for corrosion
650 ● ◊ ◊ ◊ ▽	Remove & replace -5 skin	980 ● ◊ ◊ ◊ ▽	Paint interior & exterior
660 ● ◊ ◊ ◊ ▽	Shove rivets in -59, -60, -61, -62, -63, -24 Frame	○ ◊ ◊ ◊ ▽	Delay
670 ● ◊ ◊ ◊ ▽	Treat corrosion	○ ◊ ◊ ◊ ▽	Move to MABPAB 95 MABPAB
680 ● ◊ ◊ ◊ ▽	Drill drain holes in cowling	○ ◊ ◊ ◊ ▽	Delay
690 ● ◊ ◊ ◊ ▽	Drill alignment pin holes	990 ● ◊ ◊ ◊ ▽	Condition T92
700 ● ◊ ◊ ◊ ▽	Remove cowling from fixture	○ ◊ ◊ ◊ ▽	
710 ● ◊ ◊ ◊ ▽	Trim all skins	○ ◊ ◊ ◊ ▽	
720 ● ◊ ◊ ◊ ▽	Drill Rivet Pattern in new longeron	○ ◊ ◊ ◊ ▽	
730 ● ◊ ◊ ◊ ▽	Install Doubler & Mill Rivet Pattern in -99 longerons	○ ◊ ◊ ◊ ▽	
740 ● ◊ ◊ ◊ ▽	Install clips @ latch openings	○ ◊ ◊ ◊ ▽	
750 ● ◊ ◊ ◊ ▽	Attach clip to frame (-57)	○ ◊ ◊ ◊ ▽	

710 N/A (Final)

*****							
15025A * WORK CONTROL DOCUMENT * MISTR 1. DATE 88054 PAGE 2 OF 7 PAGES							
15. DISP-16. PDM/							
STATION	OP NO.	17. WORK TO BE ACCOMPLISHED			18. MECH	19. P	20. R
95	120	FRAME #3 (-60)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	130	FRAME #4 (-81)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	140	FRAME #5 (-15)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	150	FRAME #6 (-16)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	160	FRAME #7 (-17)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	170	FRAME #8 (-18)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	180	FIREWALL ASSEMBLY (-62)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	190	FTRESEAL (-91)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	200	FRAME #10 (-20)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	210	FRAME #11 (-63)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	220	FRAME #12 (-22)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	230	FRAME #13 (-23)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	240	FRAME #14			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	250	FRAME #15			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	260	REPLACE CLIPS AS REQUIRED			/	/	
	MBPAB						
3001	270	WELD AS REQUIRED. REF T.O. 1-1A-1			/	/	
	MTPIW	REQ'D	NOT REQ'D				
		WELDING DONE AT POST K-73.					
95	280	LONGERON (-8)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			
95	290	INSTALL SPRING CLIP P/N 60-2366-4			/	/	
	MBPAB	REQ'D	NOT REQ'D				
95	300	LONGERON (-98)			/	/	
	MBPAB	REPAIR	REPLACE	NOT REQ'D			

95	310	INSTALL HOOKS		/	/
	MBPAB	#2 5-96762 REQ'D NOT REQ'D			
		#3 5-96766-1 REQ'D NOT REQ'D			
		#4 5-96766-2 REQ'D NOT REQ'D			
		#5 5-96762 REQ'D NOT REQ'D			
		#6 SPEAR 5-96719			
		REQ'D NOT REQ'D			
95	320	SEAL, 90-7988		/	
	MBPAB	REPLACE NOT REQ'D			
95	330	DOOR FRAME (-111)		/	
	MBPAB	REPLACE NOT REQ'D			
95	340	DOOR ASSEMBLY (-112)		/	/
	MBPAB	REPAIR REPLACE NOT REQ'D			
95	345	LONGERON (-10)		/	/
	MBPAB	REPAIR REPLACE NOT REQ'D			
95	350	LONGERON (-113)		/	/
	MBPAB	REPAIR REPLACE NOT REQ'D			
95	360	LONGERON (-100)		/	
	MBPAB	REPAIR REPLACE NOT REQ'D			
95	370	INSTALL LATCHES		/	/
	MBPAB	#2 H-28-2			
		REPAIR REPLACE NOT REQ'D			
		#3 H-28-2			
		REPAIR REPLACE NOT REQ'D			
		#4 H-28-1			
		REPAIR REPLACE NOT REQ'D			
		#5 H-28-1			
		REPAIR REPLACE NOT REQ'D			
		#6 H-40-1			
		REPAIR REPLACE NOT REQ'D			
95	380	INSTALL PIN PLATES		/	/
	MBPAB	REQ'D NOT REQ'D			
95	390	REMOVE STEEL MOUNTING PLATE (-77)		/	/
	MBPAB	REQ'D NOT REQ'D			
95	400	DUCT, 90-3343-2		/	/
	MBPAB	REPAIR REPLACE NOT REQ'D			
95	410	GASKET, 69-22576-1		/	/
	MBPAB	REPLACE NOT REQ'D			

*****				
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15.DISP-10.PDN/				
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED				
95	420	SEAL BELLOWS, 1200874-10		
	MBPAB	REPLACE _____ NOT REQ'D _____	/	/
95	430	VENT, 50-6213-1		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	440	DUCT ASSEMBLY, (-82)		
	MBPAB	REPLACE _____ NOT REQ'D _____	/	/
95	450	REMOVE #1 FRAME (-59)		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	460	LONGERON (-99)		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	470	DRILL SKIPS - 30, AS REQUIRED		
	MBPAB	#1 REQ'D _____ NOT REQ'D _____	/	/
		#2 REQ'D _____ NOT REQ'D _____		
		#3 REQ'D _____ NOT REQ'D _____		
		#4 REQ'D _____ NOT REQ'D _____		
		#5 REQ'D _____ NOT REQ'D _____		
		#6 REQ'D _____ NOT REQ'D _____		
95	480	FIXTURE		
	MBPAB	PLACE COWLING IN FIXTURE	/	/
95	490	REPLACE (-99) LONGERON		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	500	REPLACE #1 FRAME (-59), (-92)		
	MBPAB	DOUBLER & #1 LATCH & HOOK	/	/
		REQ'D _____ NOT REQ'D _____		
95	510	ATTACH (-89) LONGERON TO (-60) FRAME		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	520	#1 LATCH H-28-3		
	MBPAB	REPAIR _____ REPLACE _____ NOT REQ'D _____	/	/
95	521	#1 HOOK 5-96762		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	530	REPLACE HINGE SPEAR 5-96719		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	540	TACK DOUBLERS TO LONGERONS		
	MBPAB	REQ'D _____ NOT REQ'D _____	/	/
95	550	LOCATE & TACK FUEL AIR EXHAUST		
	MBPAB	ASSEMBLY IN PLACE	/	/
		REQ'D _____ NOT REQ'D _____		



STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH 19"R" 120"R

95	560	TACK (-111) DOOR FRAME IN PLACE MBFAB REQ'D NOT REQ'D	E	/
95	570	REMOVE AND REPLACE (-1) SKIN MBFAB REQ'D NOT REQ'D	E	/
95	580	TRIM (-1) SKIN IAW 50W 82 1/4 MBFAB REQ'D NOT REQ'D	E	/
95	590	REMOVE & REPLACE (-2) SKIN MBFAB REQ'D NOT REQ'D	/	/
95	600	REMOVE & REPLACE (-1) SKIN MBFAB REQ'D NOT REQ'D	/	/
95	610	REMOVE & REPLACE VENT LOUVER MBFAB P/N 50-3377-3 REQ'D NOT REQ'D	/	/
95	620	REMOVE & REPLACE (-810) DOUBLE MBFAB REQ'D NOT REQ'D	/	/
95	630	REMOVE & REPLACE (-4) SKIN MBFAB REQ'D NOT REQ'D	/	/
95	640	REMOVE & REPLACE (-3) SKIN MBFAB REQ'D NOT REQ'D	/	/
95	650	REMOVE & REPLACE (-5) SKIN MBFAB REQ'D NOT REQ'D	/	/
95	660	SHOOT ALL RIVETS IN -59, -60, -61, MBFAB -62, -63, & -24 FRAMES	/	/
95	670	REMOVE CORROSION & APPLY CORROSION MBFAB PROTECTIVE FINISH TO ALL REWORKED SURFACES IAW T.O. 1C-135(K)A-3-4 AND T.O. 1-1-2	/	/
95	680	DRILL DRAIN HOLES IN COWLING MBFAB REQ'D NOT REQ'D	/	/
95	690	DRILL ALIGNMENT PIN HOLES MBFAB REQ'D NOT REQ'D	E	/
95	700	REMOVE COWLING FROM FIXTURE MBFAB	/	/
95	710	FINAL MBFAB	/	/
95	715	TRIM ALL SKINS IAW 50W 82-174 MBFAB	/	/
95	720	DRILL RIVET P.A. IN NEW LONGERON MBFAB (-10) REQ'D NOT REQ'D (-113) REQ'D NOT REQ'D	/	/

(CONTINUED)

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15025A * WORK CONTROL DOCUMENT * MSIR 1, DATE 38054 PAGE 5 OF 7 PAGES						
15. DISP-16. PDN/						
16. STATION/OP NO.			17. WORK TO BE ACCOMPLISHED		18. MECH/UP/DN/2000	
				(-100) REQ'D	NOT REQ'D	
95	730	MBFAB	INSTALL (-37) DOUBLER & DRILL RIVET PATTERN IN (-99) LONGERON	REQ'D	NOT REQ'D	/ /
95	740	MBFAB	INSTALL CLIPS AT LATCH OPENINGS	REQ'D	NOT REQ'D	/ /
95	750	MBFAB	ATTACH (-514) & (-515) TO (-59) FRAME	REQ'D	NOT REQ'D	/ /
95	760	MBFAB	ATTACH (-99) LONGERON TO ANGLE AT (-59) & (-60) FRAMES	REQ'D	NOT REQ'D	/ /
95	770	MBFAB	STEP DELETED			/ /
95	780	MBFAB	INSTALL TABS AT END OF (-100) & (-99) LONGERONS	REQ'D	NOT REQ'D	/ /
95	790	MBFAB	INSTALL (-805) GUIDE PLATE TO (-60) FRAME	REQ'D	NOT REQ'D	/ /
95	800	MBFAB	INSTALL ALIGNMENT PINS & PLATES IN LONGERONS			/ /
				(-10) REQ'D	NOT REQ'D	
				(-100) REQ'D	NOT REQ'D	
				(-99) REQ'D	NOT REQ'D	
95	810	MBFAB	DRILL RIVET PATTERNS IN NEW LONGERONS			/ /
				(-8) REQ'D	NOT REQ'D	
				(-98) REQ'D	NOT REQ'D	
95	820	MBFAB	DOUBLE COUNTERSINK & INSTALL RIVETS IN LONGERONS:			/ /
				(-8) REQ'D	NOT REQ'D	
				(-98) REQ'D	NOT REQ'D	
95	830	MBFAB	INSTALL TABS AT END OF (-98) LONGERONS	REQ'D	NOT REQ'D	/ /
95	840	MBFAB	SAND EXCESS RIVET BUTTS ON INTERIOR OF LONGERONS & (-52) FRAME			/ /

(CONTINUED)

STATION/NO.		WORK TO BE ACCOMPLISHED	REQ'D	NOT REQ'D
95	850 MBFAB	INSTALL RIVETS AND SPACERS AT AFT END OF LONG RUN (-3) FEET	/	/
95	860 MBFAB	COUNTERSINK & INSTALL RIVETS IN ALL NEW LIPS	/	/
95	930 MBFAB	INSTALL BUMPERS, AFT SIDE OF (-25) FRAME REQ'D NOT REQ'D	/	/
95	940 MBFAB	INSPECT COULING AND ENSURE THAT ALL RIVETS ARE INSTALLED IN FRAMES, BUMPERS, CLIPS, DOUBLERS, ETC.	E	/
95	950 MBFAB	SHAVE ALL HIGH RIVETS IN SKINS	/	/
95	960 MBFAB	PLACE COULING IN ALIGNMENT FIXTURE, ACCOMPLISH ALIGNMENT CHECK, MOVE TO MBPCB	E	/
2280	970 MBPCB	FINAL WASH AND TREAT FOR CORROSION	/	/
2280	980 MBPCB	PAINT INTERIOR AND EXTERIOR, INSTALL EXTERIOR STENCILS PER SOW 82-174 MOVE TO MBFAB	/	/
95	990 MBFAB	WORK COMPLETE, CONDITION TAG & IDENTIFY IW NAOI 65-1 DATED 9 MAY 77 NOTE: ANY WORK PERFORMED AND NOT COVERED BY THIS DOCUMENT WILL BE NUMBERED AND RECORDED BELOW.	E	/
		MBEBS L. MULLINAX 3-22-89		
		MBFAB L. STEWARD 3-22-89		
		MAQBF T. HAYES 3-22-89		
		MABSCS H. NGUYEN 3-22-89		

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
1102-	5-85638 15113A	PANEL ASSY, RIGHT HAND SIDE COWL, ENGINE NACELLE (FOR . . . NHA SEE FIG. 1100)	REF	A
	33-32370-1	PANEL ASSY, RIGHT HAND SIDE COWL, ENGINE NACELLE (FOR . . . NHA SEE FIG. 1100)	1	A
	7727042-10	PANEL ASSY, RIGHT HAND SIDE COWL, ENGINE NACELLE (FOR . . . NHA SEE FIG. 1100)	1	A
1	(DELETED)			
2	NAS1103-23DW	. BOLT (FOR REPLACEMENT ORDER BACB3ONE3D23)	1	A
3	AN960D10L	. WASHER	4	A
4	AN320-3	. NUT (FOR REPLACEMENT ORDER BACN10JD103)	1	A
5	H28-3	. LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL . . . (83014) (ALTERNATE 24L1-3 (71286)) (BOEING SPEC 10-2731-4)	1	A
5A	9-66304	. U-BOLT, LATCH, ENGINE NACELLE COWL . . . (ATTACHING PARTS)	4	A
5B	AN316-5R	. NUT	8	A
6	H29523-5	. NUT, 12 PT, EXT WRENCHING, SELF-LKG 450°F (15653) . . . (ALTERNATES FN22A524 (03680) LH3393-054 (72962) VN406A054 (92215)) (BACN10BL5L) (FOR REPLACEMENT ORDER 66796-524 (03680) (BACN10GW5))	8	A
6A	9-66304	. U-BOLT, LATCH, ENGINE NACELLE COWL . . . (ATTACHING PARTS)	1	A
6B	AN316-5R	. NUT	2	A
6C	H29523-5	. NUT, 12 PT EXT WRENCHING, SELF-LKG°F (15653) . . . (ALTERNATES FN22A524 (03680) LH3393-054 (72962) VN406A054 (92215)) (BACN10BL5L) (FOR REPLACEMENT ORDER 66796-524 (03680) (BACN10GW5))	2	A
6D	90-3261-2	. FITTING, ATTACHMENT, U-BOLT, NACELLE COWL PANEL . . .	1	A
6E	90-3261	. FITTING, ATTACHMENT, U-BOLT, NACELLE COWL PANEL . . .	2	A
6F	90-3251-1	. FITTING, ATTACHMENT, U-BOLT, NACELLE COWL PANEL . . .	2	A
7	60-3329	. SEAL, ATTACHMENT, U-BOLT, ENGINE NACELLE COWL . . .	3	A
8	60-3329-1	. SEAL, ATTACHMENT, U-BOLT, ENGINE NACELLE COWL . . .	1	A
9	66-4025	. PIN, SHEAR, ENGINE NACELLE COWL PANEL . . . (ATTACHING PARTS)	1	A
	NAS679A4W	. NUT (FOR REPLACEMENT ORDER BACN10JC4)	1	A
	5-85638-55	. DOOR INSTL, FORWARD FIRE, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE	1	A
	5-85638-54	. DOOR INSTL, AFT FIRE, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE	1	A
9A	6-25391-1	. . . SPRING, FIRE CONTROL DOOR . . .	3	A
10	90-2907	. . . DOOR ASSY, ACCESS, FIRE EXTINGUISHER, ENGINE . . . NACELLE (USED ON 5-85638-55)	1	A
11	90-2908	. . . DOOR ASSY, ACCESS, FIRE EXTINGUISHER, ENGINE . . . NACELLE (USED ON 5-85638-54)	1	A
12	MS25083-1AA10	. . . JUMPER ASSY . . . (ATTACHING PARTS)	1	A
	NAS601-6	. . . SCREW (FOR REPLACEMENT ORDER NAS601-6P)	1	A
	NAS679A06W	. . . NUT (FOR REPLACEMENT ORDER BACN10JC06)	1	A
12A	5-85638-53	. . . PAN, FIRE DOOR FWD (USED ON 5-85638-55)	1	A
13	5-96762	. HOOK, HINGE, NACELLE COWLING . . .	2	A
14	5-96766	. HOOK, HINGE, NACELLE COWLING . . .	1	A
15	5-96766-1	. HOOK, HINGE, NACELLE COWLING . . .	1	A
16	5-96766-2	. HOOK, HINGE, NACELLE COWLING . . . (ATTACHING PARTS)	1	A
	AN5-10A	. BOLT (FOR REPLACEMENT ORDER BACB3ONE5-10)	4	A
	NAS1105-9W	. BOLT (FOR REPLACEMENT ORDER BACB3ONE5-9)	1	A
	AN960-516L	. WASHER	10	A
	MS21042L3	. NUT (REPLACES NAS679A5 OR BACN10JC5)	5	A
	AN3-7A	. BOLT (FOR REPLACEMENT ORDER BACB3ONE3-8)	5	A
	AN960-10L	. WASHER	5	A
	NAS679A3W	. NUT (FOR REPLACEMENT ORDER BACN10JC3)	5	A
17	5-96719-800	. HINGE, SPEAR, ENGINE NACELLE COWL PANEL . . . (ATTACHING PARTS)	1	A
	AN4-10A	. BOLT (FOR REPLACEMENT ORDER BACB3ONE4-9)	1	A
	AN960-416	. WASHER	1	A
	AN960-416L	. WASHER	1	A
	NAS679A4W	. NUT (REPLACEMENT ORDER BACN10JC4)	1	A
	AN3-7A	. BOLT (FOR REPLACEMENT ORDER BACB3ONE3-8)	1	A
	AN960-10	. WASHER	1	A
	AN960-10L	. WASHER	1	A
	NAS679A3W	. NUT (FOR REPLACEMENT ORDER BACN10JC3)	1	A

### Power Plant

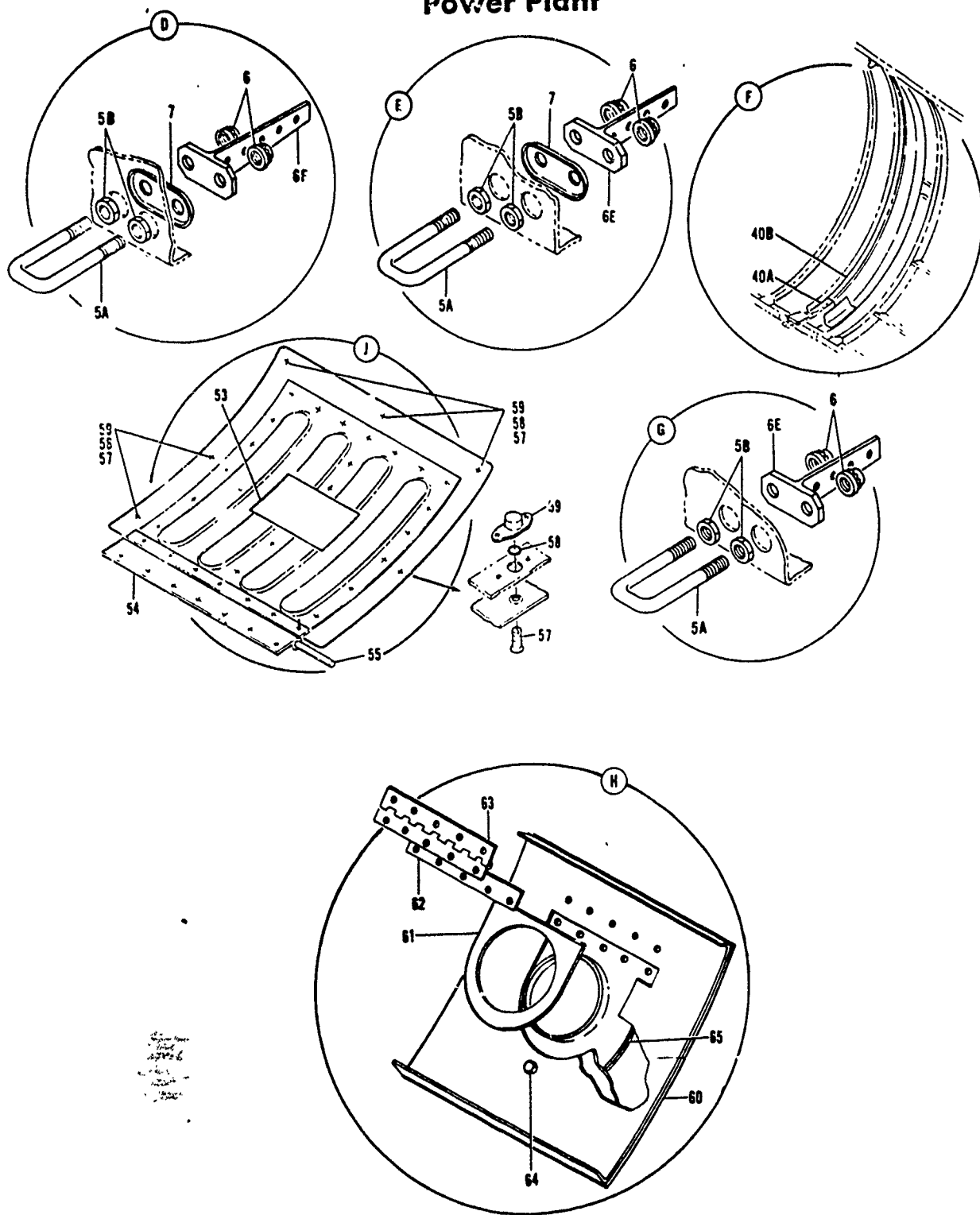


Figure 1102. Engine Nacelle Right Hand Side Cowl Panel Assembly (Sheet 2 of 2)

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
1102-				
18	65-1296	. . VENT INSTL, OIL BREATHER LINE, ENGINE . . . . .	1	A
	65-1296-1	. . . VENT ASSY, OIL BREATHER LINE, ENGINE. . . . .	1	A
	65-1843	. EXHAUST INSTL, WATER INJECTION PUMP ENGINE. . . . .	1	A
19	65-1843-10	. . EXHAUST INSTL, WATER INJECTION PUMP, ENGINE . . . . .	1	A
	1200874	. . SEAL ASSY, EXIT BELLOWS, FUEL AIR STARTER EXHAUST . . (87273) (ALTERNATE 8449402 (71688) (BOEING SPEC 10-1748) (FOR REPLACEMENT ORDER 1200874-10 (87273) (BOEING SPEC 10-2748-1)) (FOR 1200874-10 REPAIR, ON 65-1843-10 INST ONLY, ORDER 69B25097-1)	1	A
20	65-1843-6	. . COVER, EXHAUST, WATER INJECTION PUMP, ENGINE (MAKE. . FROM 2024-T3 CLAD SHEET 0.040 X 7.2 X 8.6) (ATTACHING PARTS)	1	A
20A	AN3-4A	. . BOLT (ALTERNATE NAS1303-2) (DO NOT SUBSTITUTE AN3-4A. FOR NAS1303-2)	10	A
20B	AN3-3A	. . BOLT (ALTERNATE NAS1303-1) (DO NOT SUBSTITUTE AN3-3A. FOR NAS1303-1)	10	A
20C	AN960D10	. . WASHER. . . . .	10	A
20D	NAS679A3W	. . NUT . . . . .	10	A
20E	65-1843-19	. . EXHAUST ASSY, WATER INJECTION PUMP ENGINE . . . . .	1	A
20F	65-1843-11	. . DUCT ASSY, EXHAUST, WATER INJECTION PUMP, ENGINE. . .	1	A
21	65-1843-1	. . DUCT ASSY, EXHAUST WATER INJECTION PUMP, ENGINE . . .	1	A
	5-85638-1	. SKIN, FORWARD, RIGHT HAND SIDE COWL PANEL, ENGINE . . . NACELLE	1	A
22	5-85638-2	. SKIN, MIDDLE, RIGHT HAND SIDE COWL PANEL, ENGINE. . . . NACELLE	1	A
23	5-85638-4	. SKIN, UPPER AFT, RIGHT HAND SIDE COWL PANEL, ENGINE . . . NACELLE	1	A
24	5-85638-3	. SKIN, LOWER AFT, RIGHT HAND SIDE COWL PANEL, ENGINE . . . NACELLE	1	A
	5-85638-70	. FRAMF AND SKIN ASSY, PANEL, RIGHT HAND SIDE COWL, . . . ENGINE NACELLE	1	A
25	5-85638-5	. . SKIN, AFT, RIGHT HAND SIDE COWL PANEL, ENGINE . . . . NACELLE	1	A
26	5-85638-20	. . FRAME, PANEL STATION 180.00, RIGHT HAND SIDE COWL, . . . ENGINE NACELLE	1	A
27	5-85638-22	. . FRAME, PANEL STATION 200.00, RIGHT HAND SIDE COWL, . . . ENGINE NACELLE	1	A
28	5-85638-23	. . FRAME, PANEL STATION 210.00, RIGHT HAND SIDE COWL, . . . ENGINE NACELLE	1	A
29	5-85638-25	. . FRAME, PANEL STATION 235.00, RIGHT HAND SIDE COWL, . . . ENGINE NACELLE	1	A
30	5-85638-26	. . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.	1	A
	5-85638-48	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . . NACELLE (WHEN EXHAUSTED USE 5-85638-94)	1	A
	5-85638-94	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . . NACELLE (SUITABLE SUB. FOR 5-85638-48) (WHEN EXHAUSTED USE 5-85638-99)	1	A
	5-85638-99	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . . NACELLE	1	A
31	5-85638-7	. . LONGERON, UPPER FORWARD, RIGHT HAND SIDE COWL PANEL . . ENGINE NACELLE	1	A
31	5-85638-92	. . LONGERON, UPPER FORWARD, RIGHT HAND SIDE COWL PANEL . . ENGINE NACELLE	1	A
31	5-85638-97	. . LONGERON, UPPER FORWARD, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE	1	A
	5-85638-49	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . . NACELLE (FOR I/W INFO SEE 5-85638-91)	1	A
	5-85638-91	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . . NACELLE	1	A
32	5-85638-29	. . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.	1	A
32	5-85638-89	. . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.	1	A
33	5-85638-8	. . LONGERON, UPPER AFT, RIGHT HAND SIDE COWL, ENGINE . . . NACELLE	1	A
34	5-85638-62	. LONGERON, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE .	1	A
	5-85638-81	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . . NACELLE	1	A
35	5-85638-59	. . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.	1	A
36	5-85638-58	. . LONGERON, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE	1	A

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE
1102-											
37	5-85638-60	. DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE. .								1	A
	5-85638-46	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . NACELLE								1	A
38	5-85638-9	. . LONGERON, LOWER FORWARD, RIGHT HAND SIDE COWL PANEL, . ENGINE NACELLE								1	A
	5-85638-47	. LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . . NACELLE								1	A
39	5-85638-10	. . LONGERON, LOWER AFT, RIGHT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
	5-85638-38	. FRAME ASSY, LOWER AFT, RIGHT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
40	5-85638-19	. . FRAME, STATION 171.20 RIGHT HAND SIDE COWL PANEL. . . ENGINE NACELLE								1	A
40A	5-85638-803	. . FRAME, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
40B	5-85638-804	. . FRAME, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
	5-85638-805	. . SPLICE, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . ENGINE NACELLE								1	A
	5-85638-806	. . SPLICE, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . ENGINE NACELLE								1	A
	5-85638-35	. FRAME ASSY, STATION 171.20, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE								1	A
41	5-85638-11	. . FRAME, STATION 89.50, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
42	5-85638-12	. FRAME, STATION 100.43, RIGHT HAND SIDE COWL PANEL. . . ENGINE NACELLE								1	A
	5-85638-36	. FRAME ASSY, STATION 100.43, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE								1	A
43	5-85638-13	. . FRAME, STATION 112.50, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
44	5-85638-14	. FRAME, STATION 120.00, RIGHT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
45	5-85638-15	. FRAME, STATION 131.50, RIGHT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
	5-85638-37	. FRAME ASSY, COWL PANEL, RIGHT HAND SIDE, ENGINE NACELLE (WHEN EXHAUSTED USE 5-85638-101)								1	A
	5-85638-101	. FRAME ASSY, COWL PANEL, RIGHT HAND SIDE, ENGINE NACELLE								1	A
46	5-85638-100	. . FRAME, STATION 142.80, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
47	5-85638-17	. FRAME, STATION 152.75, RIGHT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
48	5-85638-18	. FRAME, STATION 161.50, RIGHT HAND SIDE COWL PANEL, . . . ENGINE NACELLE								1	A
	5-85638-39	. FRAME ASSY, STATION 161.50, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE								1	A
49	5-85638-21	. . FRAME, STATION 190.00, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
	5-85638-40	. FRAME ASSY, STATION 190.00 RIGHT HAND SIDE COWL PANEL, . ENGINE NACELLE (WHEN EXHAUSTED USE 5-85638-90)								1	A
	5-85638-90	. FRAME ASSY, STATION 190.00, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE								1	A
50	5-85638-24	. . FRAME, STATION 225.00, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
50	5-85638-86	. . FRAME, STATION 225.00, RIGHT HAND SIDE COWL PANEL, . . ENGINE NACELLE								1	A
51	5-85638-34	. SEGMENT, LONGERON, RIGHT HAND SIDE COWL PANEL, ENGINE . NACELLE								1	A
52	5-85638-6	. CAP, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE . . . .								1	A
	35-376-1	. DOOR ASSY, ACCESS, PNEUMATIC CARTRIDGE STARTER. . . . .								1	A
53	35-376-1	. . MARKER, FOIL. . . . .								1	A
54	35-376-5	. . HINGE HALF (MAKE FROM MS20001PH6-1040). . . . .								2	A
55	MS20253P2-1015	. . PIN, HINGE. . . . .								1	A
56	F5T14	. . STUD (72794). . . . .								3	A
57	F5T9	. . STUD (72794). . . . .								3	A
58	GH5	. . GROMMET (72794). . . . .								6	A
59	RF5	. RECEPTACLE (72794). . . . .								6	A

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PFR ASSY	USE ON CODE
1102-											
60	7727014-10	. DOOR ASSY, CONSTANT SPEED DRIVE ACCESS. . . . .								1 A	
61	7727014-03	. . FILLER (MADE FROM AL ALLOY SHT PER QQ-A-250/4 2024T . .050 X 10.00 X 10.40)								1 A	
62	7727014-05	. . DOUBLER; (MADE FROM AL ALLOY 2024-T4 PER QQ-A-250/4 . .050 THK)								1 A	
63	7727014-07	. . SPACER; (MADE FROM AL ALLOY 2024-T4 PER QQ-A-450/4 . .050 THK)								1 A	
64	AN257-4-5	. . HINGE, 5 INCHES LONG. . . . .								1 A	
65	99947P-130	. . RECEPTACLE, SPRING (83058). . . . .								1 A	
	5-85637-112	. . DOOR. . . . .								1 A	
		A 2201 THRU 2299, 3001 THRU 3015									
		ALSO SEE FIGURE 1132									



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12.ORIG/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHED 16.DATE COMP  
 | 15113A | | MABFAB | 89093 |

17.PART NUMBER 19.ITEM SERIAL NR 18/12.TECH DATA/OPTIONAL  
 | 772-7042-10 | | | DRWG 5-85638

10.MODEL/DESIGN/SERIES 11.STOCK NR | T.O.1-1A-1  
 | KC-135 | 1560010419310FL | T.O.1-1-2

13.MISC 14.NOUN/END ITEM NOUN | T.O.1C-135(K)A-3-1  
 | | SIDE COWL PANEL R.H. | T.O.1C-135(K)A-3-4  
 | | | 1C-135(K)A-3-1.3-4

-----L. MULLINAX/MABERS/65246

15.DISP-16.PDN/  
 18.MECH 17" P" 120" W"

17	19	18/12	17	18	17	18
2122	010	RECEIVE & UNCRATE SIDE COWL.			/	/
	MBPCD	NOTE				
		OBSERVE CAUTION THAT SIDE COWL IS NOT DAMAGED DURING UNCRATING.				
2122	020	WASH INTERIOR & EXTERIOR IAW T.O. 1C-135(K)A-3-4, PARA 11-7 AND SOW 1560FL-82-174.			/	/
	MBPCA					
2122	030	STRIP ALL INTERIOR & EXTERIOR PAINT FROM SIDE COWL IAW T.O. 1C-135(K)A-3-4, PARA 11-15 SOW DC1560FL-82-174			/	/
	MBPCA					
2122	040	ABRASIVE BLAST SIDE COWL IAW T.O. 1C-135(K)A-3-4 SEC 9 PARA 16 AND T.O. 1-1-2.			/	/
	MBPCA					
95	050	ACCOMPLISH VISUAL INSPECTION IAW SOW 82-174.			/	/
	MBFAB					
95	065	TEARDOWN			/	/
	MBFAB	NOTE: DEPOT OVERHAUL OF J-57 RIGHT HAND SIDE COWL WILL BE DONE IN ACCORDANCE WITH INSTRUCTIONS IN SOW DC1560/82-174 AND 1C-135(K)A-3-4	/			
95	070	REMOVE CORROSION & APPLY CORROSION PROTECTIVE FINISH TO ALL REWORKED SURFACES IAW T.O. 1C-135(K)A-3-4 AND T.O. 1-1-2			/	/
	MBFAB					
3001	075	WELD AS REQD. REF T.O.1-1A-1			/	/
	MPIW	REQD-----NOT REQD-----				
		WELDING DONE AT POST K-73				
95	080	ASSEMBLE (-81) LONGERON (-85) DOUBLER AND 637-131 PLATE.			/	/
	MBFAB	REQ'D _____ NOT REQ'D _____				
95	090	STEP DELETED			/	/
	MBFAB		/			
95	100	LONGERON (-46)			/	/
	MBFAB	REPAIR _____ REPLACE _____ NOT REQ'D _____				

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15.DIST-16.PDN/									
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED									
18.MECH 19"P" 20"Q"									
95	110	LONGERON (-34)						E	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	120	LONGERON (-47)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	130	ASSEMBLE -75 TO -99						/	/
	MBPAB	REQ'D	NOT REQ'D						
95	140	LONGERON (-99)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	150	ASSEMBLE -73 TO 91						/	/
	MBPAB	REQ'D	NOT REQ'D						
95	160	LONGERON (-91)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	170	LONGERON (-62)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	180	FRAME #1, (-11) OR (-35) ASSEMBLY						E	/
	MBPAB	REPAIR	NOT REQ'D						
95	190	FRAME #2 (-12)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	200	FRAME #3 (-13) OR (-36) ASSEMBLY						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	210	FRAME #4 (-14)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	220	FRAME #5 (-15)						/	/
	MBPAB	REPAIR	NOT REQ'D						
95	230	FRAME #6 (-16) OR (-101) ASSEMBLY						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	240	FRAME #7 (-17)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	250	FRAME #8 (-18)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	260	FRAME #9 (-19) OR (-38) ASSEMBLY						/	/
	MBPAB	REPAIR	NOT REQ'D						
95	270	FRAME #10 (-20)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					
95	280	FRAME #11 (-21) OR (-39) ASSEMBLY						/	/
	MBPAB	REPAIR	NOT REQ'D						
95	290	FRAME #12, (-22)						/	/
	MBPAB	REPAIR	REPLACE	NOT REQ'D					

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
95	300 MBPAB	ASSEMBLE 60-4921 TO 638-23 FRAME REQ'D _____ NOT REQ'D _____	/	/	
95	310 MBPAB	FRAME #13 (-23) REPAIR _____ REPLACE _____ NOT REQ'D _____	/	/	
95	320 MBPAB	FRAME #14 (-24) OR (-90) ASSEMBLY REPAIR _____ NOT REQ'D _____	/	/	
95	330 MBPAB	FRAME #15 (-25) REPAIR _____ REPLACE _____ NOT REQ'D _____	/	/	
95	340 MBPAB	REPAIR OR REPLACE ALL ANGLES AND NECESSARY.	/	/	
95	350 MBPAB	BELLOWS SEAL, 1200874-10 REPLACE _____ NOT REQ'D _____	/	/	
95	360 MBPAB	BELLOWS, 65-1843-1 REPAIR _____ REPLACE _____ NOT REQ'D _____	/	/	
95	370 MBPAB	DRILL SKINS AS REQ'D #1 REQ'D <u>100</u> NOT REQ'D _____ <sup>H12</sup> 1.0 #2 REQ'D <u>80</u> NOT REQ'D _____ 1.0 #3 REQ'D <u>50</u> NOT REQ'D _____ .50 <sup>2</sup> 3.25 #4 REQ'D <u>75</u> NOT REQ'D _____ .75 #5 REQ'D <u>75</u> NOT REQ'D _____ .75	/	/	
95	380 MBPAB	SKINS REPAIRED IAW SOW #1 REQ'D _____ NOT REQ'D _____ #2 REQ'D _____ NOT REQ'D _____ #3 REQ'D _____ NOT REQ'D _____ #4 REQ'D _____ NOT REQ'D _____ #5 REQ'D _____ NOT REQ'D _____	/	/	
95	390 MBPAB	FIXTURE PLACE COWLING IN FIXTURE	/	/	
95	400 MBPAB	REMOVE CORROSION & APPLY CORROSION PROTECTIVE FINISH TO ALL REWORKED SURFACES IAW T.O. 1C-135(K)A-3-4 AND T.O. 1-1-2	/	/	
95	410 MBPAB	REPLACE (-81) LONGERON REQ'D _____ NOT REQ'D _____	/	/	
95	420 MBPAB	REMOVE & REPLACE (-11) FRAME OR (-35) ASSEMBLY	/	/	

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15113A * WORK CONTROL DOCUMENT * MISTR 1.DATE 88054 PAGE 4 OF 9 PAGES						
15.DISP-16.PDN/						
STATION/OP NO.		17.WORK TO BE ACCOMPLISHED			18.MECH 12"P" 120"R"	
		REQ'D	NOT REQ'D			
95	430	POSITION (-12) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	440	POSITION (-13) FRAME OR (-36) ASSY		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	450	POSITION (-14) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	455	POSITION (-15) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	460	REMOVE & REPLACE (-15) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	470	POSITION (-16) FRAME OR (-101) ASSY		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	480	POSITION (-17) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	490	POSITION (-18) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	500	REMOVE & REPLACE (-19) FRAME		/	/	
	MBPAB	OR (-38) ASSEMBLY				
		REQ'D	NOT REQ'D			
95	505	POSITION (-19) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	510	POSITION (-20) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	515	POSITION (-21) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	520	REMOVE & REPLACE (-21) FRAME OR		/	/	
	MBPAB	(-39) ASSEMBLY				
		REQ'D	NOT REQ'D			
95	525	POSITION (-22) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	530	POSITION (-23) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	540	REMOVE & REPLACE (-24) FRAME		E	/	
	MBPAB	REQ'D	NOT REQ'D			
95	545	POSITION (-24) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			
95	550	POSITION (-25) FRAME		/	/	
	MBPAB	REQ'D	NOT REQ'D			

15. DISP-16. PDN/ STATION/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19. P	20. Q
95 MBPAB	#1 SKIN (-1) REPLACE _____ NOT REQ'D _____		E	/
95 MBPAB	#2 SKIN (-2) NOTE IF #2 SKIN IS REPLACED DELETE 65-63019-11 VENT REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	#3 SKIN (-3) REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	#4 SKIN (-4) REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	#5 SKIN (-5) REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	SPLICE (-26) REPAIR _____ REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	BELLOWS. 65-1843-1 REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	DOUBLER 50-3377-5 REPAIR _____ REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	LOUVER 50-3377-3 REPAIR _____ REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	STARTER CARTRIDGE DOOR, 35-32376-1 REPAIR _____ REPLACE _____ NOT REQ'D _____		/	/
95 MBPAB	REPLACE "T" ANGLES AS REQUIRED REQ'D _____ NOT REQ'D _____		/	/
95 MBPAB	REMOVE COWL FROM FIXTURE		/	/
95 MBPAB	<b>FINAL ASSEMBLY</b>		/	/
95 MBPAB	INSTALL (-81) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95 MBPAB	INSTALL (-57) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95 MBPAB	INSTALL (-46) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95 MBPAB	INSTALL (-34) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95 MBPAB	INSTALL (-47) LONGERON REQ'D _____ NOT REQ'D _____		/	/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"R"	20"Q"
95	650 MBPAB	INSTALL (-28) DOUBLER REQ'D _____ NOT REQ'D _____		/	/
95	655 MBPAB	INSTALL (-99) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95	660 MBPAB	INSTALL (-88) DOUBLER REQ'D _____ NOT REQ'D _____		/	/
95	665 MBPAB	INSTALL (-91) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95	670 MBPAB	INSTALL (-62) LONGERON REQ'D _____ NOT REQ'D _____		/	/
95	675 MBPAB	INSTALL #2 FRAME (-12) REQ'D _____ NOT REQ'D _____		/	/
95	680 MBPAB	INSTALL #3 FRAME (-13) OR (-36) ASSEMBLY REQ'D _____ NOT REQ'D _____		/	/
95	685 MBPAB	INSTALL #4 FRAME (-14) REQ'D _____ NOT REQ'D _____		/	/
95	690 MBPAB	INSTALL #5 FRAME (-15) REQ'D _____ NOT REQ'D _____		/	/
95	700 MBPAB	INSTALL #6 FRAME (-16) OR (-101) ASSEMBLY REQ'D _____ NOT REQ'D _____		/	/
95	705 MBPAB	INSTALL #7 FRAME (-17) REQ'D _____ NOT REQ'D _____		/	/
95	710 MBPAB	INSTALL #8 FRAME (-18) REQ'D _____ NOT REQ'D _____		/	/
95	715 MBPAB	INSTALL #9 FRAME (-19) OR (-38) ASSEMBLY REQ'D _____ NOT REQ'D _____		/	/
95	720 MBPAB	INSTALL #10 FRAME (-20) REQ'D _____ NOT REQ'D _____		/	/
95	725 MBPAB	INSTALL #11 FRAME (-21) OR (-39) ASSEMBLY REQ'D _____ NOT REQ'D _____		/	/
95	730 MBPAB	INSTALL #12 FRAME (-22) REQ'D _____ NOT REQ'D _____		/	/
95	735 MBPAB	INSTALL #13 FRAME (-23) REQ'D _____ NOT REQ'D _____		/	/
95	740 MBPAB	INSTALL #14 FRAME (-24) OR (-90) ASSEMBLY REQ'D _____ NOT REQ'D _____		/	/

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15.DISP-16.FDN/					
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
95	745	INSTALL #15 FRAME (-25)		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	750	FIREDOOR PAN (-53)		/	/
	MBFAB	REPAIR _____ REPLACE _____ NOT REQ'D _____			
95	755	INSTALL FIRE EXTINGUISHER DOOR		/	/
	MBFAB	(90-2907)			
		REQ'D _____ NOT REQ'D _____			
95	760	FIREDOOR PAN (-52)		/	/
	MBFAB	REPAIR _____ REPLACE _____ NOT REQ'D _____			
95	765	INSTALL FIRE EXTINGUISHER DOOR		/	/
	MBFAB	(90-2908)			
		REQ'D _____ NOT REQ'D _____			
95	767	ENSURE FIRE EXTINGUISHER ACCESS		/	/
	MBFAB	DOORS COMPLY WITH STEP 8 SEC 3.2.5			
		SOW OC1560FL/82-174.			
95	770	SPRING CLIPS P/N 6-35391-1		/	/
	MBFAB	REPLACE _____ NOT REQ'D _____			
		NOTE:			
		ENSURE SPRING CLIPS ARE MADE UP			
		STAINLESS STEEL			
95	773	INSTALL VENT ASSY (50-6075-8)		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	775	INSTALL VENT ASSEMBLY (90-5528-1)		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	780	INSTALL CONSTANT SPEED/DRIVE DOOR		/	/
	MBFAB	77-27014-10			
		REQ'D _____ NOT REQ'D _____			
95	785	INSTALL STARTER CARTRIDGE DOOR		/	/
	MBFAB	35-32376-1			
		REQ'D _____ NOT REQ'D _____			
95	790	INSTALL (-51) STAINLESS STEEL PLATE		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	793	INSTALL (-50) STAINLESS STEEL PLATE		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	795	INSTALL CAP COVER (60-2866-3)		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	800	INSTALL DRAIN CAP (6-5989-1)		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			
95	805	INSTALL BUMPERS (60-6174)		/	/
	MBFAB	REQ'D _____ NOT REQ'D _____			

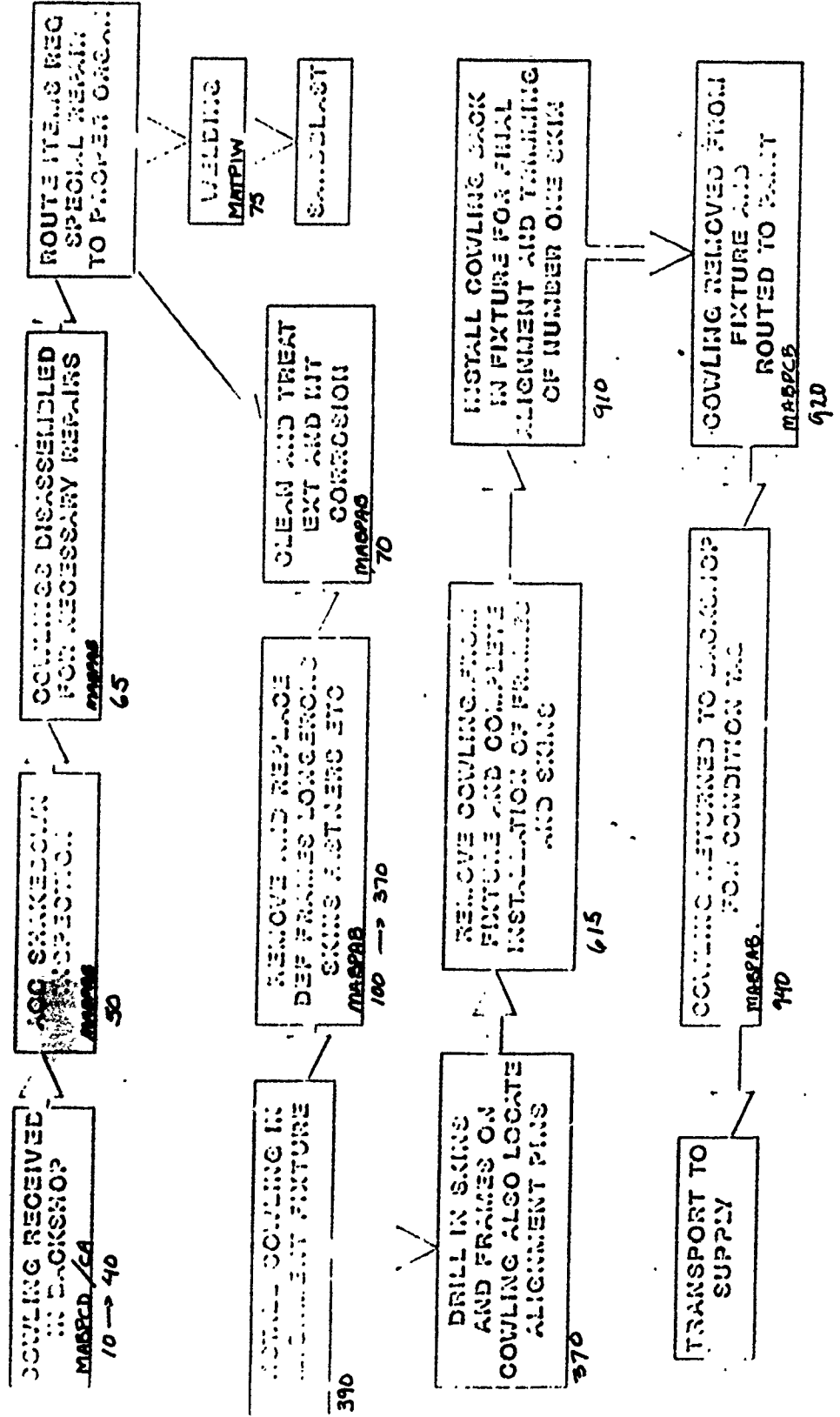
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15.DISP-16.PDN/									
STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"									
95	810	INSTALL OIL BREATHER VENT 65-1296-1						/	/
	MBPAB	REQ'D NOT REQ'D							
95	815	INSTALL (-56) PLATE						/	/
	MBPAB	REQ'D NOT REQ'D							
95	820	INSTALL (-72) PLATE						/	/
	MBPAB	REQ'D NOT REQ'D							
95	825	INSTALL (-1) SKIN						L	/
	MBPAB	REQ'D NOT REQ'D							
95	830	INSTALL (-2) SKIN						/	/
	MBPAB	REQ'D NOT REQ'D							
95	835	INSTALL (-3) SKIN						/	/
	MBPAB	REQ'D NOT REQ'D							
95	840	INSTALL (-4) SKIN						/	/
	MBPAB	REQ'D NOT REQ'D							
95	845	INSTALL (-5) SKIN						/	/
	MBPAB	REQ'D NOT REQ'D							
95	850	INSTALL LATCHES AS REQUIRED						/	/
	MBPAB	REQ'D NOT REQ'D							
95	855	INSTALL #1 HINGE HOOK						/	/
	MBPAB	P/N 5-96762							
		REQ'D NOT REQ'D							
95	860	INSTALL #2 HINGE HOOK						/	/
	MBPAB	5-96766							
		REQ'D NOT REQ'D							
95	865	INSTALL #3 HINGE HOOK						/	/
	MBPAB	5-96766-1							
		REQ'D NOT REQ'D							
95	870	INSTALL #4 HINGE HOOK						/	/
	MBPAB	5-96766-2							
		REQ'D NOT REQ'D							
95	875	INSTALL #5 HINGE HOOK						/	/
	MBPAB	5-96762							
		REQ'D NOT REQ'D							
95	880	INSTALL HINGE SPEAR (5-96719)						/	/
	MBPAB	REQ'D NOT REQ'D							
95	890	DRILL ALL DRAIN HOLES						/	/
	MBPAB	IAW SOW GC1560FL/82-174							
95	895	INS ALL CLIPS AS REQUIRED						/	/
	MBPAB								
95	900	INSPECT COWLTR. ENSURE THAT ALL						E	/
	MBPAB	RIVETS ARE INSTALLED IN FRAMES,							

(CONTINUED)

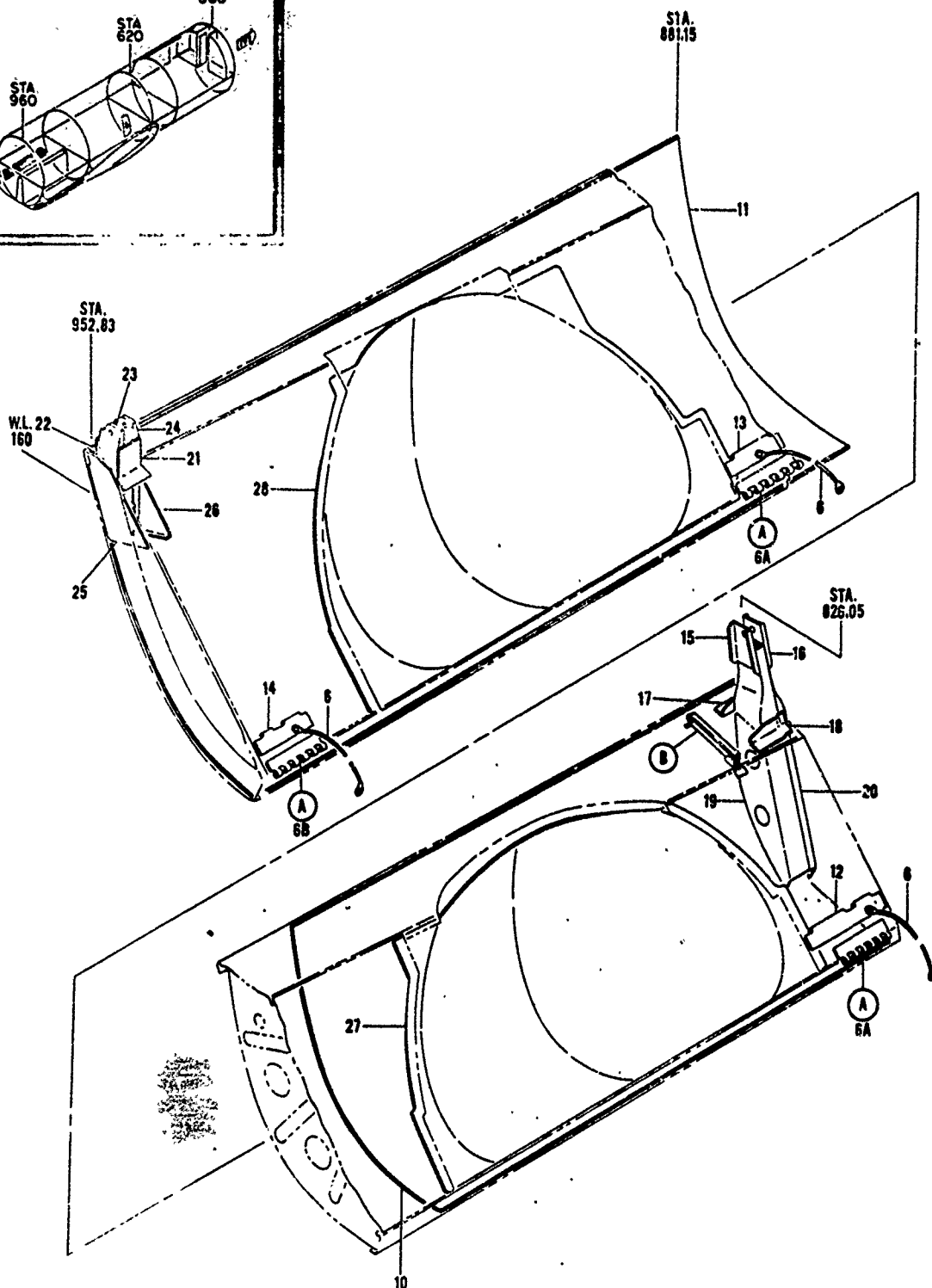
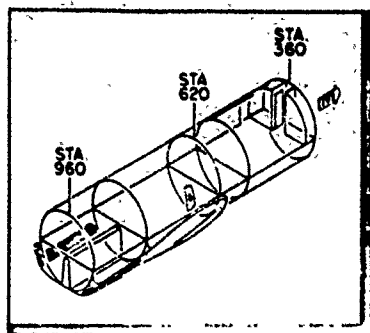


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115.DISP-16.PDN/					
STATION/OP NO.		117.WORK TO BE ACCOMPLISHED	118.MECH	119"P"	120"Q"
		LONGERONS, CLIPS, ANGLES, DOUBLERS, SKINS, ETC.			
95	905 MBPAB	SHAVE ALL HIGH RIVETS IN SKIN AND TRIM LONGERONS AND AFT EDGES.		/	/
95	910 MBPAB	PLACE COWLING IN ALIGNMENT FIXTURE AND ACCOMPLISH ALIGNMENT INSPECTION CHECK.		E	/
95	915 MBPAB	TRIM #1 SKIN IAW SOW		E	/
95	920 MBPAB	INSTALL ALIGNMENT PLATES AND PINS MOVE TO MBPCB		/	/
2280	930 MBPCB	FINAL WASH & TREAT FOR CORROSION		/	/
2280	935 MBPCB	PAINT INTERIOR & EXTERIOR, INSTALL EXTERIOR STENCILS PER SOW DC1560FL/82-174 MOVE TO MBPAB		/	/
95	940 MBPAB	WORK COMPLETE, CONDITION TAG & IDENTIFY IAW MA01 65-1	/	E	/
		NOTE: ANY WORK PERFORMED AND NOT COVERED BY THIS DOCUMENT WILL BE NUMBERED AND RECORDED BELOW.			
		MABPAB L. STEWARD 3-22-89			
		MABEBS L. MULLINAX 3-22-89			
		MAQBF T. HAYES 3-22-89			
		MABSCS H. NGUYEN 3-22-89			

# FLOW CHART SIDE COWL REPAIR SHOP



Fuselage  
Center Section



3153-677a

Figure 675. Main Gear Outboard Door Assemblies (Sheet 1 of 2)

FLOW PROCESS CHART

SUBJECT MLG DOOR OUTBD

DATE 4/5/89

PCN: 15119A RH  
15221A LH

WCD: 15119A WCD DATE: 8907

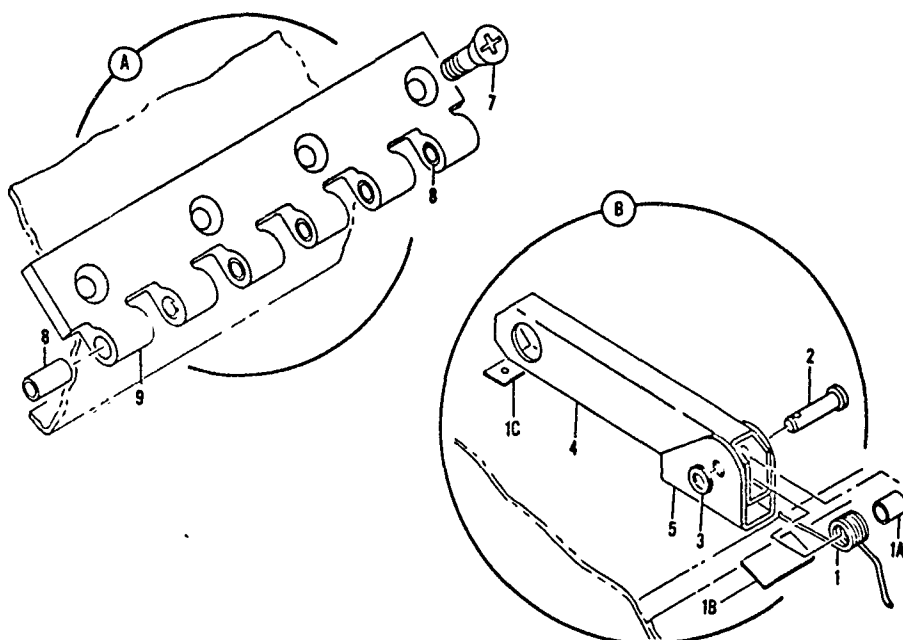
CHART BEGINS:

CHART ENDS:

PREPARED BY: LARRY M./RICARDO B.

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
010 ● ◊ D □ ▽	RECEIVE/UNCRATE 2122 MBPCD	230 ● ◊ D □ ▽	REPLACE JUMPER
○ ◊ D □ ▽	DELAY	○ ◊ D □ ▽	DELAY
○ ◊ D □ ▽	MOVE	○ ◊ D □ ▽	MOVE TO 2280
○ ◊ D □ ▽	DELAY	○ ◊ D □ ▽	DELAY
020 ● ◊ D □ ▽	WASH STRIP 2122 MBPCA	240 ● ◊ D □ ▽	FINAL WASH + GRASSHAWK TREAT 2280 MBPCB
○ ◊ D □ ▽	DELAY	250 ● ◊ D □ ▽	PAINT INTERIOR
○ ◊ D □ ▽	MOVE TO 95	260 ● ◊ D □ ▽	PAINT EXTERIOR
○ ◊ D □ ▽	DELAY	270 ● ◊ D □ ▽	STENCIL
030 ● ◊ D □ ▽	SHAKEDOWN INSPECTION 95 MBPAB	○ ◊ D □ ▽	DELAY
○ ◊ D □ ▽	DELAY	○ ◊ D □ ▽	MOVE TO 95
040 ● ◊ D □ ▽	DISASSEMBLE FOR REPAIR	○ ◊ D □ ▽	DELAY
050 ● ◊ D □ ▽	REMOVE AFT FAIRING	080 ● ◊ D □ ▽	WORK COMPLETE / CONDITION TAG
060 ● ◊ D □ ▽	REMOVE AND TREAT INTERNAL & EXTERNAL CORROSION	○ ◊ D □ ▽	
070 ● ◊ D □ ▽	INSTALL IN FIXTURE P/N 590CJ1110	○ ◊ D □ ▽	
080 ● ◊ D □ ▽	REPLACE WORN HINGE ASSY	○ ◊ D □ ▽	
090 ● ◊ D □ ▽	CHECK/REPAIR NAT PLATES	○ ◊ D □ ▽	
100 ● ◊ D □ ▽	REPLACE BUSHINGS	○ ◊ D □ ▽	
110 ● ◊ D □ ▽	REP/REP SAFETY LINK	○ ◊ D □ ▽	
120 ● ◊ D □ ▽	REP/REP CHANNEL	○ ◊ D □ ▽	
130 ● ◊ D □ ▽	REP/REP CHANNEL	○ ◊ D □ ▽	
140 ● ◊ D □ ▽	REP/REP TUBE HANGER (-27)	○ ◊ D □ ▽	
150 ● ◊ D □ ▽	REP/REP TUBE HANGER (-29)	○ ◊ D □ ▽	
160 ● ◊ D □ ▽	REPLACE BAD FASTENERS	○ ◊ D □ ▽	
170 ● ◊ D □ ▽	REP/REP RIBS & LONGBOARDS	○ ◊ D □ ▽	
180 ● ◊ D □ ▽	REMOVE FOD + CLOSE DOOR INSPECTION	○ ◊ D □ ▽	
190 ● ◊ D □ ▽	SMOOTH SKIN PANELS	○ ◊ D □ ▽	
200 ● ◊ D □ ▽	CHECK DOOR CORNERS	○ ◊ D □ ▽	
210 ● ◊ D □ ▽	CHECK ALIGNMENT	○ ◊ D □ ▽	
220 ● ◊ D □ ▽	CHECK SECURITY OF ATTACHMENTS	○ ◊ D □ ▽	

Fuselage  
Center Section



3153-677b

Figure 675. Main Gear Outboard Door Assemblies (Sheet 2 of 2)

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
675 -	5-86308-5	DOOR ASSY, OUTBOARD, MAIN GEAR (LH) (FOR NHA . . . . .)							REF	
	5-86308-6	DOOR ASSY, OUTBOARD, MAIN GEAR (RH) (FOR NHA . . . . .)							REF	
1	63-8412	• SPRING, SAFETY LINK, MAIN GEAR DOOR . . . . .							1	
1A	NAS43DD4-24	• SPACER . . . . .							1	
1B	63-8411	• STRIP, RUB, SAFETY LINK, MAIN GEAR DOOR (MAKE FROM LAM THERMOSETTING SHT COTTON FABRIC PHENOLIC RESIN MIL-P-15035 TYPE FBM 0.064 X 1.10 X 2.3)							1	
1C	63-8411-1	• STRIP, RUB, SAFETY LINK, MAIN GEAR DOOR (MAKE FROM LAM THERMOSETTING SHT COTTON FABRIC PHENOLIC RESIN MIL-P-15035 TYPE FBM 0.064 X 1.00 X 1.8)							1	
2	AN394-23	• PIN (FOR REPLACEMENT ORDER MS20392-3C23) . . . . .							1	
3	AN960-416L	• WASHER . . . . .							1	
4	30-1572	• LINK, SAFETY, MAIN GEAR DOOR (MAKE FROM 6800 BAC1501-684 5.80 LG)							1	
5	30-1573-1	• FITTING, SAFETY LINK, MAIN GEAR DOOR (LH ONLY) . . . . .							1	
	30-1575-2	• FITTING, SAFETY LINK, MAIN GEAR DOOR (RH ONLY) . . . . .							1	
6	MS25083-2886	• JUMPER ASSY . . . . .							3	
	NAS603-10	• SCREW (FOR REPLACEMENT ORDER NAS603-10P) . . . . .							3	
	BACW10P151AL	• WASHER, PLAIN . . . . .							3	
	BACW10T17L	• WASHER, 5052 AL (FOR REPLACEMENT ORDER NAS1197-10L) . . . . .							3	
6A	9-65317-1	• HINGE HALF ASSY, OUTBOARD, MAIN GEAR DOOR . . . . .							2	
6B	9-65317-5	• HINGE HALF ASSY, OUTBOARD, MAIN GEAR DOOR (LH ONLY) . . . . .							1	
	9-65317-6	• HINGE HALF ASSY, OUTBOARD, MAIN GEAR DOOR (RH ONLY) . . . . .							1	
7	NAS517-4-7	• SCREW (FOR REPLACEMENT ORDER BACB30LU4-7) . . . . .							12	
8	AA397	• BEARING, SINTFRED, PLAIN COP-TIN (90646) . . . . .							6	
		(ALTERNATES C250V0500 (71129) P349-32 (79039) A2505-3145-32 (00481)) (BACB10D130)								

CHANGED 28 JUNE 1967

2-1759

Section II  
Group Assembly Parts List

T.O.1C-135 A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
675-				
9	9-65317-3	. . HINGE HALF, OUTBOARD, MAIN GEAR DOOR (USED ON . . 9-65317-1)	1	
9	9-65317-7	. . HINGE HALF, OUTBOARD, MAIN GEAR DOOR (USED CN . . 9-65317-5)	1	
	9-65317-8	. . HINGE HALF, OUTBOARD, MAIN GEAR DOOR (USED ON . . 9-65317-6)	1	
10	5-86308-15	. PANEL, FOWARD OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR (LH ONLY)	1	
	5-86308-16	. PANEL, FOWARD OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR (RH ONLY)	1	
11	5-86308-17	. PANEL, AFT OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR . (LH ONLY)	1	
	5-86308-18	. PANEL, AFT OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR . (RH ONLY)	1	
12	5-86308-53	. GUSSET, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	5-86308-54	. GUSSET, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
13	5-86308-55	. GUSSET, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	5-86308-56	. GUSSET, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
14	5-86308-57	. GUSSET, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	5-86308-58	. GUSSET, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
15	5-86308-31	. CHANNEL, MAIN GEAR OUTBOARD DOOR . . . . .	1	
16	5-86308-32	. CHANNEL, MAIN GEAR OUTBOARD DOOR . . . . .	1	
17	60-2623-1	. CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	60-2623-2	. CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
18	60-2623-3	. CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	60-2623-4	. CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
19	5-86308-25	. BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . .	1	
	5-86308-63	. BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . .	1	
20	5-86308-26	. BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . .	1	
	5-86308-64	. BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . .	1	
21	60-2622-1	. CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	60-2622-2	. CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
22	60-2622-3	. CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	60-2622-4	. CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
23	5-86308-27	. TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . . . . (LH ONLY)	1	
	5-86308-28	. TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . . . . (RH ONLY)	1	
24	5-86308-29	. TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . . . . (LH ONLY)	1	
	5-86308-30	. TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . . . . (RH ONLY)	1	
25	5-86308-33	. STIFFENER, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	5-86308-34	. STIFFENER, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
26	5-86308-35	. STIFFENER, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .	1	
	5-86308-36	. STIFFENER, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .	1	
27	5-97061-1	. FAIRING, FORWARD WHEEL, MAIN LANDING GEAR OUTBOARD . DOOR (LH ONLY)	1	
	5-97061-2	. FAIRING, FOWARD WHEEL, MAIN LANDING GEAR OUTBOARD . DOOR (RH ONLY)	1	
28	5-97061-3	. FAIRING, AFT WHEEL, MAIN LANDING GEAR OUTBOARD DOOR (LH ONLY)	1	
	5-97061-2	. FAIRING, AFT WHEEL, MAIN LANDING GEAR OUTBOARD DOOR (RH ONLY)	1	

12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 | | | MBPAB | 89093 | |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 | | | REVI AUG 01-78, REV  
 | | | NO3-20 MAY 80, 78-1-25  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | WORK STATEMENT UC-1560  
 | KC-135 | | FL/78-1-25, 27 JUN 78  
 | | | 1C 135(K)A-3-3, & 4  
 13. MISC 14. NOUN/END ITEM NOUN |  
 | MLG DOOR - OUTBD |  
 | PHYLLIS HEALD/MABFBS/65265 |  
 P/N NON C/N  
 5-86308-5(M) 1560003397220FL 15119A  
 1560003404191FL 15321A\

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

2122	010	RECEIVE AND UNCRATE MOVE TO MBPCA MBPCA	/	/
2122	020	WASH AND STRIP, MOVE TO BLDG MBPCA 95 MBPAB	/	/
95	030	SHAKEDOWN INSPECTION MBPAB	/	/
95	040	DISASSEMBLE AS REQUIRED TO ACCUM- MBPAB LISH REPAIR.	/	/
95	050	REMOVE AFT. FAIRING MBPAB REQ NOT REQ	/	/
95	060	REMOVE AND TREAT INTERNAL AND MBPAB EXTERNAL CORROSION	E	/
95	070	INSTALL MLG DOOR IN JIG P/N MBPAB 590CJ1110 - CHECK ALIGNMENT	/	/
95	080	RELACE WORN HINDE ASSY MBPAB REQ NOT REQ	/	/
95	090	CHECK NUT FLATES MBPAB REQ NOT REQ	/	/
95	100	REPLACE BUSHINGS MBPAB REQ NOT REQ	/	/
95	110	REPAIR OR REPLACE SAFETY LINK MBPAB P/N 30-1572 REQ NOT REQ	/	/
95	120	REPAIR OR REPLACE CHANNEL MBPAB P/N 5-86308-31 REQ NOT REQ	/	/
95	130	REPAIR OR REPLACL CHANNEL MBPAB P/N 5-86308-32 REQ NOT REQ	/	/

STATION	OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19 "P"	20 "Q"
95	140	REPAIR OR REPLACE TUBE HANGER MBFAB BRACKET L/H 5-86308-27 R/H 5-86308-28 REQ _____ NOT REQ _____		/	/
95	150	REPAIR OR REPLACE TUBE HANGER MBFAB BRACKET L/H 5-86308-29 R/H 5-86308-30 REQ _____ NOT REQ _____		/	/
95	160	REPAIR OR REPLACE LOOSE, MBFAB MISSING OR DEFECTIVE FASTENERS, PINS, NUTS AND BOLTS. REQ _____ NOT REQ _____		/	/
95	170	REPAIR OR REPLACE RIBS AND LONGERONS MBFAB REQ _____ NOT REQ _____		/	/
95	180	REMOVE FOREIGN MATERIAL AND CLOSE MBFAB OUT INSPECTION. REQ _____ NOT REQ _____		E	/
95	190	SMOOTH OUT SKIN PANELS LESS THAN 20% MBFAB DAMAGE MORE THAN 20%, REPLACE SKIN REQ'D _____ NOT REQ'D _____	Replace 10 Repair 2 hrs	L	/
95	200	CHECK THAT DOOR CORNERS ARE NOT MBFAB SEALED AND ARE FREE OF DIRT.		/	/
95	210	CHECK ALIGNMENT WITH MLGR DOOR MBFAB IN JIG P/N 590CJ1110		L	/
95	220	CHECK ENTIRE MLG DOOR FOR SECUR- MBFAB RITY OF ATTACHMENTS BEFORE REMOVAL FROM FIXTURE.		E	/
95	230	REPLACE JUMPLER AS BY MBFAB REQ _____ NOT REQ _____ MOVE TO MBPCB		/	/
2280	240	FINAL WASH AND CORROSION TREAT MBFPCB REQ _____ NOT REQ _____		/	/
2280	250	PAINT INTERIOR WITH EPOXY PRIMER MBFPCB MIL-P-23377 AND POLYURETHANE PER MIL-C-83286 COLOR 37200 NOTE: TAPE BUSHINGS AND HINGE BUSHING		/	/
2280	260	PAINT EXTERIOR IAW TO 1C-135(K) MBFPCB A-3-4 SECT XI PARA 11-30		/	/
2280	270	INSTALL ALL STENCILS IAW DRAWING MBFPCB 5-86308 NOTE: PARTS STOCKLISTED AS FIELD OR DEPOT MANUFACTURE, AND NON-STOCK LISTED PARTS WITHIN THE CAPABILITY OF THE REPAIR FACILITY, WILL BE LOCALLY FABRICATED TO ENABLE		/	/

7 people - 21 hrs  
24 hrs + 12 + 3 hrs

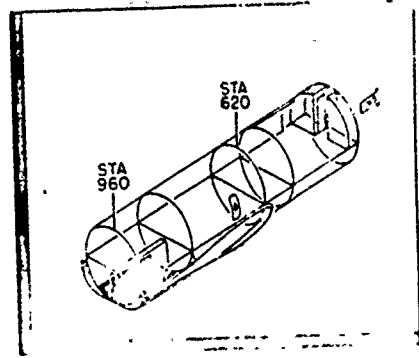
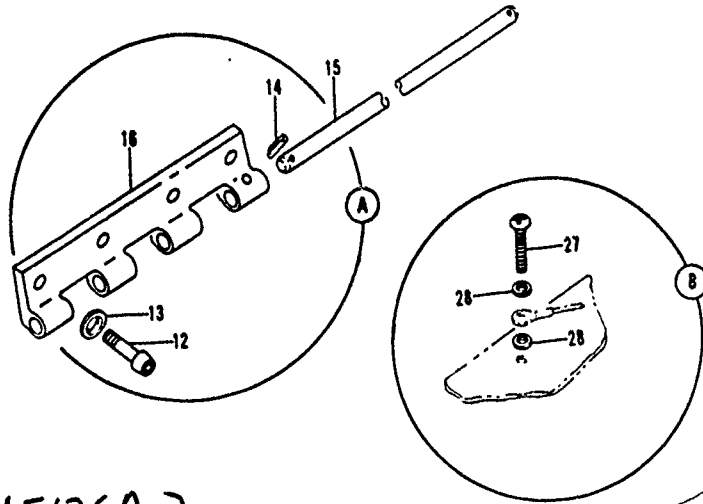


15.DISP-16.PDN/  
 STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH119"P"120"Q"

		COMPLETION OF THE UNITS UNDERGOING REPAIR MOVE TO 95, MABPAB			
95	280 MABPAB	WORK COMPLETED, CONDITION TAG CONDITION TAGGED AFW 67-1. DATE MOVE TO CRATING NOTE: PART WILL HAVE OC-ALC FORM 586, 587, OR 588 IDENTIFICATION LABELS APPLIED TO COMPLETED ITEM AFLCR 66-51 CHG. 1, PARA 2. ACCEPTANCE DATE ON THE LABEL ALONG WITH "M" STAMP OF THE PERSON PERFORMING THE OVERHAUL CAUTION: SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAMINATION. NOTE: COMPLETE "REMARKS" COLUMN OF AFLC FORM 1574 IAW MAOI 66-36. THIS PARAGRAPH IS NOT APPLICABLE TO NON-PROGRAMMED AIRCRAFT WORKLOAD.		/	/

		COORDINATION	DATE		
		MABSCS	CONNIE WEBBER	22	MARCH 89
		MABBF	TED HAYES	22	MARCH 89
		MABPAB	JESSE JACOBS	22	MARCH 89
		MABEBS	PHYLLIS HEALD	22	MARCH 89

Fuselage  
Center Section



15126A }  
15300A }

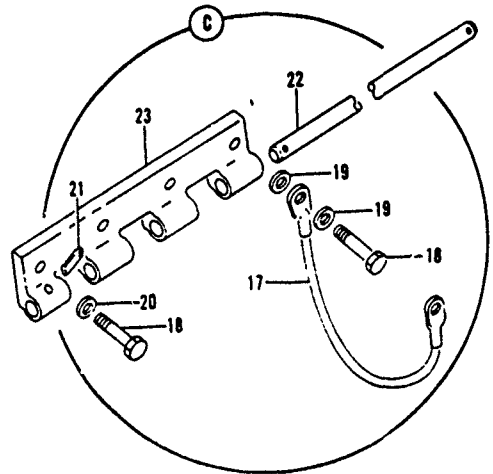
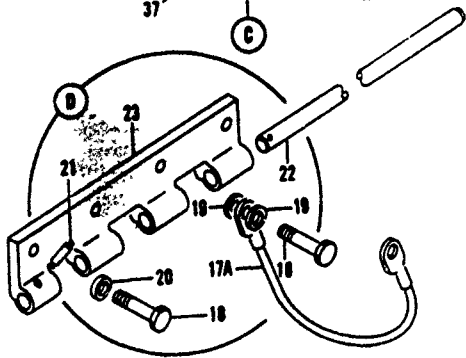
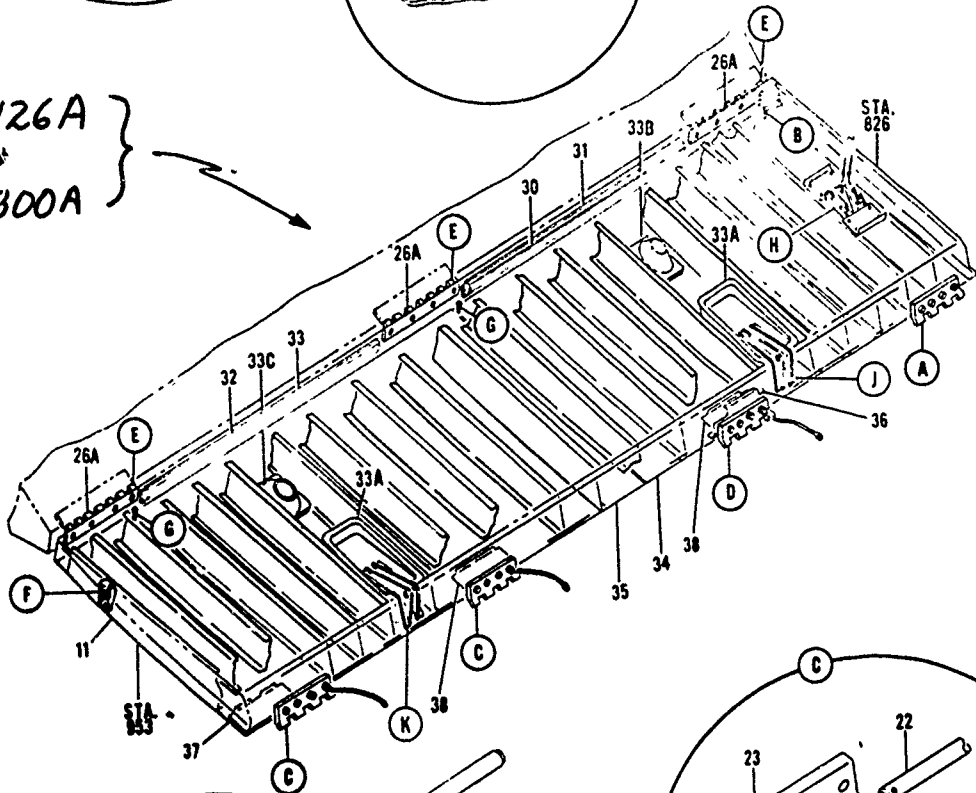


Figure 673. Main Gear Inboard Door Assemblies (Sheet 1 of 3)

FLOW PROCESS CHART

SUBJECT: Mlb Door Fald LH or RH

DATE: 4/5/89

PCN: 15126A  
15300A

WCD: 15126A WCD DATE: 89073

CHART BEGINS: Operation 210

CHART ENDS: Operation 270

PREPARED BY: Tim Hall

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
● ◊ D □ ▽	Receive and uncrate 2122 MABPCA	○ ◊ D □ ▽	Move to 2280 2280 MABPCA
○ ◊ D □ ▽	Delay	○ ◊ D □ ▽	Delay
○ ◊ D □ ▽	Move to MABPCA 2122 MABPCA	● ◊ D □ ▽	230 Final Wash & Corrosion Treat
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	240 Paint interior with epoxy primer
● ◊ D □ ▽	220 Wash and strip	● ◊ D □ ▽	250 Paint exterior
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	260 Install all stencils
○ ◊ D □ ▽	Move to Bldg 95 95 MABPCA	○ ◊ D □ ▽	Delay
○ ◊ D □ ▽	Delay	○ ◊ D □ ▽	Move to 95 95 MABPCA
● ◊ D □ ▽	230 Shutdown	○ ◊ D □ ▽	Delay
● ◊ D □ ▽	240 Disassemble	● ◊ D □ ▽	270 Condition Tag
● ◊ D □ ▽	250 Repair or replace seals & retainers	○ ◊ D □ ▽	
● ◊ D □ ▽	260 Remove aft fairing	○ ◊ D □ ▽	
● ◊ D □ ▽	270 Treat Corrosion	○ ◊ D □ ▽	
● ◊ D □ ▽	280 Install Mlb Door in Jig	○ ◊ D □ ▽	
● ◊ D □ ▽	290 Replace Worn Hinge Assembly	○ ◊ D □ ▽	
● ◊ D □ ▽	300 Replace Bushings	○ ◊ D □ ▽	
● ◊ D □ ▽	310 Replace Fittings, Emergency brake	○ ◊ D □ ▽	
● ◊ D □ ▽	320 Repair or replace defective fasteners, nuts & bolts	○ ◊ D □ ▽	
● ◊ D □ ▽	330 Repair or replace ribs or lag screws	○ ◊ D □ ▽	
● ◊ D □ ▽	340 Install pans	○ ◊ D □ ▽	
● ◊ D □ ▽	350 Remove foreign matter or close out gaps	○ ◊ D □ ▽	
● ◊ D □ ▽	360 Smooth out skin panels or replace if 70% damaged	○ ◊ D □ ▽	
● ◊ D □ ▽	370 Install pan - 2393	○ ◊ D □ ▽	
● ◊ D □ ▽	380 Install pan - 2394	○ ◊ D □ ▽	
● ◊ D □ ▽	390 Check alignment with Mlb door	○ ◊ D □ ▽	
○ ◊ D □ ▽	400 Inspect Mlb door	○ ◊ D □ ▽	
○ ◊ D □ ▽	410 Inspect door corners	○ ◊ D □ ▽	
● ◊ D □ ▽	420 Replace jumper assy	○ ◊ D □ ▽	
○ ◊ D □ ▽	Delay	○ ◊ D □ ▽	

### Fuselage Center Section

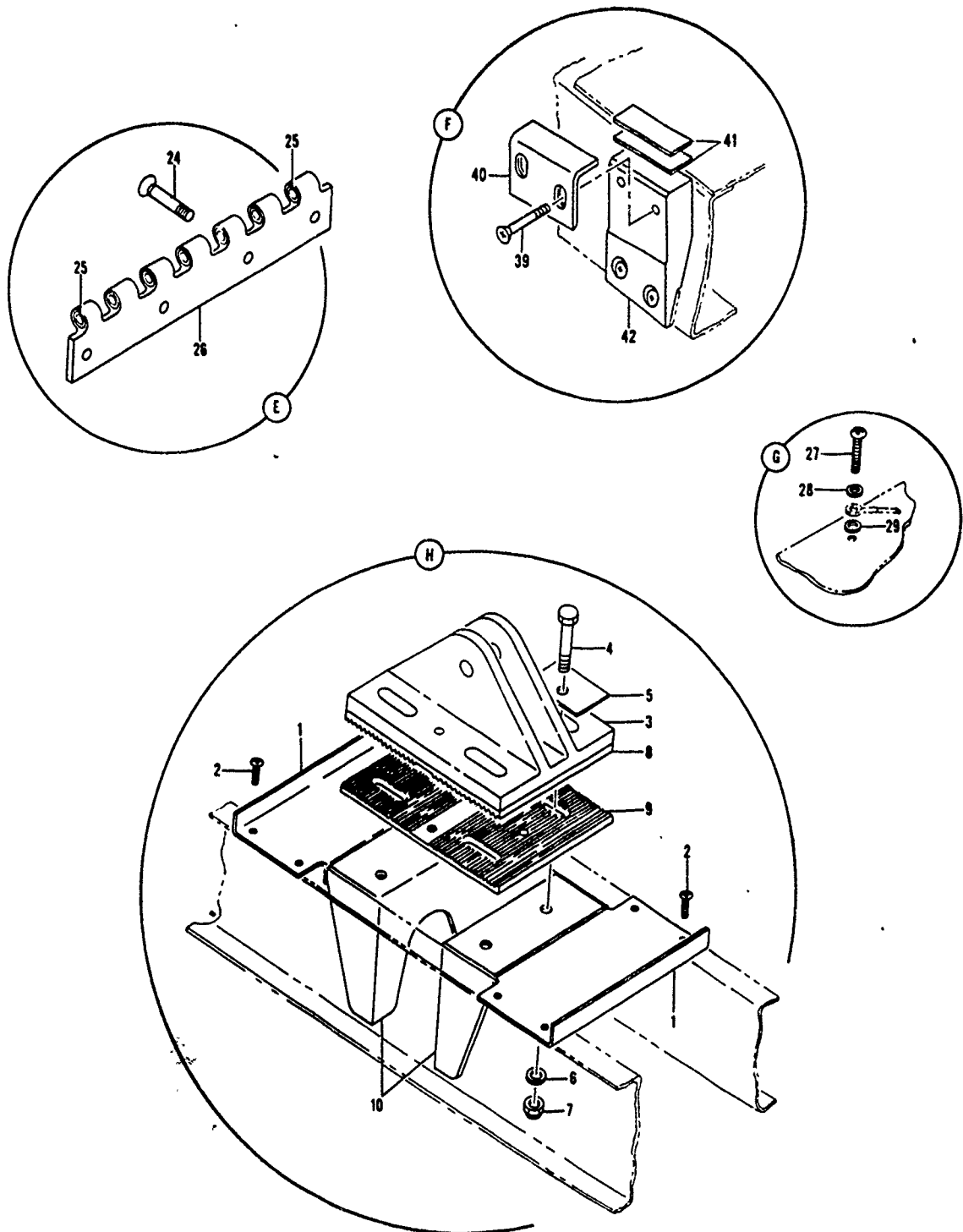


Figure 673. Main Gear Inboard Door Assemblies (Sheet 2 of 3)

### Fuselage Center Section

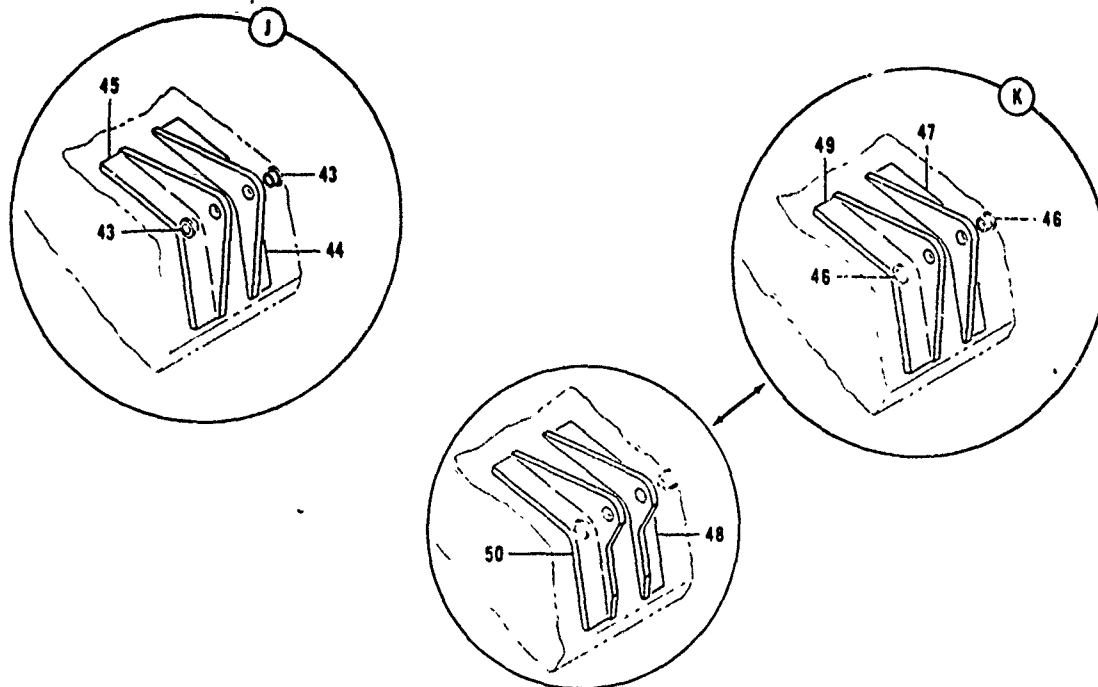


Figure 673. Main Gear Inboard Door Assemblies (Sheet 3 of 3)

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE	
		1	2	3	4	5	6	7			
873-	5-86308-3									REF	
	5-86308-4									REF	
	65-26845-1									REF	
	65-26845-2									REF	
1	5-86308-23									2	
1	5-86308-2023									2	
2	NAS603-8P									8	
3	9-65400									1	
3	9-65400-3000									1	
4	AN6-16A									4	
5	5-86308-38									4	
5	5-86308-2038									4	
6	AN960-616									4	
7	MS21042L6									4	
8	6-83599-1									1	
9	6-83599									1	

15126A  
15300A

15126A  
15300A

Section II  
Group Assembly parts List

T.O. 135A-4

F. URE & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE
		DESCRIPTION								
673-										
10	9-65343								2	
10	9-65343-2000								2	
	SALPT8-7								16	
	SALPT8-8								4	
	NAS528A7								16	
	NAS528A8								4	
11	5-96183-1								1	
	5-96183-2								1	
	9-65127-3								1	
	9-65127-4								1	
	9-65127-3003								1	
	9-65127-3004								1	
12	MS20005-13								4	
13	MS20002C5								4	
14	NAS561P3-12								1	
15	9-65127-8								1	
15	9-65127-2008								1	
16	9-65127-7								1	
16	9-65127-2007								1	
17	MS25083-2CC4								2	
17A	MS25083-2BC4								1	
	9-65125								3	B
	9-65125-5								3	A
	9-65125-2000								3	
18	AN4-10A								12	
19	BACW10P142AL								6	
20	AN960D416								9	
21	52-022-094-0812								1	
22	9-65125-4								1	B
22	9-65125-4								1	
22	9-65125-6								1	A
23	9-65125-2								1	
23	9-65125-2002								1	
	9-35317								3	
24	NAS517-4-7								12	
25	AA397								7	
26	9-65317-2								1	
26A	9-65317-3000								3	
	NAS517-4-7								12	
27	NAS603-7								3	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
		1 2 3 4 5 6 7		
673-				
27	AN520-10R7	. SCREW (FOR REPLACEMENT ORDER NAS603-7P) (USED ON . . . . . 65-26845-1, -2)	3	
28	BACW10P151AL	. WASHER, PLAIN . . . . .	4	
29	BACW10T10L	. WASHER, 5052 AL (FOR REPLACEMENT ORDER NAS1197-10L) . . . . .	2	
	5-86308-39	. SEAL ASSY, FORWARD, MAIN GEAR DOOR, LH (LH ONLY) (FOR REPLACEMENT USE BAC1521-274 AND 5-86308-43)	1	
	5-86308-40	. SEAL ASSY, FORWARD, MAIN GEAR DOOR, RH (RH ONLY) (FOR REPLACEMENT USE BAC1521-274 AND 5-86308-44) (ATTACHING PARTS)	1	
	NAS603-8	. SCREW (FOR REPLACEMENT ORDER NAS603-8P) . . . . .	12	
30	5-86308-41	. . SEAL RUBBER, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . . . BAC1521-274 X 53.6) (LH ONLY)	1	
	5-86308-42	. . SEAL, RUBBER, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . . . BAC1521-274 X 53.6) (RH ONLY)	1	
31	5-86308-43	. . RETAINER, SEAL, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . . . BAC1492-169 X 60) (LH ONLY)	1	
	5-86308-44	. . RETAINER, SEAL, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . . . BAC1492-169 X 60) (RH ONLY)	1	
	5-86308-45	. SEAL ASSY, DOOR AFT, MAIN GEAR, LH (LH ONLY) . . . . .	1	
	5-86308-46	. SEAL ASSY, DOOR AFT, MAIN GEAR, RH (RH ONLY) . . . . . (ATTACHING PARTS)	1	
	NAS603-8	. SCREW (FOR REPLACEMENT ORDER NAS603-8P) . . . . .	12	
32	5-86308-47	. . SEAL, RUBBER, DOOR AFT, MAIN GEAR (MAKE FROM . . . . . BAC1521-274 X 50.8) (LH ONLY)	1	
	5-86308-48	. . SEAL, RUBBER, DOOR AFT, MAIN GEAR (MAKE FROM . . . . . BAC1521-274 X 50.8) (RH ONLY)	1	
33	5-86308-49	. . RETAINER, SEAL, DOOR AFT, MAIN GEAR (LH ONLY) . . . . .	1	
	5-86308-50	. . RETAINER, SEAL, DOOR AFT, MAIN GEAR (RH ONLY) . . . . .	1	
33A	9-67575	. PAN, BAR, DOOR SAFETY, MAIN LANDING GEAR (USED ON . . . . . 5-86308-3, -4)	2	
33A	69-9342	. PAN, BAR, DOOR SAFETY, MAIN LANDING GEAR (USED ON . . . . . 65-26845-1, -2)	2	
33B	90-2394	. PAN, CLEARANCE, DOOR AXLE, MAIN GEAR. . . . .	1	
33C	90-2393	. PAN, CLEARANCE, DOOR AXLE, MAIN GEAR. . . . .	1	
34	5-86308-9	. SKIN, OUTBOARD PANEL, INBOARD DOOR, MAIN GEAR . . . . . (USED ON 5-86308-3)	1	
	5-86308-10	. SKIN, PANEL, FORWARD OUTBOARD, INBOARD DOOR, MAIN . . . . . GEAR (USED ON 5-86308-4)	1	
34	5-86308-3139	. SKIN, FORWARD PANEL, INBOARD DOOR, MAIN GEAR (USED ON . . . . . 65-26845-1)	1	
	5-86308-3140	. SKIN, FORWARD PANEL, INBOARD DOOR, MAIN GEAR (USED ON . . . . . 65-26845-2)	1	
35	5-86308-11	. SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . . . (USED ON 5-86308-3)	1	
	5-86308-12	. SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . . . (USED ON 5-86308-4)	1	
35	5-86308-3119	. SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . . . (USED ON 65-26845-1)	1	
	5-86308-3120	. SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . . . (USED ON 65-26845-2)	1	
36	30-2222-1	. CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . . . 5-86308-3)	1	
	30-2222-2	. CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . . . 5-86308-4)	1	
36	30-2222-3001	. CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . . . 65-26845-1)	1	
	30-2222-3002	. CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . . . 65-26845-2)	1	
37	5-86308-59	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-3) . . . . .	1	
	5-86308-60	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-4) . . . . .	1	
37	5-86308-2059	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-1) . . . . .	1	
	5-86308-2060	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-2) . . . . .	1	
38	5-86308-61	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-3) . . . . .	2	
	5-86308-62	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-4) . . . . .	2	
38	5-86308-2061	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-1) . . . . .	2	
	5-86308-2062	. GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-2) . . . . .	2	
39	NAS517-3-17	. SCREW (FOR REPLACEMENT ORDER BACB30LU3-17) (USED ON . . . . . 65-26845-1, -2)	2	
40	63-1985-2001	. ANGLE, STOP, MAIN GEAR DOOR (USED ON 65-26845-1) . . . . .	1	
	63-1985-2002	. ANGLE, STOP, MAIN GEAR DOOR (USED ON 65-26845-2) . . . . .	1	
41	BACS40C9-27	. SHIM, LAY, 0.093 THK . . . . .	2	
42	66-3668-3001	. BLOCK, DOOR STOP, MAIN GEAR DOOR (USED ON 65-26845-1) . . . . .	1	
	66-3668-3002	. BLOCK, DOOR STOP, MAIN GEAR DOOR (USED ON 65-26845-2) . . . . . (ATTACHING PARTS)	1	
	NAS517-3-5	. SCREW (FOR REPLACEMENT ORDER BACB30LU3-5) . . . . .	2	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
673-	65-26845-3	. FILLER, INBOARD DOOR, MAIN GEAR . . . . .	1	
	5-96183-2275	. FILLER, INBOARD DOOR, MAIN GEAR . . . . .	1	
	9-67006-3	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (LH ONLY) (REPLACE WITH 9-67006-11)	1	
	9-67006-4	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (RH ONLY) (REPLACE WITH 9-67006-12)	1	
43	NAS77A6-25P	. . BUSHING . . . . .	1	
44	9-67006-7	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-3)	1	
45	9-67006-8	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-4)	1	
	9-67006-3	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (USED ON 5-86308-3)	1	
	9-67006-12	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (SUITABLE SUB. FOR 9-67006-2) (USED ON 5-86308-4)	1	
	9-67006-3002	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (REWORKED BY 65-26845) (USED ON 5-86308-66)	1	
	9-67006-4	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (USED ON 5-86308-3)	1	
	9-67006-11	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (SUITABLE SUB. FOR 9-67006-1) (USED ON 5-86308-4)	1	
	9-67006-3001	. FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. . (REWORKED BY 65-26845) (USED ON 5-86308-66)	1	
46	NAS77A6-25P	. . BUSHING . . . . .	1	
47	9-67006-7	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-3)	1	
	9-67006-10	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-12)	1	
48	9-67006-2006	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-3002)	1	
49	9-67006-8	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-4)	1	
	9-67006-9	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9-67006-11)	1	
50	9-67006-2005	. . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . . (USED ON 9 67006-3001)	1	
		A 2201 THRU 2299		
		B 3001 THRU 3099		



12.ORIG/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHED 16.DATE COMP  
 | | | MABPAB | | 89073 | |

17.PART NUMBER 19.ITEM SERIAL NR 18/12.TECH DATA/OPTIONAL  
 | | | | 1. WORK STATEMENT  
 | | | | 0C-1560FL/73-1-25  
 10.MODEL/DESIGN/SERIES 11.STOCK NR | 2. 07 JUNE 78, 78 1-25  
 | RC 135 | | | 1C-135(K)A-3, 3, & 4  
 | | | | 3. REV NOS 20 MAY 80  
 13.MISC 14.NOUN/END ITEM NOUN | |  
 | | DOOR MLG INBD LH OR RH | |  
 | | PHYLJS HLALD/MABEBS/65265 | |  
 P/N NSN C/N  
 5-86308-3 156000340915FL 15126A  
 5-86308-4 15600034092161L 15300A

15.DISP STATION	16.PDN/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MI	19"P"	20"Q"
2122	010	RECEIVE AND UNCRATL MBPCD MOVE TO MBPCA		/	/
2122	020	WASH AND STRIP MBPCA MOVE TO BLDG 95		/	/
95	030	SHAKEDOWN INSPECTION MBPAB		/	/
95	040	DISASSEMBLE AS REQUIRED TO MBPAB ACCOMPLISH REPAIR.		/	/
95	050	REPAIR OR REPLACE SEALS & RETAINERS MBPAB REQ'D----- NOT REQ'D-----		E	/
95	060	REMOVE AFT FAIRING MBPAB REQ'D----- NOT REQ'D-----		/	/
95	070	REMOVE AND TREAT INTERNAL AND MBPAB EXTERNAL KORROSION. REQ'D----- NOT REQ'D-----		/	/
95	080	INSTALL MLG DOOR IN JIG P/N MBPAB 590CJ1100 - CHECK ALIGNMENT		/	/
95	090	REPLACE WORN HINJE ASSY MBPAB REQ'D----- NOT REQ'D-----		/	/
95	100	REPLACE BUSHINGS MBPAB REQ'D----- NOT REQ'D-----		/	/
95	110	REPLACE FITTINGS, EMERGENCY LINK. MBPAB REQ'D----- NOT REQ'D-----		/	/
95	120	REPAIR OR REPLA L LOOSE, MISSING, MBPAB OR DEFECTIVE FASTENERS, NUTS & BOLTS REQ'D----- NOT REQ'D-----		E	/
95	130	REPAIR OR REPLA RTBS OR LONGERONS MBPAB REQ'D----- NOT REQ'D-----		E	/



STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 110.MECH119"P"120"Q"

95	270 MBFAB	WORK COMPLETED, CONDITION TAGGED IAW AFM-67-1. DATE _____ MOVE TO CRATING. NOTE: PART WILL HAVE OC-ALC FORM 586 587 OR 588 IDENTIFICATION LABELS APPLIED TO COMPLETED ITEM IAW AFLCR 66-51 CHG. 1. PARA 2. ACCEPTANCE DATE ON THE LABEL LONG WITH "M" STAMP OF THE PERSON PERFORMING THE OVERHAUL. CAUTION: SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAM INATION. NOTE: COMPLETE "REMARK" COLUMN OF AFLO FORM 1574 IAW AAOI 66-36. THIS PARAGRAPH IS NOT APPLICABLE TO NON- PROGRAMMED AIRCRAFT WORKLOAD.	/	E	/
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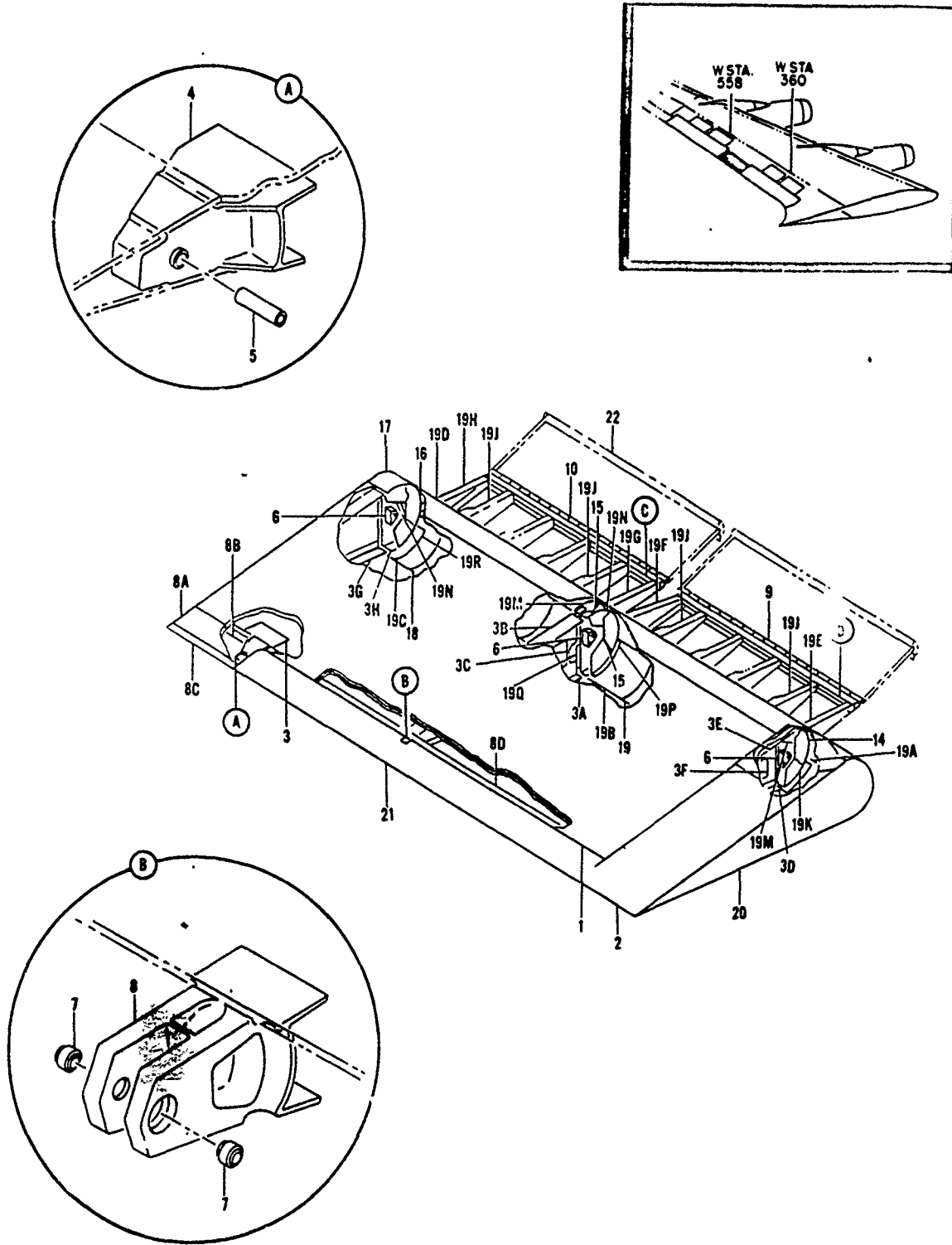
COORDINATION:	DATE:
MABJCS CONNIE WEBBER	22 MARCH 89
MADDF TLD HAYES	22 MARCH 89
MADPAB JESSIE JACOBS	22 MARCH 89
MABEBS PHYLLIS HEALD	22 MARCH 89

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
36 -	5-86072-167	AILERON AND TAB ASSY, INBOARD (LH) (FOR NHA SEE . . . . FIG. 35)	REF	
	5-86072-168	AILERON AND TAB ASSY, INBOARD (RH) (FOR NHA SEE . . . . FIG. 35)	REF	
1	5-86072-169	AILERON ASSY, INBOARD (LH ONLY) . . . . .	1	
	5-86072-170	AILERON ASSY, INBOARD (RH ONLY) . . . . .	1	
2	4-5205-1	PANEL ASSY, UPPER, SKIN, INBOARD AILERON (ALTERED FROM 4-5205) (LH ONLY)	1	
	4-5205-2	PANEL ASSY, UPPER, SKIN, INBOARD AILERON (ALTERED FROM 4-5205) (RH ONLY)	1	
3	4-5205-3	PANEL ASSY, LOWER, SKIN, INBOARD AILERON (ALTERED FROM 4-5205) (REWORKED BY 65-13097-1) (LH ONLY)	1	
	4-5205-4	PANEL ASSY, LOWER, SKIN, INBOARD AILERON (ALTERED FROM 4-5205) (REWORKED BY 65-13097-2) (RH ONLY) (ATTACHING PARTS)	1	
3A	NAS517-3-3	SCREW . . . . .	15	
	NAS517-3-4	SCREW . . . . .	70	
	NAS517-3-5	SCREW . . . . .	26	
	NAS517-3-6	SCREW . . . . .	4	
	NAS517-3-7	SCREW . . . . .	2	
	NAS517-3-8	SCREW . . . . .	2	
	NAS221-14	SCREW . . . . .	4	
3B	5-86072-145	PANEL ASSY, ACCESS, INBOARD AILERON (LH ONLY) . . . .	1	
	5-86072-146	PANEL ASSY, ACCESS, INBOARD AILERON (RH ONLY) . . . . (ATTACHING PARTS)	1	
3C	NAS517-3-3	SCREW . . . . .	7	
	NAS517-3-6	SCREW . . . . .	1	
3D	5-86072-71	CHORD, RIB, LOWER, INBOARD AILERON . . . . .	1	
	5-86072-73	CHORD, RIB, UPPER, INBOARD AILERON . . . . .	1	
3E	5-86072-107	WEB ASSY, BONDED, INBOARD AILERON (LH ONLY) . . . . .	1	
	5-86072-108	WEB ASSY, BONDED, INBOARD AILERON (RH ONLY) . . . . .	1	
3F	5-86072-93	CHORD, RIB, LOWER, INBOARD AILERON (LH ONLY) . . . .	1	
	5-86072-94	CHORD, RIB, LOWER, INBOARD AILERON (RH ONLY) . . . .	1	
3G	5-86072-91	CHORD, RIB, UPPER, INBOARD AILERON (LH ONLY) . . . .	1	
	5-86072-92	CHORD, RIB, UPPER, INBOARD AILERON (RH ONLY) . . . .	1	
3H	5-86072-109	WEB ASSY, BONDED, INBOARD AILERON (LH ONLY) . . . . .	1	
	5-86072-110	WEB ASSY, BONDED, INBOARD AILERON (RH ONLY) . . . . .	1	
4	69-5854-1	RIB ASSY, NO. 7, INBOARD AILERON (LH ONLY) . . . . .	1	
	69-5854-2	RIB ASSY, NO. 7, INBOARD AILERON (RH ONLY) . . . . .	1	
5	6-73856-1	RIB, NOSE, INBOARD AILERON (LH ONLY) . . . . .	1	
	6-73856-2	RIB, NOSE, INBOARD AILERON (RH ONLY) . . . . .	1	
6	65-7273-1	FITTING ASSY, SUPPORT, OUTBOARD TAB HINGE, INBOARD AILERON (LH ONLY)	1	
	65-7273-2	FITTING ASSY, SUPPORT, OUTBOARD TAB HINGE, INBOARD AILERON (RH ONLY)	1	
7	65-7273-3	FITTING, SUPPORT, OUTBOARD TAB HINGE, INBOARD AILERON (LH ONLY)	1	
	65-7273-4	FITTING, SUPPORT, OUTBOARD TAB HINGE, INBOARD AILERON (RH ONLY)	1	
8	90-9473-28	BUSHING, PRESSED FIT, STRUCTURAL . . . . .	1	
	6-58450-2	SUPPORT ASSY, BEARING, INBOARD AILERON (FOR BREAKDOWN SEE FIG. 37) (ATTACHING PARTS)	3	
9	NAS1104-170W	BOLT (FOR REPLACEMENT ORDER NAS1104-17D) . . . . .	2	
	NAS1104-190W	BOLT (FOR REPLACEMENT ORDER NAS1104-39D) . . . . .	2	
	NAS1104-43DM	BOLT (FOR REPLACEMENT ORDER NAS1104-43D) . . . . .	2	
	AN980-416L	WASHER . . . . .	12	
	AN320-4	NUT (FOR REPLACEMENT ORDER BACN10JD104) . . . . .	6	
	6-72071-6	FITTING ASSY, SUPPORT, CENTER HINGE TAB, INBOARD AILERON	1	
7	NAS537D4P136	BUSHING . . . . .	1	
8	6-72071-7	FITTING, SUPPORT, CENTER HINGE TAB, INBOARD AILERON	1	
8A	5-86072-147	SKIN ASSY, UPPER, PANEL, INBOARD AILERON (LH ONLY)	1	
8B	5-86072-148	SKIN ASSY, UPPER, PANEL, INBOARD AILERON (RH ONLY)	1	
	5-86072-149	SKIN ASSY, LOWER, PANEL, INBOARD AILERON (LH ONLY)	1	
8C	5-86072-150	SKIN ASSY, LOWER, PANEL, INBOARD AILERON (RH ONLY)	1	
	5-86072-127	FILLER, TRAILING EDGE, INBOARD AILERON . . . . .	1	
9	69-4383-7	BEAM INSTL, TRAILING EDGE, INBOARD AILERON (LH ONLY)	1	
	69-4383-8	BEAM INSTL, TRAILING EDGE, INBOARD AILERON (RH ONLY)	1	

15136A  
15137A

15136A  
15137A

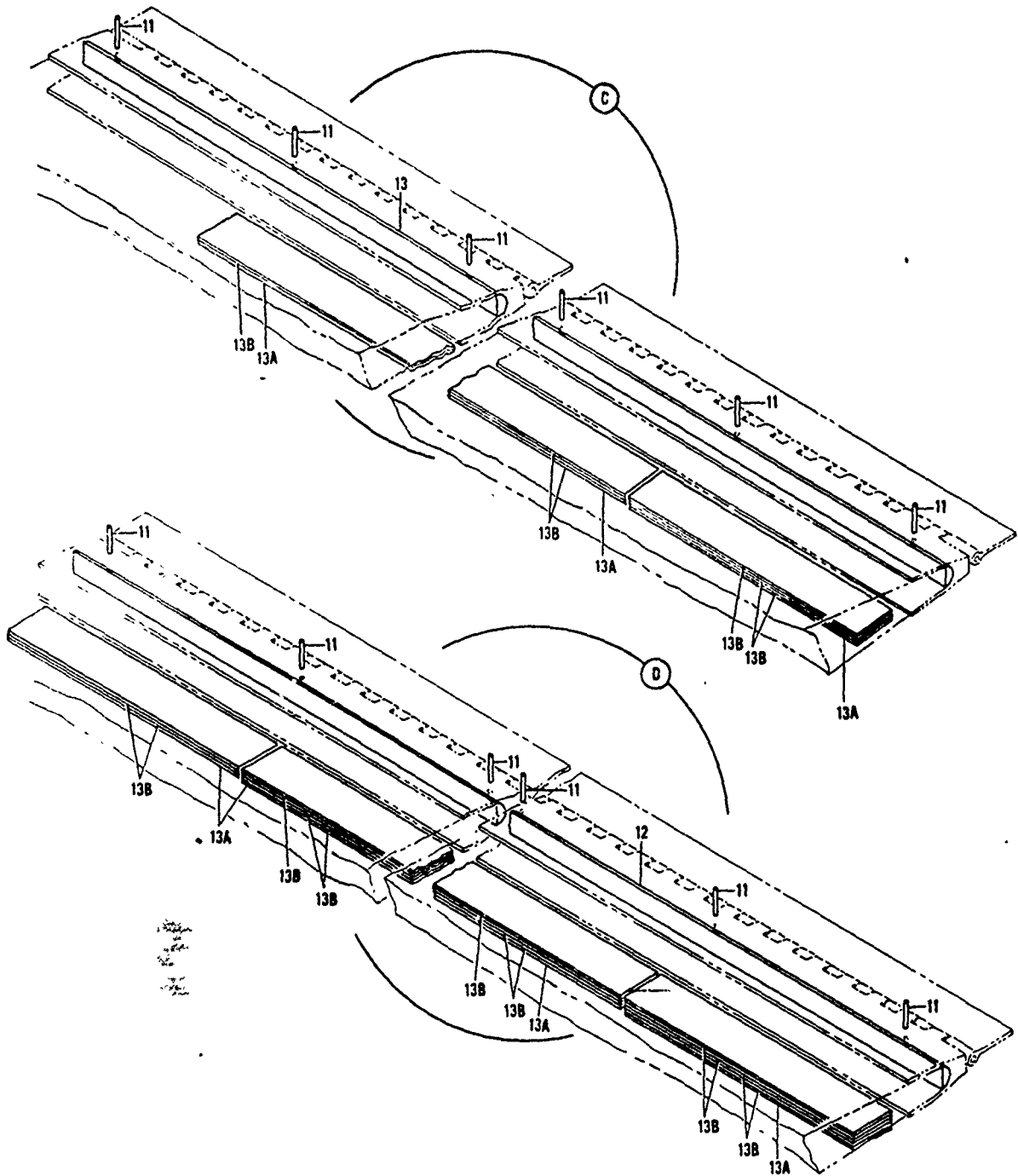
### Wing Control Surfaces



3153-36a

Figure 36. Inboard Aileron and Tab Assemblies (Sheet 1 of 2)

### Wing Control Surfaces



3153-36b

Figure 36. Inboard Aileron and Tab Assemblies (Sheet 2 of 2)

Section II  
Group Assembly Parts List

TO IC-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
36 - 80	69-4383-5	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	69-4383-6	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	NAS517-3-4	. . .	. . .	. . .	. . .	. . .	. . .	. . .	50	
	5-86074-25	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	5-86074-26	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
9	9-61122-37	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61122-38	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
10	9-61122-39	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61122-40	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
11	NAS561P3-11	. . .	. . .	. . .	. . .	. . .	. . .	. . .	12	
12	60-2641-3001	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
13	60-2641-3002	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
13A	65-1091-1	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	65-1091-2	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
13B	65-1091-16	. . .	. . .	. . .	. . .	. . .	. . .	. . .	AR	
14	90-5529	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
15	90-5529-3	. . .	. . .	. . .	. . .	. . .	. . .	. . .	2	
	AN3-5A AN960D10 NAS679A3W	. . .	. . .	. . .	. . .	. . .	. . .	. . .	6 6 6	
16	90-5529-1	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	90-5529-2	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	AN3-6A AN960D10 NAS679A3W	. . .	. . .	. . .	. . .	. . .	. . .	. . .	2 2 2	
17	66-9351-1625	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	66-9351-1626	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
18	9-61173-23	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61173-24	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
19	9-61173-21	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61173-22	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
19A	9-61173-27	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61173-28	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
19B	9-61173-5	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61173-6	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
19C	9-61173-9	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61173-10	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
19D	9-61172-7	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-61172-8	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
19E	9-60369-1	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	
	9-60369-2*	. . .	. . .	. . .	. . .	. . .	. . .	. . .	1	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
36 -				
19F	9-60370-1	. . . RIB, NOSE, INBOARD AILERON, STATION 501 (LH ONLY)	1	
	9-60370-2	. . . RIB, NOSE, INBOARD AILERON, STATION 501 (RH ONLY)	1	
19G	9-60370-3	. . . RIB, NOSE, INBOARD AILERON, STATION 501 (LH ONLY)	1	
	9-60370-4	. . . RIB, NOSE, INBOARD AILERON, STATION 501 (RH ONLY)	1	
19H	4-60371-1	. . . RIB, NOSE, INBOARD AILERON, STATION 535.14 . . . (LH ONLY)	1	
	7-60371-2	. . . RIB, NOSE, INBOARD AILERON, STATION 535.14 . . . (RH ONLY)	1	
19J	6-68499	. . . RIB, NOSE, INBOARD AILERON . . . . .	8	
19K	9-63015-1	. . . FORMER, NOSE, INBOARD AILERON (LH ONLY) . . . . .	1	
	9-63015-2	. . . FORMER, NOSE, INBOARD AILERON (RH ONLY) . . . . .	1	
19L	DELETED			
19M	9-63015-4	. . . FORMER, NOSE, INBOARD AILERON . . . . .	2	
19N	9-63015-3	. . . FORMER, NOSE, INBOARD AILERON . . . . .	2	
19P	9-63015-6	. . . FORMER, NOSE, INBOARD AILERON . . . . .	1	
19Q	9-63015-5	. . . FORMER, NOSE, INBOARD AILERON . . . . .	1	
19R	9-63015-7	. . . FORMER, NOSE, INBOARD AILERON (LH ONLY) . . . . .	1	
	9-63015-8	. . . FORMER, NOSE, INBOARD AILERON (RH ONLY) . . . . .	1	
20	5-86071-115	. . . END INSTL, INBOARD AILERON (LH ONLY) (FOR BREAKDOWN SEE FIG. 38)	1	
	5-86071-116	. . . END INSTL, INBOARD AILERON (RH ONLY) (FOR BREAKDOWN SEE FIG. 38)	1	
21	65-6774-7	. . . TAB INSTL, INBOARD AILERON (LH ONLY) (FOR BREAKDOWN . SEE FIG. 39)	1	
	65-6774-8	. . . TAB INSTL, INBOARD AILERON (RH ONLY) (FOR BREAKDOWN . SEE FIG. 39)	1	
22		PANEL INSTL, BALANCE, INBOARD AILERON (FOR REF . . . . . SEE FIG. 41)	REF	



FLOW PROCESS CHART

SUBJECT Aileron Assy Inbd DATE 4/5/89

PCN: 15136A WCD: 15136A WCDDATE: 88205  
15137A

CHART BEGINS Operation 010

CHART ENDS Operation 440 PREPARED BY: Tim Hall

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
010 ● ◊ D □ ▽	Receive and Uncrate 2122 MABPCA	160 ● ◊ D □ ▽	Replace defective ribs and nose string
○ ◊ D □ ▽	Delay	170 ● ◊ D □ ▽	Replace defective bearings
○ ◊ D □ ▽	Move to MABPCA 2122 MABPCA	180 ● ◊ D □ ▽	Replace in over panel hinges
○ ◊ D □ ▽	Delay	190 ● ◊ D □ ▽	Replace loose or missing fasteners
020 ● ◊ D □ ▽	Wash & strip paint	200 ● ◊ D □ ▽	Replace chafing stripes
030 ● ◊ D □ ▽	Treat for corrosion	210 ● ◊ D □ ▽	Repair delamination of upper & lower skin panels
○ ◊ D □ ▽	Delay	220 ● ◊ D □ ▽	Replace upper skin panels
○ ◊ D □ ▽	Move to 95 95 MABMB	230 ● ◊ D □ ▽	Replace Lower skin panels
○ ◊ D □ ▽	Delay	240 ● ◊ D □ ▽	Install aileron in Jig
040 ● ◊ D □ ▽	Shakedown	250 ● ◊ D □ ▽	Remove & replace Tab Hinge Fitting
050 ● ◊ D □ ▽	Treat Corrosion	260 ● ◊ D □ ▽	Remove FDB & accomplish close out
○ ◊ D □ ▽	Delay	270 ● ◊ D □ ▽	Install skin panels
○ ◊ D □ ▽	Move to 3001 3001 MATPKT	280 ● ◊ D □ ▽	Perform alignment check
○ ◊ D □ ▽	Delay	290 ● ◊ D □ ▽	Remove from jig
060 ● ◊ D □ ▽	Replace bushing in center hinge fitting	300 ● ◊ D □ ▽	Replace defective seals
070 ● ◊ D □ ▽	Replace bushing in Tab Hng Fitting	310 ● ◊ D □ ▽	Replace defective access doors
080 ● ◊ D □ ▽	Replace Rod end bearings	320 ● ◊ D □ ▽	Install access panels
090 ● ◊ D □ ▽	Install bushing in inboard aileron	330 ● ◊ D □ ▽	Replace Fairings
100 ● ◊ D □ ▽	Install bushing in center ailerons	340 ● ◊ D □ ▽	Repair dents, gouges, nicks & scratches
110 ● ◊ D □ ▽	Install bushing in bellcrank 985y	350 ● ◊ D □ ▽	Fill skin
120 ● ◊ D □ ▽	Install bushing in outbd aileron	○ ◊ D □ ▽	Delay
130 ● ◊ D □ ▽	Install bushing in inboard aileron snubber	○ ◊ D □ ▽	Move to MABPCB 2280 MABPCB
130 ● ◊ D □ ▽	Install bushing in support control mechanism	○ ◊ D □ ▽	Delay
135 ● ◊ D □ ▽	Transfer holes on 8- bearing support bolt	○ ◊ D □ ▽	Final Wash
140 ● ◊ D □ ▽	Transfer holes on top support bolt - 2001	360 ● ◊ D □ ▽	Mask off aileron
○ ◊ D □ ▽	Delay	370 ● ◊ D □ ▽	Prime
○ ◊ D □ ▽	Move to 95 95 MABPCB	380 ● ◊ D □ ▽	Paint
○ ◊ D □ ▽	Delay	390 ● ◊ D □ ▽	Delay
150 ● ◊ D □ ▽	Check nose end ribs for cracks	○ ◊ D □ ▽	Move to 95 95 MABPCB



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 | 15136A \* WORK CONTROL DOCUMENT \* MISTR 1.DATE 88205 PAGE 1 OF 5 PAGES |  
 |-----\*\*\*\*\*-----|  
 | 12.ORIG/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHLD 16.DATE COMP |  
 | | | MABPAB | | 89093 | |

-----  
 | 17.PART NUMBER 19.ITEM SERIAL NR 18/12.TECH DATA/OPTIONAL |  
 | | | | 1. SOW C/N UC 156078-1- |  
 |-----  
 | 24. DTD 22 JUN 78 |  
 | 10.MODEL/DESIGN/SERIES 11.STOCK NR | 2.REV NO.1, DTD 19 FEB 79 |  
 | C-135 | | 3.WRITE ADD'D WORK REQ'D |  
 |-----  
 | 4.1.0.1C (135(K)A-3 1,3-3, |  
 | 13.MISC.14.NOUN/END ITEM NOUN | 6.1 1 4,1-1 8. |  
 | | AILERON ASSY INBD | |  
 |-----  
 | MICHAEL TYTANIC/MABERS/65261 |

P/N	NSN	C/N
(M) 5-86072-169	1560004413621FL	15136A✓
5-86072-165	1560006740912FL	15219A
5-86072-105	1560006046701FL	15301A
5-86072-161	1560006210777FL	15303A
5-86072-153	1560006714863FL	15304A
5-86072-117M	1560006527448FL	15306A
(M) 5-86072-170	1560004457470FL	15137A✓
5-86072-166	1560006740713FL	15215A
5-86072-106	1560006046702FL	15302A
5-86072-154	1560006214834FL	15305A
5-86072-118M	1560006527449FL	15307A

15. DTD 16. DNY /  
 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED

STATION/OP NO.	WORK TO BE ACCOMPLISHED	CO	12	12
2122 010	RECEIVE & UNCRATE MBPCD MOVE TO WASH RACK BLDG 2122 MBPCA	CO	/	/
2122 020	WASH & STRIP EXTERIOR PAINT IAW T.O. MBPCA 1C-135(K)A-3-4, SECTION XI. NOTE: PLUG ALL DRAIN HOLES TO PREVENT STRIPPER FROM ENTERING INTERIOR.	4W	/	/
2122 030	TREAT FOR CORROSION IAW T.O. 1C-135 MBPCA (K)A-3-4, SECTION JV	4W	/	/
95 040	REMOVE LOWER SKIN PANELS AND MBPAB ACCOMPLISH SHAKEDOWN INSPECTION IAW SOW. ANNOTATE DISCREPANCIES.	EG	/	/
95 050	REMOVE & TREAT CORROSION IAW T.O. MBPAB 1C-135(K)A-3-4, SECTION IV. REQ'D _____ NOT REQ'D _____ MOVE TO MTPIT	EG	/	/
0-65 060	REPLACE BUSHING IN CENTER TAB HINGE MTPIT FITTING IAW 1C-135(K)A-3-3 REQ'D _____ NOT REQ'D _____	JA	/	/
0-65 070	REPLACE BUSHING ON OUTBRD TAB HINGE MTPIT FITTING IAW T.O. 1C-135(K)A-3-3 REQ'D _____ NOT REQ'D _____	JA	/	/

BLDG  
3001

3001

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

0-65	080 MTPIT	REPLACE WORN OR LOOSE ROD END BEARINGS IAW T.O. 1C-135(K)A-3-3, FIG 2-10, DETAIL I, JOINT 2	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0 65	090 MTPIT	INSTALL BUSHING IN INBOARD AILERON ATTACH BEARING SUPPORT IAW 1C-135 (K)A 3-3, FIG 2 10. DETAIL I, JOINT. 3 & 12.	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0 65	100 MTPIT	INSTALL BUSHING IN CENTER AILERON ATTACH BEARING SUPPORT IAW 1C-135(K) A-3 3, FIG 2-10, DETAIL III, JOINT 3	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0-65	105 MTPIT	INSTALL BUSHINGS IN BELLEKAMP ASSY. IAW 1C 135(K)A 3-3, FIG 2-10, DETAIL I, JOINT 3 & 12. MAX. .2495 .2505	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0-65	110 MTPIT	INSTALL BUSHING IN OUTBOARD AILERON ATTACH BEARING SUPPORT IAW 1C-135(K) A-3-3, FIG 2-10 DETAIL II, JOINT 3	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0-65	120 MTPIT	INSTALL BUSHING IN INBOARD AILERON SNUBBER IAW 1C-135(K)A-3-3, FIG 2-10B	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0 65	130 MTPIT	INSTALL BUSHING IN SUPPORT CONTROL MECHANISM IAW 1C-135 (K)A-3-3	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0-65	135 MTPIT	TRANSFER HOLES ON BEARING SUPPORT BRACKET, P/N 69-1353 8 & 9 IAW WITH T.O. 135(K)A-3-3.	JA	/	/
		REQ'D _____ NOT REQ'D _____			
0-65	140 MTPIT	TRANSFER HOLES ON BEARING SUPPORT BRACKET, P/N 7-60366-2001 IAW 1C-135 (K)A-3-3	JA	/	/
		REQ'D _____ NOT REQ'D _____			
95	150 MBPAB	CHECK NOSE END RIBS FOR CRACKS. IF CRACKED, REMOVE NOSE SKIN & INSPECT ALL NOSE RIBS.	ES	/	/

(CONTINUED)

15. DISP-16. PDN/

STATION	OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19. P	20. Q
		REQ'D _____ NOT REQ'D _____			
95	160 MBPAB	REPLACE RIDGS AND ROSE SKINS THAT HAVE CRACKS AND/OR OVERSIZED HOLES.	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	170 MBPAB	REPLACE DAMAGED, LOOSE OR FROZEN BEARINGS.	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	180 <del>MBPAB</del> MBPAB	REPLACE BALANCE PANEL HINGES.	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	190 MBPAB	REPLACE LOOSE AND/OR MISSING FASTENERS IAW WORK STATEMENT.	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	200 MBPAB	REPLACE CHAFING STRIPS	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	210 MBPAB	REPAIR DELAMINATION OF UPPER & LOWER SKIN PANELS IAW T.O. 1C-135(K)A-3-1, SECTION X	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	220 MBPAB	REPLACE UPPER SKIN PANELS	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	230 MBPAB	REPLACE LOWER SKIN PANELS. NOTE: CLEAN & CLOSE OUT INSPECTION REQ'D.	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	240 MBPAB	INSTALL AILERON IN JIG P/N59UCJ 1010	ES	/	/
95	250 MBPAB	REMOVE & REPLACE DAMAGED CAB HINGE FITTING WITH NEW FITTING PART NO. 1C-135(K)A-3-1	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	260 MBPAB	REMOVE FOD & ACCOMPLISH CLOSE OUT	ES	/	/
95	270 MBPAB	INSTALL SKIN PANELS	ES	/	/
		REQ'D _____ NOT REQ'D _____			
95	280 MBPAB	PERFORM ALIGNMENT CHECK. 1C-135(K)A-3-4, XXXXXXXXXXXXXXXXXXXXX	ES	/	/

*****					
15136A * WORK CONTROL DOCUMENT * MISTR 1.DATE 98205 PAGE 4 OF 5 PAGES					
115.DISP-16.PDN/					
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED			118.MECH 19"P" 20"Q"		
95	290	REMOVE FROM JIG	ES	/	/
	MBPAB				
95	300	REPLACE DAMAGED OR WORN FELT SEALS	ES	/	/
	MBPAB	WITH NEW SEALS.			
		REQ'D NOT REQ'D			
95	310	REPLACE ANY DAMAGED ACCESS DOORS	ES	/	/
	MBPAB				
		REQ'D NOT REQ'D			
95	320	INSTALL ACCESS PANELS. NOTIFY CLOS	ES	/	/
	MBPAB	OUT INSPECTION REQUIRED. MOVE TO			
		BLDG 2280-MBPCB.			
95	330	REPLACE FAIRINGS P/N9-66805 1 &	ES	/	/
	MBPAB	69-8605-5 IF DAMAGED.			
		REQ'D NOT REQ'D			
95	340	REPAIR ALL DENTS, GOUGES, NICKS &	ES	/	/
	MBPAB	SCRATCHES IAW T.O.1C-135(K)A-3-1			
		REQ'D NOT REQ'D			
95	350	FILL SKIN TO STRUCTURE GAPS WITH	ES	/	/
	MBPAB	ENVIRONMENTAL SEALANT.			
2280	360	FINAL WASH & TREAT PRIOR TO PAINT.	ES	/	/
	MBPCB	MOVE TO PAINT-BLDG 2280-MBPCB			
2280	370	MASK OFF AILERON IAW 1C-135(K)A 3-4,	3B	/	/
	MBPCB	XXXXXXXXXXXXXXXXXXXX			
2280	380	AFTER MASKING OFF AILERON PRIME IAW			
	MBPCB	1C-135(K)A-3-4, XXXX XXXX XXXX XXX			
2280	390	PAINT AILERON IAW T.O. 1C-135(K)	3B	/	/
	MBPCB	A-3-1.			
		MOVE TO BLDG 95, MBPAB			
95	400	BALANCE AILERON IAW T.O. 1C-135(K)	ES	/	/
	MBPAB	A-3-1			
95	410	REMOVE OR MARK OUT EXISTING WEIGHT	ES	/	/
	MBPAB	MARKINGS.			
95	420	INSTALL NEW WEIGHT & BALANCE DATA &	ES	/	/
	MBPAB	DATE.			
95	430	SERVICE BEARINGS AND WRAP WITH	ES	/	/
	MBPAB	BARRIER PAPER			
95	440	WORK COMPLETED. CONDITION TAG IAW	ES	/	/
	MBPAB	AFM 67-1. DATE			
		MOVE TO CRATING.			
		NOTE: PART WILL HAVE LITHER OC-ALC			

(CONTINUED)

15.DISP-16.PDN/

STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.MECH | 19."F" | 20"Q"

FORM 586,587 OR 588 IDENTIFICATION  
 LABELS APPLIED TO COMPLETED ITEM IAW  
 AFLCR 66-51, CHG 2  
 ACCEPTANCE DATE ON THE LABEL ALONG  
 WITH "M" STAMP OF THE PERSON PERFORM  
 ING THE OVERHAUL.  
 CAUTION: SURFACES TO WHICH LABELS ARE  
 APPLIED MUST BE FREE OF CONTAMINA-  
 TION. NOTE: COMPLETE "REMARKS"  
 COLUMN OF AFLC FORM 1574 IAW MAUI  
 66-56.

MABEFS	MICHAEL TYTANIC	23	FLB	88
MAQBF	TED HATES	23	FLB	88
MABSF	PAT HANLOCK	23	FLB	88
MBFAB	GARY HART	23	FLB	88

Power Plant

15140 A

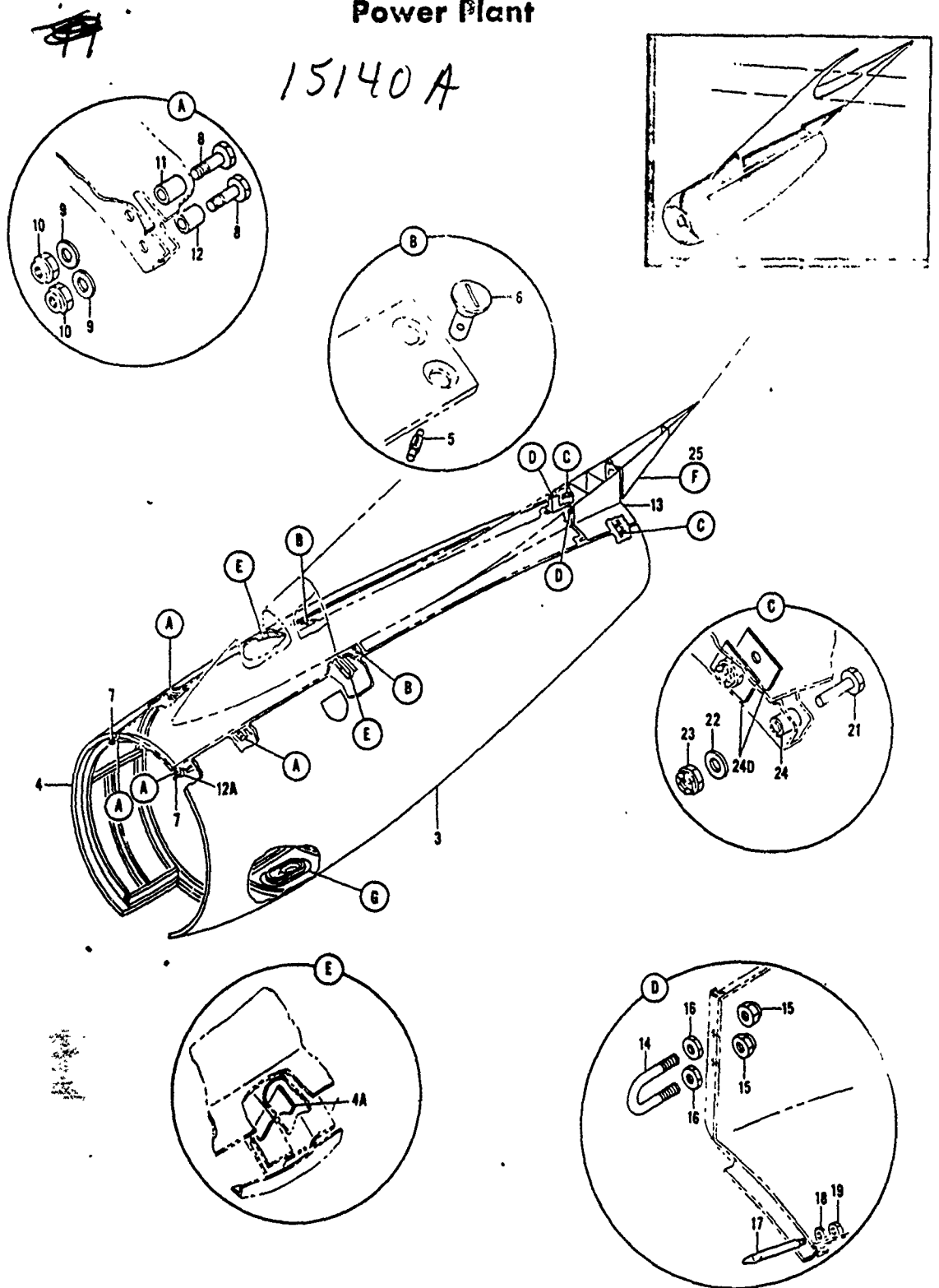


Figure 1100. Engine Nacelle Cowl Installations (Sheet 1 of 2)



FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	JSE
			PER ASSY	ON CODE
1100-	50-3371	COWL INSTL, ENGINE NACELLE (ENGINES NO. 1, 2 AND 3) . . . (FOR NHA SEE FIG. 1099)	REF	A
	50-3371-1	COWL INSTL, ENGINE NACELLE (ENGINE NO. 4) (FOR NHA SEE . . FIG. 1099)	REF	A
1	NAS514P1032-6	. SCREW (FOR REPLACEMENT ORDER NAS514P1032-6P) . . . . .	10	A
2	NAS679A3W	. NUT (ALTERNATE BACN10JC3) . . . . .	10	A
2A	90-3342	. DUCT, AIR EXHAUST, ALTERNATOR COOLING (USED ON 50-3371)	1	A
2A	90-3343-2	. DUCT, EXHAUST, FUEL AIR STARTER (USED ON 50-3371-1) . . .	1	B
2A	90-3343-1	. DUCT, EXHAUST, FUEL AIR STARTER (USED ON 50-3371-1) . . .	1	C
2B	1200874-10	. SEAL ASSY, BELLOW, EXHAUST EXIT, FUEL AIR STARTER. . . . (98769) (BOEING SPEC 10-2748-1) (ALTERNATE 65-32834-1) (USED ON 50-3371-1)	1	B
2B	1200874	. SEAL ASSY, BELLOW, EXHAUST EXIT, FUEL AIR STARTER. . . . (98769) (ALTERNATE 8449402 (71688)) (BOEING SPEC 10-2748) (FOR REPLACEMENT ORDER 1200874-10 (98769) (BOEING SPEC 10-2748-1)) (USED ON 50-3371-1)	1	C
2B	1200874	. SEAL ASSY, BELLOW, EXHAUST EXIT, FUEL AIR STARTER. . . . (98769) (ALTERNATE 8449402 (71688)) (BOEING SPEC 10-2748) (FOR REPLACEMENT ORDER 1200874-10 (98769) (BOEING SPEC 10-2748-1)) (USED ON 50-3371) FOR REPAIR OF 1200874 AND 1200874-10 ORDER 69B25097-1)	1	A
2C	69-22576-1	. SEAL, GASKET, STARTER EXHAUST EXIT (USED ON 50-3371-1).	AR	B
3	5-85637	. PANEL ASSY, SIDE COWL, LEFT HAND, ENGINE NACELLE (FOR . BREAKDOWN SEE FIG. 1101)	1	A
3	35-32371-1	. PANEL ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE (FOR. . BREAKDOWN SEE FIG. 1101)	1	A
4	5-85638	. PANEL ASSY, SIDE COWL, RIGHT HAND, ENGINE NACELLE . . . (FOR BREAKDOWN SEE FIG. 1102)	1	A
4	35-32370-1	. PANEL ASSY, SIDE COWL, RIGHT HAND, ENGINE NACELLE (FOR. BREAKDOWN SEE FIG. 1102)	1	A
4	7727042-10	. PANEL ASSY, SIDE COWL, RIGHT HAND, ENGINE NACELLE (FOR. BREAKDOWN SEE FIG. 1102)	1	A
	5-85654-25	. FAIRING ASSY, NACELLE FORWARD . . . . .	1	B
	5-85654	. FAIRING ASSY, NACELLE FORWARD (ALTERNATE AND FOR. . . . REPLACEMENT ORDER 5-85654-25)	1	C
4A	5-85654-21	. . . . . BLOCK, STOP, NACELLE FORWARD. . . . .	2	A
5	99836	. . . . . PIN, COWL FASTNR (61864) (BACP18A5) . . . . .	4	A
6	98265-2-.230	. . . . . STUD, COWL FASTNR (61864) (BACS21B5FH23) . . . . .	4	A
7	60-1507	. . . . . PIN, FAIRING SUPPORT, FORWARD NACELLE . . . . . (ATTACHING PARTS)	2	A
	NAS517-3-8	. . . . . SCREW (ALTERNATE BACB30LU3-8) . . . . .	2	A
	NAS517-3-12	. . . . . SCREW (ALTERNATE BACB30LU3-12) . . . . .	2	A
	AN960-10L	. . . . . WASHER. . . . .	4	A
	NAS679A3W	. . . . . NUT (ALTERNATE BACN10JC3) . . . . .	4	A
8	NAS1104-11W	. . . . . BOLT (ALTERNATE BACB30NE4-11) . . . . .	8	A
9	AN960-416	. . . . . WASHER. . . . .	8	A
10	NAS679A4W	. . . . . NUT (ALTERNATE BACN10JC4) . . . . .	8	A
11	6-84606	. . . . . SPACER, HINGE, COWL PANEL, ENGINE NACELLE . . . . .	4	A
12	6-84606-1	. . . . . SPACER, HINGE, COWL PANEL, ENGINE NACELLE . . . . .	4	A
12A	5-85654-3	. . . . . FRAME, FORWARD FAIRING, NACELLE . . . . .	1	A
	5-85653-51	. . . . . FAIRING ASSY, AFT, ENGINE NACELLE, SECTION 71 . . . . .	1	A
13	5-85653-52	. . . . . FAIRING ASSY, AFT FWD, ENGINE NACELLE, SECTION 71 . . . . .	1	A
14	9-64304-1	. . . . . U-BOLT, COWL LATCH, ENGINE NACELLE. . . . . (ATTACHING PARTS)	2	A
15	MS21042L5	. . . . . NUT (REPLACES NAS679A5 OR BACN10JC5) . . . . .	4	A
16	AN375-SR	. . . . . NUT . . . . .	4	A
17	60-1491	. . . . . PIN, GUIDE, COWL FAIRING, ENGINE NACELLE. . . . . (ATTACHING PARTS)	2	A
18	AN960-6.16L	. . . . . WASHER. . . . .	2	A
19	MS21042L6	. . . . . NUT (REPLACES NAS679A6 OR BACN10JC6) . . . . .	2	A

FLOW PROCESS CHART

SUBJECT FAIRING ASSY FWD NACELLE DATE 4/5/89

PCN: 15140A WCD: 15140A WCD DATE: 89073

CHART BEGINS \_\_\_\_\_ PAGE 1 OF 1

CHART ENDS \_\_\_\_\_ PREPARED BY: R. BOLANDS

WCD OF #	SYMBOLS	DESCRIPTION	WCD OF #	SYMBOLS	DESCRIPTION
10	● ◊ □ ▽	REC. + CONCRATE 222 MABPCD	240	● ◊ □ ▽	R/R PINS
	○ ◊ □ ▽	DELAY	250	● ◊ □ ▽	CHECK ALIGNMENT
	○ ◊ □ ▽	MOVE TO CLEAN + STRIP MABPCA	260	● ◊ □ ▽	INSTALL UPPER BUSHINGS
	○ ◊ □ ▽	DELAY	270	● ◊ □ ▽	ASSURE LATCH FITS BUSHING
20	● ◊ □ ▽	STRIP PAINT + CLEAN		○ ◊ □ ▽	DELAY
	○ ◊ □ ▽	DELAY		○ ◊ □ ▽	MOVE TO WASH + PAINT 2280 MABPCB
	○ ◊ □ ▽	MOVE TO SHEETMETAL 95 MABPAB		○ ◊ □ ▽	DELAY
	○ ◊ □ ▽	DELAY	280	● ◊ □ ▽	WASH
30	○ ◊ □ ▽	SHAKEDOWN INSPECTION	290	● ◊ □ ▽	PAINT INTERIOR SURFACE
40	● ◊ □ ▽	REMOVE CORROSION		○ ◊ □ ▽	DELAY
50	● ◊ □ ▽	REPAIR L.H. LONGERON		○ ◊ □ ▽	MOVE TO SHEETMETAL 95 MABPAB
60	○ ◊ □ ▽	BLANK STEP		○ ◊ □ ▽	DELAY
70	● ◊ □ ▽	R/R FRAME 5-85654-5	300	● ◊ □ ▽	WORK COMPLETED INSPECT TAG
80	● ◊ □ ▽	ASSY. 60-1512-1 + 60-1512-2 PLATES, INSTALL BLOCK + L. BUSHING		○ ◊ □ ▽	
90	● ◊ □ ▽	R/R FRAME 5-85654-4		○ ◊ □ ▽	
100	● ◊ □ ▽	R/R LONGERON IN FIXTURE 5-85647-ASMT "		○ ◊ □ ▽	
110	● ◊ □ ▽	INSTALL PLATES		○ ◊ □ ▽	
120	● ◊ □ ▽	R/R FORMER		○ ◊ □ ▽	
130	● ◊ □ ▽	ASSY. PLATES		○ ◊ □ ▽	
140	● ◊ □ ▽	R/R FRAME IN FIXTURE		○ ◊ □ ▽	
150	● ◊ □ ▽	R/R SKIN ON FIXTURE 5-85654-800		○ ◊ □ ▽	
160	● ◊ □ ▽	R/R SKIN ON FIXTURE -801		○ ◊ □ ▽	
170	● ◊ □ ▽	R/R STIFFENER		○ ◊ □ ▽	
180	● ◊ □ ▽	R/R ANGLE R.H.		○ ◊ □ ▽	
190	● ◊ □ ▽	R/R ANGLE L.H.		○ ◊ □ ▽	
200	● ◊ □ ▽	R/R FRAME 60-1514-1		○ ◊ □ ▽	
210	● ◊ □ ▽	R/R " -2		○ ◊ □ ▽	
220	● ◊ □ ▽	R/R FASTENERS		○ ◊ □ ▽	
230	● ◊ □ ▽	R/R DENTS/SCRATCHES		○ ◊ □ ▽	

NO OPERATION  
DONE ←

2. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 | | | MBFAB | | 89093 | |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 | | | | 1. IC-135(K)A-3-1, 3-4, A  
 | | | | 4 0C-1560FL/78-1-1,  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | 2. ECO 13MAY83  
 | C 135 | | | 3. FILL IN ANY ADD'L  
 | | | | 4. WORK REQ'D.  
 13. MISC 14. NOUN/END ITEM NOUN | |  
 | FAIRING ASSY FWD NACELLE | |  
 | PHYLLIS HEAD/MABEBS/65265 | |  
 P/N NSN C/N  
 5-85654-15 1560004637577FL 15140A  
 5-85654-28 1560001361731FL 15107A  
 5-85654 1560003407212FL 15125A

15. DISP	16. PDN/STATION/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	15" P"	120" Q"
	2122 010 MBPCD	RECEIVE & UNCRATE MOVE TO MBPCA		/	/
	2122 020 MBPCA	STRIP INTERIOR OF ZINC CHROMATE & CLEAN EXTERIOR SURFACE IAW IC-135(K) A-3-4 MOVE TO BLDG. 95, MBFAB		/	/
	95 030 MBFAB	SHAKEDOWN INSPECTION IAW WORK RLT ANNOTATE DISCREPANCIES. MBFAB.		/	/
	95 040 MBFAB	REMOVE CORROSION IAW IC-135(K)A-3-4 PARA. 4-9 THRU 4-17 REQ'D _____ NOT REQ'D _____		/	/
	95 050 MBFAB	REPAIR OR REPLACE L.H. LONGERON P/N 5-85654-1 IAW IC-135(K)A-3-1, FIG 10 -3 IN FIXTURE P/N 5-8564ASMJ ECO 13MAY83 CLARIFY CUTOUT FOR -1 LONGERON IN SHOP. REQ'D _____ NOT REQ'D _____		E	/
	95 060 MBFAB	THIS STEP LEFT BLANK INTENTIONALLY			
	95 070 MBFAB	FRAME P/N 5-85654-5 REPAIR _____ REPLACE _____ NOT REQ'D _____		/	/
	95 080 MBFAB	ASSEMBLE 60-1512-1 AND 60-1512-2 PLATES ON 5-85654-5. INSTALL BLOCKS AND LOWER BUSHINGS. REQ'D _____ NOT REQ'D _____		/	/
	95 090 MBFAB	FRAME P/N 5-85654 4 REPAIR _____ REPLACE _____ NOT REQ'D _____		C	/
	95 100 MBFAB	R.H. LONGERON P/N 5-85654-2 IAW IC- 135(K)A-3-1, FIG 10 3 IN FIXTURE P/N 5-85654-ASMJ		E	/

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15140A * WORK CONTROL DOCUMENT * MISTR 1. DATE 39073 PAGE 2 OF 3 PAGES																		
15.DISP-16.PDN/																		
STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"																		
			REPAIR	REPLACE	NOT REQ'D													
95	110	MBPAB	INSTALL PLATES P/N 60-1513, 60-1510 AND STIFFENER P/N 60-1515-2 ON 5-85654-2 LONGERON										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	120	MBPAB	FORMER P/N 5-85654-3										E	/				
			REPAIR	REPLACE	NOT REQ'D													
95	130	MBPAB	ASSEMBLE PLATES 60-1511-3 & 60-1511-4. FRAMES 60-1514-3 & 60-1514-4 ON FORMER P/N 5-85654-3. INSTALL BLOCKS AND LOWER BUSHINGS.										/	/				
			REQ'D		NOT REQ'D													
95	140	MBPAB	FRAME P/N 5-85654-6 IN FIXTURE P/N 5-85654ASMJ										/	/				
			REQ'D		NOT REQ'D													
95	150	MBPAB	PLACE IN FIXTURE TO REPAIR/REPLACE SKIN P/N 5-85654-800										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	160	MBPAB	PLACE IN FIXTURE TO REPAIR/REPLACE SKIN P/N 5-85654-801										E	/				
			REPAIR	REPLACE	NOT REQ'D													
95	170	MBPAB	STIFFENER P/N 5-85654-02										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	180	MBPAB	R.H. ANGLE P/N 5-85654-24										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	190	MBPAB	L.H. ANGLE P/N 5-85654-25										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	200	MBPAB	FRAME P/N 60-1514-1 IN FIXTURE										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	210	MBPAB	FRAME P/N 60-1514-2 IN FIXTURE										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	220	MBPAB	LOOSE, MISSING & DEFECTIVE FASTENERS										/	/				
			REPAIR	REPLACE	NOT REQ'D													
95	230	MBPAB	REPAIR ALL MINOR DENTS, SCRATCHES, NICKS AND ABRASIONS.										/	/				
			REQ'D		NOT REQ'D													
95	240	MBPAB	REPLACE PIN P/N 60-1507 IF WORN BEYOND DRAWING DIMENSIONS.										/	/				
			REQ'D		NOT REQ'D													
95	250	MBPAB	CHECK IN FIXTURE P/N 5-85654-ASMJ FOR ALIGNMENT.										E	/				

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15140A * WORK CONTROL DOCUMENT * M131R 1. DATE 89073 PAGE 3 OF 3 PAGES					
15.DISP-16.FDN/					
STATION/OP NO.		17.WORK TO BE ACCOMPLISHED		18.MECH 19"P" 20"Q"	
95	260 MBFAB	INSTALL UPPER BUSHINGS IN FORMERS P/N 5-85657-3 & 5-85654 5.		/	/
95	270 MBFAB	MAKE SURE LATCH P/N 5-96762-2 & 5-96766-3, FITS BUSHING & SLOTS AT NO. 5 RIB & NO. 3 RIB, BOTH SIDES		E	/
2200	280 MBPCB	FINAL WASH & CORROSION TREATMENT		/	/
2200	290 MBPCB	PAINT INTERIOR SURFACE WITH MIL-P- 23377 1AW 10-135(K)A-3-4, SECTION XI MOVE TO BLDG. 95		/	/
95	300 MBFAB	WORK COMPLETED. CONDITION TAG DATE _____ MOVE TO CRATING NOTE: PART WILL HAVE EITHER DC-ALC FORM 586,587,588 IDENTIFICATION, LABELS APPLIED TO COMPLETED ITEM IAW NADI 66-4. ACCEPTANCE DATE ON THE LABELS ALONG WITH "M" STAMP OF THE PERSON PERFORMING THE OVERHAUL.		/	C /
COORDINATION					
MABEBS PHYLLIS HEALD 22 MARCH 89					
MABSCS CONNIE WEBBER 22 MARCH 89					
MABFAB JESSIE JACOBS 22 MARCH 89					
MAGUM ILL HAYES 22 MARCH 89					

15150 A

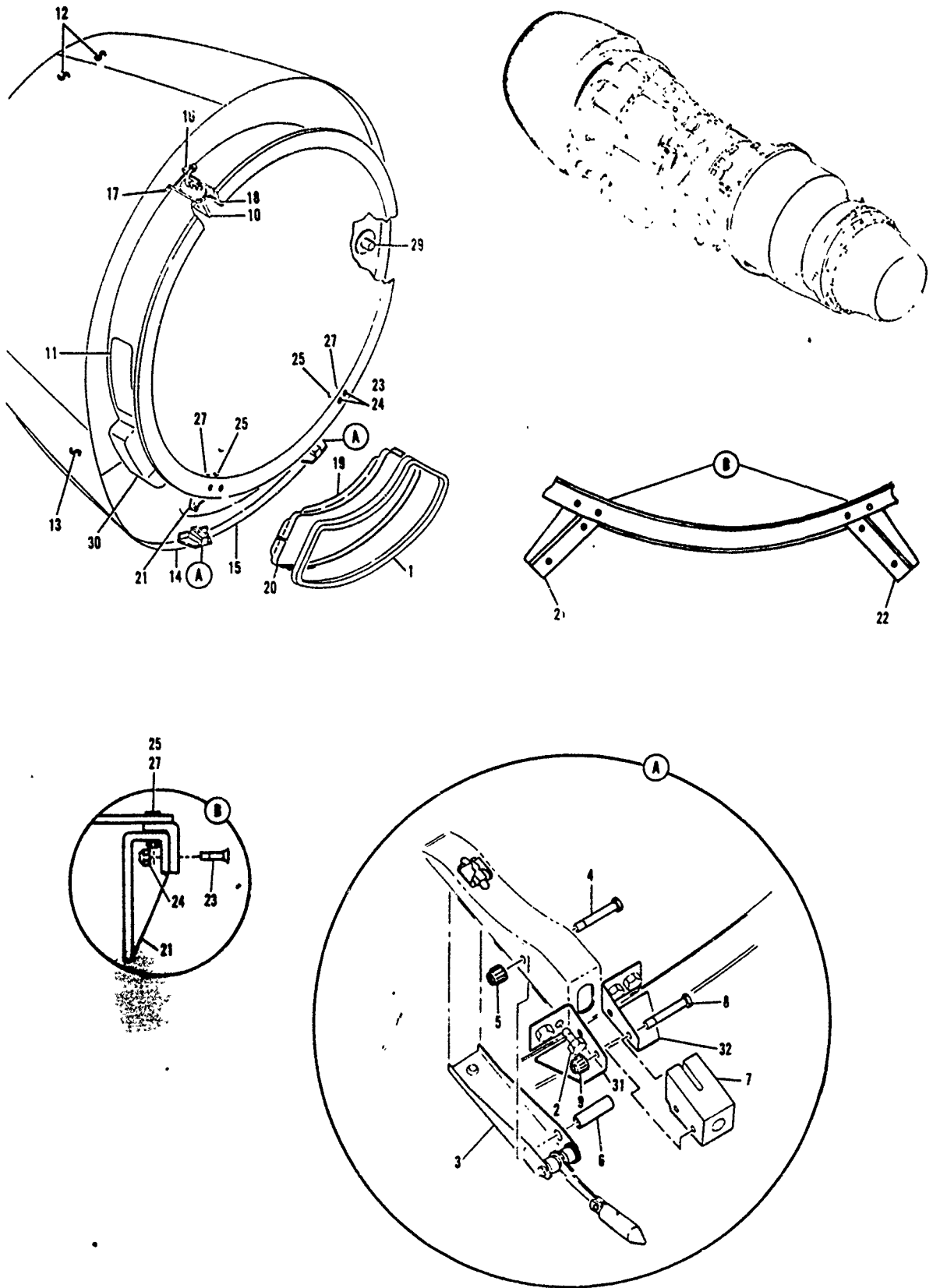


Figure 4-24. Nose Cowl Assembly

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							REF ASSY	UN CODE
			4-24	5-85655-150	COWL ASSY, Engine nacelle nose (see figure 4-2, . . . . . index 5)						
	5-85655-811	. DUCT ASSY . . . . .									1
-1	60-5176	. SEAL . . . . .									1
-2	NAS1103-3DW	. BOLT (For replacement order BACB30NF3D3). . . . .									8
-3	90-3588-4	. LATCH ASSY, Engine cowl panel safety (optional. . . . . 90-3588)									2
		(ATTACHING PARTS)									
-4	NAS1303-16	. BOLT (Replaces AN3-13A, (for replacement order . . . . . BACB30NF3-16)									2
-5	MS21042L3	. NUT, Self-locking 500°F (replaces NAS679A3W) (for . . . . . replacement order BACN10JC3)									2
-6	NAS43-3-65	. SPACER (For replacement order NAS43HT-3-65) . . . . .									2
		-----									
-7	60-5700	. FITTING, Engine cowl safety latch . . . . .									2
		(ATTACHING PARTS)									
-8	NAS1303-14	. BOLT (Replaces AN3-12A) (for replacement order. . . . . BACB30NF3-14)									2
-9	MS21042L3	. NUT, Self-locking 500°F (replaces NAS679A3W) (for . . . . . replacement order BACN10JC3)									2
		-----									
-10	65-63031-501	. PROBE ASSY, Engine inlet pressure (optional . . . . . 65-1570-8, 65-1570, 65-63031; 65-63031-9 use until exhausted)									2
		-----									
-11	BACN10B62-9DK	. METAL-CAL . . . . .									2
-12	5-85655-6	. SKIN ASSY, Outer. . . . .									1
-13	5-85655-3	. SKIN ASSY, Outer. . . . .									1
	5-85655-4	. SKIN ASSY, Outer (opposite 5-85655-3) . . . . .									1
	5-85655-2	. SKIN ASSY, Lower forward. . . . .									1
-14	5-85655-8	. SKIN ASSY, Lower forward. . . . .									1
-15	5-85655-5	. SKIN ASSY, Lower aft. . . . .									1
-16	5-85655-148	. BRACKET . . . . .									1
-17	5-85655-149	. CLIP . . . . .									1
-18	66-20097	. STIFFENER, Probe support. . . . .									1
-19	5-85655-94	. RETAINER Seal. . . . .									1
-20	5-85655-95	. RETAINER, Seal. . . . .									1
-21	50-9571-7	. FITTING ASSY, Oil cooler support. . . . .									1
-22	50-9571-8	. FITTING ASSY, Oil cooler support. . . . .									1
		(ATTACHING PARTS)									
-23	NAS1503-12	. BOLT, Nose cowl fitting . . . . .									8
-24	MS21042L3	. NUT (Replaces NAS679A3W) (optional BACN10JC3) . . . . .									2
-25	(a) NAS1456-4	. PIN, Sarge locking (optional BACB30GX6-4) . . . . .									4
-26	(a) NAS1080-6	. COLLAR, Sarge locking (optional NAS1080R6). . . . .									4
-27	(b) HL21PB6-4	. HI-LOCK FASTENER (73197). . . . .									4
-28	(b) HL86PB6	. COLLAR (Optional HL86PBW6). . . . .									4
-29	90-6964	. EJECTOR ASSY, Nose cowl anti-ice. . . . .									1
-30	50-6395	. DUCT ASSY, Alternator exhaust . . . . .									1
-31	60-5199-1	. BRACKET . . . . .									2
-32	60-5199-2	. BRACKET . . . . .									2

(a) Used on inboard position at field level repair.  
 (b) Optional on outboard side of each bracket when replaced at field level.

FLOW PROCESS CHART

SUBJECT Nose Cowling Assembly DATE 4/4/89

PCN: 15150A WCD: 15150A WCDDATE: 88054

CHART BEGINS \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: Tom Hall

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
010	Receive & Unarchive 2132 MARKED Delay	160	Replace outer skins S-85655-3 MARKED
		170	Replace outer skin S-85655-4
	Move to MABPCA 2132 MARKED	180	Replace outer skin S-85655-2
	Delay	190	Replace outer skin S-85655-13
020	Wash	200	" S-85655-14
021	Strip	210	Repair Webs
	Delay	220	Repair Frame S-85655-123
	Move to Bldg 95 95 MARKED	230	Replace Frame S-85655-123
	Delay	240	Remove Corrosion & Treat
025	Position on Fixture	250	Repair Anti-ice manifold
030	Shakedown	260	Repair Latches
	Delay	270	Replace latches if cracks are found
040	Inspect - Fluorescent Bldg 95 MARKED	280	Replace Latches if wear exceeds limits
	Delay	290	Repair dents in nose cowling
050	Treat for Corrosion MARKED	300	Replace bad, loose, missing or defective fasteners
060	Replace Inner Skin	310	Measure and trim off of outer skins
061	Replace former PIN	320	Place in Fixture
062	Replace Structural Plate	325	Replace ejector
063	Repair air duct bulkhead	330	Install Access Covers
064	Replace Duct Assy	340	Repair Lip Strips
065	Repair Attachment Ring	350	Replace Lip strips
066	Replace attach. ring	360	Replace seal
090	Repair oil cooler tab attach hole	370	Remove all foreign objects
100	Replace oil cooler support Fittings		Delay
110	Repair Probe, pressure check remove nicks & burrs		Move to bldg 2280 2280 MARKED
120	Inspect probe & manifold		Delay
130	Replace probe, pressure check	380	Final Wash
140	Replace outer skin PIN S-85655-5	385	Final Corrosion Treat
150	Replace outer skin PIN S-85655-6	390	Paint & Apply Finish





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| 15150A * WORK CONTROL DOCUMENT * REGISTER 1. DATE 08054 PAGE 1 OF 5 PAGES |
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| 12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/ROLL 15. DATE SCHED 16. DATE COMP |
| 15150A | | MBPAB | 89093 | | |
|-----|-----|-----|-----|-----|-----|
| 17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL |
| 5-85655-150 | | | SOW OC/1560FL/85-61, |
| | | | DID 24 OCT 84 |
|-----|-----|-----|-----|-----|
| 10. MODEL/DESIGN/SERIES 11. STOCK NR |
| KC 135 | 1560006067420FL |
|-----|-----|-----|-----|
| 13. DISC 14. NOUN/END ITEM NOUN |
| | NOSE COWL ASSY |
|-----|-----|-----|-----|
| 15. DISP-16. PON/ |
| STATION/UP NO. 17. WORK TO BE ACCOMPLISHED 18. ALCH 19. 20. 21. |
|-----|-----|-----|-----|-----|
| 2122 | 010 | RECEIVE, IDENTIFY & UNCRATE. | | | |
| | MBPCD | NOSE COWL | | | |
|-----|-----|-----|-----|-----|
| 2122 | 020 | WASH INT & EXT IAW T.O. KC 135(K) | | | |
| | MBPCA | A-3-4 PARA 11-7 & SOW OC/1560FL | | | |
| | | 85-61 | | | |
|-----|-----|-----|-----|-----|
| 2122 | 021 | STRIP INT & EXT SURFACES OF NOSE | | | |
| | MBPCA | COWL IAW T.O. KC 135(K) A-3-4 PARA | | | |
| | | 11-13 THRU 11-15 & SOW 85-61. | | | |
| | | REQD----- NOT REQD----- | | | |
| | | MOVE TO MBPAB | | | |
|-----|-----|-----|-----|-----|
| 95 | 025 | POSITION NOSE COWL ON FIXTURE | | | |
| | MBPAB | P/N 5-85655-0 CHECK RING FLATNESS | | | |
| | | IAW SOW OC 1560 85-61 | | | |
|-----|-----|-----|-----|-----|
| 95 | 030 | SHAKEDOWN AS PER SOW OC/1560FL/85-61 | | | |
| | MBPAB | SEC III | | | |
|-----|-----|-----|-----|-----|
| 95 | 040 | PERFORM FLOURESCENT PENETRANT INSP. | | N | |
| | MBPCA | IAW SOW OC/1560FL/85-61, SEC III | / | | |
|-----|-----|-----|-----|-----|
| 95 | 050 | CORROSION TREAT IAW SOW | | | |
| | MBPAB | OC 1560 85-61 & T.O. 10-135(K) A-3-4 | | | |
| | | SEC 4. | | | |
|-----|-----|-----|-----|-----|
| 95 | 060 | REPLACE INNER SKIN IAW SOW | | E | |
| | MBPAB | OC/1560FL/85-61, SEC III | | | |
| | | REQD----- NOT REQD----- | | | |
|-----|-----|-----|-----|-----|
| 95 | 061 | REPLACE FORMER P/N 5-85655-129 | | | |
| | MBPAB | REQD----- NOT REQD----- | | | |
|-----|-----|-----|-----|-----|
| 95 | 062 | REPLACE STRUCTURAL PLATE P/N | | | |
| | MBPAB | 5-85655-147 REQD----- NOT REQD----- | | | |
|-----|-----|-----|-----|-----|
| 95 | 063 | REPLACE AIRDUCT BULKHEAD P/N | | | |
| | MBPAB | 5-85655-118 REQD----- NOT REQD----- | | | |
|-----|-----|-----|-----|-----|
| 95 | 064 | REPLACE DUCT ASST P/N 50-6395 | | | |
| | MBPAB | REQD----- NOT REQD----- | | | |
|-----|-----|-----|-----|-----|
| 95 | 070 | REPAIR ATTACH | | | |
| | MBPAB | 10-135(K) A-3-3 | | | |
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15150A * WORK CONTROL DOCUMENT * NISTR 1 DATE 88054 PAGE 2 OF 5 PAGES					
15.DISP-16.FDN/					
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		REQD _____ NOT REQD _____			
95	080 MBPAB	REPLACE ATTACH RING IAW SOW OC/1560FL/85-61, SEC III USE "Z" FIXTURE TO LOCATE RING. REQD _____ NOT REQD _____		E	/
95	090 MBPAB	REPAIR OIL COOLER TAB ATTACH HOLE OC/150FL/85-61, SEC III & T.O. 1C-135(K)A-3-1 REQD _____ NOT REQD _____		/	/
95	100 MBPAB	REPLACE OIL COOLER SUPPORT FITTINGS AND CHECK LOCATION OF MOUNT HOLES IN RING IAW SOW OC/1560FL/85-61, SEC III		/	/
95	110 MBPAB	REPAIR PROBE (PT2) PRESSURE CHECK, REMOVE NICKS & BURRS IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		/	/
95	120 MBPAB	CHECK PROBE (PT2) WITH VACUUM IAW SOW OC/1560FL/85-61, SEC III		/	/
95	130 MBPAB	REPLACE PROBE (PT2) PRESSURE CHECK IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		/	/
95	140 MBPAB	REPLACE OUTER SKIN, P/N 5-85655-5 IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		E	/
95	150 MBPAB	REPLACE OUTER SKIN P/N 5-85655-6 IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		/	/
95	155 MBPAB	REPLACE SKIN P/N 5-85655-6 <i>(same part no. as of 1500 but there are two skins)</i> REQD _____ NOT REQD _____		/	/
95	160 MBPAB	REPLACE OUTER SKINS, P/N 5-85655-3 IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		/	/
95	170 MBPAB	REPLACE OUTER SKIN P/N 5-85655-4 IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		E	/
95	180 MBPAB	REPLACE OUTER SKIN P/N 5-85655-2 IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		/	/
95	190 MBPAB	REPLACE OUTER SKIN P/N 5-85655-13 IAW SOW OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____		/	/
95	200 MBPAB	REPLACE OUTER SKIN P/N 5-85655-14 IAW SOW OC/1560FL/85-61, SEC III		/	/

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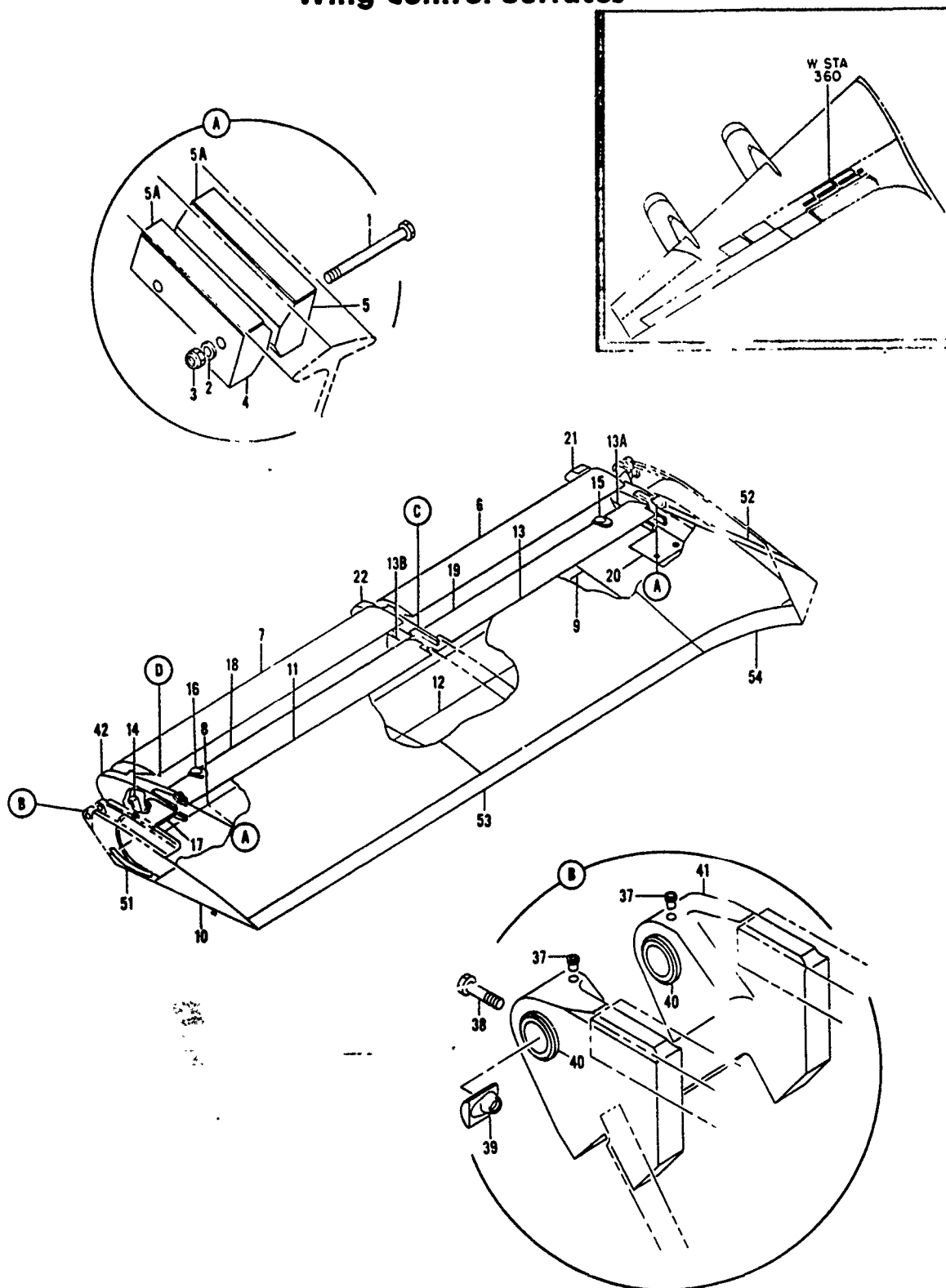
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15150A * WORK CONTROL DOCUMENT * MISTR 1. DATE 08054 PAGE 3 OF 5 PAGES					
15.DISP-16.PDN/					
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED			18.MECH 19"P" 20"Q"		
		REQD _____ NOT REQD _____			
95	210	REPAIR WEBS IAW SOW DC/1560FL/85-61, MBPAB SEC III REQD _____ NOT REQD _____	/	/	
95	220	REPAIR FRAME, P/N 5-85655-123 IAW MBPAB SOW DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	230	REPLACE FRAME, P/N 5-85655-123 IAW MBPAB SOW DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	240	REMOVE CURROSION & TREAT IAW SOW MBPAB DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	250	REPAIR ANTI-ICE MANIFOLD IAW SOW MBPAB DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	260	REPAIR LATCHES IAW SOW MBPAB DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	270	REPLACE LATCHES IF CRACKS ARE FOUND MBPAB IAW SOW DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	280	REPLACE LATCHES IF WEAR EXCEEDS MBPAB LIMITS AS STATED IN SOW DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	290	REPAIR DENIS IN NOSE COWL IAW SOW MBPAB DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	E	/	
95	300	REPLACE BAD, LOOSE, MISSING OR MBPAB DEFETIVE FASTENERS IAW SOW DC/1560FL/85-61, SEC III REQD _____ NOT REQD _____	/	/	
95	310	MEASURE AND TRIM AFT END OF OUTER MBPAB SKINS USE LOCAL MFG FIXTURE. REQD _____ NOT REQD _____	/	/	
95	320	PLACE NOSE COWL IN FIXTURE, MBPAB P/N 5-85655-0 AND PERFORM FINAL CHECKS IAW SOW DC/1560FL/85-61, SEC III	E	/	
95	325	REPLACE EJECYOR P/N 20 8254 MBPAB REQD _____ NOT REQD _____	/	/	

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19."P"	20."W"
95	330	INSTALL ACCESS COVERS ON NOSE COWL.		/	/
	MBPAB				
95	340	REPAIR LAP STRIPS JAW SOW		/	
	MBPAB	OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____			
95	350	REPLACE LAP STRIP JAW SOW		/	/
	MBPAB	OC/1560FL/85-61, SEC III REQD _____ NOT REQD _____			
95	360	REPLACE SEAL (OIL COOLER)		/	
	MBPAB	REQD _____ NOT REQD _____			
95	370	REMOVE ALL FOREIGN OBJECTS		L	/
	MBPAB				
2280	380	FINAL WASH JAW SOW OC/1560FL/85-61, SEC III		/	/
	MBPCB				
2280	385	FINAL CORROSION TREAT JAW SOW		/	/
	MBPCB	OC/1560FL/85-61 & T.O. 10-135(K)A-3, 4, SEC 4.			
2280	390	PAINT & APPLY FINISH JAW SOW		/	/
	MBPCB	OC/1560FL/85-61, SEC III			
95	400	APPLY IDENTIFICATION & MARKINGS AND DECALS JAW SOW OC/1560FL/85-61, SEC III		/	/
	MBPAB				
95	410	APPLY SCOTCH TAP #850 TO TRAYING SURFACE JAW T.O. 10-135(K)A-3, 1, SEC I		L	/
	MBPAB				
95	420	WORK COMPLETE, CONDITION TAG JAW AFM 67-1, MOVE TO CRATING		L	/
	MBPAB				
95	430	PARTS WILL HAVE OC ALC FORM 506, 587 OR 588 IDENTIFICATION LABELS APPLIED TO COMPLETED ITEM JAW MADI 66-36.		L	/
	MBPAB				
		ACCEPTANCE DATE ON THE LABEL ALONG WITH "P" STAMP OF THE PERSON PER- FORMING THE OVERHAUL. CAUTION: SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CON- TAMINATION. NOTE: COMPLETE "REMARKS" COLUMN OF AFLC FORM 1574 JAW MADI 66-36. NOTE #2: OOB10 SUPPORT OOB10 MFG DOUBLERS, SHIMS, CLIPS, SPACERS & ETC AS REQD IN B SKILL.			

STATION/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MIGHT BE DEVELOPED
	COORDINATION: DATE:	
	MABEBS LARRY MULLINAX 3-21-89	
	MABQBF TED HAYES 3-21-89	
	MABSCS H. NGUYEN 3-21-89	
	MABFAB D. LENOX 3-21-89	

15191A  
15192A

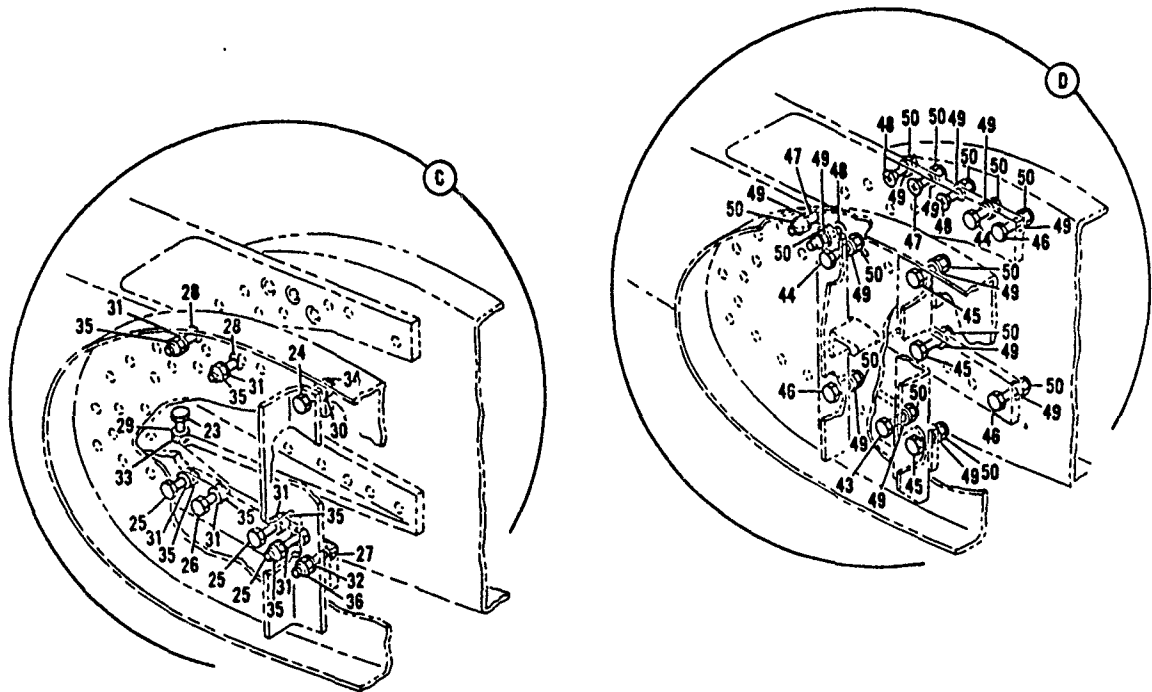
### Wing Control Surfaces



3153-48a

Figure 48. Inboard Flap Installations (Sheet 1 of 2)

### Wing Control Surfaces



3153-48bA

Figure 48. Inboard Flap Installations (Sheet 2 of 2)

FIGURE & INDEX NO	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
48 -	5-73131-1 5-73131-2 5-96315								REF REF	
1	NAS464P4A25								2	
2	AN960D416L								2	
3	NAS679A4W								2	
4	3-93742-3								1	
5	3-93742-4								1	
5A	BACS40A7-37								AR	
	5-86892-129								1	
	5-86892-130								1	
6	65-7360-1								1	A
	65-7360-2								1	A
7	65-7360-3								1	A
	65-7360-4								1	A
	AN4-10A								16	

CHANGED 28 MARCH 1969

2-123

C/N 15191A  
15192A



Section II  
Group Assembly Parts List

T.O. 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
48 -	AN960D416 AN960PD416L	..	..	..	..	..	..	..	16 AR	
8	5-88721-23	..	..	..	..	..	..	..	1	F
8	5-88721-15	..	..	..	..	..	..	..	1	G
	5-88721-24	..	..	..	..	..	..	..	1	F
	5-88721-16	..	..	..	..	..	..	..	1	G
9	5-88720-23	..	..	..	..	..	..	..	1	F
9	5-88720-15	..	..	..	..	..	..	..	1	G
	5-88720-24	..	..	..	..	..	..	..	1	F
	5-88720-16	..	..	..	..	..	..	..	1	G
10	50-4669-11	..	..	..	..	..	..	..	1	F
10	50-4669-1	..	..	..	..	..	..	..	1	G
	50-4669-12	..	..	..	..	..	..	..	1	F
	50-4669-2	..	..	..	..	..	..	..	1	G
11	50-4669-13	..	..	..	..	..	..	..	1	F
11	50-4669-3	..	..	..	..	..	..	..	1	G
	50-4669-14	..	..	..	..	..	..	..	1	F
	50-4669-4	..	..	..	..	..	..	..	1	G
12	50-4668-11	..	..	..	..	..	..	..	1	F
12	50-4668-1	..	..	..	..	..	..	..	1	G
	50-4668-12	..	..	..	..	..	..	..	1	F
	50-4668-2	..	..	..	..	..	..	..	1	G
13	50-4668-13	..	..	..	..	..	..	..	1	F
13	50-4668-3	..	..	..	..	..	..	..	1	G
	50-4668-14	..	..	..	..	..	..	..	1	F

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE
48 -	50-4668-4	. . . PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . . . INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022) (RH ONLY)								1	G
13A	69-18412-1	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 287.63 (LH ONLY)								1	C
	69-18412-2	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 287.63 (RH ONLY)								1	C
13B	69-18413-6	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 360.0 (SUITABLE SUB. FOR 69-18413-1)								1	F
13B	69-18413-1	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 360.0 (WHEN EXHAUSTED USE 69-18413-6)								1	H
14	69-18414-11	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 444.0 (SUITABLE SUB. FOR 69-18414-1) (LH ONLY)								1	F
14	69-18414-1	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 444.0 (WHEN EXHAUSTED USE 69-18414-11) (LH ONLY)								1	H
	69-18414-12	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 444.0 (SUITABLE SUB. FOR 69-18414-2) (RH ONLY)								1	F
	69-18414-2	. . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. . 444.0 (WHEN EXHAUSTED USE 69-18414-12) (RH ONLY)								1	H
15	69-9610-3	. . . CAM ASSY, INBOARD FLAP, STATION 419.95 (LH ONLY). . .								1	
	69-9610-4	. . . CAM ASSY, INBOARD FLAP, STATION 419.95 (RH ONLY). . .								1	
16	69-9611-3	. . . CAM ASSY, INBOARD FLAP, STATION 300.05 (LH ONLY). . .								1	
	69-9611-4	. . . CAM ASSY, INBOARD FLAP, STATION 300.05 (RH ONLY). . .								1	
17	5-86892-25	. . . SKIN, OUTBOARD NOSE, INBOARD FLAP (LH ONLY) . . . . .								1	
	5-86892-26	. . . SKIN, OUTBOARD NOSE, INBOARD FLAP (RH ONLY) . . . . .								1	
18	5-86892-117	. . . SKIN, CENTER NOSE, INBOARD FLAP (LH ONLY) . . . . .								1	
	5-86892-118	. . . SKIN, CENTER NOSE, INBOARD FLAP (RH ONLY) . . . . .								1	
19	5-86892-115	. . . SKIN, INBOARD NOSE, INBOARD FLAP (LH ONLY) . . . . .								1	
	5-86892-116	. . . SKIN, INBOARD NOSE, INBOARD FLAP (RH ONLY) . . . . .								1	
20	5-86892-93	. . . SKIN, INBOARD FORWARD NOSE, INBOARD FLAP (LH ONLY). .								1	
	5-86892-94	. . . SKIN, INBOARD FORWARD NOSE, INBOARD FLAP (RH ONLY). .								1	
21	5-86894-235	. . . RIB INSTL, INBOARD ACTUATOR AND TRACK, INBOARD FLAP . (LH ONLY) (FOR BREAKDOWN SEE FIG. 50)								1	
	5-86894-236	. . . RIB INSTL, INBOARD ACTUATOR AND TRACK, INBOARD FLAP . (RH ONLY) (FOR BREAKDOWN SEE FIG. 50)								1	
	5-86896-75	. . . RIB INSTL, CENTER TRACK, INBOARD FLAP (LH ONLY) . . .								1	
	5-86896-76	. . . RIB INSTL, CENTER TRACK, INBOARD FLAP (RH ONLY) . . .								1	
22	5-87846-1	. . . CARRIAGE ASSY, CENTER, INBOARD FLAP (FOR. . . . . BREAKDOWN SEE FIG. 52) (ATTACHING PARTS)								1	
23	NAS1103-6W	. . . BOLT (FOR REPLACEMENT ORDER NAS1103-6) . . . . .								2	
24	NAS1105-9W	. . . BOLT (FOR REPLACEMENT ORDER NAS1105-9) . . . . .								2	
25	NAS1104-7W	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-7) . . . . .								36	
26	NAS1104-8W	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-8) . . . . .								4	
27	NAS1105-9W	. . . BOLT (FOR REPLACEMENT ORDER NAS1105-9) . . . . .								2	
28	NAS517-4-7	. . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-7) . . . . .								6	
29	AN960D10	. . . WASHER. . . . .								2	
30	AN960D516	. . . WASHER. . . . .								2	
31	AN960D416	. . . WASHER. . . . .								46	
32	AN960D516	. . . WASHER. . . . .								2	
33	NAS679A3W	. . . NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539). . H10-3BAC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))								2	
34	MS21042L5	. . . NUT (REPLACES NAS679A5 OR 96-054 (56878) (80539). . H10-5BAC (15653) T6S524J (71087) RMLH9075-5W (72962) (BACN100C5))								2	
35	NAS679A3W	. . . NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) . H10-4BAC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))								46	
36	MS21042L5	. . . NUT (REPLACES NAS679A5 CR 96-054 (56878) (80539). . H10-5BAC (15653) T6S524J (71087) RMLH9075-5W (72962) (BACN10JC5))								2	
	5-88108-165	. . . RIB INSTL, OUTBOARD ACTUATOR, INBOARD FLAP (LH ONLY).								1	
	5-88108-166	. . . RIB INSTL, OUTBOARD ACTUATOR, INBOARD FLAP (RH ONLY).								1	
	9-61951-9	. . . FITTING ASSY, SCREW SUPPORT, FLAP . . . . .								1	
37	NAS516-1	. . . FITTING . . . . .								2	
38	AN4-10A	. . . BOLT (FOR REPLACEMENT ORDER BACB30NE4-9) . . . . .								2	

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
48 -										
39	63-1519	. . . . . NUTPLATE ASSY, CONVEX, WING FLAPS . . . . .							2	
40	3-98762	. . . . . BEARING, SCREW SUPPORT, FLAP. . . . .							2	
41	9-61951-11	. . . . . FITTING, SCREW SUPPORT, FLAP. . . . .							1	
	5-87849-81	. . . RIB INSTL, OUTBOARD TRACK, INBOARD FLAP (LH ONLY) . . .							1	
	5-87849-82	. . . RIB INSTL, OUTBOARD TRACK, INBOARD FLAP (RH ONLY) . . .							1	
42	5-87847-3	. . . CARRIAGE ASSY, END, INBOARD FLAP (LH ONLY) (FOR . . .							1	
		BREAKDOWN SEE FIG. 49)								
	5-87847-4	. . . CARRIAGE ASSY, END, INBOARD FLAP (RH ONLY) (FOR . . .							1	
		BREAKDOWN SEE FIG. 49)								
		(ATTACHING PARTS)								
43	NAS1104-6W	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-6). . . . .							29	
44	NAS1104-7W	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-7). . . . .							3	
45	NAS1104-8W	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-8). . . . .							3	
46	NAS1104-9W	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-9). . . . .							3	
47	NAS517-4-6	. . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-6) . . . . .							3	
48	NAS517-4-7	. . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-7) . . . . .							3	
49	AN960D416	. . . WASHER. . . . .							44	
50	NAS679A4W	. . . NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) . . .							44	
		H10-4BAC (15653) T6S428J (71087) RMLH9075-4W								
		(72962) (BACN10JC4))								
51	5-86892-65	. . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .							1	D
		BAC1523-20N X 13.3 IN. LG) (FOR I/W INFO SEE								
		5-86892-133)								
51	5-86892-133	. . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .							1	E
		BAC1523-20N X 13.3 IN. LG) (I/W 5-86892-65)								
		(USE 5-86892-65 UNTIL EXHAUSTED)								
51	5-86892-66	. . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .							1	D
		BAC1523-20N X 48.9 IN. LG) (FOR I/W INFO SEE								
		5-86892-134)								
52	5-86892-134	. . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .							1	E
		BAC1523-20N X 48.9 IN. LG) (I/W 5-86892-66								
		(USE 5-86892-66 UNTIL EXHAUSTED)								
	50-4681-85	. . TRAILING EDGE INSTL, INBOARD FLAP (LH ONLY) . . . . .							1	
	50-4681-86	. . TRAILING EDGE INSTL, INBOARD FLAP (RH ONLY) . . . . .							1	
53	50-4681-87	. . . TRAILING EDGE ASSY, INBOARD FLAP (LH ONLY). . . . .							1	
	50-4681-88	. . . TRAILING EDGE ASSY, INBOARD FLAP (RH ONLY). . . . .							1	
		(ATTACHING PARTS)								
	NAS517-3-4	. . . SCREW (FOR REPLACEMENT ORDER BACB30LU3-4) . . . . .							93	
	NAS517-3-5	. . . SCREW (FOR REPLACEMENT ORDER BACB30LU3-5) . . . . .							2	
		-----*								
	4-5211-15	. . PANEL INSTL, SKIN, INBOARD FLAP (LH ONLY) . . . . .							1	
	4-5211-16	. . PANEL INSTL, SKIN, INBOARD FLAP (RH ONLY) . . . . .							1	
54	50-8038-29	. . . TRAILING EDGE ASSY, INBOARD FLAP. . . . .							1	
		A 2201 THRU 2299, 3001 THRU 3099								
		B DELETED								
		C 2201 THRU 2299, 3029 THRU 3099								
		D 3001								
		E 2201 THRU 2299, 3002 THRU 3099								
		F 2201 THRU 2299								
		G 3001 THRU 3099								
		H 3029 THRU 3099								

FLOW PROCESS CHART

SUBJECT WING FLAP, INBOARD

DATE 4/4/89

PCN: 15192A

WCD: 15151A

WCD DATE: 88055

15191A  
CHART BEGINS

1 of 2

CHART ENDS

PREPARED BY: LARRY

New Seq. on WCD

HISTORY RECORDS  
40/50  
60  
70  
80

NO CHANGE in WCD SEQ.

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
● ◊ D □ ▽	Receive Uncrate 2122 MBPCD	● ◊ D □ ▽	REPLACE LEADING EDGE RIB W/REP
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	REPLACE LEADING EDGE ANGLES CLIPS & CHANNEL
○ ◊ D □ ▽	95 MBPAB	● ◊ D □ ▽	REPLACE LEADING EDGE ASSY SKIN
○ ◊ D □ ▽	Move To 95	● ◊ D □ ▽	REMOVE NOSE SKINS
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	INSTALL LOWER INBOARD SKIN
● ◊ D □ ▽	Remove Furl Flaps 95 MBPAB	● ◊ D □ ▽	CLOSEOUT UPPER INBOARD SKIN
● ◊ D □ ▽	Remove Honeycomb Panels/DELAY	● ◊ D □ ▽	CLOSEOUT UPPER OUTBOARD SKIN
○ ◊ D □ ▽	2122 MAB.PCA	● ◊ D □ ▽	REPLACE WORN CARTRIDGE ASSY
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	REPLACE CRACKED OR DAMAGED FAIRINGS
● ◊ D □ ▽	Plug Drain Holes	● ◊ D □ ▽	OPEN FASTENER HOLES
● ◊ D □ ▽	Clean + Stamp Wash	● ◊ D □ ▽	INSTALL LOWER SKIN PANEL
○ ◊ D □ ▽	Delay MOVE TO 95	● ◊ D □ ▽	INSTALL LOWER HONEYCOMB PANEL
○ ◊ D □ ▽	95	● ◊ D □ ▽	INSTALL INNER HONEYCOMB PANEL
○ ◊ D □ ▽	DELAY	● ◊ D □ ▽	INSTALL WING FLAP IN REPAIR JIG 590CA1020
○ ◊ D □ ▽		○ ◊ D □ ▽	INSPECT CONDITION + ALIGNMENT
○ ◊ D □ ▽		● ◊ D □ ▽	REMOVE FLAP FROM JIG
○ ◊ D □ ▽		● ◊ D □ ▽	REPLACE ALL BAD FASTENERS
● ◊ D □ ▽	ACCOMPLISH SHAKEDOWN Insp 95 MBPAB	● ◊ D □ ▽	REMOVE DRILL HOLES
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	REPAIR GROOVES IN CARTRIDGE
● ◊ D □ ▽	ACCOMPLISH NDI 95 MABCA	● ◊ D □ ▽	SEAL FLAP
○ ◊ D □ ▽	Delay	● ◊ D □ ▽	TREAT EXTERNAL CORROSION
● ◊ D □ ▽	BEGIN REPAIR (ALIGNMENT CHECK) 95 MBPAB	○ ◊ D □ ▽	Delay
● ◊ D □ ▽	REPAIR/REPLACE HONEYCOMB PANEL	○ ◊ D □ ▽	MOVE TO 2280
● ◊ D □ ▽	REP/REP " (29) TRAILING EDGE	○ ◊ D □ ▽	Delay
● ◊ D □ ▽	REP/REP " (88) TRAILING EDGE	● ◊ D □ ▽	FINAL WASH (PAINT) 2280 MBPCB
● ◊ D □ ▽	REP/REP " TRAILING SKINS	○ ◊ D □ ▽	Delay
● ◊ D □ ▽	REP/REP TRAILING RIB	○ ◊ D □ ▽	MOVE
● ◊ D □ ▽	REP/REP OTDR RIB LONGERON	○ ◊ D □ ▽	Delay
● ◊ D □ ▽	REP/REP LOWER HONEYCOMB PANEL	● ◊ D □ ▽	REPLACE BEARINGS (SCAWLE
● ◊ D □ ▽	REPLACE TRAILING EDGE RIBS	● ◊ D □ ▽	



2. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 | | | MABPAB | | 89093 | |

7. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 | | | | S.O.W. UC-1560FL/82-67  
 | | | | 1C-135(K)A-3-1  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | S.O.W. OL-1560FL/83-149  
 | C 135 | | | 1C-135(K)A-3-4

15. MISC 16. HOUN/END TYEM HOUN  
 | WING FLAP, INBOARD |  
 | MICHAEL TYTANIC/MABERS/65261 |

PN	NSN	C/N
5-86892-119		
5-86892-121	15600060674	15151A
5-86892-123		
5-86892-120	15600060674	15152A
5-86892-112	15600062107	15153A
5-86892-127	15600065660	15184A
5-86892-128	15600065660	15185A
5-86892-130	15600065662	15192A
5-86892-129	15600065662	15191A
5-86892-131	15600065662	15193A
5-86892-132	15600065662	15194A
5-86892-136	15600096752	15287A

15. DISP-16. PDM/ 17. WORK TO BE ACCOMPLISHED 18. MECH 19" P" 20" Q"

STAT	TOP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19" P"	20" Q"
	2122	010 MBPCD RECEIVE AND UNCRATE. REQ'D _____ NOT REQ'D _____	1	NC	/ /
	2122	020 MBPCA CLEAN & STRIP PAINT FROM FLAP (INCLUDING FLAP TRACK WELL) IAW NOTE: ON PDM LINE GENERATED FLAP CLEAN FLAP TRACK WELL & CARRIAGE ASSYS. ASSURE ENTIRE ASSY IS FREE OF ALL DIRTY PAINT & GREASE.	4	4W	/ /
	2122	030 MBPCA PLUG ALL DRAIN HOLES TO PREVENT PAINT STRIPPER FROM ENTERING INTO INTERIOR OF ASSY. NOTE: OMIT IF PDM LINE GENERATED FLAP.		4W	/ /
	<del>2122</del> 95	040 MBPAB REMOVE FOREFLAPS & ASSURE FOREFLAP SUPPLEMENTAL SHEET WILL ACCOMPANY APPROPRIATE ITEM.	2	DS	/ /
	<del>2122</del> 95	050 MBPAB REMOVE 2 EA UPPER 3 EA LOWER HONEYCOMB PANELS FOR ACCESS.	3	DS	/ /
	2122	060 MBPCA ACCOMPLISH INTERIOR WASH, UPPER & LOWER, FOR CORROSION & CRACKS DETERMINATION. MOVE TO <del>MBPCA</del> <b>MBPAB</b> REQ'D _____ NOT REQ'D _____	5	4W	/ /
	<del>2122</del> 95	070 MBPAB ACCOMPLISH COMPLETE SHAKEDOWN INSP OF FLAP IAW SOW, ANNOTATE DISCREP- ANCIES. MOVE TO OLDD 3001.	6	DS	/ /

(CONTINUED)

		NOTE: THE ITEM(S) INPUT ON THIS 959 WILL BE OVERHAULED IN ACCORDANCE WITH INSTRUCTIONS CONTAINED IN THE SOW AND THE TECH ORDERS & DIRECTIONS CONTAINED IN SECT 19 & TAB "A" OF THE SOW.			
95	080 MBPAB	INSP DRAIN HOLES IN FLAP CARRIAGES FOR CRACKS WITH EDDY CURRENT. "N" STAMP RECD IAW 10-135-36, SEC V, PART 2.	AI	/	
95	090 MBPAB	ACCOMPLISH ALIGNMENT CHECK IAW (I.E.). REQD _____ NOT REQD _____	DS	/	
95	100 MBPAB	REPAIR/REPLACE UPPER HONEYCOMB PANEL IAW 10-135(K)A-3-1, SEC X REQD _____ NOT REQD _____	DS	/	
95	110 MBPAB	REPAIR/REPLACE DAMAGED (-29) SMALL TRAILING EDGE IAW 10-135(K)A-3-1 REQD _____ NOT REQD _____	DS	/	/
		NOTE: HONEYCOMB TRAILING EDGE MAY REQUIRE TRIMMING. CAUTION: GAP BETWEEN HONEYCOMB PANELS & TRAILING EDGE MUST BE MAINTAINED AS SHOWN IN T.O. 10-135(K)A-3-1, FIG 10-6.			
95	120 MBPAB	REPAIR/REPLACE (-87 OR 88) LARGE TRAILING EDOL IAW 10-135(K)A-3-1. REQD _____ NOT REQD _____	DS	/	/
95	130 MBPAB	REPAIR /REPLACE INBOARD SKINS REQD _____ NOT REQD _____	DS	/	/
95	140 MBPAB	REPAIR/REPLACE INBOARD RIB AND LONGERON REQD _____ NOT REQD _____	DS	/	/
95	150 MBPAB	REPAIR/REPLACE OUTBOARD RIB AND LONGERON REQD _____ NOT REQD _____	DS	/	/
95	160 MBPAB	REPAIR/REPLACE LOWER HONEYCOMB PANELS IAW 10-135(K)A-3-1, SEC X REQD _____ NOT REQD _____	DS	/	/
95	170 MBPAB	REPLACE CRACKED TRAILING EDGE RIBS REQD _____ NOT REQD _____	DS	/	/
95	180 MBPAB	REPLACE CRACKED/DAMAGED LEADING EDGE RIBS & WEBS REQD _____ NOT REQD _____ NOTE: END ITEM WILL HAVE OC-ALC FORM 586, 587, 588 IDENTIFICATION	DS	/	/

(CONTINUED)

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15151A * WORK CONTROL DOCUMENT	MISTR	1.DATE 0055	PAGE 3 OF 5 PAGES
15.DISP-16.PDN/			
STATION/OP NO.	17.WORK TO BE ACCOMPLISHED	18. RLCH 19" P" 20" Q"	
	LABELS APPLIED TO COMPLETED ITEM 1AW AFLCR 66-51, CHAPTER 1. NOTE: ACCEPTANCE DATE ON THE LABEL WITH "M" STAMP FOR THE PERSON PERFORMING THE OVERHAUL IS REQD. CAUTION: SURFACE TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAMINATION.		
95	190 MBFAB	REPLACE CRACKED DAMAGED LEADING EDGE ANGLES CLIPS & CHANNELS. REQD _____ NOT REQD _____	DS / /
95	200 MBFAB	REPLACE CRACKED OR DAMAGED LEADING EDGE NOSE SKIN REPLACE MAGNESIUM WITH ALUMINUM. REQD _____ NOT REQD _____	DS / /
95	210 MBFAB	REMOVE NOSE SKINS IF CRACKS ARE FOUND IN END RIBS. REQD _____ NOT REQD _____	DS / /
95	220 MBFAB	INSTALL LOWER INBOARD SKIN REQD _____ NOT REQD _____	DS / /
95	230 MBFAB	ACCOMPLISH CLOSEOUT & INSTALL UPPER INBOARD SKIN WHICH INCLUDES INTERNAL CORROSION TREATMENT & REPLACEMENT OF IMPAIRED FASTENERS.	DS / /
95	240 MBFAB	ACCOMPLISH CLOSEOUT & INSTALL UPPER OUTBOARD HONEYCOMB PANEL WHICH INCLUDES INTERNAL CORROSION TREATMENT & REPLACEMENT OF IMPAIRED FASTENERS.	DS / /
95	250 MBFAB	REPLACE CRACKED OR WORN FLAP CARRIAGES. INSURE FLAP IS IN FIXTURE PRIOR TO FINAL ATTACHMENT. REQD _____ NOT REQD _____	DS / /
95	260 MBFAB	REPLACE CRACKED OR DAMAGED FAIRINGS. REQD _____ NOT REQD _____	DS / /
95	270 MBFAB	REMOVE SEAL DEPRESSOR & OPEN FASTENER HOLES. REQD _____ NOT REQD _____	DS / /
95	280 MBFAB	ACCOMPLISH CLOSEOUT & INSTALL LOWER INBOARD SKIN PANEL, INCLUDES INTERNAL CORROSION TREATMENT & REPLACEMENT OF IMPAIRED FASTENERS.	DS / /
95	290 MBFAB	ACCOMPLISH CLOSEOUT & INSTALL LOWER CENTER HONEYCOMB PANEL, INCLUDES CORROSION TREATMENT & REPLACEMENT OF IMPAIRED FASTENERS.	DS / /



STATION/OP NO.	WORK TO BE ACCOMPLISHED	NECH117"R"120"R"
95 MBPAB	300 ACCOMPLISH CLOSEOUT & INSTALL OUTBOARD HONEYCOMB PANEL, INCLUDES INTERNAL CORROSION TREATMENT & REPLACEMENT OF IMPAIRED FASTENERS.	DS / /
95 MBPAB	310 INSTALL WING FLAP IN REPAIR JIG P/N 590DA1020.	DS / /
95 MBPAB	320 ACCOMPLISH INSP & ALIGNMENT CHECK PRIOR TO REMOVAL FROM REPAIR JIG	DS / /
95 MBPAB	330 REMOVE FLAP FROM REPAIR JIG.	DS / /
95 MBPAB	340 REPLACE ALL LOOSE, SHLAKED OR MISSING FASTENERS PERMANENTLY. REQD _____ NOT REQD _____	DS / /
95 MBPAB	350 IF NO CRACKS ARE FOUND IN CARRIAGE, REWORK DRAIN HOLES IAW FIGS 1, 2 & 3 OF SOW. REQD _____ NOT REQD _____	DS / /
95 MBPAB	360 REPAIR GROOVE IN CARRIAGE CAUSED BY LATCHES & ROLLERS IAW IC-135(K)A 3-3, FIG 2-23. REQD _____ NOT REQD _____	DS E /
95 MBPAB	370 FILL ALL SKIN, TRAILING EDGL & SKIN PANEL ACCESS COVER GAPS WITH ENVIRONMENTAL SEALANT.	DS / /
95 MBPAB	380 CLEAN/TREAT ETHERNAL CORROSION IAW IC-135(K)A-3-4, PAGE 4-13 TO 4 22. REQD _____ NOT REQD _____ MOVE TO MBPCB, BLDG 2280 NOTE: OMIT IF DM LINE GENERATED FLAP. NOTE: NON-STOCKLISTED PARTS & PARTS STOCKLISTED AS FIELD OR DEPUT AIC CAPABLE. NOTE: OVERHAUL OF FLAP ASSY SHALL BE ACCOMPLISHED IAW 590DA1020 & JIG 590DA1020 TO DETERMINE CORRECT DIMENSIONS & ALIGNMENT. REMOVAL OF MORE THAN TWO PANELS AT ONE TIME WILL REQUIRE THE FLAP TO BE PLACED IN FIXTURE 590CJ1020. NOTE: USE SKINSS & PANELS KLAUVED AS TEMPLATES TO DETERMINE SIZE, LOCATION & SPACING OF RIVET HOLES. NOTE: REPLACEMENT HONEYCOMB PANELS THAT REQUIRE LEAD RIMMING WILL HAVE THOSE EDGES REMOVED PRIOR TO INSTALLATION IAW FIG 31733. LOWER PANELS WILL REQUIRE DRAIN HOLES WILL HAVE EDGES OF THE HOLES SEALED BE CAREFUL NOT TO	DS / /

(CONTINUED)

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15151A * WORK CONTROL DOCUMENT * MISTR 1, DATE 80055 PAGE 5 OF 6 PAGES					
15.DISP-16.PDN/					
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED			118.ALCH(12"X120"U)		
		LET EXCESS SEALER CREATE A DAMMING EFFECT. ALL FASTENERS WILL BE INSTALLED WET USING MIL G 81734, (MIL S-8802 OR EPOXY PAINT MIL P-2377 MAY BE USED AS AN OPTION)			
2200	390	FINAL WASH & CORROSION TREATMENT	DS	/	/
PAINT	MBPAB	NOTE: OMIT IF PDM LINE GENERATED FLAP.			
2000	400	PAINT FLAP IAW 10-135(K)A 3 1, 10-135(K)A-3-4 & 1-1-4 & 1-18 USING MIL-P-87112 POLYSULFIDE PRIMER & HIGH GLOSS GRY ALL C-83206, COLOR 1647 PAINT, MARKINGS TO BE INSTALLED IAW DWG 5-86892.	DS	/	/
	MBPAB	NOTE: OMIT IF PDM LINE GENERATED FLAP. MOVE TO MBPAB, BLDG 95			
95	410	REPLACE ALL FLAP ATTACH, BEARING SUPPORTS & SERVICE (CLEAN/GREASE) & REPLACE BEARING.	DS	/	/
	MBPAB	REQD _____ NOT REQD _____			
95	420	REPLACE DEFECTIVE FOREFLAP ATTACH NUT PLATES 1 CARRIAGES ASSY.	DS	/	/
	MBPAB	REQD _____ NOT REQD _____ CAUTION: WHEN OVERHAULING FLAP ASSY 1560009675259FL & 1560009675260FL IT IS MANDATORY TO USE THE LATEST PREFERRED FOREFLAPS IN ALL POSITIONS			
95	430	INSTALL FOREFLAPS & ASSURE INSIDE MEASUREMENTS & POSITION IS IAW DWG 5-86892 & 10-135(K)A-2-8, FIG. 5-61. NOTE: FLAP ASSY 1560006566200FL WILL HAVE FOREFLAPS P/N 65-7360-1 OR -3137 & 65-7360-3 OR -3138 & 65-7360-4, FLAP ASSY 1560009675259FL & -3137 INSTALLED. FLAP ASSY 1560009672560FL WILL HAVE FOREFLAPS P/N 65-7360-3136 & 3138 INSTALLED.	DS	E	/
	MBPAB				
95	440	REPLACE ALL WORN OR DAMAGED SEALS	DS	/	/
	MBPAB	REQD _____ NOT REQD _____			
95	450	WORK COMPLETED, CONDITION TAG DATE _____	DS	E	/
	MBPAB	IAW AFM 67-1 MOVE TO CRATING NOTE: MOVE TO AIRCRAFT IF PDM LINE GENERATED FLAP. SERIAL# _____ DATE _____ NOTE: PART WILL HAVE UD-ALC FORM 586 587 & 588 IDENTIFICATION LABELS APPLIED TO COMPLETE ITEM IAW AFLCR			

(CONTINUED)

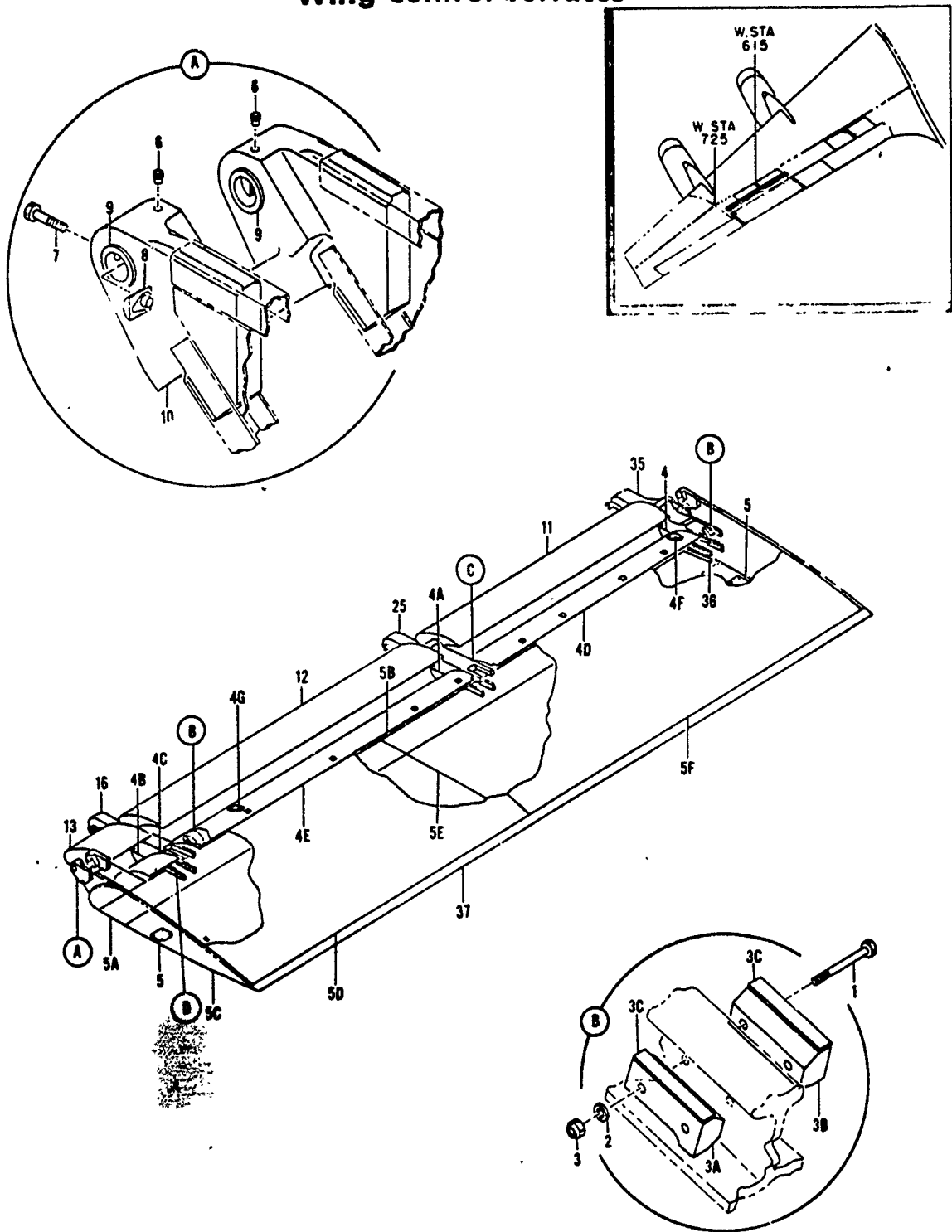
STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MATERIALS

66-51.  
ACCEPTANCE DATE ON THE LABEL ALONG  
WITH "M" STAMP OF THE PERSON PER  
FORMING THE OVERHAUL.  
CAUTION: SERIAL # IN WHICH LABELS ARE  
APPLIED MUST BE FREE OF DIRT.

COORDINATION:	DATE:
BARRETT MICHAEL TYLANIC	23 FEB 83
BARRETT PETER DONCAY	23 FEB 83
BARRETT GAIL MCCOY	23 FEB 83
BARRETT GEO HAYES	23 FEB 83

15188A  
15189A

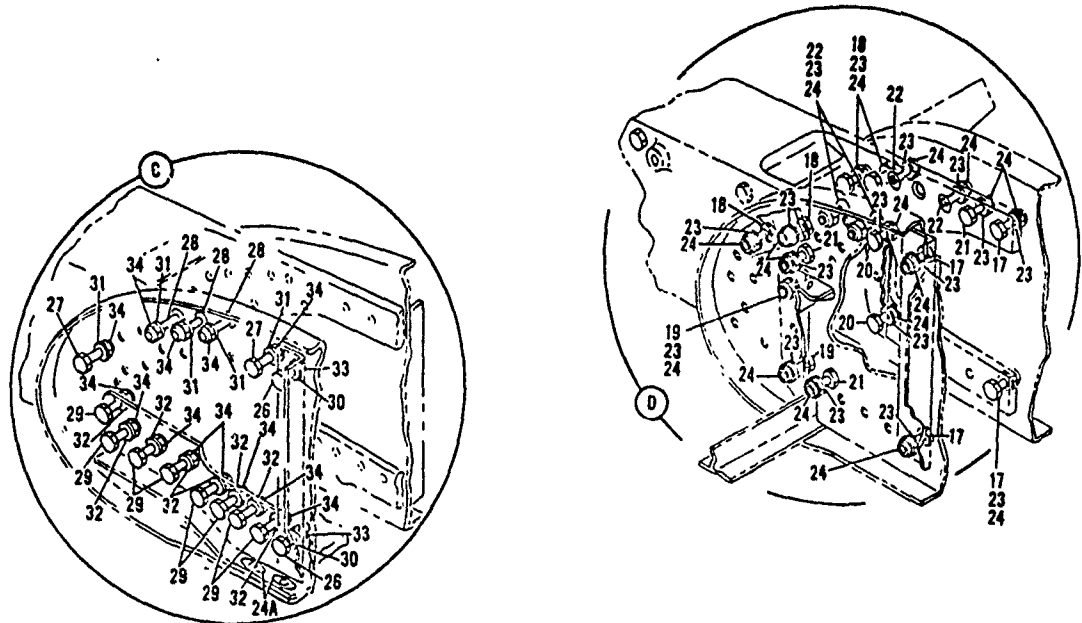
### Wing Control Surfaces



3153-44a

Figure 44. Outboard Flap Installations (Sheet 1 of 2)

### Wing Control Surfaces



3153-44b

Figure 44. Outboard Flap Installations (Sheet 2 of 2)

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
44 -	5-73132-1	FLAP INSTL, OUTBOARD (LH) (FOR NHA SEE FIG. 2) . . . . .							REF	
	5-73132-2	FLAP INSTL, OUTBOARD (RH) (FOR NHA SEE FIG. 2) . . . . .							REF	
	5-95315	. . . STOP INSTL, DOWN POSITION, OUTBOARD FLAP . . . . .							2	
1	NAS464P4A25	. . . BOLT (FOR REPLACEMENT ORDER NAS1104-25) . . . . .							2	
2	AN960D416L	. . . WASHER . . . . .							2	
3	NAS679A4W	. . . NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539) H10-4BAC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))							2	
3A	3-93742-3	. . . STOP, FLAP, DOWN POSITION (LH) . . . . .							1	
3B	3-93742-4	. . . STOP, FLAP, DOWN POSITION (RH) . . . . .							1	
3C	BACS40A7-37	. . . SHIM, LAM, 0.030 THK (ALTERNATES BACS40B7-37, . . . BACS40C7-37)							AR	
	5-87851-155	. . . FLAP ASSY, OUTBOARD (ALTERNATE, ANY AIR FORCE SPARE FLAP ASSEMBLY (5-87851-( )) LH FOR LH INSTALLATION INCORPORATING ALL APPLICABLE TECHNICAL ORDERS) (LH ONLY)							1	
	5-87851-156	. . . FLAP ASSY, OUTBOARD (ALTERNATE, ANY AIR FORCE SPARE FLAP ASSEMBLY (5-87851-( )) RH FOR RH INSTALLATION INCORPORATING ALL APPLICABLE TECHNICAL ORDERS) (RH ONLY)							1	
	65-24498-5	. . . DEPRESSORS INSTL, OUTBOARD FLAP (LH ONLY) . . . . .							1	A
	65-24498-6	. . . DEPRESSORS INSTL, OUTBOARD FLAP (RH ONLY) . . . . .							1	A
4	69-18383-1	. . . DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 546.30 (LH ONLY)							1	A
	69-18383-2	. . . DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 546.30 (RH ONLY)							1	A
4A	69-18384-1	. . . DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 615.00							1	A
4B	69-18385-1	. . . DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 700.50							1	A
4C	5-87851-143	. . . SKIN, NOSE, OUTBOARD, OUTBOARD FLAP (LH ONLY) . . . . .							1	
	5-87851-144	. . . SKIN, NOSE, OUTBOARD, OUTBOARD FLAP (RH ONLY) . . . . .							1	

CHANGED 29 SEPTEMBER 1968

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Section II  
Group Assembly Parts List

T.O. 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7						UNITS PER ASSY	USE ON CODE
44 -										
4D	5-87851-141	• • SKIN, NOSE, INBOARD, OUTBOARD FLAP (LH ONLY) . . . . .							1	
	5-87851-142	• • SKIN, NOSE, INBOARD, OUTBOARD FLAP (RH ONLY) . . . . .							1	
4E	5-87851-139	• • SKIN, NOSE, CENTER, OUTBOARD FLAP (LH ONLY) . . . . .							1	
	5-87851-140	• • SKIN, NOSE, CENTER, OUTBOARD FLAP (RH ONLY) . . . . .							1	
4F	69-9609-3	• • CAM ASSY, OUTBOARD FLAP, STATION 549.99 (LH ONLY) . . . . .							1	
	69-9609-4	• • CAM ASSY, OUTBOARD FLAP, STATION 549.99 (RH ONLY) . . . . .							1	
4G	69-9337-1	• • CAM ASSY, OUTBOARD FLAP, STATION 680.07 . . . . .							1	
5	63-8483	• • STRIP, BUMPER, ACTUATOR, OUTBOARD FLAP . . . . .							2	
5A	5-88723-15	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, . OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88723-23) (ALTERNATE 5-88723-23) (LH ONLY)							1	F
5A	5-88723-23	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, . OUTBOARD FLAP SKIN (I/W 5-88723-15) (USE 5-88723-15 UNTIL EXHAUSTED) (LH ONLY)							1	G
	5-88723-16	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, . OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88723-24) (ALTERNATE 5-88723-24) (RH ONLY)							1	F
	5-88723-24	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, . OUTBOARD FLAP SKIN (I/W 5-88723-16) (USE 5-88723-16 UNTIL EXHAUSTED) (RH ONLY)							1	G
5B	5-88722-15	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, . OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88722-23) (ALTERNATE 5-88722-23) (LH ONLY)							1	F
5B	5-88722-23	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, . OUTBOARD FLAP SKIN (I/W 5-88722-15) (USE 5-88722-15 UNTIL EXHAUSTED) (LH ONLY)							1	G
	5-88722-16	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, . OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88722-24) (ALTERNATE 5-88722-24) (RH ONLY)							1	F
	5-88722-24	• • PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, . OUTBOARD FLAP SKIN (I/W 5-88722-16) (USE 5-88722-16 UNTIL EXHAUSTED) (RH ONLY)							1	G
5C	50-4671-1	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (LH ONLY)							1	F
5C	50-4671-11	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (LH ONLY)							1	G
	50-4671-2	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . . OUTBOARD HALF (FOR REPLACEMENT ORDER 50-4671-3022) (RH ONLY)							1	F
	50-4671-12	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (RH ONLY)							1	G
5D	50-4671-3	• • PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (LH ONLY)							1	F
5D	50-4671-13	• • PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (LH ONLY)							1	G
	50-4671-4	• • PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (RH ONLY)							1	F
	50-4671-14	• • PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4671-3022) (RH ONLY)							1	G
5E	50-4670-1	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (LH ONLY)							1	F
5E	50-4670-11	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (LH ONLY)							1	G
	50-4670-2	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (RH ONLY)							1	F
	50-4670-12	• • PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (RH ONLY)							1	G
5F	50-4670-3	• • PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . . OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (LH ONLY)							1	F

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE
44 -											
5F	50-4670-13	.. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, .. OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (LH ONLY)							1	G	
	50-4670-4	.. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, .. OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (RH ONLY)							1	F	
	50-4670-14	.. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, .. OUTBOARD FLAP (FOR REPLACEMENT ORDER 50-4670-3022) (RH ONLY)							1	G	
6	9-61951-8	.. FITTING ASSY, SUPPORT, FLAP SCREW ..							1		
7	NAS516-1	.. FITTING ..							2		
8	AN4-10A	.. BOLT (FOR REPLACEMENT ORDER BACB30NE4-9) ..							2		
9	63-1519	.. NUTPLATE ASSY, CONVEX, WING FLAP ..							2		
10	3-98762	.. BEARING, SUPPORT, FLAP SCREW ..							2		
11	9-61951-7	.. FITTING, SUPPORT, FLAP SCREW ..							1		
	65-7360-5	.. FLAP ASSY, FORE (LH ONLY) (FOR REPLACEMENT ORDER .. 65-7360-3127) (FOR BREAKDOWN SEE FIG. 53)							1	B	
	65-7360-6	.. FLAP ASSY, FORE (RH ONLY) (FOR REPLACEMENT ORDER .. 65-7360-3128) (FOR BREAKDOWN SEE FIG. 53)							1	B	
12	65-7360-3129	.. FLAP ASSY, FORE (LH ONLY) (FOR BREAKDOWN SEE .. FIG. 54)							1		
	65-7360-3130	.. FLAP ASSY, FORE (RH ONLY) (FOR BREAKDOWN SEE .. FIG. 54)							1		
13	65-7360-9	.. FLAP ASSY, FORE (LH ONLY) (FOR BREAKDOWN SEE .. FIG. 55)							1		
	65-7360-10	.. FLAP ASSY, FORE (RH ONLY) (FOR BREAKDOWN SEE .. FIG. 55)							1		
	AN4-10A	(ATTACHING PARTS)									
	(A)AN4-11A	.. BOLT (FOR REPLACEMENT ORDER BACB30NE4-9) ..							20		
	NAS1104-3W	.. BOLT ..							20		
	AN960D416	.. BOLT (FOR REPLACEMENT ORDER NAS1104-3) ..							2		
	AN960PD416L	.. WASHER ..							22		
	NAS679A4W	.. WASHER ..							AR		
		.. NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539) .. H10-4BAC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))							22		
14	(DELETED)										
15	(DELETED)										
	5-87852-63	.. RIB INSTL, OUTBOARD TRACK, OUTBOARD FLAP (LH ONLY) ..							1		
	5-87852-64	.. RIB INSTL, OUTBOARD TRACK, OUTBOARD FLAP (RH ONLY) ..							1		
16	5-87847-7	.. CARRIAGE ASSY, END, OUTBOARD FLAP (FOR BREAKDOWN .. SEE FIG. 45)							1		
		(ATTACHING PARTS)									
17	NAS1104-8W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-8) ..							4		
18	NAS1104-6W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-6) ..							4		
19	NAS1104-9W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-9) ..							3		
20	NAS1104-7W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-7) ..							3		
21	NAS1104-8W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-6) ..							30		
22	NAS517-4-6	.. SCREW (FOR REPLACEMENT ORDER BACB30LU4-6) ..							6		
23	AN960D416	.. WASHER ..							50		
24	NAS679A4W	.. NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539) .. H10-4BAC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))							50		
	5-87852-72	.. RIB INSTL, CENTER TRACK, OUTBOARD FLAP ..							1		
24A	NAS4630416L	.. SHIM ..							4		
25	5-87848-3	.. CARRIAGE ASSY, CENTER, OUTBOARD FLAP (FOR .. BREAKDOWN SEE FIG. 52)							1		
		(ATTACHING PARTS)									
26	NAS1105-8W	.. BOLT (FOR REPLACEMENT ORDER NAS1105-8) ..							4		
27	NAS1104-6W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-6) ..							20		
28	NAS517-4-6	.. SCREW (FOR REPLACEMENT ORDER BACB30LU4-6) ..							6		
29	NAS1104-7W	.. BOLT (FOR REPLACEMENT ORDER NAS1104-7) ..							16		
30	AN960D516	.. WASHER ..							4		
31	AN960D416	.. WASHER ..							26		
32	AN960D416L	.. WASHER ..							16		
33	MS21042L5	.. NUT (REPLACES NAS679A5) ..							4		
34	NAS679A4W	.. NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539) .. H10-4BAC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))							42		

Section II  
Group Assembly Parts List

T.O.1C-135A-4

FIGURE & INDEX NO	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
44 - 35	5-87841-239	•	•	•	•	•	•	•	1	
	5-87841-240	•	•	•	•	•	•	•	1	
36	5-87851-91	•	•	•	•	•	•	•	1	D
36	5-87851-161	•	•	•	•	•	•	•	1	E
37	90-4577-49	•	•	•	•	•	•	•	1	
	90-4577-50	•	•	•	•	•	•	•	1	
	90-4577-51	•	•	•	•	•	•	•	1	
	90-4577-52	•	•	•	•	•	•	•	1	
	NASS17-3-4	•	•	•	•	•	•	•	117	
		----- A 3029 THRU 3099 B 2201 THRU 2299, 3001 THRU 3099 C DELETED D 3001 THRU 3001 E 3002 THRU 3099 F 3001 THRU 3099 G 2201 THRU 2299								



**NOTE:**

THIS FOREFLAP  
COMES OFF 15151A  
AT OPS 40 OR  
30 IN NEW AREA,  
AND IS ACSY IN  
OPS 430

**FLOW PROCESS CHART**

SUBJECT WING FLAP INBOARD FORE FLAP DATE 4/5/89

PCN: 15191A WCD: 15152A WCD DATE: 88055  
15192A

CHART BEGINS \_\_\_\_\_ PAGE 01 OF \_\_\_\_\_

CHART ENDS \_\_\_\_\_ PREPARED BY: R. BOLANDS

WCD OP #	SYMBOLS	DESCRIPTION	WCD OP #	SYMBOLS	DESCRIPTION
	○ ◊ ◐ ◑ ◒ ◓	DELAY coming off 15151A 95 from OPS 40		○ ◊ ◐ ◑ ◒ ◓	DELAY
	○ ◊ ◐ ◑ ◒ ◓	MOVE TO WASH STRIP 2122 MARPCA		○ ◊ ◐ ◑ ◒ ◓	MOVE TO CRATING
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
05	● ◊ ◐ ◑ ◒ ◓	STRIP & WASH FORE FLAP		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	MOVE TO X-RAY		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
10	● ◊ ◐ ◑ ◒ ◓	X-RAY SKINS		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	MOVE TO SHEETMETAL		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
20	● ◊ ◐ ◑ ◒ ◓	SHAKEDOWN INSPECTION		○ ◊ ◐ ◑ ◒ ◓	
25	● ◊ ◐ ◑ ◒ ◓	CHECK MOUNTING HOLES		○ ◊ ◐ ◑ ◒ ◓	
30	● ◊ ◐ ◑ ◒ ◓	R/R EXTERIOR SKINS & CLEAN		○ ◊ ◐ ◑ ◒ ◓	
40	● ◊ ◐ ◑ ◒ ◓	CHECK FOR CORROSION ANY REPAIR		○ ◊ ◐ ◑ ◒ ◓	
50	● ◊ ◐ ◑ ◒ ◓	R/R RIBS		○ ◊ ◐ ◑ ◒ ◓	
60	● ◊ ◐ ◑ ◒ ◓	R/R END ATTACHED PLATE		○ ◊ ◐ ◑ ◒ ◓	
70	● ◊ ◐ ◑ ◒ ◓	R/R INTERNAL RIBS		○ ◊ ◐ ◑ ◒ ◓	
80	● ◊ ◐ ◑ ◒ ◓	R/R RUB STRIPS		○ ◊ ◐ ◑ ◒ ◓	
90	● ◊ ◐ ◑ ◒ ◓	R/R FASTENERS		○ ◊ ◐ ◑ ◒ ◓	
100	● ◊ ◐ ◑ ◒ ◓	R/R TRAILING EDGE EXTENSION		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	MOVE TO WASH & PAINT. IF PAINT TO AIRCRAFT, NO PAINT NEEDED		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓			○ ◊ ◐ ◑ ◒ ◓	
110	● ◊ ◐ ◑ ◒ ◓	PREPARED & PAINT 2280 MARPCA		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
120	○ ◊ ◐ ◑ ◒ ◓	MOVE TO SHEETMETAL IF PDM TO AIRCRAFT.		○ ◊ ◐ ◑ ◒ ◓	
	○ ◊ ◐ ◑ ◒ ◓	DELAY		○ ◊ ◐ ◑ ◒ ◓	
130	● ◊ ◐ ◑ ◒ ◓	CONDITION TAG		○ ◊ ◐ ◑ ◒ ◓	

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 15152A WORK CONTROL DOCUMENT - MISTR 1. DATE 09055 PAGE 1 OF 2 ACLSI  
 \*\*\*\*\*  
 12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE CHLD 16. DATE COM  
 | | | MABPAB | | 87093 | |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 | | | | FORE FLAP SUPPLEMENT  
 | | | | SOW UC 1560FL/02-67  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | REVISION #1, DID 9 MAR 62  
 | 0 138 | |

13. AERO 14. NOUN/END ITLM NOUN  
 | | WING FLAP, INBOARD (FORE FLAP) | | |
 | | MICHAEL TYTANIC/MABECS/65261 |  
 | | | |  
 | 174 | | NSR | C/R |  
 | 5-86892-119 | | 1560006067421FL | 15151A |  
 | 5-86892-121 | | 1560006067421FL | 15151A |  
 | 5-86892-123 | | 1560006067421FL | 15151A |  
 | 5-86892-120 | | 1560006067422FL | 15152A |  
 | 5-86892-112 | | 1560006210781FL | 15160A |  
 | 5-86892-127 | | 1560006566065FL | 15104A |  
 | 5-86892-128 | | 1560006566066FL | 15185A |  
 | 5-86892-127 | | 1560006566200FL | 15191A |  
 | 5-86892-130 | | 1560006566201FL | 15192A |  
 | 5-86892-131 | | 1560006566202FL | 15193A |  
 | 5-86892-132 | | 1560006566203FL | 15194A |  
 | 5-86892-136 | | 156000675200FL | 15207A |

15. STATION	16. STATION NO.	17. WORK TO BE ACCOMPLISHED	18. PRG	19. QTY	20. QTY
	2122	005 STRIP AND WASH FORE FLAP MBPCA IAW 1C-135(K)A-3-4	40	/	/
	3003	010 X-RAY FORE FLAP, IF SKIN IS NOT MQCIA REMOVED. "N" STAMP RELO'D IAW 1C-135-36, SECT. 11	61	/	/
	95	020 ACCOMPLISH E&I SHAKEDOWN MBPAB	DS	/	/
	95	025 CHECK MOUNTING HOLES IN ATTACHMENT MBPAB BRACKET TO SEE IF WITHIN TOLERANCES. REQ'D _____ NOT REQ'D _____	DS	/	/
	95	030 REPAIR/REPLACE EXTERIOR SKINS IAW MBPAB IAW 1C-135(K)A-3-1, FIG 10-5 (INCLUDES CLEAN & CLOSEOUT).	DS	/	/
	95	040 CHECK FOREFLAP FOR CORROSION AND MBPAB WORK IF ANY IS FOUND. REQ'D _____ NOT REQ'D _____	DS	/	/
	95	050 REPLACE END RIB MBPAB REQ'D _____ NOT REQ'D _____	DS	/	/
	95	060 REPLACE END ATTACH PLATE MBPAB REQ'D _____ NOT REQ'D _____	DS	/	/
	95	070 REPLACE INTERNAL RIBS OR FLEED MBPAB REPAIRD RIBS. REQ'D _____ NOT REQ'D _____	DS	/	/

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15152A	*	WRK CONTROL DOCUMENT	* MISTR	1.DATE 80055	PAGL 2 OF 2 PAGL 21
15.DISP-16.PDN/					
STATION	OF NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"	20"
95	080 <sup>110</sup>	REPLACE RUB STRIPS NO. _____ MBFAB REQD _____ NOT REQD _____	DS	/	/
95	090 <sup>120</sup>	REPLACE MISSING, DEFECTIVE OR LOOSE MBFAB FASTENERS. REQD _____ NOT REQD _____	DS	/	/
95	100 <sup>130</sup>	REPLACE CRACKED TRAILING EDGE MBFAB EXTENSION. REQD _____ NOT REQD _____	DS	/	/
		MOVE TO MBPCB, BLDG 2280 NOTE: UNIT MOVE IF PDM LINE GENERATED FLAP.			
2280	110 <sup>140</sup>	FINAL WASH & CARBONIZE GREAT NOTE: UNIT MOVE IF PDM LINE GENERATED FLAP. <u>REPLACE TAIL</u> TAW JL-135(K/A 3-4 & 1 1 4 & 1 1 0 USING MIL P-87112 POLYSULFIDE PRIMER AND HIGH GLOSS GRAY MIL-C 83286 COLOR 16473 PAINT.	3D	/	/
2280	120	MOVE TO MBFAB, BLDG 95. MBPCB NOTE: MOVE TO AIRCRAFT SERIAL # _____ DATE _____ IF PDM LINE GENERATE FLAP.	3B	/	/
95	130	WORK COMPLETED, CONDITION TAG JAW MBFAB AFM 67-1. MOVE TO CRATING. DATE _____	DS	/	/
		COORDINATION:                      DATE:			
		MABEFS    MICHAEL TYTANIC    24 FEB 88			
		MABSF    PHIL DUNCAN    24 FEB 88			
		MABBF    TED HAYES    24 FEB 88			
		MBFAB    M.A. MCCOY    24 FEB 88			

FLOW PROCESS CHART

SUBJECT WING FLAP OUTBOARD

DATE 9/5

PCN: 15188A WCD: 15153 A WCD DATE: 88055  
15189A

CHART BEGINS

PAGE 1 OF 2

CHART ENDS

PREPARED BY: LARRY M

*operation numbers are in sequence of actual operations*

*Foreflaps worked on WCD 15154A*

WCD OF #	SYMBOLS	DESCRIPTION	WCD OF #	SYMBOLS	DESCRIPTION
010	● ◊ □ ▽	RECEIVE UNCRATE MBPCA	180	● ◊ □ ▽	REP/REP LEADING NOSE SKINS
	○ ◊ □ ▽	DELAY	190	● ◊ □ ▽	REPAIR NOSE SKINS IF CRACKED
	○ ◊ □ ▽	MOVE	200	● ◊ □ ▽	REPLACE CRACKED NOSE EVA RIBS
	○ ◊ □ ▽	DELAY	210	● ◊ □ ▽	CLOSEOUT / INSTALL UPPER OUTBOARD HONEYCOMB PANEL
020	● ◊ □ ▽	Remove Foreflaps MBPCA	220	● ◊ □ ▽	CLOSEOUT / INSTALL UPPER INBOARD HONEYCOMB PANEL
	○ ◊ □ ▽	95	230	● ◊ □ ▽	REPLACE WORN CARRIAGES
	○ ◊ □ ▽		240	● ◊ □ ▽	REP/REP DAMAGED FAIRINGS
	○ ◊ □ ▽		250	● ◊ □ ▽	REMOVE SEAL DEPRESSION
030	● ◊ □ ▽	Remove Honeycomb Panels	260	● ◊ □ ▽	CLOSEOUT / INSTALL LOWER INBOARD HONEYCOMB PANEL
	○ ◊ □ ▽	DELAY	270	● ◊ □ ▽	CLOSEOUT / INSTALL LOWER OUTBOARD HONEYCOMB PANEL
	○ ◊ □ ▽	MOVE TO 2122	280	● ◊ □ ▽	INSTALL IN SIG
	○ ◊ □ ▽	DELAY	290	● ◊ □ ▽	INSPECT ALIGNMENT
040	● ◊ □ ▽	Plug all drain holes 2122 MBPCA	300	● ◊ □ ▽	REMOVE FROM SIG
	○ ◊ □ ▽		310	● ◊ □ ▽	REPLACE BAD FASTENERS
	○ ◊ □ ▽		320	● ◊ □ ▽	REWORK DRAIN HOLES
	○ ◊ □ ▽		330	● ◊ □ ▽	REPAIR GROOVES
050	● ◊ □ ▽	Clean & Strip	340	● ◊ □ ▽	ACCOMPLISH AERO SEALANT
	○ ◊ □ ▽		350	● ◊ □ ▽	CLEAN/TREAT CORROSION
060	● ◊ □ ▽	ACCOMPLISH NDZ 2122 MBPCA		○ ◊ □ ▽	DELAY
	○ ◊ □ ▽	2122		○ ◊ □ ▽	MOVE TO 2280
070	● ◊ □ ▽	REPAIR (ALIGNMENT CHECK) MBPCA		○ ◊ □ ▽	DELAY
	○ ◊ □ ▽	95		○ ◊ □ ▽	DELAY
100	● ◊ □ ▽	REP/REP UPPER HONEYCOMB PANEL	360	● ◊ □ ▽	FINAL WASH + PAINT 2280 MBPCA
110	● ◊ □ ▽	REP/REP TRAILING EDGE		○ ◊ □ ▽	DELAY
120	● ◊ □ ▽	REP/REP INBOARD RIB / LONGERON		○ ◊ □ ▽	MOVE TO 95
130	● ◊ □ ▽	REP/REP OUTBOARD RIB / LONGERON		○ ◊ □ ▽	DELAY
140	● ◊ □ ▽	REP/REP LOWER HONEYCOMB PANELS	370	● ◊ □ ▽	ATTACH + SERVICE BARRINGS 95 MBPCA
150	● ◊ □ ▽	REPLACE CRACKED TRAILING EDGE RIBS	380	● ◊ □ ▽	REPLACE DEFECTIVE OVERLAP ATTACH NUTPLATES
160	● ◊ □ ▽	REPLACE CRACKED OR DAMAGED LEADING EDGE CLIPS, ETC.	390	● ◊ □ ▽	INSTALL FOREFLAPS
170	● ◊ □ ▽	REPLACE LEADING EDGE NOSE RIBS / WEBS	400	● ◊ □ ▽	REPLACE WORN OR DAMAGED SEALS

*MBPCA 070 SHARE DOWN*

*MBPCA 080 Inspection*



7. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 1. STATEMENT OF WORK FILE  
 NO. OC-1560FL/32-66.  
 10. MODEL/DESIGN/SERIES 11. STOCK NR 2. BILL IN ANY ADD'L  
 WORK REQUIREMENTS.  
 C-135  
 13. RUCC 14. NOUN/END ITEM NOUN  
 WING FLAP, GUIDD  
 MULLALL TITANIC, MAREBS/65261

P/N	NSN	U/N
5-87851-145	1560006067423FL	15153A
5-87851-146	1560006067424FL	15154A
5-87851-136	1560006210789FL	15171A
5-87851-153	1560006470303FL	15176A
5-87851-154	1560006470304FL	15177A
5-87851-155	1560006566180FL	15188A ✓
5-87851-156	1560006566181FL	15189A ✓
5-87851-159	1560006566204FL	15195A
5-87851-160	1560006566205FL	15196A
5-87851-163	1560009609837FL	15255A

15. DISP	16. PDN	17. WORK TO BE ACCOMPLISHED	18. MLCH	19. P	20. Q
2122	010 MBPCD	RECEIVE AND UNCRATE. REQ'D _____ NOT REQ'D _____	①	DC	
2122	<del>020</del> MBPCA	CLEAN AND STRIP PAINT FROM FLAP (INCLUDE FLAP TRACK WELL) IAW IC-135 (K)A-3-4, SEC. XI. NOTE: ON PDM LINE GENERATED FLAP CLEAN FLAP TRACK WELL AND CARRIAGE ASSYS. ASSURE ENTIRE ASSY. IS FREE OF ALL DIRT, PAINT AND GREASE.	④	4W	
2122	<del>030</del> MBPCA	PLUG ALL DRAIN HOLES TO PREVENT PAINT STRIPPER FROM ENLITING INTO INTERIOR OF FLAP ASSY. NOTE: OMIT IF PDM LINE GENERATED FLAP.		4W	
95	<del>040</del> MBPAB	REMOVE FOREFLAPS & ASSURE FOR FLAP SUPPLEMENTAL SHEET WILL ACCOMPANY APPROPRIATE ITEM. See WCD 15154A.	②	DS	
95	<del>050</del> MBPAB	REMOVE 2 EA UPPER AND 2 EA LOWER HONEYCOMB PANELS FOR ACCESS.	③	DS	
2122	<del>060</del> MBPCA	ACCOMPLISH INTERIOR WASH, UPPER AND LOWER FLAP FOR CORROSION. MOVE TO MBPAB. REQ'D _____ NOT REQ'D _____	⑤	4W	
95	<del>070</del> MBPAB	ACCOMPLISH SHUTDOWN INSPECTION OF FLAP IAW SOV. ANNOTATE DISCREPANCIES NOTE: THE ITEM(S) INPUT ON THIS 959 WILL BE OVERHAULED IN ACCORDANCE	⑥	DS	

(CONTINUED)

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15153A	WORK CONTROL DOCUMENT	1.041	GROUP	PAGE	10
115.DISP	16.PDN/				
STATION ID NO.	117.WORK TO BE ACCOMPLISHED			12"X12"X120"Q"	
	WITH INSTRUCTIONS CONTAINED IN WORK SPECIFICATION UC-FL/82-56 & THE TECHNICAL ORDERS AND DIRECTIVES CONTAINED IN SLOTTED TAB "A"				
95	100 MBPAB	INSPECT DRAIN HOLES IN FLAP CARRIAGE FOR CRACKS WITH LEDDY CURRENT. "N" STAMP REQUIRED IAW 10-135-56 SER V, PART 2. REQ'D _____ NOT REQ'D _____	AL	/	/
95	110 MBPAB	ACCOMPLISH ALIGNMENT CHECK IAW SER V, PART 2. REQ'D _____ NOT REQ'D _____		/	/
95	100 MBPAB	REPAIR/REPLACE UPPER HONEYCOMB PANELS IAW 10-135-56 SER V, PART 2 & PART 3. REQ'D _____ NOT REQ'D _____		/	/
95	110 MBPAB	REPAIR/REPLACE DAMAGED TRAILING EDGE IAW 10-135-(K)A 3-1 REQ'D _____ NOT REQ'D _____ NOTE: HONEYCOMB TRAILING EDGE MAY REQUIRE TRIMMING. CAUTION: GAP BETWEEN HONEYCOMB PANELS MUST BE MAINTAINED AS SHOWN IN I.O. 10-135(K)A 3-1, FIG. 10-6		/	/
95	120 MBPAB	REPAIR/REPLACE INBOARD RIB AND LONGERON. REQ'D _____ NOT REQ'D _____	DC	/	/
95	130 MBPAB	REPAIR/REPLACE OUTBOARD RIB AND LONGERON. REQ'D _____ NOT REQ'D _____	DC	/	/
95	140 MBPAB	REPAIR/REPLACE LOWER HONEYCOMB PANELS IAW 10-135(K)A 3-1, SECT. X REQ'D _____ NOT REQ'D _____	DC	/	/
95	150 MBPAB	REPLACE CRACKED TRAILING EDGE RIBS. REQ'D _____ NOT REQ'D _____	DC	/	/
95	160 MBPAB	REPLACE CRACKED OR DAMAGED LEADING EDGE NOSE RIBS AND WELDS. REQ'D _____ NOT REQ'D _____	DC	/	/
95	170 MBPAB	REPLACE CRACKED OR DAMAGED LEADING EDGE ANGLES, CLIPS AND CHANNELS REQ'D _____ NOT REQ'D _____	DC	/	/
95	180 MBPAB	REPAIR/REPLACE CRACKED OR DAMAGED LEADING NOSE SKINS (REPLACE MAGNESIUM SKIN WITH ALUMINUM). REQ'D _____ NOT REQ'D _____	DC	/	/
95	190 MBPAB	REMOVE NOSE SKINS IF CRACKS ARE FOUND.	DC	/	/

(CONTINUED)

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 15153A \* WORK CONTROL DOCUMENT \* DATE 8/1/78  
 115.01SP-16.PDN/  
 STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.FLIGHT/

		REQ'D	NOT REQ'D			
95	200 MBPAB	REPLACE CRACKED NOSE END RING. REQ'D	NOT REQ'D	DS	/	
	210 MBPAB	ACCOMPLISH CLOSEOUT & INSTALL UPPER OUTBOARD HONEYCOMB PANEL. INCLUDES INTERNAL CORROSION TREATMENT & REPLACEMENT OF IMPAIRED FASTENERS. REQ'D	NOT REQ'D	DS	/	/
	220 MBPAB	ACCOMPLISH CLOSEOUT & INSTALL LOWER OUTBOARD HONEYCOMB PANEL. INCLUDES INTERNAL CORROSION TREATMENT AND REPLACEMENT OF IMPAIRED FASTENERS. REQ'D	NOT REQ'D			
95	230 MBPAB	REPLACE CRACKED OR WORN FLAP CARTRIDGES. ENSURE FLAP IS IN POSITION PRIOR TO FLIGHT ADJUSTMENT. REQ'D	NOT REQ'D	DS	L	/
95	240 MBPAB	REPAIR/REPLACE CRACKED OR DAMAGED FAIRINGS. REQ'D	NOT REQ'D	DS	/	/
95	250 MBPAB	REMOVE GLASS DEPRESSOR AND PLUG OPEN FASTENERS HULLS. REQ'D	NOT REQ'D	DS	/	
95	260 MBPAB	ACCOMPLISH CLOSEOUT AND INSTALL LOWER INBOARD HONEYCOMB PANEL. INCLUDES INTERNAL CORROSION TREATMENT AND REPLACEMENT OF IMPAIRED FASTENERS. REQ'D	NOT REQ'D	DS	/	/
95	<del>270 MBPAB</del> <b>OK MBPAB</b>	ACCOMPLISH CLOSEOUT AND INSTALL LOWER OUTBOARD HONEYCOMB PANEL. INCLUDES INTERNAL CORROSION TREATMENT AND REPLACEMENT OF IMPAIRED FASTENERS. REQ'D	NOT REQ'D	DS	/	/
95	280 MBPAB	INSTALL WING FLAP ON REPAIR JIG P/N 590CA1030.		DS	/	/
95	290 MBPAB	ACCOMPLISH INSPECTION & ALIGNMENT CHECK PRIOR TO REMOVAL FROM JIG.		DS	E	/
95	300 MBPAB	REMOVE FLAP FROM REPAIR FIXTURE.		DS	/	/
95	310 MBPAB	REPLACE ALL EXCESSIVE WEAR LOOSE PULLED OR BENT FASTENERS. REQ'D	NOT REQ'D	DS	/	/



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15193A * WORK CONTROL DOCUMENT #	1. DATE CROSS	PAGE	4 OF	6	TABLS
113.DISP-16.PDN/					
STATION/OP NO.	117.WORK TO BE ACCOMPLISHED				
95	320 MBPAB	IF NO CRACKES ARE FOUND IN CARRIAGE REWORK DRAIN HOLES LAW FIG. 1-2 & 3 OF SOW. REQ'D _____ NOT REQ'D _____	DC	/	/
	330 MBPAB	REPAIR CRACKS IN APERTURE CAUSED BY LATCHES AND _____ A 3 3 FIG. 2 23 REQ'D _____ NOT REQ'D _____			
75	340 MBPAB	FILL ALL GRINDING TRAILING EDGES & SKIN HILL ACCORDING TO DRAWING WITH ENVIRONMENTAL SEALANT. REQ'D _____ NOT REQ'D _____			
95	350 MBPAB	CLEAN AND TREAT EXTERNAL CORROSION LAW 10-135(K)A 3-4 PAGES 5-15 TO 4-22. OBSERVE ALL NOTICES, CAUTIONS & WARNINGS. REQ'D _____ NOT REQ'D _____ MOVE TO MBPCB, BLDG. 2280 NOTE: OMIT IF PDM LINE GENERATED FLAP.	DC	/	/
7280	360 MBPCB	FINAL WASH AND CORROSION TREAT. NOTE: OMIT IF PDM LINE GENERATED FLAP. REQ'D _____ NOT REQ'D _____ PAINT WING FLAP LAW 10-135(K)A 3-3 10-135(K)A 3-4, 3-1-1 4-3 & 1-1-3 USING MIL-P-8711Z POLYURETHANE PRIMER & HIGH GLOSS GRAY HFL-C-8326/COLOUR 16473 PAINT NOTE: MARKINGS TO BE INSTALLED LAW DRAWING 5-87851. MOVE TO MBPAB, BLDG. 95 NOTE: OMIT IF PDM LINE GENERATED FLAP.	DC	/	/
95	370 MBPAB	REPLACE ALL FLAP ATTACH BEARING SUPPORTS & SERVICE (CLEAN & UNFACED) REPLACE BEARINGS. REQ'D _____ NOT REQ'D _____	DC	/	/
75	380 MBPAB	REPLACE DEFECTIVE FORFLAP ATTACH NUTPLATES IN CARRIAGE ASSY. REQ'D _____ NOT REQ'D _____ CAUTION: WHEN OVERHAULING FLAP ASSY, 156009609837FL & 1560009609838FL, IT IS MANDATORY TO USE THE LATEST PREFERRED FORFLAPS IN ALL POSITIONS.	DC	/	/
95	390 MBPAB	INSTALL FOREFLAPS AND ASSURE INST. MEASUREMENTS AND POSITIONS IS LAW DRAWING 5-87851 & 10-135(K)A-2 8 FIG. 5 31. NOTE: FLAP ASSY. 1560000000101FL WILL HAVE FOREFLAPS 178 35-7360 3	DC	/	/

(CONTINUED)

STATION/OP NO.	17. WORK TO BE ACCOMPLISHED	18. FLIGHT/QUALITY CONTROL
15100A 15. DESK 16. PDN/ 15. STATION/OP NO.	<p>OR - 3127 AND 65-7360-7 AND 65-7360-3129 INSTALLED.</p> <p>FLAP ASSY. 15600065661811L WILL HAVE FOREFLAPS P/N 65-7360-10 OR 3160 AND 65-7360-6 OR 6528 65 7360 3129</p> <p>REPLACE ALL BURN OR DAMAGED GLASS.</p> <p>REPAIR OR REPLACE ALL CRACKED GLASS.</p> <p>NOTE: NON STOCK LISTED PARTS &amp; SUPPLIES WILL BE LOCALLY FABRICATED IF AVAILABLE.</p> <p>NOTE: OVERHAUL OF FLAP HOUSING SHALL BE ACCOMPLISHED JAW P/N 5-87003 &amp; 511 SPECIALLY TO INSURE CORRECT ALIGNMENT. REMOVAL OF MORE THAN 2 PANELS AT ONE TIME WILL REQUIRE THE FLAP TO BE PLACED IN FIXTURE 57041030.</p> <p>NOTE: USE SKINS &amp; PANELS REMOVED AS TEMPLATES TO DETERMINE SIZE, LOCATION &amp; LOCATION OF RIVETS HOLES.</p> <p>NOTE: REPLACEMENT OF NONSTOCKING PANELS THAT REQUIRE EDGE TRIMMING WILL HAVE THOSE EDGES RESEALED PRIOR TO INSTALLATION WITH MIL-S-8836.</p> <p>LOWER PANELS THAT REQUIRE DRAIN HOLES WILL HAVE THE EDGES OF THE SEALED BEING CAREFUL NOT TO LET EXCESS SEALER CREATE A DAMMING EFFECT. ALL FASTENERS WILL BE INST. WET USING MIL-S-81733 (MIL-S-8807) OR EPOXY PAINT MEL 12337 MAY BE USED AS AN OPTION.</p>	
75 430 MBPAB	<p>WORK COMPLETED. CONDITION TAG DATE</p> <p>JAW AFM 67-1</p> <p>MOVE TO CRATING</p> <p>NOTE: MOVE TO AIRCRAFT IF PDM LINE GENERATED FLAP.</p> <p>SERIAL# _____ DATE _____</p> <p>NOTE: PART WILL HAVE OC-ALC FORM 506 587, &amp; 588 IDENTIFICATION LABELS APPLIED TO COMPLETE ITEM JAW AFMCR 66-51.</p> <p>ACCEPTANCE DATE ON THE LABEL ALONG WITH "M" STAMP TO THE PERSON PERFORMING THE OVERHAUL.</p> <p>CAUTION: SURFACE TO WHICH LABELS ARE APPLIED MUST BE FREE OF DIRT</p>	
	<p>COORDINATION DATE</p> <p>MABSFS MICHAEL LITVINIC 23 FEB 88</p> <p>MABSFS PHIL DUNCAN 23 FEB 88</p> <p>MABPAB M.A. MOULT 23 FEB 88</p>	

(CONTINUED)

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 15153A WORK CONTROL DOCUMENT  
 115.01SP-16.PDN/  
 STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.FILCH 11/11/70/00

MAQBFA TED HAYES

23 FEB 68

NOTE:

THIS FOREFLAP  
COMES OFF 15153A  
AT OPERATION 40  
OR 30 IN THE NEW  
SEQUENCE. AND IS  
ASBY IN OPS 390.

FLOW PROCESS CHART

SUBJECT WING FLAP, OUTBOARD FORE FLAP DATE 4/5/89

PCN: 15188A WCD: 15154A WCD DATE: 88055  
15189A

CHART BEGINS \_\_\_\_\_ PAGE 1 OF 1

CHART ENDS \_\_\_\_\_ PREPARED BY: R. BOLANOS

WCD OP #	SYMBOLS	DESCRIPTION	WCD OP #	SYMBOLS	DESCRIPTION
	○ ◊ ◻ ▽	DELAY MABPAB		○ ◊ ◻ ▽	DELAY
	○ ◊ ◻ ▽	MOVE TO WASH ? STRIP MABPCA	140 145	● ◊ ◻ ▽	WORK COMPLETE TAG
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	DELAY
05	● ◊ ◻ ▽	STRIP & WASH Z122 MABPCA		○ ◊ ◻ ▽	IF PDM MOVE TO AIRCRAFT LINE OTHERWISE MOVE TO CRATING
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	MOVE TO X-RAY (From 30) 3001 MAGCIA		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
20	● ◊ ◻ ▽	X-RAY FORE FLAP		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	MOVE TO SHEETMETAL 95 MABPAB		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
30	● ◊ ◻ ▽	R/R PIN		○ ◊ ◻ ▽	
40	● ◊ ◻ ▽	SHAKEDOWN ACC EYE		○ ◊ ◻ ▽	
50	○ ◊ ◻ ▽	CHECK FOR CORROSION		○ ◊ ◻ ▽	
55	● ◊ ◻ ▽	R/R BRACKET		○ ◊ ◻ ▽	
60	● ◊ ◻ ▽	R/R EXTERIOR SKINS & CLEAN		○ ◊ ◻ ▽	
80	● ◊ ◻ ▽	R/R RIBS		○ ◊ ◻ ▽	
90	● ◊ ◻ ▽	R/R END ATTACH PLATE		○ ◊ ◻ ▽	
100	● ◊ ◻ ▽	R/R INTERNAL RIB		○ ◊ ◻ ▽	
110	● ◊ ◻ ▽	REPLACE R/R STRIP		○ ◊ ◻ ▽	
120	● ◊ ◻ ▽	REPLACE DEFECTIVE RIVETS		○ ◊ ◻ ▽	
130	● ◊ ◻ ▽	" CRACKED TRAILING EDGE EXTRUSION		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	MOVE TO WASH / PAINT Z200 MABPCD		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
140	● ◊ ◻ ▽	FINAL WASH & TREAT FOR CORROSION		○ ◊ ◻ ▽	
150	● ◊ ◻ ▽	PAINT		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	DELAY		○ ◊ ◻ ▽	
	○ ◊ ◻ ▽	MOVE TO SHEETMETAL 95 MABPAB		○ ◊ ◻ ▽	

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 1515-A WORK CONTROL DOCUMENT \* BULK 1. DATE MOSS PAGE 1 OF 2 PAGES  
 12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/REL 15. DATE BUILT 16. DATE SHIP  
 MABPAB 89073

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 REQUIRED.  
 FORE FLAP SUPPLEMENT  
 10. MOD. E. DESIGN/SERIES 11. STOCK NR 1. QUANTITY  
 C 135  
 TECH DATA/OPTIONAL  
 FILL IN ANY ADD'L WORK.  
 13. DISC 14. NOUN/END ITEM NOUN

P/N	QTY	STOCK NR	REL	TECH DATA/OPTIONAL
87351-133	150	1500006210	87351	15171A
87351-134	150	1500006470306	87351	15176A
87351-134	154	1500006470304	87351	15177A
87351-135	150	1500006566100	87351	15180A
87351-136	150	1500006566131	87351	15189A
87351-139	150	1500006566204	87351	15195A
87351-130	150	1500006566205	87351	15176A
87351-130	150	1500007609037	87351	15255A

15. DISC	16. PDR	17. WORK TO BE ACCOMPLISHED	18. TECH DATA/OPTIONAL	19. P"R" 19"R" 20"R"
212	005	STRIP AND WASH FORE FLAP MABPAB IAW IC-135(K)A-3-4 MOVE TO MOCIA	4W	/ /
3001	020	X-RAY FOR FLAP, IF SKIN IS NOT MOCIA REMOVED. NO STAMP REQUIRED IAW IC 135-36 SECTION PART 2.	RN	N /
95	030	IF P/N 65-7360-7 OR 8 IS INSTALLED MABPAB REPLACE WITH 65-7360 3129 & 3130 REQ'D NOT REQ'D	DS	/ /
95	040	ACC E&I SHAKEDOWN MABPAB	DS	/ /
95	045	CHECK FOREFLAP FOR CORROSION AND MABPAB WORK IF ANY IS FOUND REQ'D NOT REQ'D	DS	/ /
95	055	CHECK MOUNTING BOLTS IN ATTACHMENT MABPAB BRACKET TO SEE IF WITHIN TOLERANCES. REQ'D NOT REQ'D	DS	/ /
95	060	REPAIR/REPLACE EXTERIOR SKINS MABPAB IAW IC-135(K)A-3.1, FIG 10-5 (INCLUDES CLEAN & FLOREOUT). REQ'D NOT REQ'D	DS	/ /
95	080	REPLACE END RIB. MABPAB REQ'D NOT REQ'D	DS	/ /
95	090	REPLACE END ATTACHMENT BALL. MABPAB REQ'D NOT REQ'D	DS	/ /

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15154A * WORK CONTROL DOCUMENT * MSTR 1 DATE 00055 PAGE 2			
16. WORK TO BE ACCOMPLISHED			
17.	18.	19.	20.
95	100	REPLACE INTERNAL RIBC OR FIELD MABPAB REPAIRED RIBS. REQ'D. NOT REQ'D.	DS
95	110	REFLECT RUB STRIPS TO MABPAB REQ'D. NOT REQ'D.	DS
95	120	REPLACE MISSING OR DEFECTIVE RIBS. MABPAB REQ'D. NOT REQ'D.	DS
95	130	REPLACE BUCKLE RAILING EDGE MABPAB EXTENSION. REQ'D. NOT REQ'D. MOVE TO MABPAB.	DS
200	140	FINAL WASH & CORROSION TREAT MABPAB RIBS UNIT IF CORROSION GENERATED FLAP	DS
200	150	PREPARE & PAINT JAW TO DIMENSIONS 4 & 5 MABPAB 1 1 G USING MIL P 87112 POLYURETHANE PRIMER & HIGH GLOSS GRAY MIL-O-BOND COLOR 16473 PAINT. UNIT OF PDM LINE GENERATED FLAP. MOVE TO MABPAB BLDG. 20	DS
95	160	NOTE: MOVE TO AIRCRAFT SERIAL# MABPAB DATE IF PDM LINE GENERATED FLAP.	DS
95	165	WORK COMPLETED, CONDITION TAG JAW MABPAB AFM 67-1. MOVE TO CRAFTING. DATL.	DS
	170	MABEFS MICHAEL TITARI 23 FEB 80 MABEFS PHIL DUNCAN 23 FEB 80 MABPAB M. A. MCCOY 23 FEB 80 MABEFS TED HAYES 23 FEB 80	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE
1892 -	50-4694-1	TAIL CONE ASSY, STATION 301.10 TO 341.25, BOOM . . . . . (FOR REPLACEMENT ORDER 50-4694-18) (FOR NHA SEE FIG. 1890)								REF	A
	50-4694-18	TAIL CONE ASSY, STATION 301.10 TO 341.25, BOOM (FOR NHA SEE FIG. 1890)								REF	
	50-4694-2C	TAIL CONE ASSY, STATION 301.10 TO 341.35, BOOM (FOR SPARES ONLY) (PARTS KITS AVAILABLE)								REF	
		PARTIAL BREAKDOWN FOLLOWS									
1	50-5125	• LIGHT INSTL, TAIL CONE, BOOM (FOR BREAKDOWN SEE FIG. 1893)								REF	C
1	50-5125-1	• LIGHT INSTL, TAIL CONE, BOOM (FOR BREAKDOWN SEE FIG. 1893)								REF	D
2	5-961 2-53	• HYDRAULIC INSTL, FLYING BOOM (FOR BREAKDOWN SEE FIG. 1929)								REF	
	50-4694-2	• STRUCTURE ASSY, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	A
	50-4694-19	• STRUCTURE ASSY, TAIL CONE, STATION 301.10 TO 341.25, BOOM (USED ON 50-4694-16)								REF	B
	50-4694-21	• STRUCTURE ASSY, TAIL CONE, STATION 301.10 TO 341.25, BOOM (USED ON 50-4694-20)								REF	
3	NAS514P632-6	• SCREW (X) (LH)								2	G
4	NAS519A066	• NUT (X) (LH)								2	G
5	50-4694-12	• BUMPER, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	H
6	50-4694-11	• BUMPER, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	J
6	50-4694-16	• BUMPER, TAIL CONE, STATION 301.10 TO 341.25, BOOM								1	K
7	50-4694-10	• STRAP, TAIL CONE, STATION 301.10 TO 341.25, BOOM (MAKE FROM 2024-T6 ALUM CLAD 0.051 THK. APPROX. SIZE 1.10 X 1.00)								REF	G
8	50-4694-9	• SKIN, TAIL CONE, STATION 301.10 TO 341.25, BOOM								1	
	50-4694-3	• WELD ASSY, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	L
	50-4694-15	• WELD ASSY, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	M
9	50-4694-4	• SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	L
9	50-4694-14	• SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	M
10	50-4694-5	• SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	
11	50-4694-6	• SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM								REF	
12	50-4694-7	• SKIN, LOWER, TAIL CONE, STATION 301.10 TO 341.25, BOOM (LH)								1	
13	50-4694-8	• SKIN, LOWER, TAIL CONE, STATION 301.10 TO 341.25, BOOM (LH)								1	
14	50-4694-13	• FILLER, TAIL CONE, STATION 301.10 TO 341.25								REF	N
15	66-2944	• CUP, DRAIN, TAIL CONE, BOOM FAIRING								1	P
	50-5135	• FRAME INSTL, STATION 301.10, BOOM (USED ON 50-4694-2)								REF	A
	50-5135-6	• FRAME INSTL, STATION 301.10, BOOM (USED ON 50-4694-19)								REF	B
	50-5135-9	• FRAME INSTL, TAIL CONE, STATION 301.10, BOOM (USED ON 50-4694-21)								REF	
16	50-5135-3	• SPLICE, TAIL CONE, STATION 301.10, BOOM								1	
17	50-5135-4	• SPLICE, TAIL CONE, STATION 301.10, BOOM								REF	
18	50-5135-5	• FILLER, TAIL CONE, STATION 301.10, BOOM								2	
19	50-5135-5	• FILLER, TAIL CONE, STATION 301.10, BOOM (USED ON 50-5135, -6)								16	
20	50-5135-10	• TAB, TAIL CONE, STATION 301.10, BOOM (USED ON 50-5135-9)								REF	
21	50-5135-1	• FRAME, HALF, TAIL CONE, STATION 301.10, BOOM								1	A
22	50-5135-7	• FRAME, HALF, TAIL CONE, STATION 301.10, BOOM								1	R
23	50-5135-2	• FRAME, HALF, TAIL CONE, STATION 301.10, BOOM								1	A
24	50-5135-8	• FRAME, HALF, TAIL CONE, STATION 301.10, BOOM								1	R
	50-6037	• FRAME INSTL, TAIL CONE, STATION 309.15, BOOM								REF	
25	50-6037-4	• CHANNEL, FRAME SPLICE, TAIL CONE, STATION 309.15, BOOM								1	
26	50-6037-3	• CHANNEL, FRAME SPLICE, TAIL CONE, STATION 309.15, BOOM								1	
27	50-6037-5	• STRIP, FRAME REINFORCING, TAIL CONE, STATION 309.15, BOOM								REF	
28	50-6037-6	• STRIP, FRAME REINFORCING, TAIL CONE, STATION 309.15, BOOM								REF	
29	50-6037-7	• BRACKET, FRAME TEE, TAIL CONE, STATION 309.15, BOOM								1	P
30	50-6037-1	• FRAME, HALF, TAIL CONE, STATION 309.15, BOOM								1	
31	50-6037-2	• FRAME, HALF, TAIL CONE, STATION 309.15, BOOM								1	

### Aerial Refueling Boom

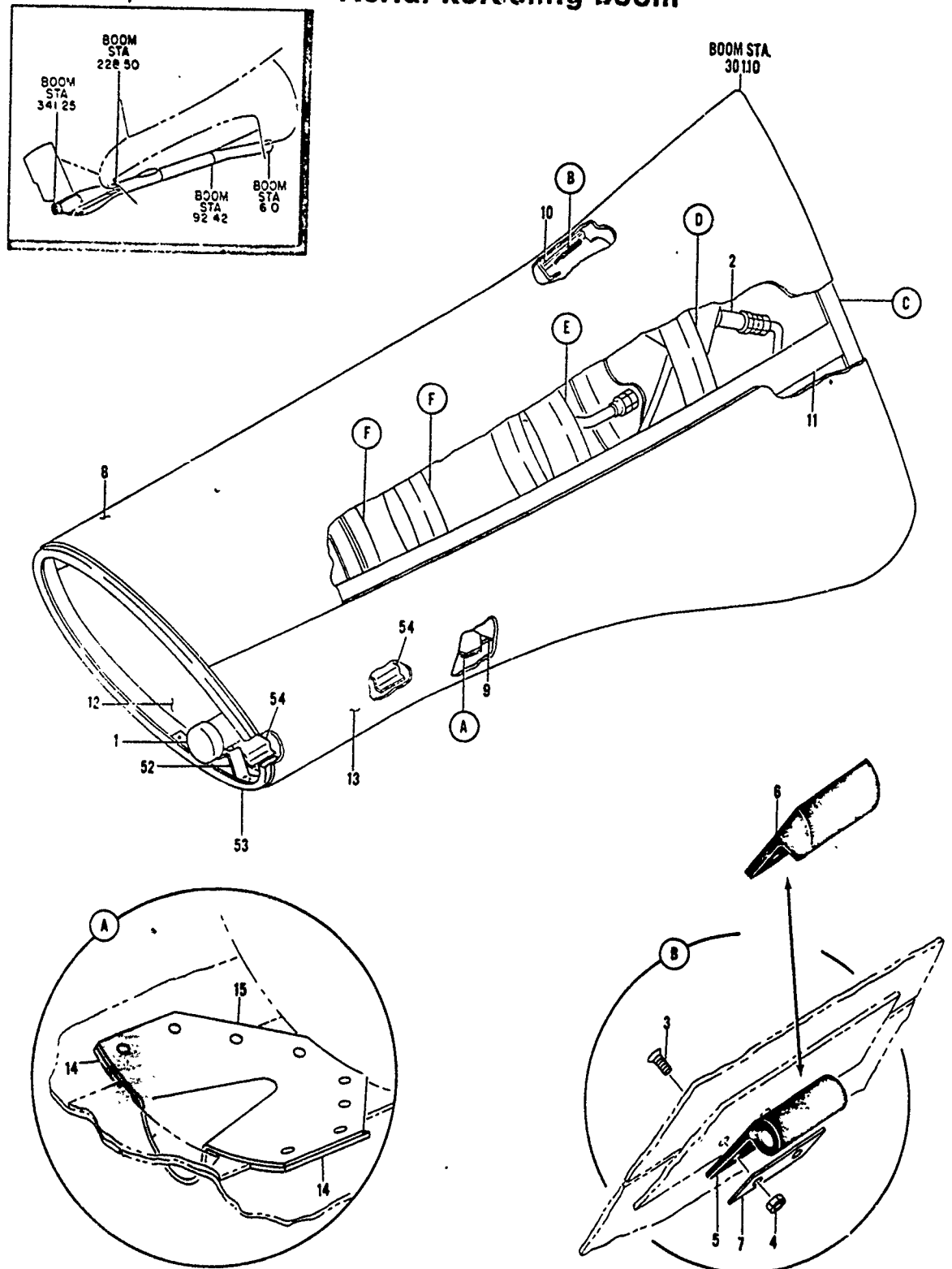
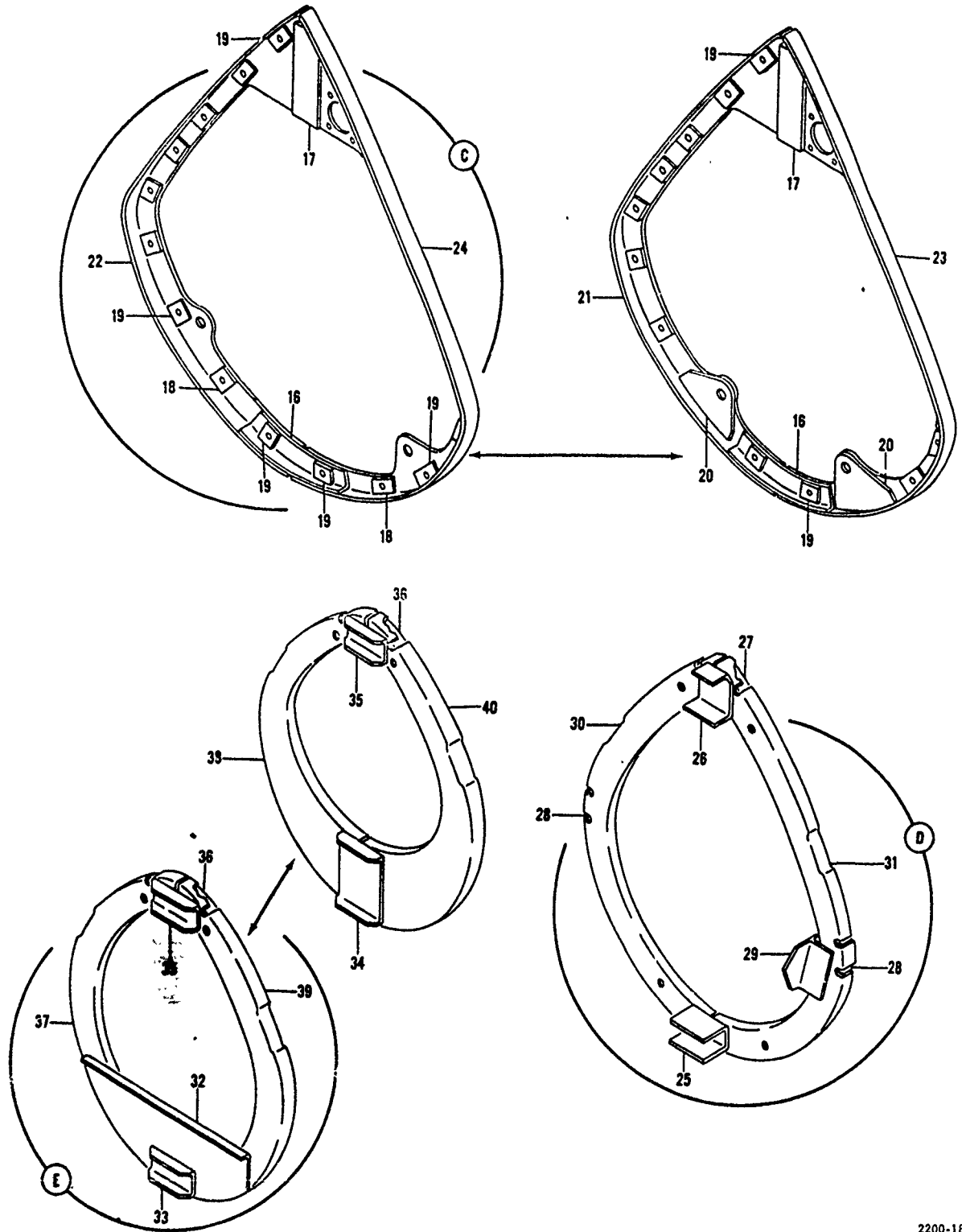


Figure 1892. Boom Station 301.10 to 341.25 Tail Cone Assembly (Sheet 1 of 3)



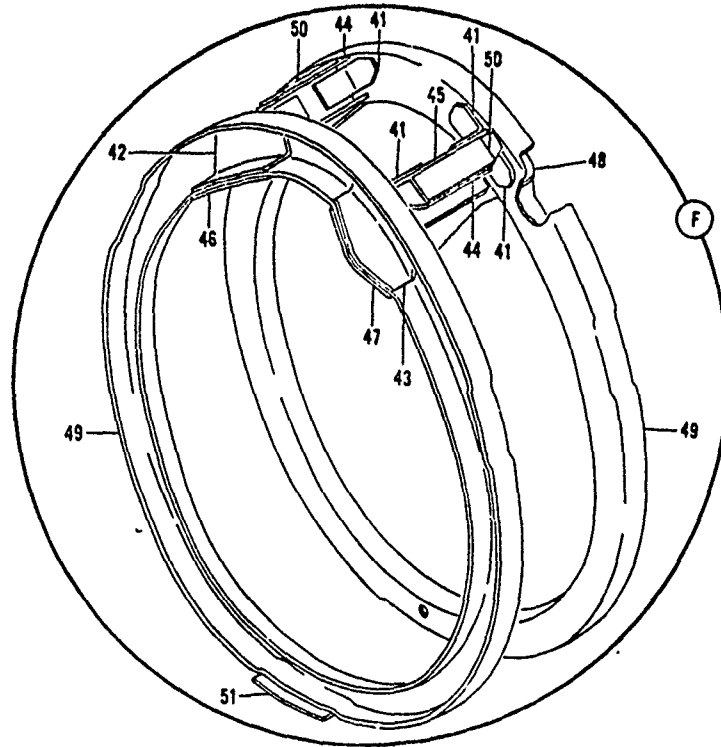
### Aerial Refueling Boom



2200-1892b

Figure 1892. Boom Station 301.10 to 341.25 Tail Cone Assembly (Sheet 2 of 3)

### Aerial Refueling Boom



2200-1892c

Figure 1892. Boom Station 301.10 to 341.25 Tail Cone Assembly (Sheet 3 of 3)

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
1892 -	50-6034	..	..	..	..	..	..	..	REF	L
	50-6034-6	..	..	..	..	..	..	..	REF	M
32	66-2936	..	..	..	..	..	..	..	REF	P
33	50-6034-3	..	..	..	..	..	..	..	REF	L
34	50-6034-9	..	..	..	..	..	..	..	1	M
35	50-6034-4	..	..	..	..	..	..	..	1	
36	50-6034-5	..	..	..	..	..	..	..	1	
37	50-6034-1	..	..	..	..	..	..	..	REF	L
38	50-6034-2	..	..	..	..	..	..	..	1	M
39	50-6034-3	..	..	..	..	..	..	..	REF	L
40	50-6034-4	..	..	..	..	..	..	..	1	M
	50-6012	..	..	..	..	..	..	..	REF	
41	50-6012-7	..	..	..	..	..	..	..	REF	
42	50-6012-5	..	..	..	..	..	..	..	1	
43	50-6012-6	..	..	..	..	..	..	..	1	
44	50-6012-3	..	..	..	..	..	..	..	2	
45	50-6012-4	..	..	..	..	..	..	..	2	
46	50-6012-1	..	..	..	..	..	..	..	REF	
47	50-6012-2	..	..	..	..	..	..	..	REF	
48	50-6012-9	..	..	..	..	..	..	..	REF	
49	50-6012-8	..	..	..	..	..	..	..	2	
50	BACS40A15-48	..	..	..	..	..	..	..	AR	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
1892 -										
51	BACS40B13-320	. . . SHIM, LAM, 0.062 THK (ALTERNATES BACS40C13-320, . BACS40D13-320) (KD)							AK	
	50-6043	. . . FRAME INSTL, FAIRING, STATION 333.46 TO . . . . . 341.25, BOOM							REF	E
	50-6043-3	. . . FRAME INSTL, FAIRING, STATION 333.46 TO . . . . . 341.25, BOOM							REF	N
	50-6043-5	. . . FRAME INSTL, FAIRING, STATION 333.46 TO . . . . . 341.25, BOOM							REF	M
52	50-6043-2	. . . BRACKET, FRAME LIGHT SUPPORT, FAIRING, STATION . 333.46 TO 341.25, BOOM							REF	L
53	50-6043-1	. . . FRAME, FAIRING, STATION 333.46 TO 341.25, BOOM .							REF	E
53	50-6043-4	. . . FRAME, FAIRING, STATION 333.46 TO 341.25, BOOM .							REF	N
53	50-6043-6	. . . FRAME, FAIRING, STATION 333.46 TO 341.25, BOOM .							1	M
54	66-18464-1	. . . BRACKET, NOZZLE LIGHT SUPPORT, REFUELING BOOM . . (MAKE FROM 9535 2024-D CLAU QQ-A-362 TEMPER 4.0 X 1.5 X 0.032)							2	
		A BOOM UNIT 1-1 THRU 1-119								
		B BOOM UNIT 3-120 AND ON								
		C BOOM UNIT 1-1 THRU 1-99								
		D BOOM UNIT 1-100 AND ON								
		E BOOM UNIT 1-1 THRU 1-3								
		F BOOM UNIT 1-4 THRU 1-119								
		G BOOM UNIT 1-5 AND ON								
		H BOOM UNIT 1-5 THRU 1-11								
		J BOOM UNIT 1-12 THRU 1-29								
		K BOOM UNIT 1-30 AND ON								
		L BOOM UNIT 1-1 THRU 1-16								
		M BOOM UNIT 1-17 AND ON								
		N BOOM UNIT 1-4 THRU 1-16								
		P BOOM UNIT 1-4 AND ON								

FLOW PROCESS CHART

SUBJECT Beam Tail Cone DATE 4/5/89

PCN: 15175A WCD: 15175A WCD DATE: 89073

CHART BEGINS Operation 010

CHART ENDS Operation 440

PREPARED BY: Tim Hall

see supplementary  
sheet for  
020 + 030

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
010 ● ◊ D □ ▽	Receive and Uncrate 2122 MABPAB	220 ● ◊ D □ ▽	Repair AFT Frame Supt 6012-8
○ ◊ D □ ▽	Delay	230 ● ◊ D □ ▽	Repair Frame 6043-6
○ ◊ D □ ▽	Move to Bldg 95 95 MABPAB	240 ● ◊ D □ ▽	Repair Defective fasteners & the Nut plate
○ ◊ D □ ▽	Delay	250 ● ◊ D □ ▽	Replace cup drain
020 ● ◊ D □ ▽	Remove Hyd Tubing & valves	260 ● ◊ D □ ▽	Replace bumper 4694-11
040 ● ◊ D □ ▽	Remove all wiring & lights	270 ● ◊ D □ ▽	Replace strap 4694-10
○ ◊ D □ ▽	Delay	280 ● ◊ D □ ▽	Replace support
○ ◊ D □ ▽	Move to 2122	290 ● ◊ D □ ▽	Replace 2 eq. isolator vibrators
○ ◊ D □ ▽	Delay	300 ● ◊ D □ ▽	Treat corrosion
050 ● ◊ D □ ▽	Strip paint 2122 MABPAB	310 ● ◊ D □ ▽	Remove Tail Cone From Fixture
○ ◊ D □ ▽	Delay	○ ◊ D □ ▽	Delay
○ ◊ D □ ▽	Move to 95 95 MABPAB	○ ◊ D □ ▽	Move to Bldg 2280 2280 MABPAB
○ ◊ D □ ▽	Delay	○ ◊ D □ ▽	Delay
060 ● ◊ D □ ▽	Shakedown	320 ● ◊ D □ ▽	Wash
070 ● ◊ D □ ▽	Install Tail Cone	330 ● ◊ D □ ▽	Paint
080 ● ◊ D □ ▽	Repair Skin - 9	340 ● ◊ D □ ▽	Paint - anti-corrosion
090 ● ◊ D □ ▽	Replace splice	○ ◊ D □ ▽	Delay
100 ● ◊ D □ ▽	Repair Skin - 8	○ ◊ D □ ▽	Move to Bldg 95 95 MABPAB
110 ● ◊ D □ ▽	Replace -14 splice	○ ◊ D □ ▽	Delay
120 ● ◊ D □ ▽	Repair Skin	360 ● ◊ D □ ▽	Inspect wiring & light
140 ● ◊ D □ ▽	Replace -5 splice	370 ● ◊ D □ ▽	Repair wiring
140 ● ◊ D □ ▽	Smooth out scratches, joints	380 ● ◊ D □ ▽	Repair Terminals
150 ● ◊ D □ ▽	Repair -7 Frame Half	390 ● ◊ D □ ▽	Repair Light fixtures
160 ● ◊ D □ ▽	Repair Frame Half - 8 5135	400 ● ◊ D □ ▽	Replace lamps
170 ● ◊ D □ ▽	Repair -1 Frame Half 6037	410 ● ◊ D □ ▽	Conduct Continuity check
180 ● ◊ D □ ▽	Repair -2 Frame Half Frame half	420 ● ◊ D □ ▽	Reinstall hyd. Tubing & valves
190 ● ◊ D □ ▽	Repair 6034 - 7 Frame Half	○ ◊ D □ ▽	Delay
200 ● ◊ D □ ▽	Repair 6034 - 8 Frame Half	430 ○ ◊ D □ ▽	Move to MABPAB 95 MABPAB
210 ● ◊ D □ ▽	Repair FWD. Frame Supt. 6012-8	○ ◊ D □ ▽	Delay







*****					
15175A * WORK CONTROL DOCUMENT * MLSTR 1. DATE 89073 PAGE 2 OF 4 PAGES					
115. DISP-16. PDN/					
11. STATION/OP NO.		17. WORK TO BE ACCOMPLISHED		18. MECH 19" 120"	
95	120 MBFAB	SKIN, P/N 50-4694-7. REPAIR__REPLACE__NOT REQ'D__		E	/
95	130 MBFAB	REPLACE SPLICE, P/N 50-4694-5. REQ'D__NOT REQ'D__		/	/
95	140 MBFAB	SMOOTH OUT SCRATCHES, GOUGES, & ETC. LAW S.O.W PARA 3.2.5D.		E	/
95	150 MBFAB	FRAME HALF, P/N 50 5135 7. REPAIR__REPLACE__NOT REQ'D__		/	/
95	160 MBFAB	FRAME HALF, P/N 50 5135 8. REPAIR__REPLACE__NOT REQ'D__		/	/
95	170 MBFAB	FRAME HALF P/N 50 6037 1. REPAIR__REPLACE__NOT REQ'D__		/	/
95	180 MBFAB	FRAME HALF P/N 50-6037 2 REPAIR__REPLACE__NOT REQ'D__		/	/
95	190 MBFAB	FRAME HALF, P/N 50 6034 7 REPAIR__REPLACE__NOT REQ'D__		/	/
95	200 MBFAB	FRAME HALF, P/N 50 6034-8 REPAIR__REPLACE__NOT REQ'D__		/	/
95	210 MBFAB	FWD FRAME SUPT., P/N 50-6012-8 REPAIR__REPLACE__NOT REQ'D__		E	/
95	220 MBFAB	AFT FRAME SUPT., P/N 50-6012-8 REPAIR__REPLACE__NOT REQ'D__		E	/
95	230 MBFAB	FRAME P/N 50-6043-6 REPAIR__REPLACE__NOT REQ'D__		/	/
95	240 MBFAB	DEFECTIVE FASTENERS AND/OR NUT PLATE REPAIR__REPLACE__NOT REQ'D__		/	/
95	250 MBFAB	REPLACE CUP DRAIN, P/N 66-2944.		/	/
95	260 MBFAB	REPLACE BUMPER, P/N 50-4694-11.		/	/
95	270 MBFAB	REPLACE STRAP, P/N 50-4694-10		/	/



115.DISP 16.IDN/

STATION/OP NO.		117.WORK TO BE ACCOMPLISHED	118.MECH 19"P"120"Q"	
95	280 MBFAB	REPLACE SUPPORT, LIGHT, P/N 60-6662-1	/	/
	290 MBFAB	REPLACE 2 EA. SUPPORT FOR TAB, P/N 60-6662-1	/	/
95	300 MBFAB	REMOVE CORROSION AND TREAT IAW 10-135(K)A-3-4. REPAIR__NOT REQ'D__	/	/
95	310 MBFAB	REMOVE TAIL CONE FROM FIXTURE. MOVE TO BLDG 2280, MBPCB	/	/
2280	320 MBPCB	ACCOMPLISH FINAL WASH	/	/
2280	330 MBPCB	PAINT INTERIOR AND EXTERIOR WITH EPOXY PRIMER MJL-P 8/112, P/N 8010 00-082-2477.	/	/
2280	340 MBPCB	PAINT EXTERIOR WITH ANTI-CORROSION FINISH MIL-C-83206-B, P/N 8010 00 A93-2614.(PENCIL OR WARNING) MOVE TO BLDG. 25, MBPMA.	/	/
95	360 MBPAA	INSPECT WIRING AND LIGHTS IAW 6A3-4- 3. REINSTALL ALL WIRING AND LIGHTS IAW DRAWING 5-96333. CONDUCT CONTIN UITY CHECK ON INSTALLED HARNESS. ALSO REFERENCE T.O. J-1A-1, AND T.O. 10-135(K)A-2-12-1.	/	/
95	370 MBPAA	WIRING IAW 6A3-4-3 & DRAWING 5-96333 REPAIR__REPLACE__NOT REQ'D__	/	/
95	380 MBPAA	TERMINALS REPAIR__REPLACE__NOT REQ'D__	/	/
95	390 MBPAA	LIGHT FIXTURES. REPAIR__REPLACE__NOT REQ'D__	/	/
95	400 MBPAA	REPLACE ALL LAMPS.	/	/
95	410 MBPAA	CONDUCT CONTINUITY CHECK ON COMPLETED ITEM.	/	/
95	420 MBPAA	REINSTALL HYDRAULIC TUBING & VALVES IN BOOM TAIL CONE ASSY IAW DRAWING 5-96162.	/	/
95	425 MBFAB	CHECK FULL DUMP MECHANISM WITH MECHANICAL ARM STOPPED AGAINST THE RUBBER BUMPER, MANUALLY MOVE THE MECHANISM ARM INBOARD TOWARD THE CENTERLINE OF THE BOOM ASSEMBLY TO DETERMINE WEAR, IF ARM PLAY	/	/

(CONTINUED)

EXCEEDS ALLOWABLE LIMITS OF 0.70,  
 REPAIR FUEL DUMP MECHANISM ASSEMBLY.  
 REF. T.O. 6A3-4-3, FIG 5-5.

95 430 MBPAA ROUTE ITEM TO MBPAC WITH THIS 959. /

95 440 MBPAP WORK COMPLETED. CONDITION TAG  
 DATE \_\_\_\_\_ MOVE TO CRATING. / L /  
 CONDITION TAGGED 1AW AFM 67-1.  
 NOTE: COMPLETE "REMARKS" COLUMN OF  
 AFIC FORM 3574 1AW NAOI 66 35.  
 NOTE: PART WILL HAVE DC-ALL FORMS  
 506, 507, & 508 IDENTIFICATION LABELS  
 APPLIED TO COMPLETED ITEM 1AW AFICR  
 66-51 ACCEPTANCE DATE ON THE LABEL  
 ALONG WITH "M" STAMP OF THE PERSON  
 PERFORMING THE OVERHAUL.  
 CAUTION: SURFACES TO WHICH LABELS  
 ARE APPLIED MUST BE FREE OF  
 CONTAMINATION.

COORDINATION

MABEBS PHYLLIS HEALD 22 MARCH 89  
 MABSCS CONNIE WEBBER 22 MARCH 89  
 MABPAB JESSIE JACOBS 22 MARCH 89  
 MAQBF TED HAYES 22 MARCH 89

15178A

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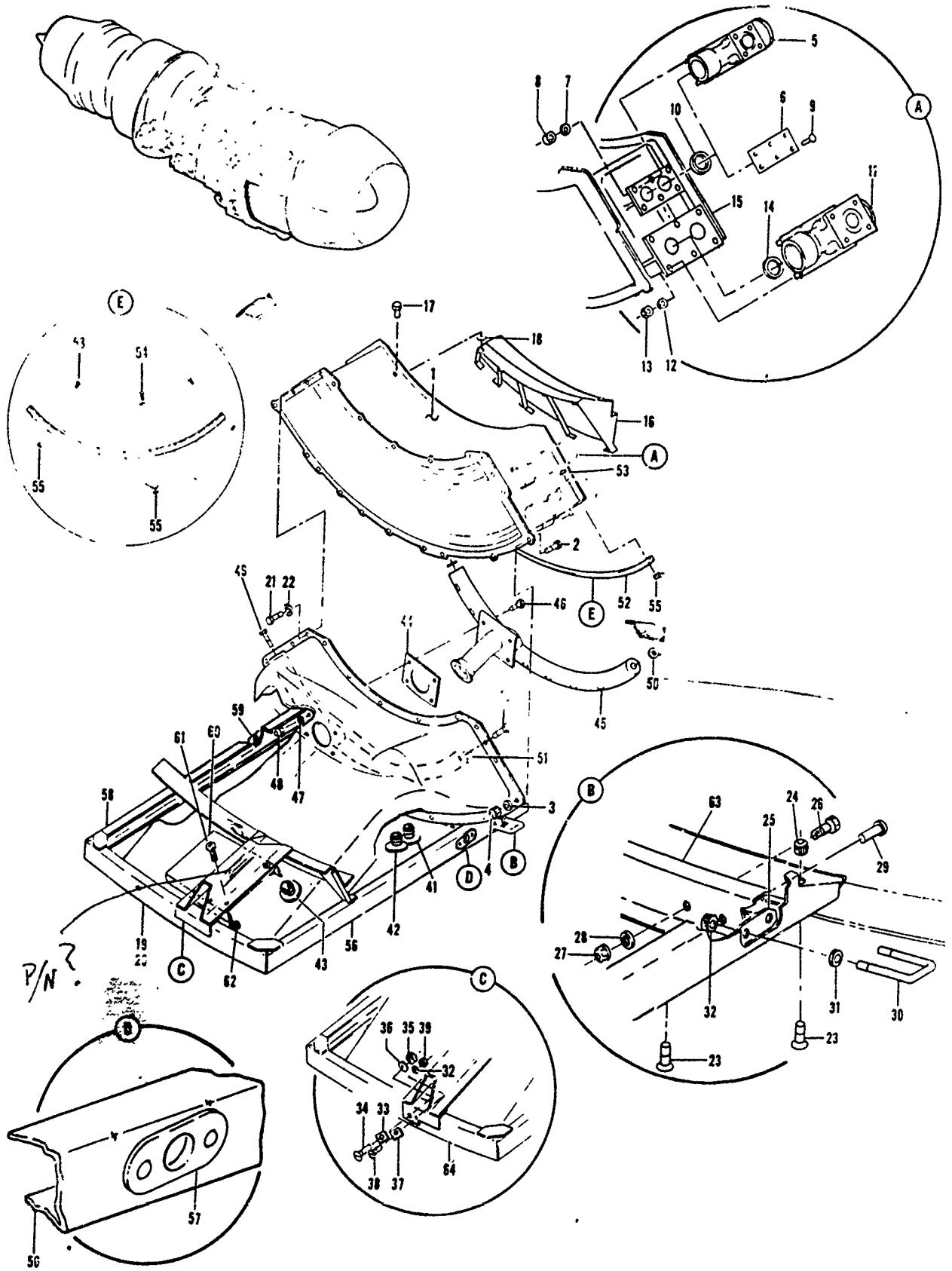


Figure 4-22. Engine and Generator Drive Oil Cooler Installation

T.O. 1C-135(K)A-10

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	CA CODE
4-22	5-88456	COOLER INSTL, Engine and generator drive oil. . . . .	Ref	
-1	998A1	. COOLER ASSY, Engine and generator drive oil . . . . . (57733) (Boeing Specification 10-2571-8) (optional 65-13008) (for T.O. covering parts breakdown see introduction to Section IV.) (ATTACHING PARTS)	1	
-2	NAS1303-4	. BOLT (Replaces AN3-5A) (for replacement, order. . . . . BACB30NF3D4)	15	
-3	AN960D10	. WASHER. . . . .	11	
-4	MS21042L3	. NUT, Self-locking 500°F (replaces NAS679A3W) (for . . . replacement, order BACN10JC3)	15	
-5	G712504	. . VALVE ASSY., Generator drive oil bypass and relief. . . (57733) (Boeing Specification 10-2571-4)	1	C
-6	No Number	. . COVER PLATE (Fabricate from 0.125 to 0.250. . . . . inch thick aluminum, 2.820 x 1.916, drill 6 each holes 0.193 inch diameter to match core) (ATTACHING PARTS)	1	D
-7	AN960D10	. . WASHER. . . . .	6	
-8	MS21C42L3	. . NUT, Self-locking 500°F (replaces NAS679A3W). . . . . (for replacement, order BACN10JC3)	6	
-9	NAS1303-4	. . BOLT (Replaces AN3-5A). . . . .	6	D
-10	MS29561-211	. . GASKET, O-ring (BACG10T16) (optional PRP 1847-211 . . . (25184), SRC-CZ1415-16 (95272), 47-071-2-211 (83259))	2	
-11	G712503	. . VALVE ASSY., Engine oil bypass and relief . . . . . (57733) (Boeing Specification 10-2571-3) (ATTACHING PARTS)	1	
-12	AN960PD416	. . WASHER. . . . .	6	
-13	MS21042L4	. . NUT, Self-locking 500°F (replaces NAS679A4W). . . . . (for replacement, order BACN10JC4)	6	
-14	MS29561-217	. . GAS T, O-ring (BACG10T22) (optional PRP 1847-217 . . . (25184), SRC-CZ1415-22 (95272), 47-071-2-217 (83259))	2	
-15	G715802	. . CORE ASSY, Oil cooler (57733) (Boeing . . . . . Specification 10-2571-9) (optional G712502 (57733) (Boeing Specification 10-2571-2) with holes drilled for hail shield attachment)	1	
-16	G715800	. . SHIELD, Hail (57733) (Boeing Specification. . . . . 10-2571-10) (ATTACHING PARTS)	1	
-17	MS9316-04	. . SCREW (96906) (optional NAS603-13 or NAS603-13P). . .	5	
-18	AN960D10	. . WASHER. . . . .	AR	
-19	50-2458-35	. . TAB ASSY., Oil cooler exit duct (optional 50-2458). . .	1	A
-20	50-2458-41	. . TAB ASSY., Oil cooler exit duct (optional 50-2458-37) . . (ATTACHING PARTS)	1	B
-21	NAS1303-8V	. . BOLT (For replacement, order BACB30NE3-8) . . . . .	6	
-22	AN960PD10L	. . WASHER. . . . .	6	
-23	NAS517-4-2	. . SCREW, (Optional MS24694999 when nose cowl doubler. . . is installed)	6	
-24	MS21042L4	. . NUT, Self-locking 500°F (replaces NAS679A4W) (for . . . replacement, order BACN10JC4)	2	
-25	68C75396-1	. . FITTING, U-bolt . . . . .	2	
-26	NAS1103-3	. . BOLT. . . . .	3	
-27	MS21042-3	. . NUT, Self-locking . . . . .	3	
-28	AN960PD10	. . WASHER. . . . .	3	
-29	MS2047AD6-8	. . RIVET . . . . .	1	
-30	9-66304-1	. . U-BOLT. . . . . (ATTACHING PARTS)	2	
-31	AN316-5R	. . NUT . . . . .	4	
-32	H23-5	. . NUT (15653) (BACN10B-L5L) (optional FN22A-524 . . . . . (03680), LH3393-054 (72962) VN406-A-054 (92215))	4	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							A
		1	2	3	4	5	6	7	
4-22(Cont)									
-33	50-2458-804								1
-34	NAS334CPA6								1
-35	MS21042L4								1
-36	AN960D416L								1
-37	50-2458-805								1
-38	NAS514P1032-8								1
-39	MS21042L3								1
-40	AN960C10L								1
-41	BACF22H6-3								1
-42	BACF22H8-3								1
-43	BACF22J6D								1
	50-6379-21								1
	50-6379								1
-44	60-5730								1
-45	90-6937-4								1
-46	NAS1304-3								4
-47	AN960D416L								4
-48	MS21012L4								4
-49	NAS1304-9H								2
-50	AN960-416								2
-51	60-5732								2
-52	90-7940								1
-53	MS9316-04								3
-54	MS9316-06								6
-55	MS21042L3								AR
-56	50-2458-27								1
-57	3-74650								1
-58	50-2458-28								1
-59	3-74650								1
-60	(a) 36-7367-1								1
-61	(a) NAS603-8P								4
-62	(a) MS21042L3								2
-63	50-2458-3								1
-64	50-2458-10								1

A Use with 50-4678  
 B Use with 50-4678-36  
 C Used on 5-96388 oil system  
 D Used on 5-96388-1 oil system  
 E Used on 50-2458-35, -37, and -41 tab assy

(a) Added by T.O. 1C-135-920

FLOW PROCESS CHART

SUBJECT Oil Cooler Tab Assy

DATE 4/4/89

PCN: 15178A WCD: 15178A WCDDATE: 88054

CHART BEGINS Operation 010

CHART ENDS Operation 260

PREPARED BY: Tim Hall

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
10 ● ◊ □ ▽	RECEIVE / UNCRATE 2122 MBPCA	140 ● ◊ □ ▽	Replace Frame 95 MBPCA
○ ◊ □ ▽	DELAY	150 ● ◊ □ ▽	Replace Hot Set brackets
○ ◊ □ ▽	MOVE	160 ● ◊ □ ▽	Replace support brackets
○ ◊ □ ▽	DELAY	170 ● ◊ □ ▽	Replace support Frame
12 ● ◊ □ ▽	CLEAN OIL COOLER TAB 2122 MBPCA	180 ● ◊ □ ▽	Replace air ejector Tube assy + gasket
15 ● ◊ □ ▽	STRIP PAINT 2122 MBPCA	190 ● ◊ □ ▽	Replace cover plate (skin)
18 ● ◊ □ ▽	ABRASIVE BLAST 2122 MBPCA	200 ● ◊ □ ▽	Replace bearing block
○ ◊ □ ▽	DELAY	210 ● ◊ □ ▽	Replace striking plates
○ ◊ □ ▽	MOVE TO 95	220 ● ◊ □ ▽	Replace Flange Flared Tube (Large)
○ ◊ □ ▽	DELAY	230 ● ◊ □ ▽	Replace Flange Flared Tube (Small)
22 ● ◊ □ ▽	ACCOMPLISH SHUTDOWN INSPECTION 95 MBPCA	○ ◊ □ ▽	Delay
○ ◊ □ ▽	DELAY	○ ◊ □ ▽	Move to Bldg 2280 2280 MBPCA
○ ◊ □ ▽	MOVE TO 3001	○ ◊ □ ▽	Delay
○ ◊ □ ▽	DELAY	240 ● ◊ □ ▽	Prime interior surfaces
26 ● ◊ □ ▽	WELD 3001 MTPW	○ ◊ □ ▽	Delay
○ ◊ □ ▽	DELAY	○ ◊ □ ▽	Move to Bldg 95 95 MBPCA
○ ◊ □ ▽	MOVE TO 95	○ ◊ □ ▽	Delay
○ ◊ □ ▽	DELAY	● ◊ □ ▽	Condition T92
30 ● ◊ □ ▽	REPAIR / TREAT CORROSION 95 MBPCA	○ ◊ □ ▽	
40 ● ◊ □ ▽	REPLACE FASTENERS	○ ◊ □ ▽	
50 ● ◊ □ ▽	Replace 'U' bolt bracket	○ ◊ □ ▽	
60 ● ◊ □ ▽	Delete one bolt nearest 'U' bolt & substitute with rivet	○ ◊ □ ▽	
70 ● ◊ □ ▽	Replace stop 95 needed	○ ◊ □ ▽	
80 ● ◊ □ ▽	Replace rib	○ ◊ □ ▽	
90 ● ◊ □ ▽	Replace R.H. longeron	○ ◊ □ ▽	
100 ● ◊ □ ▽	Replace L.H. longeron	○ ◊ □ ▽	
110 ● ◊ □ ▽	Replace Latch Support	○ ◊ □ ▽	
120 ● ◊ □ ▽	Replace 'U' bolt	○ ◊ □ ▽	
130 ● ◊ □ ▽	Replace Lap strip	○ ◊ □ ▽	

\*\*\*\*\*  
 15170A \* WORK CONTROL DOCUMENT \* MISTR 1.DATE 88054 PAGE 1 OF 3 PAGES  
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12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHLD 16. DATE COMP  
 15178A | | NABPAB | 89093 |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 50 2458-41 | | | SOW UC1560FL/83-158  
 | | | 36 MAR 84

10. MODEL/DESIGN/SERIES 11. STOCK NR  
 C-135 | 1560006513615FL

13. MISC 14. NOUN/END ITEM NOUN  
 | OIL COOLER TAB ASSY  
 | L. MULLINAX/MABEBS/65266

15. DISP 16. PDN/  
 17. WORK TO BE ACCOMPLISHED 18. CH 19. 20. 21.

2122	010	RECIEVE & UNCRATE	/	/	/
	MBPCD				
2122	012	CLEAN OIL COOLER TAB IAW T.O. 1 1 1	/	/	/
	MBPCA				
2122	015	STRIP AND REMOVE ALL PAINT IAW T.O. 10-135(K)A-3-4, SEC XI. MOVE TO BLDG 75	/	/	/
	MBPCA				
2122	018	ABRASIVE BLAST OIL COOLER TAB IAW T.O. 10 135(K)A 3 4, SEC IV AND T.O. 1 1-2.	/	/	/
	MBPCA				
95	022	ACCOMPLISH SHakedown INSPECTION IAW SOW UC/1560FL/83-158.	/	/	/
	MBPAB				
3001	026	WELD AS NECESSARY USING OIL COOLER SUPPORT FITTING LOCATOR JIG, P/N 7026872. RECD NOT RECD--	/	/	/
	MTP1W				
95	030	REMOVE/TREAT CORROSION IAW 10-135(K) A-3-4 RECD----- NOT RECD	/	/	/
	MBPAB				
95	040	REPLACE CORRODED, LOOSE, WORN OR DAMAGED FASTENERS OR MOUNTING HRDWRE RECD----- NOT RECD	/	/	/
	MBPAB				
95	050	REPLACE "U" BOLT BRACK P/N60-3505 -1AND-2 WITH BRACKET P/N 68C25398-1 RECD----- NOT RECD	/	/	/
	MBPAB				
95	060	DELETE ONE BOLT NEAREST "U" BOLT AND SUBSTITUTE WITH RIVLT P/N MS20470AD6 7 RECD----- NOT RECD	/	/	/
	MBPAB				
95	070	REPLACE AS NEEDED/STOP P/N 50-2458-804 RECD----- NOT RECD	/	/	/
	MBPAB				
95	080	REPLACE RIB P/N 50-2458-2 RECD----- NOT RECD	/	/	/
	MBPAB				

(CONTINUED)

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15. DISP 16. PDN/					
STATION	UP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19 "P"	20 "Q"
95	090 MBPAB	REPLACE LONGERON R.H. P/N 50-2458-28 IAW SOW, PARA 4  REQ'D _____ NOT REQ'D _____		E	/
95	100 MBPAB	REPLACE LONGERON L.H. P/N 50-2458-27 IAW SOW, PARA 4  REQ'D _____ NOT REQ'D _____		E	/
95	110 MBPAB	REPLACE LATCH SUPPORT P/N 50-2458-3  REQ'D _____ NOT REQ'D _____		/	/
95	120 MBPAB	REPLACE "U" BOLT P/N 9-66304-1 (2EA)  REQ'D _____ NOT REQ'D _____		/	/
95	130 MBPAB	REPLACE LAP STRIP P/N 50-2458-29  REQ'D _____ NOT REQ'D _____		/	/
95	140 MBPAB	REPLACE FRAME P/N 50-2458-10  REQ'D _____ NOT REQ'D _____		E	/
95	150 MBPAB	REPLACE HOT SCT BRCKT P/N 69-1147-1  REQ'D _____ NOT REQ'D _____		/	/
95	160 MBPAB	REPLACE SUPPORT BRCKT P/N 66-1143-801  REQ'D _____ NOT REQ'D _____		/	/
95	170 MBPAB	REPLACE SUPPORT FRAME P/N 50-2458-33  REQ'D _____ NOT REQ'D _____		/	/
95	180 MBPAB	REPLACE AIR EJECTOR TUBE ASSY P/N 90-6937-4 & GASKET P/N 60-5730 REQ'D _____ NOT REQ'D _____		E	/
95	190 MBPAB	RPLC CVR PLATE (SKIN) P/N 50-2458-1  REQ'D _____ NOT REQ'D _____		/	/
95	200 MBPAB	REPLACE BEARING BLOCK P/N 50-2458-804  REQ'D _____ NOT REQ'D _____		/	/
95	210 MBPAB	REPLACE STRIKE PLATES (2EA) P/N 3-74650  REQ'D _____ NOT REQ'D _____		/	/



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

95	220 MBFAB	REPLACE FLANGE FLARED TUBE (LARGE) P/N BACF22H8-3 REQ'D _____ NOT REQ'D _____	/	/
95	230 MBFAB	REPLACE FLANGE FLARED TUBE (SMALL) P/N BACF22H6-3 REQ'D _____ NOT REQ'D _____ MOVE TO BLDG 2280 MBPCB	/	/
2280	240 MBPLB	INTERIOR SURFACES FINISHED WITH TWO COATS OF EPOXY PRIMER MIL P-23377 MOVE TO BLDG 95 MBFAB	/	/
95	250 MBFAB	CONDITION TAG AND DECAL, RETURN TO SUPPLY SERVICEABLE.	/	E /
95	260 MBFAB	CONDITION TAGGED IAW AFM 67-1. NOTE: COMPLETE "REMARKS" COLUMN ON AFIC FORM 1574 IAW MAOI 66-36 NOTE: PART WILL HAVE OC-ALC FORM 586- 587 OR 588 ID LABEL APPLIED TO COMPLETED END ITEM IAW AFLOR 66-51 WITH ACCEPTANCE DATE ON LABEL ALONG WITH "M" STAMP OF THE PERSON PER- FORMING THE OVERHAUL. CAUTION: SUR- FACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAMINATION.	/	E /

COORDINATION:	DATE:
MABEBS LARRY NULLINAX	3-28-87
MAQBF TED HAYES	3-28-87
MABSCS CONNIE WEBBER	3-28-87
MABFAB JESSIE JACOBS	3-28-87

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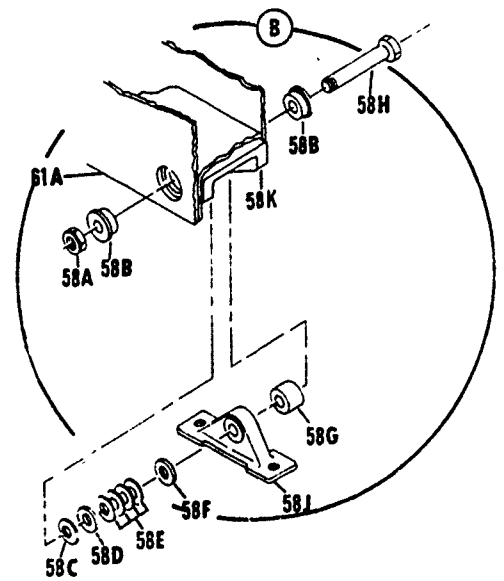
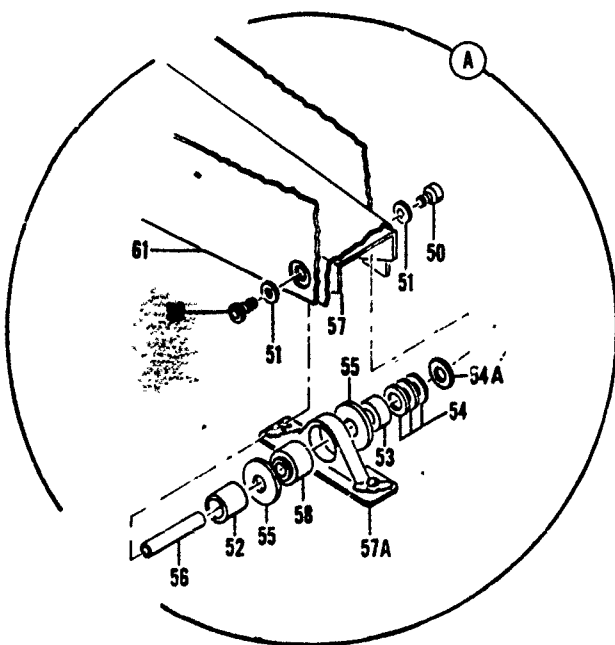
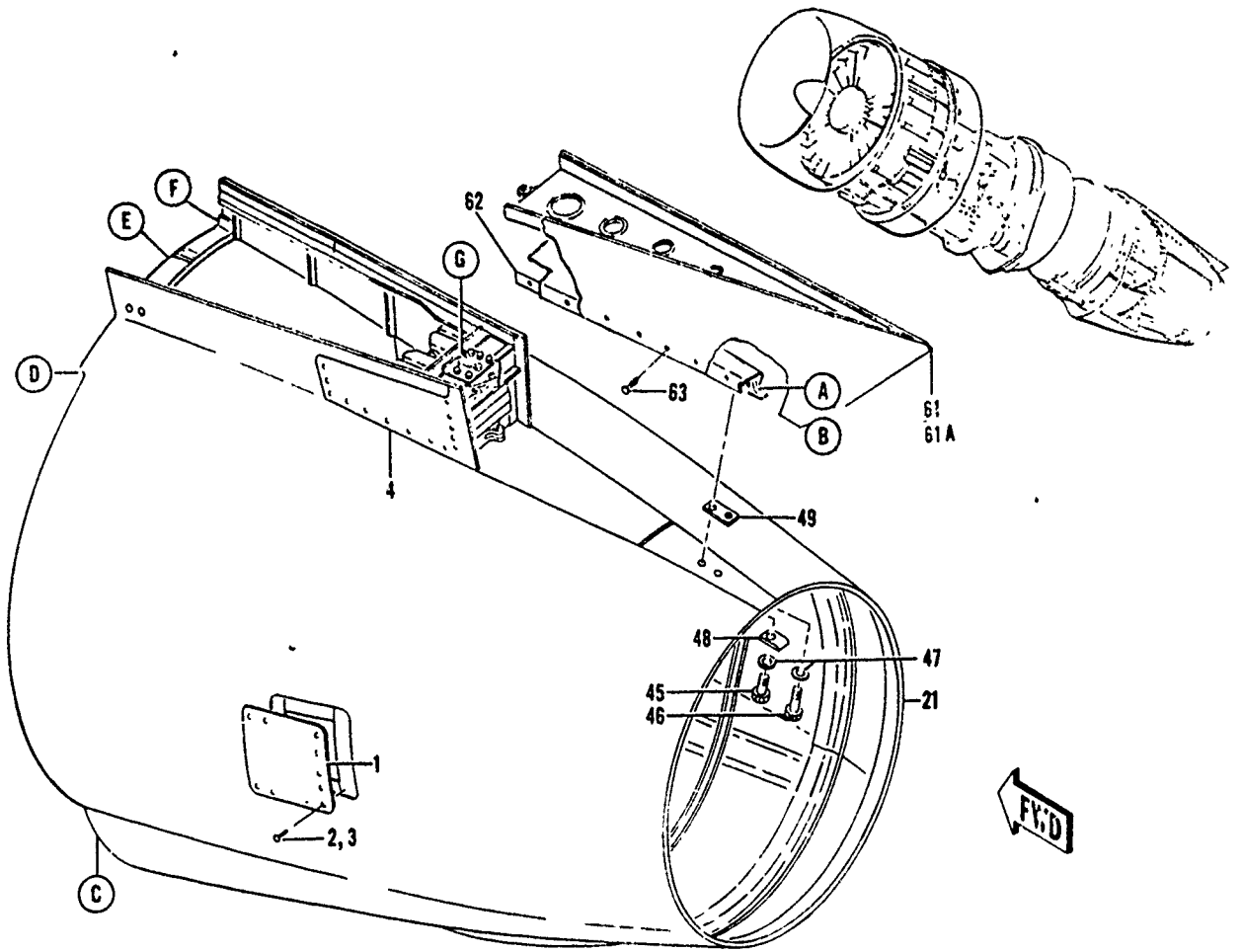


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 1 of 3)

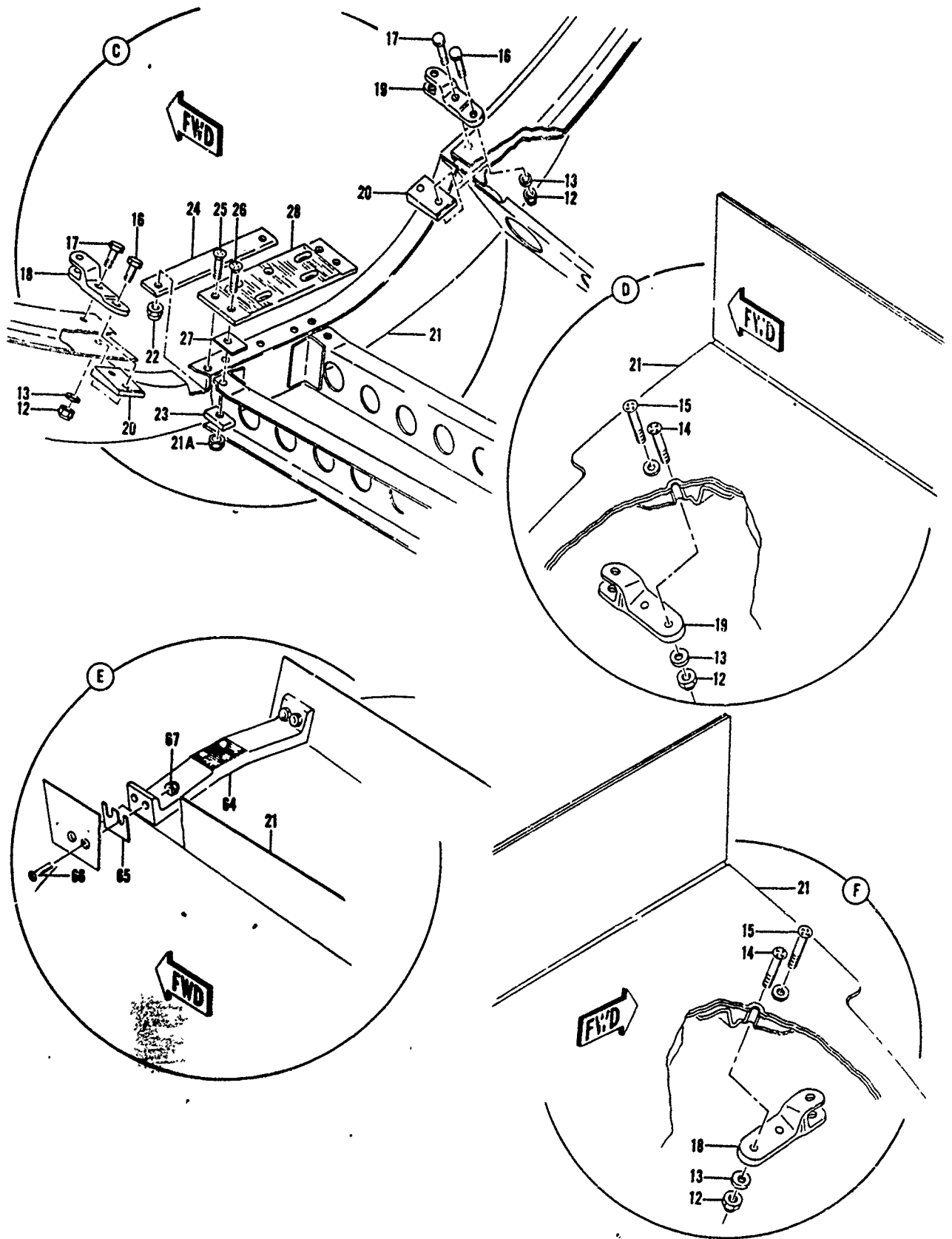


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 2 of 3)

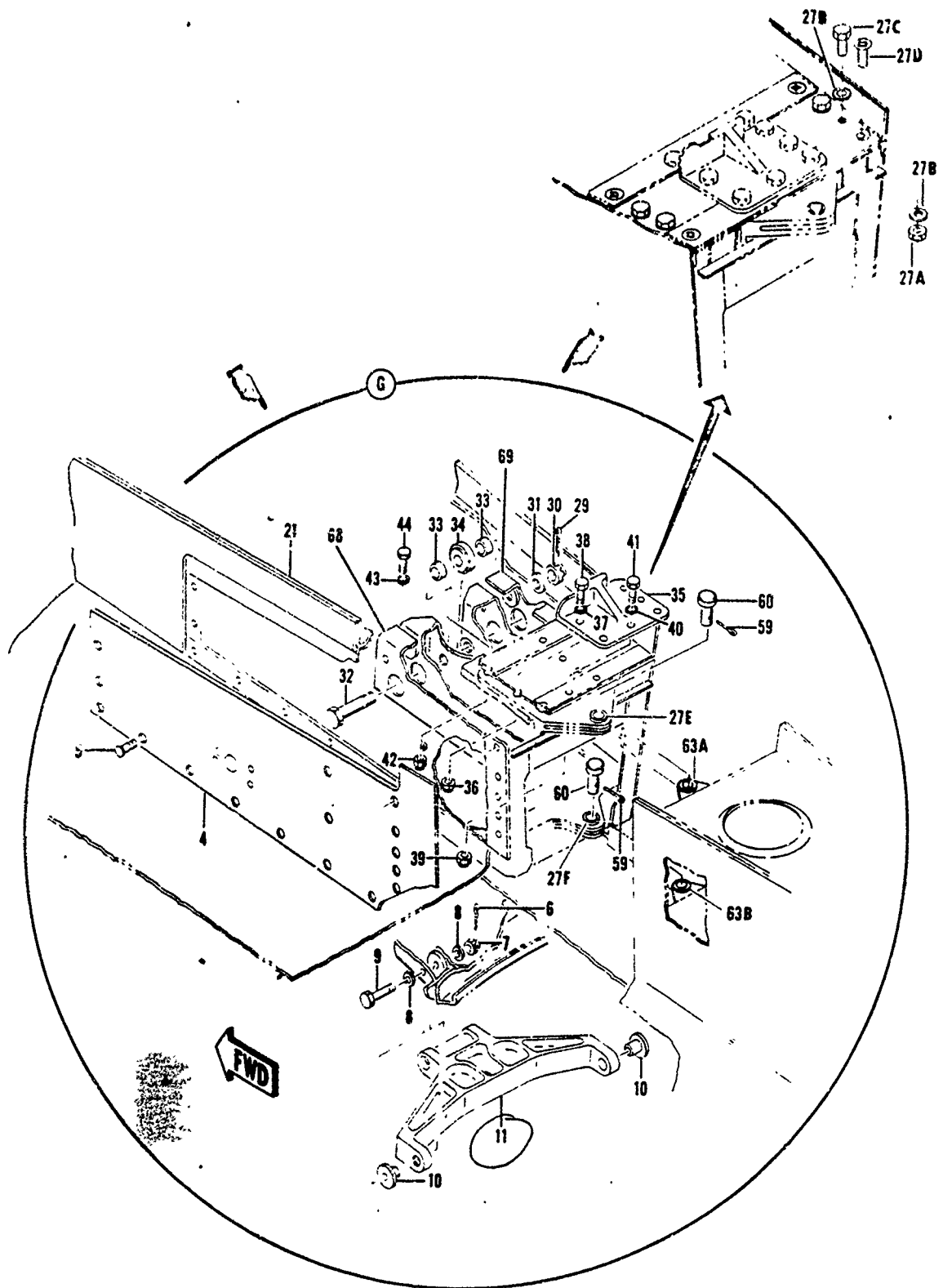


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 3 of 3)

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							QTY PER ASSY	USE CODE
4-19	65-10505-402	SLEEVE ASSY, Aft thrust reverser (optional 65-10505-401, 65-10505-353 and 65-10505-289; 65-10505-402 preferred for replacement) (See figure 4-18, index 43)								Ref	
-1	65-10505-11	. ACCESS PANEL ASSY, Bottom and sides . . . . .								3	
-2	NAS517-3-3	(ATTACHING PARTS)									
-3	NAS517-3-2	. SCREW (Used on side access panels). . . . .								32	
		. SCREW (Used on bottom access panels). . . . .								16	
-4	65-10505-360	. PANEL ASSY, Access (optional 65-10505-268, 65-10505-360 preferred for replacement)								1	
	65-10505-361	. PANEL ASSY, Access (opposite 65-10505-360) (optional 65-10505-251, 65-10505-361 preferred for replacement)								1	
		(ATTACHING PARTS)									
-5	NAS517-3-2	. SCREW . . . . .								32	
-6	AN381-2-8	. PIN, Cotter . . . . .								8	
-7	AN320C4	. NUT . . . . .								8	
-8	AN960C416	. WASHER. . . . .								16	
-9	BAC-B30BH-4-12	. BOLT. . . . .								8	
	65-10526	. LINK ASSY, Support. . . . .								4	
-10	66-10244	. BUSHING . . . . .								2	
-11	65-10526-1	. LINK. . . . .								1	
-12	NAS679C3W	. NUT . . . . .								8	
-13	AN960C10	. WASHER. . . . .								8	
-14	NAS517-3-13	. SCREW . . . . .								2	
-15	NAS517-3-15	. SCREW . . . . .								2	
-16	BAC-B30BG-3-13A	. BOLT. . . . .								2	
-17	BAC-B30BG-3-15A	. BOLT. . . . .								2	
-18	65-10527-1	. FITTING, Left lower, right upper. . . . .								2	
-19	65-10527-2	. FITTING, Right lower, left upper. . . . .								2	
-20	66-10240-2	. FILLER, Lower fitting . . . . .								2	
-21	65-10505-403	. SLEEVE ASSY (Preferred replacement for 65-10505-400 and 65-10505-270)								1	E
-21	65-10505-400	. SLEEVE ASSY (Optional 65-10505-403 and 65-10505-270; 65-10505-403 preferred for replacement)								1	C
-21	65-10505-270	. SLEEVE ASSY (Optional 65-10505-400 and 65-10505-403; 65-10505-403 preferred for replacement)								1	D
-21A	MS2C500-428	. NUT . . . . .								2	
-22	MS20500-1032	. NUT . . . . .								2	
-23	66-10240	. FILLER, Radius. . . . .								2	
-24	66-10240-1	. FILLER, Radius. . . . .								1	
-25	BAC-B30BF-3-C7	. BOLT. . . . .								2	
-26	NAS560HK4-10	. BOLT. . . . .								2	
-27	BAC-S40SD-13-17	. SHIM, Laminated (make from BAC1524-62SS). . . . .								2	
-27A	NAS679A3W	. NUT . . . . .								8	
-27B	AN960C10L	. WASHER. . . . .								8	
-27C	AN3C4A	. BOLT. . . . .								4	
-27D	BACB30LH3U3	. BOLT (Optional BACB30BF3C3 or BACB30BF3-3). . . . .								4	
	69-12671	. FITTING ASSY, Hinge trailing edge fairing . . . . .								1	
	69-12671-1	. FITTING, Hinge. . . . .								1	
-27E	NAS77A5-13P	. BUSHING, Flanged. . . . .								2	
	65-15604	. FITTING ASSY, Hinge, aft thrust reverser. . . . .								1	
	65-15604-1	. FITTING, Hinge. . . . .								1	
-27F	NAS77A5-13P	. BUSHING, Flanged. . . . .								2	
-28	66-10242	. FITTING, Lower serrated . . . . .								1	
-29	AN381-3-14	. PIN, Cotter . . . . .								1	
-30	AN320C6	. NUT . . . . .								1	
-31	AN960C816	. WASHER. . . . .								1	
-32	BAC-B30BH-6-22	. BOLT. . . . .								1	
-33	65-1057T6-028	. SPACER. . . . .								2	
-34	69-103063	. BEARING, Needle (60380) (BAC-B10B-317). . . . .								1	
-35	69-10330-6	. STOP (Optional 69-10330-4). . . . .								1	
		(ATTACHING PARTS)									
-36	NAS679A3W	. NUT . . . . .								5	
-37	AN960C10L	. WASHER. . . . .								5	
-38	NAS501-3-6A	. BOLT. . . . .								5	

FIGURE & INDEX NO	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							QTY PER ASSY	UNIT
4-19(Cont)											
-39	NAAS679C3W	. NUT . . . . .									1
-40	AN960C10	. WASHER. . . . .									1
-41	AN3C5A	. BOLT. . . . .									1
-42	NAS679A3W	. NUT . . . . .									2
-43	AN960C10L	. WASHER. . . . .									2
-44	BAC-B30BF-3-6A	. BOLT. . . . .									2
-45	AN4C6A	. BOLT. . . . .									1
-46	AN4C5A	. BOLT. . . . .									1
-47	AN960C416	. WASHER. . . . .									2
-48	65-10505-824	. FILLER, Radius (take from AISI301 sheet per MIL-S-5059, comp 30, ser. cond. 2D 1/2 hard, 0.20 x 3.3 x 3.4 inches)									1
-19	65-10505-209	. SHIM, Laminated . . . . .									1
-50	MS16996-10	. SCREW (Optional BACS12AG8F and MS16996-10B) . . . . .									2
-51	AN960-10L	. WASHER. . . . .									1
-52	NAS42HT10-2S	. SPACER. . . . .									1
-53	NAS42HT10-14	. SPACER. . . . .									1
-54	AN960-516	. WASHER. . . . .									3
-54A	AN960-516L	. WASHER. . . . .									1
-55	MS15795-811	. WASHER (Optional BACW10F115S) . . . . .									2
-56	66-11683	. PIN . . . . .									1
-57	69-12687-2	. SUPPORTING FITTING. . . . .									1
	69-12689	. FITTING ASSY, Anchor, fairing . . . . .									1
-57A	69-12687-1	. FITTING, Anchor . . . . .									1
-58	BSSR-5000-G	. BEARING (81376) (BACB10A203GD) (optional KWB-5SSG (J7613)) . . . . .									1
-58A	NAS509-3	. NUT . . . . .									1
-58B	66-20473-1	. BUSHING, Flanged. . . . .									2
-58C	66-21131-1	. SHIM, Laminated . . . . .									1
-58D	AN960-516	. WASHER. . . . .									1
-58E	AN960-516L	. WASHER. . . . .									4
-58F	NAS42HT10-10	. SPACER. . . . .									1
-58G	NAS42HT10-22	. SPACER (Make from NAS42HT10-28) . . . . .									1
-58H	BACB30GN5-25	. BOLT. . . . .									1
-58J	69-30242-1	. FITTING, Anchor (optional 69-12689-2) . . . . .									1
-58K	69-27531-1	. SUPPORT FITTING . . . . .									1
-59	AN380-3-3	. PIN, Cotter . . . . .									2
-60	MS20392-4C21	. PIN, Flathead (optional MS20392-4-21) . . . . .									2
-61	65-10505-271	. FAIRING ASSY, Aft . . . . .									1
-61A	65-10505-354	. FAIRING ASSY, Aft . . . . .									1
-62	69-12695-1	. SEAL ASSY, Fairing. . . . .									1
	69-12695-2	. SEAL ASSY (Opposite 69-12695-1) . . . . .									1
-63	NAS517-3-2	. SCREW (Optional BACB30LU3-2). . . . .									14
	65-15593	. FITTING ASSY, Hinge, aft fairing. . . . .									1
	65-15593-1	. FITTING, Hinge. . . . .									1
-63A	NAS76A5-004P	. BUSHING, Plain. . . . .									1
	69-12679	. FITTING ASSY, Hinge, aft fairing. . . . .									1
	69-12679-1	. FITTING, Hinge. . . . .									1
-63B	NAS76A5-004P	. BUSHING, Plain. . . . .									1
-64	65-16771-1	. FITTING, Support. . . . .									1
-65	BACS4QSC22-27	. SHIM (Make from BAC1524-14SS) . . . . .									AR
-66	NAS1221-4-15	. BOLT. . . . .									4
-67	US20500-428	. NUT . . . . .									4
-68	69-10333-1	. CHANNEL ASSY. . . . .									1
-69	69-10333-2	. CHANNEL ASSY. . . . .									1
	*65-98055-2	KIT ASSY, Aft fairing attach fitting replacement. . . . .									1
	65-99332-2	KIT ASSY, Sleeve structure modification . . . . .									1

A Used On 65-10505-269  
 B Used On 65-10505-353, -401 and -402  
 C Used On 65-10505-401  
 D Used On 65-10505-269 and -353  
 E Used On 65-10505-402

\*See detailed illustration B.  
 Kit consists of items 58A thru 58K.

FLOW PROCESS CHART

SUBJECT SLEEVE ASSEMBLY

DATE 4/5/89

PCN: 15236A

WCD: 15236A

WCD DATE: 88054

CHART BEGINS operation 010

CHART ENDS operation 350

PREPARED BY: MICHAEL

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
010	RECEIVE + UNMATE 2122 MBRCD		Delay
	DELAY		Move to 3001 3001 MATPZW
	MOVE		Delay
	DELAY	115	Weld Hat 1/2 Section
016	WASH INT. & EXT. 2122 MBRCA		Delay
			Move to 95 95 MBRPAB
			Delay
		150	Replace unserviceable or damaged parts
036	STRIP INT. & EXT.	155	Disassemble box
	Delay		Delay
	Move to 816, 95 95 MBRPAB		Perform penetrant inspection check
			Delay
040	Remove panels		Reassemble box after inspection
050	Remove Fairing assembly	180	Replace Link Brackets
060	Remove support link	190	Replace aft tub strip
	Delay	200	Repair or replace skin - 407
	Move to 2122 2122 MBRPCA	210	Repair or replace skin - 408
	Delay	220	Repair or replace skin - 405
070	Abrasive blast sleeve	230	Repair or replace skin - 404
	Delay	240	Replace damaged nut plates & screws
	Move to 95 95 MBRPAB	250	Repair or replace fire seals
	Delay	260	Repair or replace heat shields
080	Visual Inspection	270	replace aluminum parts w/ stainless steel
090	Treat Corrosion	280	replace damaged nutplates & screws
100	Remove tackweld & cutter pins & replace w/ new matl.	290	Install Fairing gssy
110	Replace Fasteners, nuts, nut plates & screws	300	Install support link and bushings
120	Remove minor scratches, nicks & corrosion	310	Reinstall all parts removed for repairs
130	Repair defects in threaded areas	320	attach access panels & hardware
140	Correct minor separation defects		Dr. g/

095 - PIN 65-10526-1 is removed and sent to Bldg 3001 for magnetic particle inspection and then returned, tagged good or bad. This part is interchangeable, the sl assembly repair process continues independent of this inspection.





12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHD 16. DATE COMP  
 | | | MBPAB | | 89023 | |

17. PART NUMBER 19. ITEM SERIAL NR 10/12. TECH DATA/OPTIONAL  
 | 65-10505-269 | | | 1. WORK SPEC. UC 1560FL/  
 | | | | 78-1-45, 78-1-45  
 10. MODLL/DESIGN/SERIES 11. STOCK NR | 2. IC-135B-10, IC-135(C)  
 | IC-135 | 1560008075321FL | C10,

13. PROJ 14. ROOM/END ITEM ROOM  
 | | | SLEEVE ASSEMBLY  
 | | | L. NO. L MAX. MABLES/65266  
 15. DTP 16. PDR

STATION NO. 17. WORK TO BE ACCOMPLISHED 18. MCHT " " " " " "

2122	010	RECEIVE & UNCRATE		
	MBPAB			
2122	020	WASH INTERIOR AND EXTERIOR IAW SOW UC1560FL/78-1-45 AND T.O. IC-135(K)A-3-4 SEC 11 & T.O. IC-135B-10 SEC 6-64.		
	MBPAB			
2122	030	STRIP INTERIOR AND EXTERIOR IAW SOW UC 1560 FL/78-1-45 SEC 7 & 11 AND T.O. 1-2.		
	MBPAB			
95	040	REMOVE PANELS (360), (361) AND 1175.		
	MBPAB	REQD _____ NOT REQD _____		
95	050	REMOVE FAIRING ASSEMBLY P/N 65-10505-271.		
	MBPAB	REQD _____ NOT REQD _____		
95	060	REMOVE SUPPORT LINK.		
	MBPAB	REQD _____ NOT REQD _____ MOVE SLEEVE, LINKS AND ASSOCIATED PARTS TO MBPAB FOR ABRASIVE BLAST		
2122	070	ABRASIVE BLAST SLEEVE AND ASSOCIATED PARTS AND HARDWARE IAW SOW UC 1560 FL/78-1-45 AND T.O. IC-135(K)A-3-4 SEC 9 AND T.O. 1-2. REQD --- NOT REQD --- MOVE TO MBPAB		
	MBPAB			
95	080	ACCOMPLISH VISUAL INSPECTION IAW SOW UC1560FL/78-1-45.		
	MBPAB	REQD _____ NOT REQD _____		
3001	085	IAW SOW UC1560FL/78-1-45 AND T.O. IC-135B-10 SECTION SIX PERFORM MAGNETIC PARTICLE INSPECTION ON P/N 65-10526-1. REQD --- NOT REQD --- POST 0-69, MIPHA BLDG 3001		
	MIPHA			
95	090	REMOVE CORROSION AND APPLY CORROSION PROTECTIVE FINISH TO ALL REWORKED SURFACES IAW T.O. IC 135(K)A-3-4 & T.O. 1-1-2.		
	MBPAB			

15236A

15.DJSP-16.PDN/  
 STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 18.MECH 19"PH 20"PH

95	100 MBPAB	REMOVE ALL LOCKWIRE AND COTTER PINS REPLACE WITH NEW MATERIAL UPON REASSEMBLY. REQ'D _____ NOT REQ'D _____	/	/
95	110 MBPAB	REPLACE CORRODED, LOOSE OR DAMAGED FASTENERS NUTS NUT PLATES AND SCREWS IAW SOW OC1560FL/78-1 45. REQ'D _____ NOT REQ'D _____	E	/
95	120 MBPAB	REMOVE BURR SCRATCHES, NICKS AND IMPRESSION BY POLISHING WHEELS OR BRUSHES TO A FINISH 220 GRIT OR FINEER. REQ'D _____ NOT REQ'D _____	/	/
95	130 MBPAB	REMOVE BURR SCRATCHES, NICKS AND IMPRESSION BY POLISHING WHEELS OR BRUSHES TO A FINISH 220 GRIT OR FINEER. REQ'D _____ NOT REQ'D _____	/	/
95	140 MBPAB	REMOVE BURR SCRATCHES, NICKS AND IMPRESSION BY POLISHING WHEELS OR BRUSHES TO A FINISH 220 GRIT OR FINEER. REQ'D _____ NOT REQ'D _____	/	/
3001	145 MTPIW	WELD HAT RING SECTION AS NECESSARY. REQUIRED --- NOT REQ'D --- WELDING ACCOMPLISHED AT POST K-73	/	/
95	150 MBPAB	REPLACE ALL PARTS FOUND UNSERVICABLE OR DAMAGED BEYOND PRESCRIBED OR SAMPLE REPAIR IAW SOW OC1560FL/78-1 45.	/	/
95	155 MBPAB	DISASSEMBLE BOX AND PREPARE PARTS FOR INSPECTION.	/	/
95	160 MOCIA	PERFORM PENETRANT INSPECTION/CHECK IAW SOW OC1560FL/78-1 45 AND T.O. 135B-10 SEC SIX ON THE FOLLOWING PARTS: 65-10527-1 REQ'D --- NOT REQ'D --- 65-10527-2 REQ'D --- NOT REQ'D --- 69-10330-6 REQ'D --- NOT REQ'D --- 65-15604 1 REQ'D --- NOT REQ'D --- 69-12671-1 REQ'D --- NOT REQ'D ---	/	/
95	165 MBPAB	REASSEMBLE BOX AFTER INSPECTION.	/	/
95	180 MBPAB	REPLACE LINK BRACKETS 69-10331-5 & 6 IAW T.O.1C-135B-10 FIG 8-39 AS REQ'D. REQ'D _____ NOT REQ'D _____	/	/
95	190 MBPAB	REPLACE AFT RUB STRIP 66-10259 (SEA) BRACKET. REQ'D _____ NOT REQ'D _____	/	/

*****					
15236A * WORK CONTROL DOCUMENT * MISTR 1.DATE 88054 PAGE 3 OF 3 PAGES					
15.DISP-16.PDN/					
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
95	200 MBPAB	SKIN,P/N 65-10505-407 REPAIR___REPLACE___NOT REQ'D___		/	/
95	210 MBPAB	SKIN, 65-10505-406 REPAIR___REPLACE___NOT REQ'D___		L	/
95	220 MBPAB	SKIN, 65 0505 405 REPAIR___REPLACE___NOT REQ'D___		/	/
95	230 MBPAB	SKIN, 65 10505 404 REPAIR___REPLACE___NOT REQ'D___		E	/
95	240 MBPAB	REPLACE DAMAGED NUT PLATES & SCREWS		/	/
95	250 MBPAB	FIRE SEALS, 283, & 284 REPAIR___REPLACE___NOT REQ'D___		/	/
95	260 MBPAB	HEAT SHIELDS, -831 & -832 REPAIR___REPLACE___NOT REQ'D___		/	/
95	270 MBPAB	REPLACE ALL ALUMINUM PARTS WITH STAINLESS STEEL PARTS 1AW SOW OC560FL/78-11-45		/	/
95	280 MBPAB	INSPECT & REPLACE DAMAGED NUTPLATES AND SCREWS. REQ'D___NOT REQ'D___		/	/
95	290 MBPAB	INSTALL FAIRING ASSY (-271). NOTE: PRIOR TO INSTALLATION CONDUCT THOROUGH CLOSE OUT INSPECTION.		/	/
95	300 MBPAB	INSTALL SUPPORT LINK AND BUSHINGS REQ'D___NOT REQ'D___		/	/
95	310 MBPAB	REINSTALL ALL PARTS REMOVED FOR REPAIRS AND INSPECTION.		/	/
95	320 MBPAB	ATTACH ACCESS PANELS AND HARDWARE SLEEVE. MOVE TO MBPCB		/	/
2122	330 MBPCB	FINAL WASH AND CORROSION TREAT		/	/
2122	340 MBPCB	REFINISH AND PAINT 1AW SOW OC1560FL/ 78-1-45 AND T.O. 1C-135(K)A-3-4 SEC11. MOVE TO MBPAB		/	/
95	350 MBPAB	WORK COMPLETED. CONDITION TAG AND IDENTIFY PER MAINT 65-1	/	E	/
		MABEBS L. MURPHY 3-22-89			
		MABBF T. HANCOCK 3-22-89			
		MBPAB D. LENOIR 3-22-89			
		MABSCS H. NUOTIN 3-22-89			

15236A

15236B

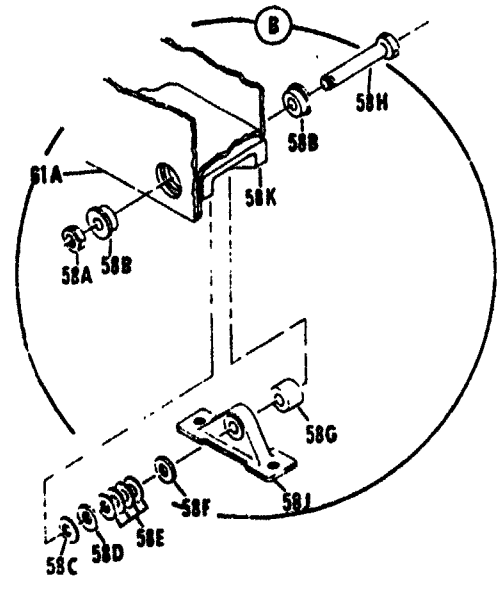
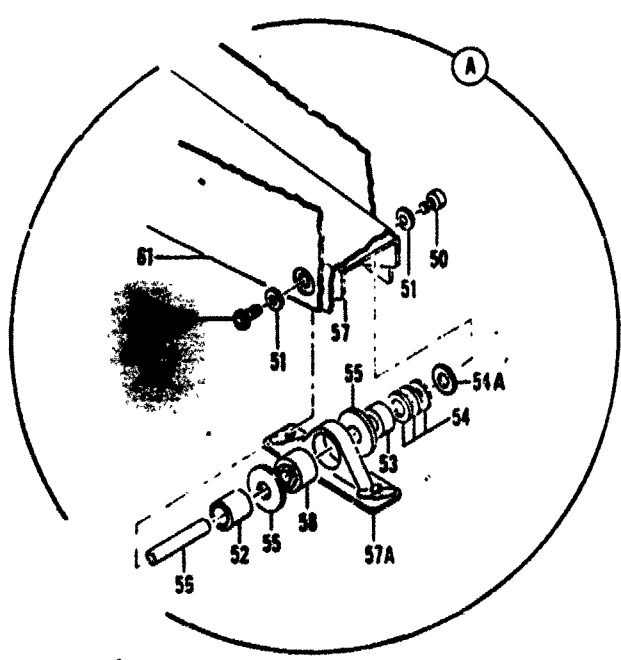
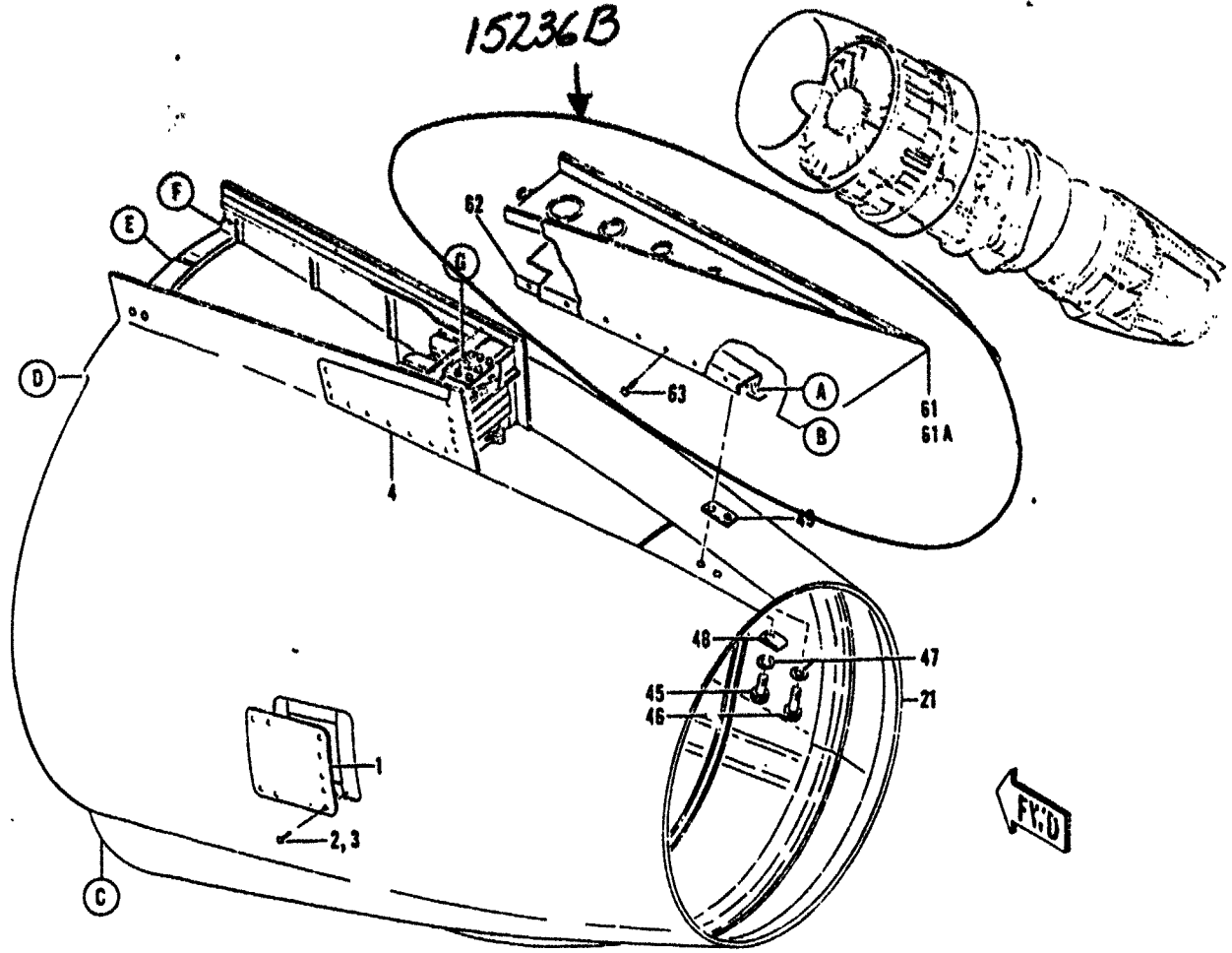


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 1 of 3)

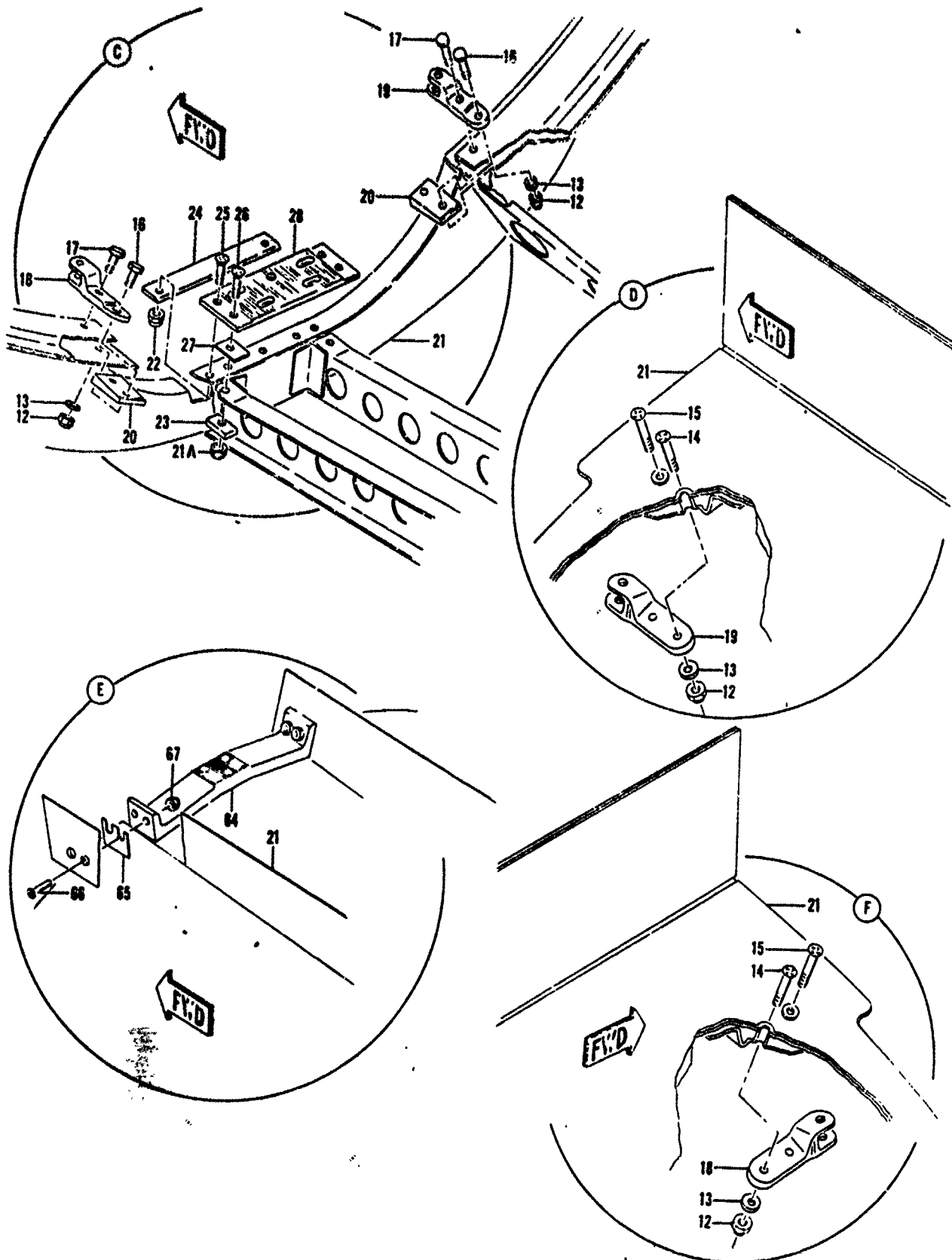


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 2 of 3)

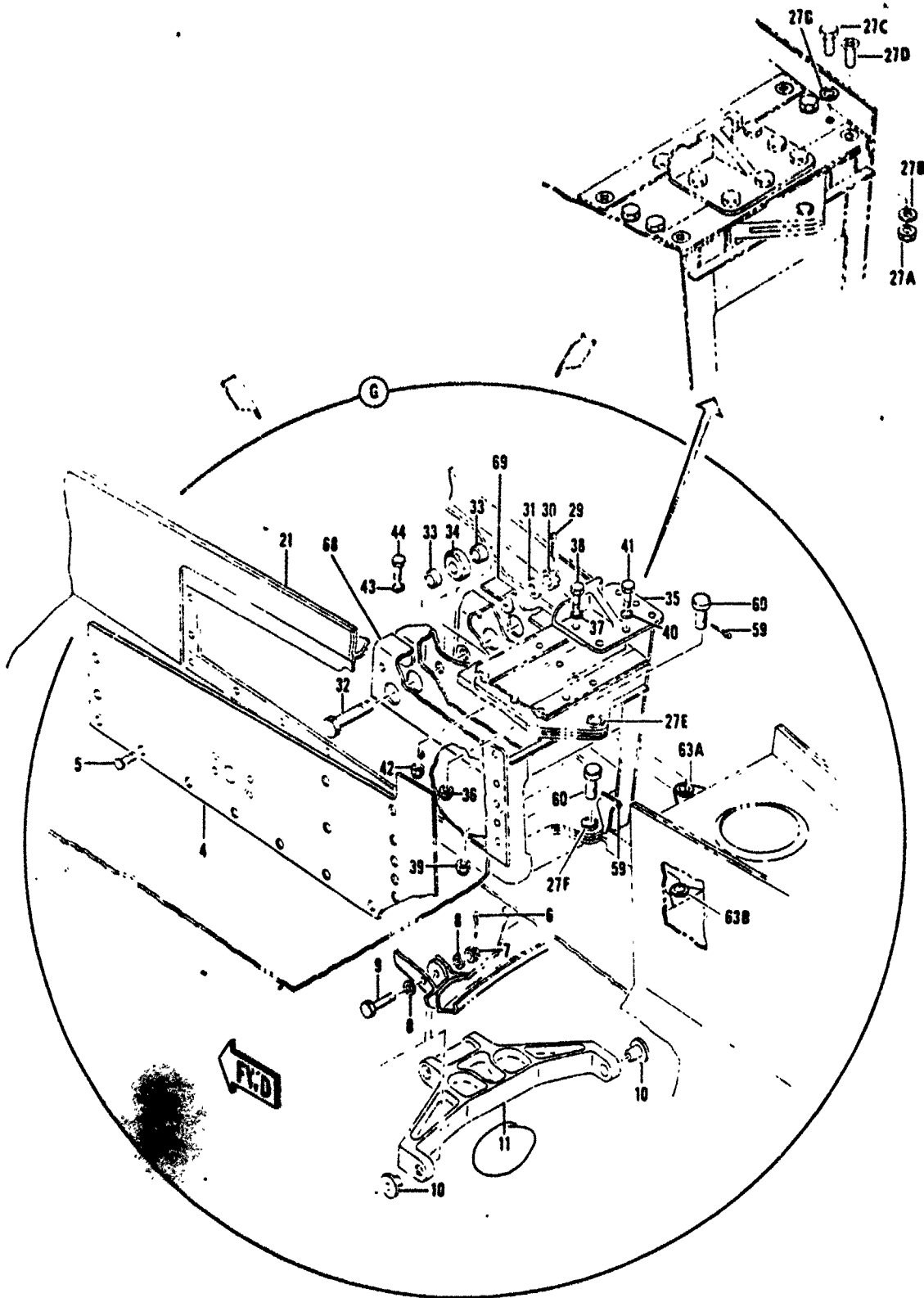


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 3 of 3)

**FLOW PROCESS CHART**

SUBJECT FAIRING AFT

DATE 4/10/89

PCN: 15237A WCD: 15238B WCD DATE: 88069

CHART BEGINS 10

CHART ENDS 230

PREPARED BY: R. BOLANOS

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
10 ● ◊ ◻ ▽	REC. + UNCRATE 2122 MABPCA	100 ○ ◊ ◻ ▽	R/R SEAL ASSY #1
○ ◊ ◻ ▽	DELAY	110 ○ ◊ ◻ ▽	R/R SEAL ASSY #2
○ ◊ ◻ ▽	MOVE TO STRIP MABPCA	○ ◊ ◻ ▽	DELAY
○ ◊ ◻ ▽	DELAY	○ ◊ ◻ ▽	MOVE TO WASH 2280 MABPCA
20 ● ◊ ◻ ▽	STRIP PAINT	○ ◊ ◻ ▽	DELAY
30 ● ◊ ◻ ▽	WASH W/ SOLVENT BLEN	200 ● ◊ ◻ ▽	WASH
40 ● ◊ ◻ ▽	DRAIN + CLEAN	210 ● ◊ ◻ ▽	REFINISH SURFACE
○ ◊ ◻ ▽	DELAY	○ ◊ ◻ ▽	DELAY
○ ◊ ◻ ▽	MOVE TO SHEETMETAL 95 MABPCA	○ ◊ ◻ ▽	MOVE TO SHEETMETAL 95 MABPCA
○ ◊ ◻ ▽		○ ◊ ◻ ▽	DELAY
50 ○ ◊ ◻ ▽	SHAKEDOWN INSPECTION	● ◊ ◻ ▽	MARK TO ID.
○ ◊ ◻ ▽		● ◊ ◻ ▽	CONDITION + TME
○ ◊ ◻ ▽	MOVE TO BLAST 2122 MABPCA	○ ◊ ◻ ▽	DELAY
○ ◊ ◻ ▽		○ ◊ ◻ ▽	STORAGE
60 ● ◊ ◻ ▽	BLAST	○ ◊ ◻ ▽	
○ ◊ ◻ ▽	DELAY	○ ◊ ◻ ▽	
○ ◊ ◻ ▽	MOVE TO SHEETMETAL 95 MABPCA	○ ◊ ◻ ▽	
○ ◊ ◻ ▽		○ ◊ ◻ ▽	
70 ● ◊ ◻ ▽	REMOVE CARROUSLS	○ ◊ ◻ ▽	
80 ● ◊ ◻ ▽	R/R LOWER BULKHEAD STRUT	○ ◊ ◻ ▽	
● ◊ ◻ ▽	REPLACE SUPPORT FITTING	○ ◊ ◻ ▽	
● ◊ ◻ ▽	R/R FASTENERS	○ ◊ ◻ ▽	
110 ● ◊ ◻ ▽	STRAIGHTEN ALL MIRROR DENTS + BEAD	○ ◊ ◻ ▽	
120 ● ◊ ◻ ▽	SMOOTH ALL SCRATCHES	○ ◊ ◻ ▽	
130 ● ◊ ◻ ▽	R/R LEFT + RIGHT SKINS	○ ◊ ◻ ▽	
140 ● ◊ ◻ ▽	REPLACE UPPER BULKHEAD	○ ◊ ◻ ▽	
150 ● ◊ ◻ ▽	" RUB STRIPS	○ ◊ ◻ ▽	
160 ● ◊ ◻ ▽	" FITTING ASSY	○ ◊ ◻ ▽	
170 ● ◊ ◻ ▽	" BUSHINGS	○ ◊ ◻ ▽	

2. UNIT/PROD NR 13. QUANTITY 14. PROC SECTION, SEC 15. DATE SCHLD 16. DATE CONS  
 15237A | | MBPAB | | 87100 | |

7. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 65-10505-271 | | | | 1C-135(K)A-3-4 C/N: 00-

10. MOUCL/DESIGN/SERIES 11. STOCK NR 17. FILL IN ANY ADD'L MARK  
 KC 135 | | 1560003174274FET REQ'D. | |

13. MISS: 14. NOUN/END ITEM NOUN  
 FAIRING, AFF  
 MULLINAX / MABEL S/25285

15. DIGN 16. CON/ SECTION OF NU. 17. WORK TO BE ACCOMPLISHED 18. REQ'D BY WORK

15. DIGN	16. CON/ SECTION OF NU.	17. WORK TO BE ACCOMPLISHED	18. REQ'D BY WORK
2121	010 MBPAB	RECEIVE & OPERATE	/ /
2122	020 MBPAB	STRIP ALL PAINT IAW 1C-135(K)A-3-4	/ /
2122	030 MBPAB	WASH INTERIOR & EXTERIOR WITH SOLVENT P-0680	/ /
		DRAIN AND DRY WITH A LINT FREE CLOTH OR CLEAN DRY COMPRESSED AIR. MOVE TO 0.00 /	/ /
95	050 MBPAB	ACCOMPLISH SHAKEDOWN INSPECTION IAW SDW. ANNOTATE DISCREPANCIES.	/ /
2122	050 MBPAB	ABRASIVE BLAST TO REMOVE EXHAUST DEPOSITS IAW T.O. 1C-135(K)A-3-4. REQ ___ NOT REQ ___	/ /
95	070 MBPAB	REMOVE CORROSION & TREAT IAW T.O. 1C-135(K)A-3-4, SEC IV. REQ ___ NOT REQ ___	/ /
95	080 MBPAB	REPAIR OR REPLACE LOWER BULKHEAD STRUT P/N 65-10505-279 REQ ___ NOT REQ ___	/ /
95	090 MBPAB	REPLACE SUPPORT FITTING, P/N 69-12687-2. REQ ___ NOT REQ ___ (FITTINGS).	/ /
95	100 MBPAB	REPAIR OR REPLACE ALL LOOSE, MISSING OR DEFECTIVE FASTENERS.	/ /
95	110 MBPAB	STRAIGHTEN ALL MINOR DENTS & BENDS. REQ ___ NOT REQ ___	/ /
95	120 MBPAB	SMOOTH ALL SCRATCHES, ABRASIONS AND NICKS. REQ ___ NOT REQ ___	/ /
95	130 MBPAB	REPAIR LEFT AND RIGHT SKINS AS REQ. REQ'D ___ NOT REQ'D ___	/ /



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15. JOB	* WORK CONTROL DOCUMENT * M151R 1. DATE 88069			PAGE 2 OF 2 PAGES
16. DISP. 16. (DN)	STATION/UP NO. 17. WORK TO BE ACCOMPLISHED			18. MECH 19. P# 20. Q#
95	140 MBFAB	REPLACE UPPER BULKHEAD P/N 65-10505-212. REQ ___ NOT REQ ___	/	/
95	150 MBFAB	REPLACE RUB STRIPS 217 & 220. REQ ___ NOT REQ ___	/	/
95	160 MBFAB	REPLACE FITTING ASSEMBLY P/N 69-12689. REQ ___ NOT REQ ___	/	/
95	170	REPLACE BUSHING P/N 71-110	/	/
95	180 MBFAB	REPAIR OR REPLACE SEAL ASSEMBLY P/N 69-12695-1. REQ ___ NOT REQ ___	/	/
95	190 MBFAB	REPAIR OR REPLACE SEAL ASSY P/N 69-12695-2. REQ ___ NOT REQ ___	/	/
200	200 MBFLB	FINAL WASH	/	/
200	210 MBFCB	REFINISH ALL SURFACES EXCEPT OUTER SKIN IN AW WORK STATEMENT T.O. 10-135(K)A-3-4. MOVE TO BLDG 95.	/	/
95	220 MBFAB	MARK EA FAIRING WITH A PERMANENT MEANS OF IDENTIFICATION.	/	/
95	230 MBFAB	WORK COMPLETED, CONDITION TAGGED IAW AFM 67-L. <del>(NEW TO FILE)</del> NOTE: PART WILL HAVE ORANGE PURNS 586, 587 OR 588 ID LABELS APPLIED TO COMPLETED ITEM IAW NAUI 63-4. ACCEPTANCE DATE ON THE LABEL ALONG WITH "M" STAP OF THE PERSON PLR FORMING THE OVERHAUL. CAUTION: SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAMINATION. NOTE: COMPLETE "REMARKS" COLUMN OF MELC FORM 1574 IAW OASD 20-14, THIS PARA. NOT APPLICABLE TO NON-PROGRAMMED A/C WORKLOAD.	/	/
COORDINATION				
MABEBS L. MULLINAX 13 FEB 89				
MABSFS D. TANNI 13 FEB 89				
MABFAB DONNA LENOX 13 FEB 89				
MAWBF TED HAYES 13 FEB 89				

15237A

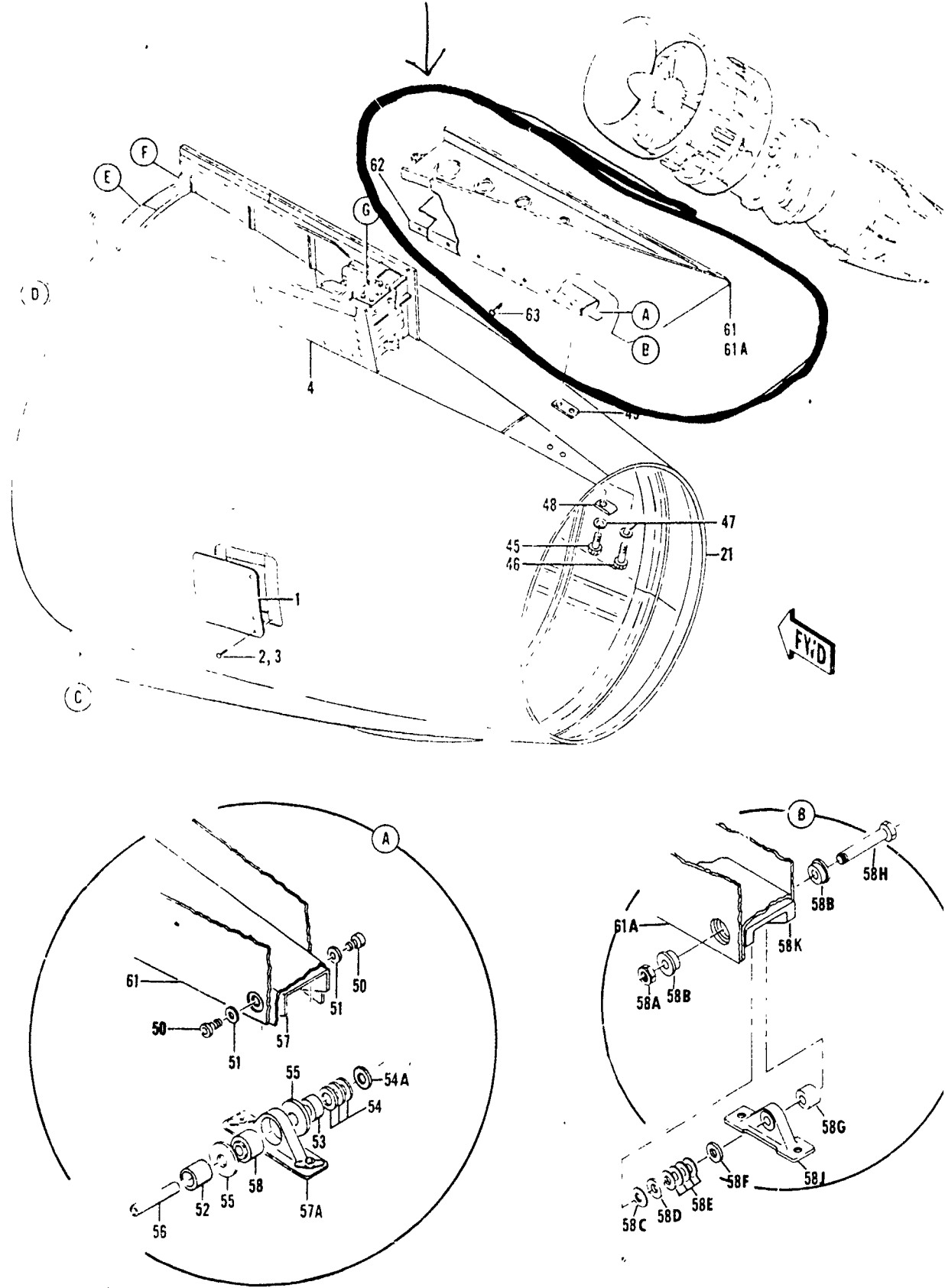


Figure 4-19 Aft Thrust Reverser and Sleeve Assembly (Sheet 1 of 3)

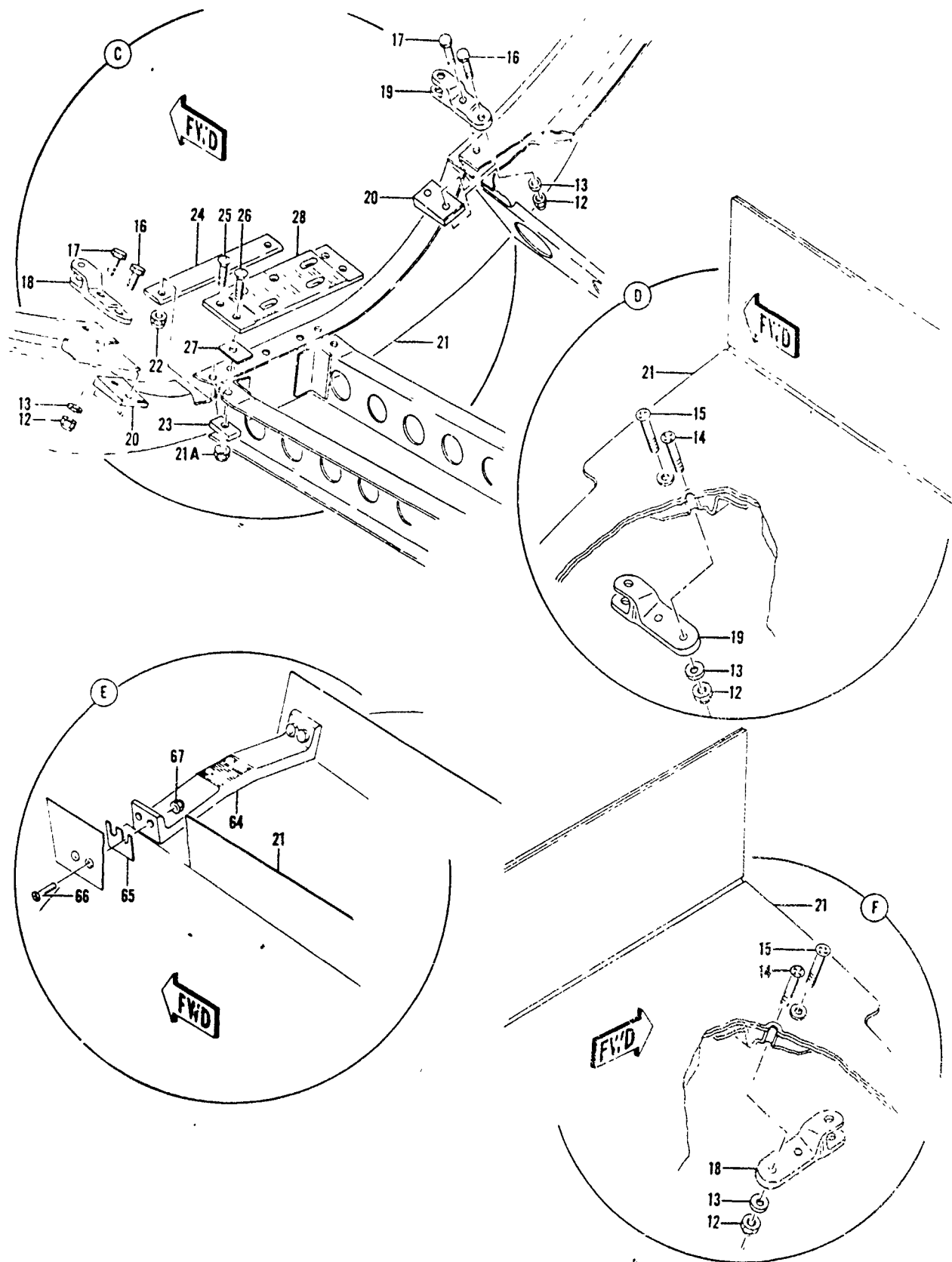


Figure 4-19 Aft Thrust Reverser and Sleeve Assembly (Sheet 2 of 3)

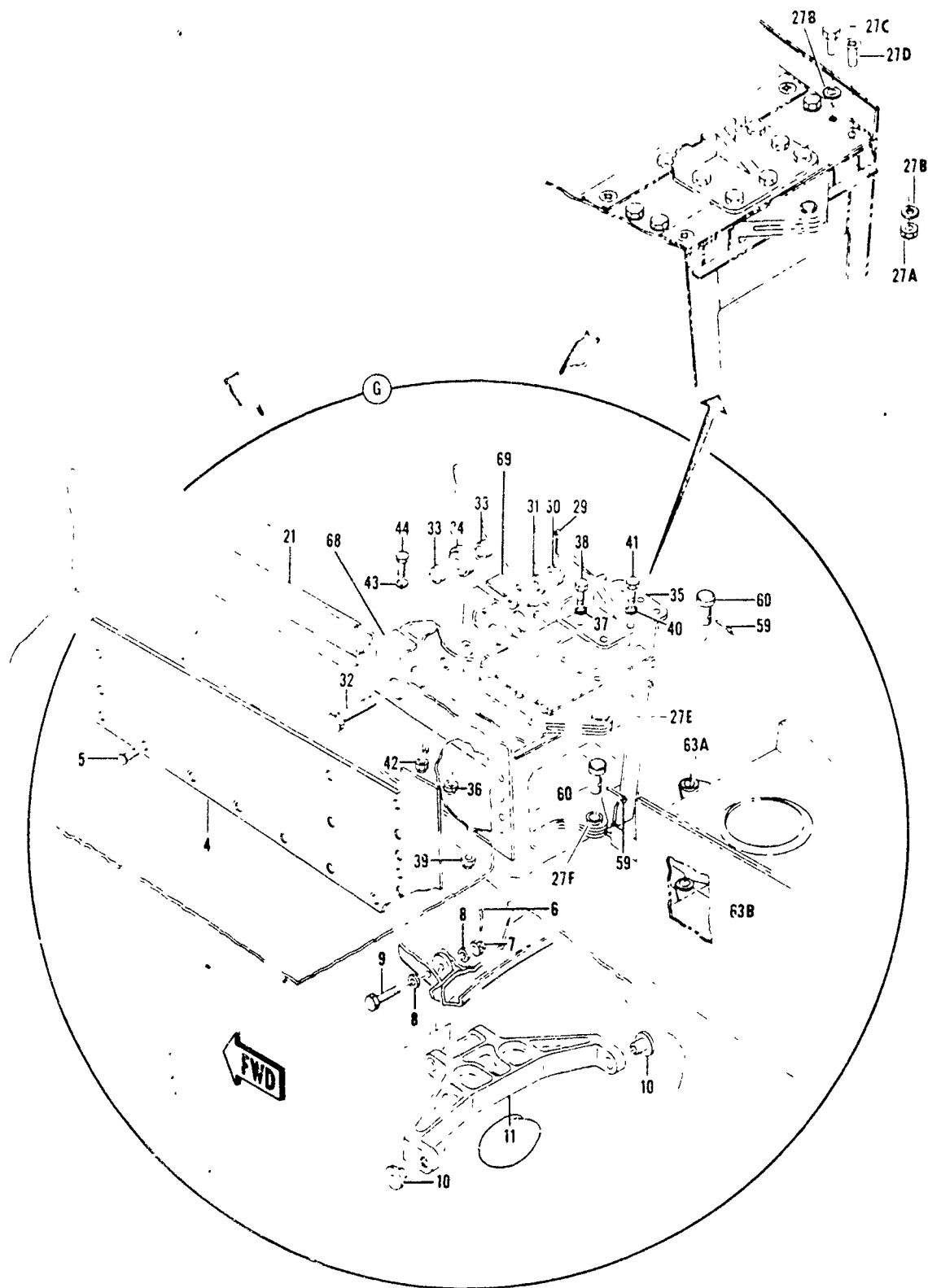


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 3 of 3)

FIGURE & INDEX NO	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							Ref	Fits ASSY	C29	
			1	2	3	4	5	6	7				
4-19	65-10505-402	SLEEVE ASSY, Aft thrust reverser (optional 65-10505-401, 65-10505-353 and 65-10505-269; 65-10505-402 preferred for replacement) (see figure 4-18, index 43)									319		
-1	65-10505-11	. ACCESS PANEL ASSY, Bottom and sides . . . . .											3
-2	NAS517-3-3	. SCREW (Used on side access panels). . . . .											32
-3	NAS517-3-2	. SCREW (Used on bottom access panels). . . . .											16
-4	65-10505-360	. PANEL ASSY, Access (optional 65-10505-268;. . . . . 65-10505-360 preferred for replacement)											1
	65-10505-361	. PANEL ASSY, Access (opposite 65-10505-360) (optional. . . . . 65-10505-254, 65-10505-361 preferred for replacement)											1
		(ATTACHING PARTS)											
-5	NAS517-3-2	. SCREW . . . . .											32
-6	AN381-2-8	. PIN, Cotter . . . . .											8
-7	AN320C4	. NUT . . . . .											8
-8	AN960C416	. WASHER. . . . .											16
-9	BAC-B30BH-4-12 65-10526	. BOLT. . . . . . LINK ASSY, Support. . . . .											9 4
-10	66-10244	. BUSHING . . . . .											2
-11	65-10526-1	. LINK. . . . .											1
-12	NAS679C3W	. NUT . . . . .											8
-13	AN960C10	. WASHER. . . . .											8
-14	NAS517-3-13	. SCREW . . . . .											2
-15	NAS517-3-15	. SCREW . . . . .											2
-16	BAC-B30BG-3-13A	. BOLT. . . . .											2
-17	BAC-B30BG-3-15A	. BOLT. . . . .											2
-18	65-10527-1	. FITTING, Left lower, right upper. . . . .											2
-19	65-10527-2	. FITTING, Right lower, left upper. . . . .											2
-20	66-10240-2	. FILLER, Lower fitting . . . . .											2
-21	65-10505-403	. SLFVE ASSY (Preferred replacement for 65-10505-400 . . . . . and 65-10505-270)											1
													E
-21	65-10505-400	. SLEEVE ASSY (Optional 65-10505-403 and 65-10505-270,. . . . . 65-10505-403 preferred for replacement)											1
													C
-21	65-10505-270	. SLEEVE ASSY (Optional 65-10505-400 and 65-10505-403,. . . . . 65-10505-403 preferred for replacement)											1
													D
-21A	MS20500-428	. NUT . . . . .											2
-22	MS20500-1032	. NUT . . . . .											2
-23	66-10240	. FILLER, Radius. . . . .											2
-24	66-10240-1	. FILLER, Radius. . . . .											1
-25	BAC-B30BF-3-C7	. BOLT. . . . .											2
-26	NAS560HK4-10	. BOLT. . . . .											2
-27	BAC-S40SD-13-17	. SHIM, Laminated (make from BAC1524-62SS). . . . .											2
-27A	NAS679A3W	. NUT . . . . .											8
-27B	AN960C10L	. WASHER. . . . .											8
-27C	AN3C4A	. BOLT. . . . .											4
-27D	BACB30LH3U3	. BOLT (Optional BACB30BF3C3 or BACB30BF3-3). . . . .											4
	69-12671	. FITTING ASSY, Hinge trailing edge fairing . . . . .											1
	69-12671-1	. FITTING, Hinge . . . . .											1
-27E	NAS77A5-13P	. BUSHING, Flanged. . . . .											2
	65-15604	. FITTING ASSY, Hinge, aft thrust reverser. . . . .											1
	65-15604-1	. FITTING, Hinge . . . . .											1
-27F	NAS77A5-13P	. BUSHING, Flanged. . . . .											2
-28	66-10242	. FITTING, Lower serrated . . . . .											1
-29	AN381-3-14	. PIN, Cotter . . . . .											1
-30	AN320C6	. NUT . . . . .											1
-31	AN960C616	. WASHER. . . . .											1
-32	BAC-B30BH-6-22	. BOLT. . . . .											1
-33	NAS1057T6-028	. SPACER. . . . .											2
-34	AC22063	. BEARING, Needle (60380) (BAC-B10B-317). . . . .											1
-35	69-10330-6	. STOP (Optional 69-10330-4). . . . .											1
		(ATTACHING PARTS)											
-36	NAS679A3W	. NUT . . . . .											5
-37	AN960C10L	. WASHER. . . . .											5
-38	NAS501-3-6A	. BOLT. . . . .											5

FIGURE & INDEX NO	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7								
			4-19(Cont)								
-39	NAS679C3W	. NUT . . . . .								1	
-40	AN960C10	. WASHER . . . . .								1	
-41	AN3C5A	. BOLT . . . . .								1	
-42	NAS679A3W	. NUT . . . . .								2	
-43	AN960C10L	. WASHER . . . . .								2	
-44	BAC-B30BF-3-6A	. BOLT . . . . .								2	
-45	AN1C6A	. BOLT . . . . .								1	
-46	AN4C5A	. BOLT . . . . .								1	
-47	AN960C416	. WASHER . . . . .								2	
-48	65-10505-824	. FILLER, Radius (Make from AISI301 sheet per MIL-S-5059, comp 30, spr. cond. 2D 1/2 hard, 0.20 x 3.3 x 3.4 inches)								1	
-49	65-10505-209	. SHIM, laminated . . . . .								1	
-50	WS16796-10	. SCREW (Optional BAC51108E and 16796-10B) . . . . .								2	
-51	AN960-10L	. WASHER . . . . .								2	
-52	NAS42HT10-28	. SPACER . . . . .								1	
-53	NAS42HT10-11	. SPACER . . . . .								1	A
-54	AN960-316	. WASHER . . . . .								3	A
-54A	AN960-316L	. WASHER . . . . .								1	A
-55	WS16796-811	. WASHER (Optional BAC10F115S) . . . . .								2	A
-56	65-11683	. PIN . . . . .								1	A
-57	69-12687-2	. SUPPORTING FITTING . . . . .								1	A
-57A	69-12687-1	. FITTING ASSY, Anchor, fairing . . . . .								1	A
-58	RS-10000-5	. BEARING (81376) (BACB10A203GD) (optional KWB-5SSG (37613)) . . . . .								1	A
-58A	NAS500-3	. NUT . . . . .								1	B
-58B	69-20173-1	. BUSHING, Flanged . . . . .								2	B
-58C	69-21131-1	. SHIM, Laminated . . . . .								1	B
-58D	AN960-316	. WASHER . . . . .								1	B
-58E	AN960-316L	. WASHER . . . . .								4	B
-58F	NAS42HT10-10	. SPACER . . . . .								1	B
-58G	NAS42HT10-22	. SPACER (Make from NAS42HT10-28) . . . . .								1	B
-58H	BAC30GN5-1	. BOLT . . . . .								1	B
-58J	69-30242-1	. FITTING, Anchor (optional 69-12689-2) . . . . .								1	B
-58K	69-20131-1	. SUPPORT FITTING . . . . .								1	B
-58L	AN960-3-3	. PIN, Cotter . . . . .								2	B
-59	WS20392-4C21	. PIN, Flathead (optional WS20392-4-21) . . . . .								2	B
-60	65-10505-271	. FAIRING ASSY, Aft . . . . .								1	A
-61	65-10505-354	. FAIRING ASSY, Aft . . . . .								1	B
-62	69-12695-1	. SEAL ASSY, Fairing . . . . .								1	
-62	69-12695-2	. SEAL ASSY (Opposite 69-12695-1) (ATTACHING PARTS) . SCREW (Optional BACB30LU3-2) . . . . .								1	
-63	NAS517-3-2	. SCREW (Optional BACB30LU3-2) . . . . .								14	
-63A	65-15593	. FITTING ASSY, Hinge, aft fairing . . . . .								1	
-63A	65-15593-1	. FITTING, Hinge . . . . .								1	
-63A	NAS76A5-004P	. BUSHING, Plain . . . . .								1	
-63A	69-12679	. FITTING ASSY, Hinge, aft fairing . . . . .								1	
-63A	69-12679-1	. FITTING, Hinge . . . . .								1	
-63B	NAS76A5-004P	. BUSHING, Plain . . . . .								1	
-64	65-16771-1	. FITTING, Support . . . . .								1	
-65	BAC34GSC22-27	. SHIM (Make from BAC1524-14SS) . . . . .								1	AR
-66	NAS1221-4-15	. BOLT . . . . .								4	
-67	WS20500-428	. NUT . . . . .								4	
-68	69-10333-1	. CHANNEL ASSY . . . . .								1	
-69	69-10333-2	. CHANNEL ASSY . . . . .								1	
-69	*65-98055-2	KIT ASSY, Aft fairing attach fitting replacement . . . . .								1	
-69	65-99332-2	KIT ASSY, Sleeve structure modification . . . . .								1	

A Used On 65-10505-269  
 B Used On 65-10505-353, -401 and -402  
 C Used On 65-10505-401  
 D Used On 65-10505-269 and -353  
 E Used On 65-10505-402

\*See detailed illustration B.  
 Kit consists of items 58A thru 58K.

FLOW PROCESS CHART

SUBJECT AFT FAIRING DATE 4/4

PCN: 15237A WCD: 15237A WCD DATE: 89073

CHART BEGINS \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: MICHAEL

SYMBOLS	DESCRIPTION	SYMBOLS	DESCRIPTION
110 ● ◊ ▣ ▽	REMOVE PALETTE 215	115 ○ ◊ ▣ ▽	DELAY
120 ○ ◊ ▣ ▽	115-24	120 ● ◊ ▣ ▽	REMOVE PALETTE
130 ○ ◊ ▣ ▽	115	125 ○ ◊ ▣ ▽	115-24
140 ○ ◊ ▣ ▽	115-24	130 ○ ◊ ▣ ▽	115-24
150 ● ◊ ▣ ▽	STRIP PAINT/WASH 215	135 ○ ◊ ▣ ▽	115-24
160 ○ ◊ ▣ ▽	DELAY	140 ● ◊ ▣ ▽	IDENTIFY ITEM 115
170 ○ ◊ ▣ ▽	115	145 ○ ◊ ▣ ▽	WORK COMPLETED 115
180 ○ ◊ ▣ ▽	115-24	150 ○ ◊ ▣ ▽	DELAY
190 ● ◊ ▣ ▽	REMOVE PALETTE 215	155 ○ ◊ ▣ ▽	115-24
200 ○ ◊ ▣ ▽	115-24	160 ○ ◊ ▣ ▽	
210 ○ ◊ ▣ ▽	115-24	165 ○ ◊ ▣ ▽	
220 ○ ◊ ▣ ▽	115-24	170 ○ ◊ ▣ ▽	
230 ○ ◊ ▣ ▽	115-24	175 ○ ◊ ▣ ▽	
240 ● ◊ ▣ ▽	REMOVE PALETTE 45	180 ○ ◊ ▣ ▽	
250 ○ ◊ ▣ ▽	115-24	185 ○ ◊ ▣ ▽	
260 ○ ◊ ▣ ▽	115-24	190 ○ ◊ ▣ ▽	
270 ○ ◊ ▣ ▽	115-24	195 ○ ◊ ▣ ▽	
280 ● ◊ ▣ ▽	REMOVE PALETTE 45	200 ○ ◊ ▣ ▽	
290 ○ ◊ ▣ ▽	115-24	205 ○ ◊ ▣ ▽	
300 ○ ◊ ▣ ▽	115-24	210 ○ ◊ ▣ ▽	
310 ● ◊ ▣ ▽	REMOVE PALETTE 75	215 ○ ◊ ▣ ▽	
320 ● ◊ ▣ ▽	REMOVE PALETTE 75	220 ○ ◊ ▣ ▽	
330 ● ◊ ▣ ▽	REMOVE PALETTE 75	225 ○ ◊ ▣ ▽	
340 ● ◊ ▣ ▽	REMOVE PALETTE 75	230 ○ ◊ ▣ ▽	
350 ● ◊ ▣ ▽	REMOVE PALETTE 75	235 ○ ◊ ▣ ▽	
360 ● ◊ ▣ ▽	REMOVE PALETTE 75	240 ○ ◊ ▣ ▽	
370 ● ◊ ▣ ▽	REMOVE PALETTE 75	245 ○ ◊ ▣ ▽	
380 ● ◊ ▣ ▽	REMOVE PALETTE 75	250 ○ ◊ ▣ ▽	
390 ○ ◊ ▣ ▽	DELAY	255 ○ ◊ ▣ ▽	
400 ○ ◊ ▣ ▽	115-24	260 ○ ◊ ▣ ▽	
410 ○ ◊ ▣ ▽	115-24	265 ○ ◊ ▣ ▽	
420 ● ◊ ▣ ▽	REMOVE PALETTE 215	270 ○ ◊ ▣ ▽	
430 ○ ◊ ▣ ▽	115-24	275 ○ ◊ ▣ ▽	
440 ○ ◊ ▣ ▽	115-24	280 ○ ◊ ▣ ▽	
450 ● ◊ ▣ ▽	REMOVE PALETTE 215	285 ○ ◊ ▣ ▽	
460 ○ ◊ ▣ ▽	115-24	290 ○ ◊ ▣ ▽	
470 ○ ◊ ▣ ▽	115-24	295 ○ ◊ ▣ ▽	
480 ○ ◊ ▣ ▽	115-24	300 ○ ◊ ▣ ▽	

\*\*\*\*\*  
 15237A \* WORK CONTROL DOCUMENT \* MISTR 1.DATE 89073 PAGE 1 OF 2 PAGES  
 \*\*\*\*\*

2. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 15237A | | MBPAB | | 09093 | |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 65 10505-271 | | | 1C-135(K)A-3-4 C/N: DC-  
 1560FL/78-1-62, 3AUG78  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | FILL IN ANY ADD'L WORK  
 KC-135 | 1560008174274FL | REQ'D.

13. DISC 14. NOUN/END ITEM NOUN  
 | PAIRING, AFT  
 PHYLLIS HEALD/MABCBS/65265

15. DISP 16. PDN/  
 SECTION TOP NO. 17. WORK TO BE ACCOMPLISHED 18. TECH 19" P" 20" W"

2122	010 MBPCD	RECLIVE & UNCRATE	/	/
2122	020 MBPCA	STRIP ALL PAINT IAW 1C-135(K)A-3-4	/	/
2122	030 MBPCA	WASH INTERIOR & EXTERIOR WITH SOLVENT P-D680	/	/
2122	040 MBPCA	ABRASIVE BLAST TO REMOVE EXHAUST DEPOSITS IAW 1C-135(K)A-3-4 REQ'D _____ NOT REQ'D _____	/	/
2122	050 MBPCA	DRAIN & DRY WITH LIGHT FINE CLOTH OR CLEAN DRY COMPRESSED AIR	/	/
2122	060 MBPCA	TREAT FOR CORROSION 1C-135(K)A-3-4 SEC IV. MOVE TO MBPAB, BLDG 95.	/	/
95	070 MBPAB	ACC SHAKEDOWN INSP. IAW WORK STATEMENT. ANNOTATE DISCREPANCIES.		
95	080 MBPAB	REMOVE CORROSION & TREAT IAW 1C-135 A-3-4 SEC IV. REQ'D _____ NOT REQ'D _____	/	/
95	090 MBPAB	REPLACE BUSHINGS P/N NAS76A5-004P (2 PLACES ON UPPER / LOWER HINGE FITTINGS).	/	/
95	100 MBPAB	REPLACE SUPPORT FITTING 69-27531 1 REQ'D _____ NOT REQ'D _____	/	/
95	110 MBPAB	REPAIR OR REPLACE ALL LOOSE, MISSING OR DEFECTIVE FASTENERS.	E	/
95	120 MBPAB	STRAIGHTEN ALL MINOR DENTS & BENDS REQ'D _____ NOT REQ'D _____	/	/
95	130 MBPAB	SMOOTH ALL SCRATCHES, ABRASIONS, & NICKS REQ'D _____ NOT REQ'D _____	E	/
95	140 MBPAB	REPAIR LEFT & RIGHT SKIN AS REQ'D. REQ'D _____ NOT REQ'D _____	E	/



15.DISP-16.PDN/  
 STATION/UP NO. 117.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"

STATION/UP NO.	WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
75	145 MBPAB REPLACE RUB STRIPS, -217 & -220. REQ'D _____ NOT REQ'D _____		/	/
	150 MOVE TO BLDG 2200, MBPAB. <i>N/A</i>			
2280	160 MBPAB FINAL WASH.		/	/
2280	170 MBPAB REFINISH ALL SURFACES EXCEPT OUTER SKIN IAW WORK STATEMENT T.O. 1C 135(K)A 3 4- PARA. 11 30, MOVE TO BLDG 95, MBPAB.		/	
95	180 MBPAB MARK LA FAIRING WITH A PERMANENT MEANS OF IDENTIFICATION.		/	/
95	190 MBPAB WORK COMPLETED, CONDITION TAGGED IAW AFM 67 1, MOVE TO CRATING NOTE: PART WILL HAVE DC ALC FORMS 506,307 OR 500 ID LABELS APPLIED TO COMPLETED ITEM IAW. NOI 66 4. ACCEPTANCE DATE ON THE LABEL ALONG WITH "M" STAMP OF THE PERSON PER- FORMING THE OVERHAUL. CAUTION: SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAM- INATION. NOTE: COMPLETE "REMARKS" COLUMN OF AFLC FROM 1574 IAW MAOI 66-36, THIS PARA. NOT APPLICABLE TO NON-PRO- GRAMMED A/C WORKLOAD.	/	E	/
	COORDINATION  MABEBS  MABSCS  MBPAB  MBQBF			

?15237A  
RECORD NOT FOUND 152

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

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RCC	FAC	PROD	NO	OPER	DESCRIPTION	SK	DCC	T/S	HOURS	TECH
MBPAB	F	15237A	00B10	REPAIR	FAIRING AFT	004N FS	1.00	N	28.00	E
MBPCA	B	15237A	00C10	WASH&STRIP	.FAIRING AFT	004N WL	1.00	N	1.00	E
MBPCB	D	15237A	00C20	FINAL WASH&PAINT	FRNG AFT	004N B3	1.00	N	2.00	E
MBPCD	B	15237A	00C30	UNCRATE	FAIRING AFT	004N CQ	1.00	N	.40	E
MBPAB	F	15237A	00D10	SHAKEDOWN	INSP FRNG AFT	004N FS	1.00	N	.60	E
MBPAB	F	15237A	00J10	FAIRING	ASSY.AFT MFG	K235 FS	1.00	N	2.00	E

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

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15249A  
15250A

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE	
			1	2	3	4	5	6	7			
25 -	5-88190-105	AILERON AND TAB ASSY, OUTBOARD WING (LH) (FOR NHA SEE . . . FIG. 24)								REF		
	5-88190-106	AILERON AND TAB ASSY, OUTBOARD WING (RH) (FOR NHA SEE . . . FIG. 24)								REF		
	5-88190-103	AILERON ASSY, OUTBOARD WING (LH ONLY) . . . . .								1		
	5-88190-117	AILERON ASSY, OUTBOARD WING (FOR SPARES ONLY) . . . . . (CONSISTS OF PARTS DENOTED BY (S)) (LH ONLY)								REF		
	5-88190-104	AILERON ASSY, OUTBOARD WING (RH ONLY) . . . . .								1		
	5-88190-118	AILERON ASSY, OUTBOARD WING (FOR SPARES ONLY) . . . . . (CONSISTS OF PARTS DENOTED BY (S)) (RH ONLY)								REF		
	1	(S)740D10-12	JUMPER ASSY, COP BOND 35 AMP (91812) (ALTERNATE . . . . . 4E3E (79550)) (BACJ40D10-12) (ATTACHING PARTS)								4	
		(S)AN3-11A	BOLT (FOR REPLACEMENT ORDER BACB30NE3-12)								4	
		(S)NASS17-3-1	SCREW (FOR REPLACEMENT ORDER BACB30LU3-2)								2	
		(S)NASS14P1032-10	SCREW . . . . .								2	
		(S)BACN10P44AL	WASHER, PLAIN . . . . .								4	
		(S)BACW10P63AL	WASHER, PLAIN . . . . .								6	
		(S)AN341-10	NUT (FOR REPLACEMENT ORDER MS20341-10A)								2	
		(S)BACS40A13-29	SHIM, LAM, 0.30 IN. THK . . . . .								AR	
		(S)5-88190-23	FILLER, AILERON, OUTBOARD WING . . . . .								4	
	(S)NAB679A3W	NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539) . . . . . H10-3EAC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))								8		
2	65-8435-3	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (LH ONLY)								1		
2	65-8435-13	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (LH ONLY)								1		
	65-8435-4	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (RH ONLY)								1		
	65-8435-14	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (FOR SPARES ONLY) (RH ONLY)								1		
3	65-8435-1	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (LH ONLY)								1		
3	65-8435-11	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (FOR SPARES ONLY) (LH ONLY)								1		
	65-8435-2	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (RH ONLY)								1		
	65-8435-12	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (FOR SPARES ONLY) (RH ONLY)								1		
4	5-97697-1	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . OUTBOARD, UPPER (FOR REPLACEMENT ORDER 5-97697-16)								1		
4	5-97697-17	PANEL ASSY, HONEYCOMB SKIN, OUTBOARD AILERON, HALF, . . . . . OUTBOARD, UPPER (FOR REPLACEMENT ORDER 5-97697-16)								1		
5	5-97697-15	PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . . . OUTBOARD, LOWER (FOR REPLACEMENT ORDER 5-97697-16)								1		
5	5-97697-18	PANEL ASSY, HONEYCOMB SKIN, OUTBOARD AILERON, HALF, . . . . . OUTBOARD, LOWER (FOR REPLACEMENT ORDER 5-97697-16)								1		
	9-64577-131	TRAILING EDGE INSTL, OUTBOARD AILERON (LH ONLY) . . . . .								1		
	(S)9-64577-131	TRAILING EDGE INSTL, OUTBOARD AILERON (FOR SPARES . . . . . ONLY) (CONSISTS OF PARTS DENOTED BY (S)) (LH ONLY)								1		
	9-64577-132	TRAILING EDGE INSTL, OUTBOARD AILERON (RH ONLY) . . . . .								1		
	(S)9-64577-132	TRAILING EDGE INSTL, OUTBOARD AILERON (FOR SPARES . . . . . ONLY) (CONSISTS OF PARTS DENOTED BY (S)) (RH ONLY)								1		
	(S)9-64577-133	TRAILING EDGE ASSY, INBOARD, OUTBOARD AILERON . . . . . (LH ONLY)								1		

### Wing Control Surfaces

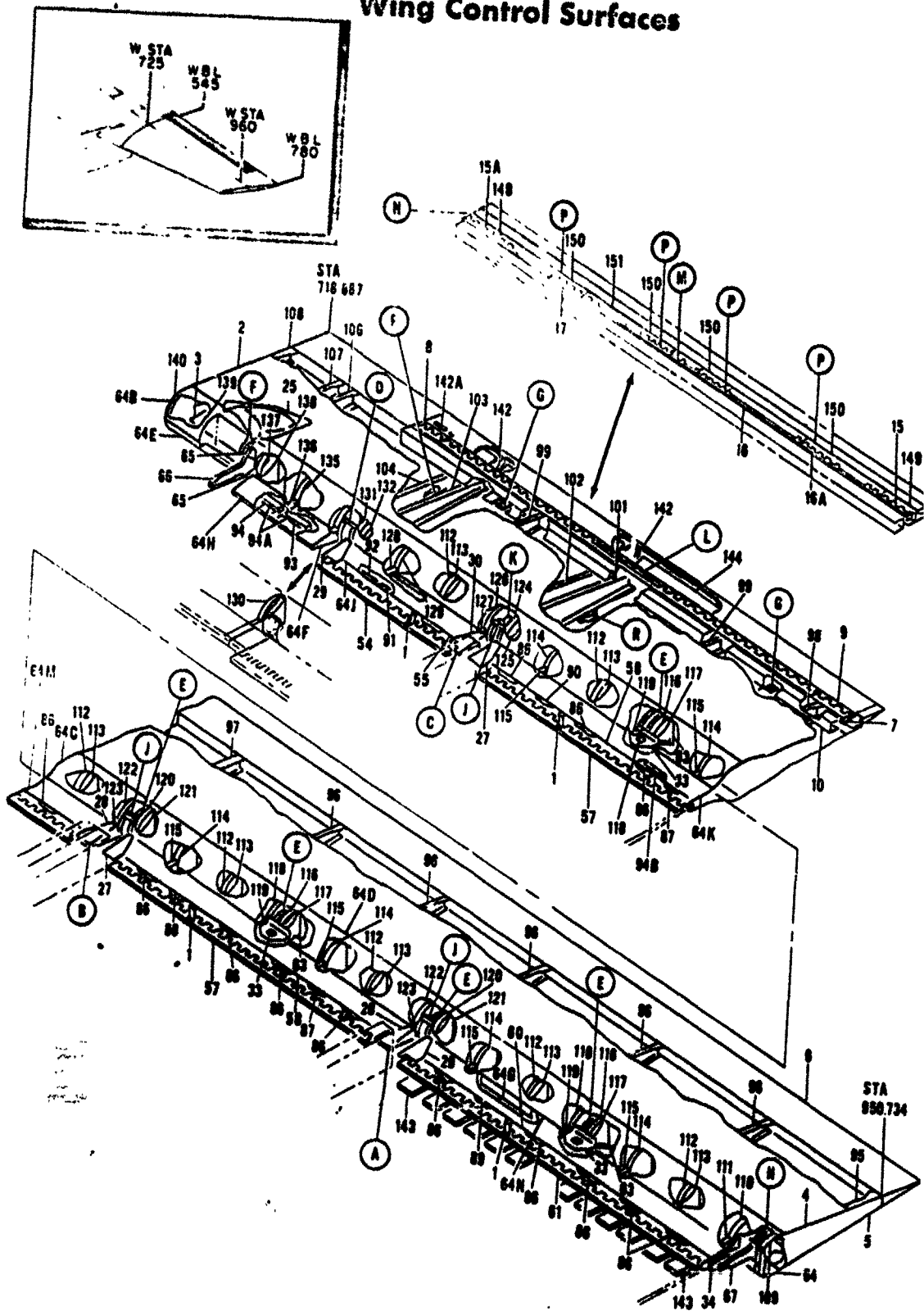
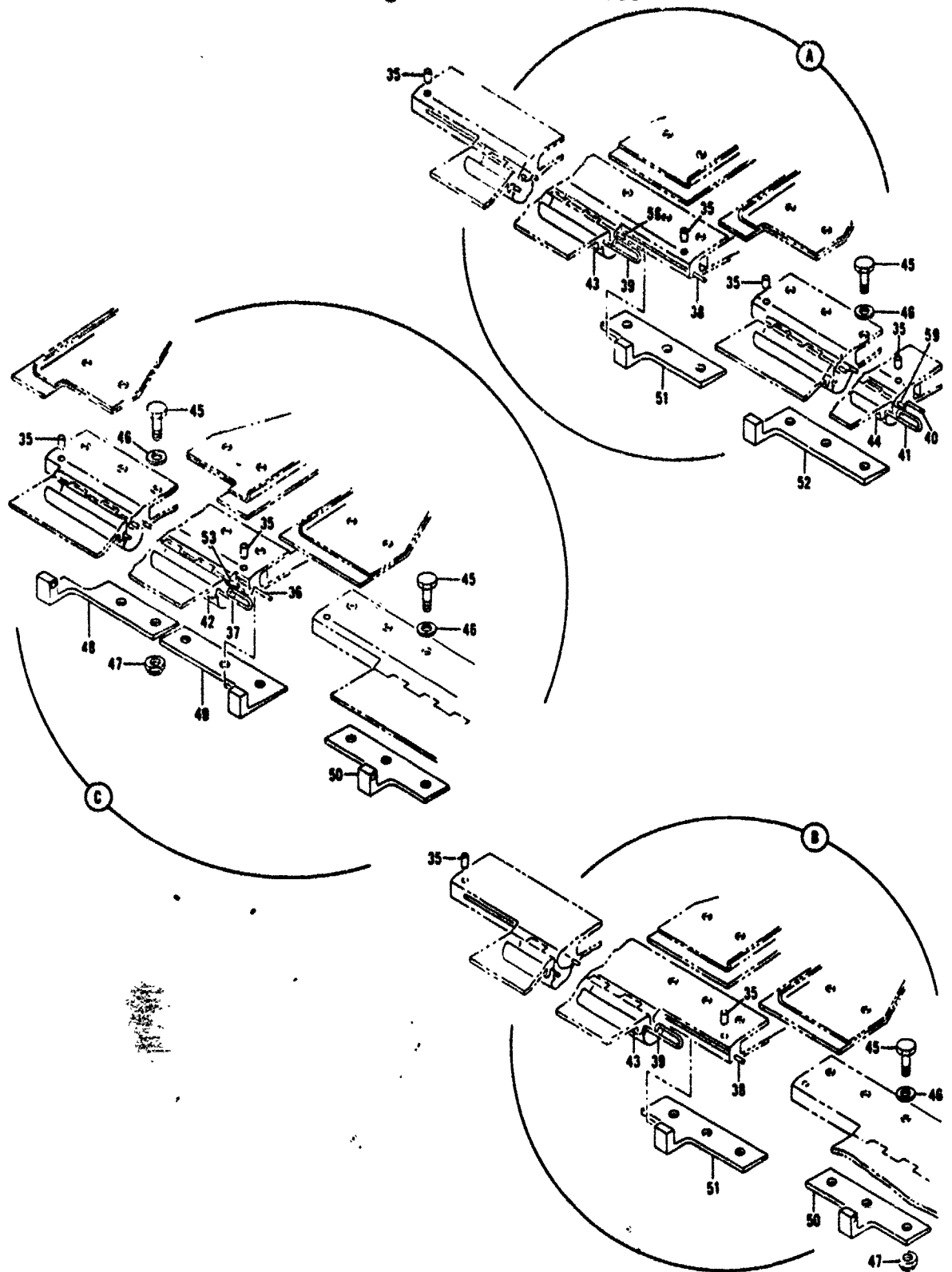


Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 1 of 5)

3153-25a1

### Wing Control Surfaces

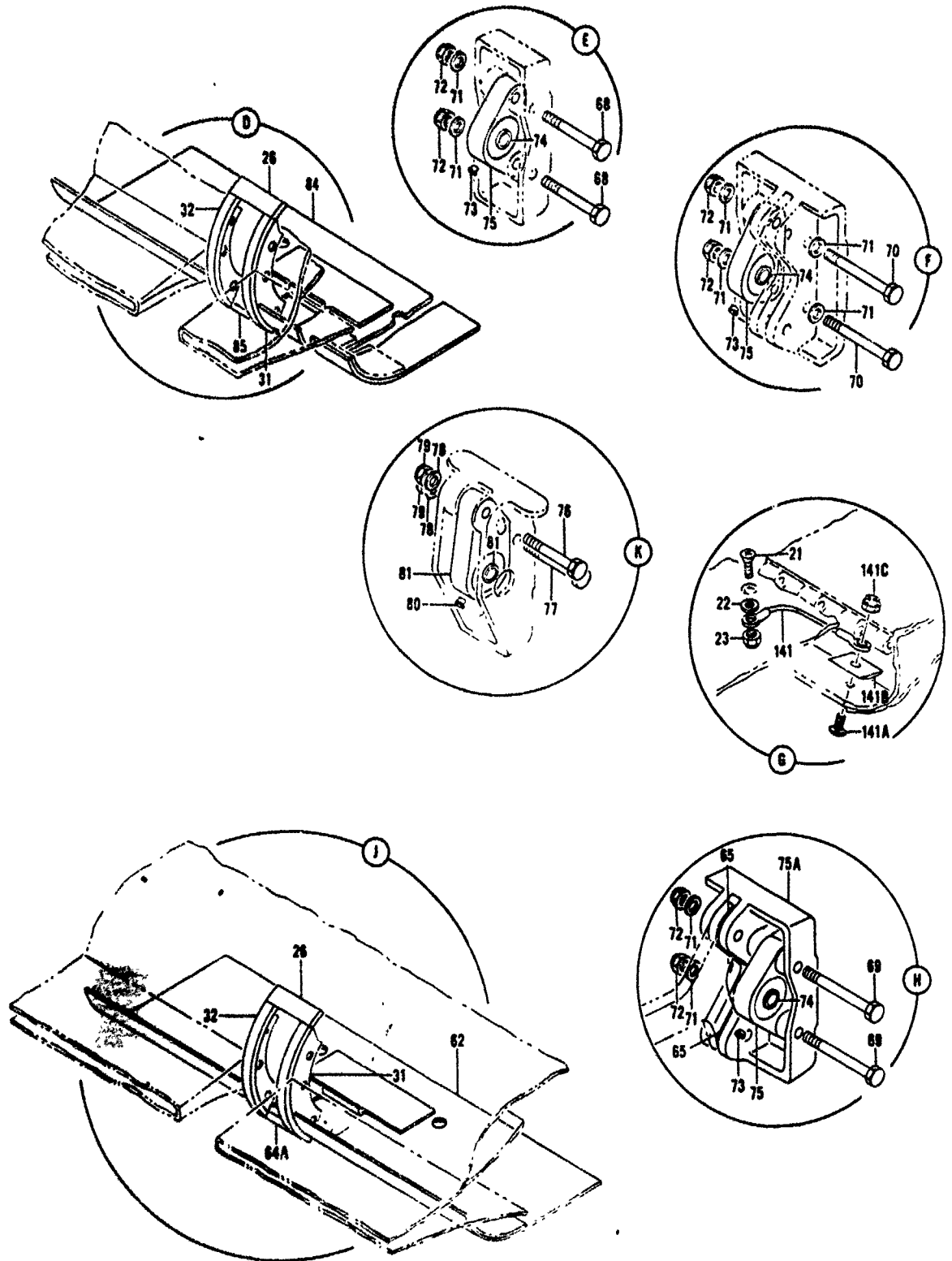


3153-251A

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 2 of 5)

CHANGED 28 JUN 1965

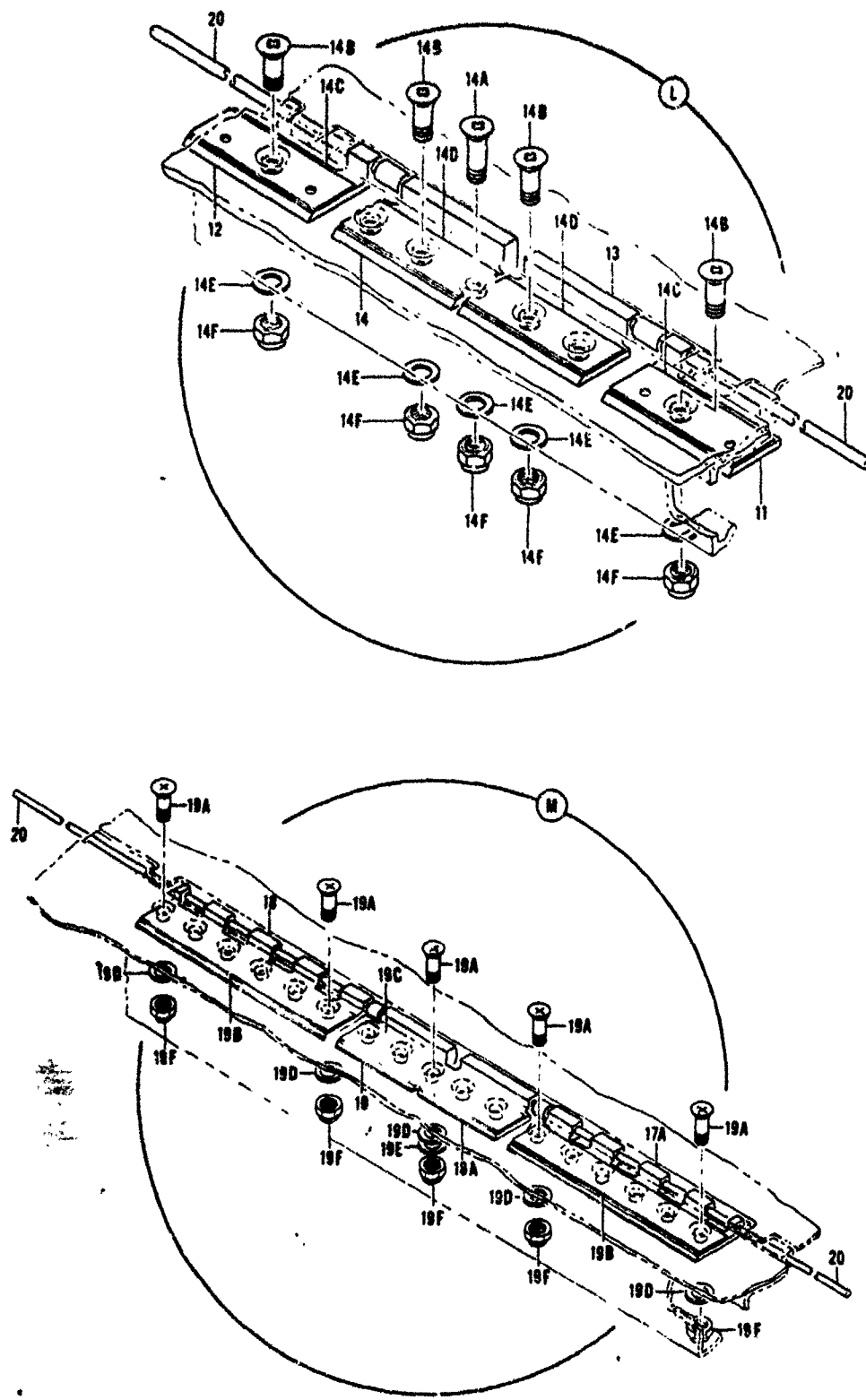
### Wing Control Surfaces



3153-25cA

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 3 of 5)

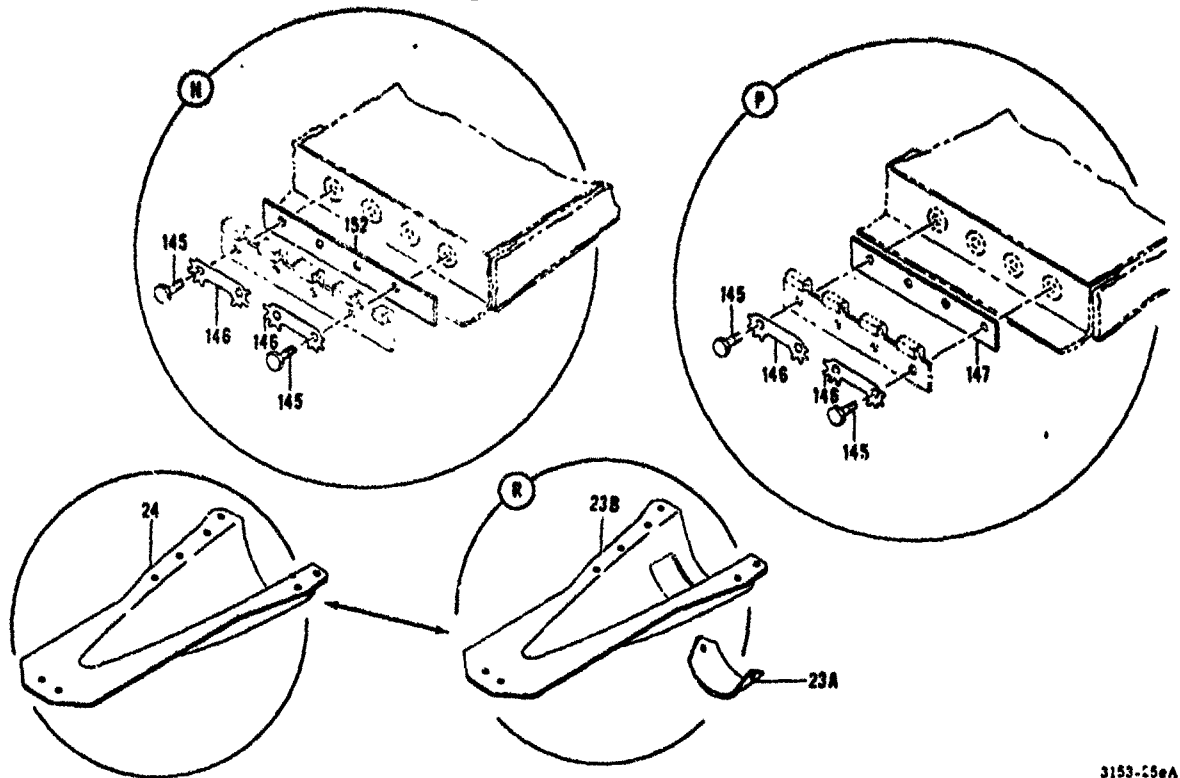
### Wing Control Surfaces



3153-25dA

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 4 of 5)

Wing Control Surfaces



3153-25a

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 5 of 5)

FIGURE & INDEX NO.	PART NUMBER								DESCRIPTION	UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7			
25 -	(S)9-64577-134	.	.	.					TRAILING EDGE ASSY, INBOARD, OUTBOARD AILERON (RH ONLY)	1	
6	(S)9-64577-85	.	.	.					TRAILING EDGE ASSY, OUTBOARD, OUTBOARD AILERON (LH ONLY)	1	
	(S)9-64577-86	.	.	.					TRAILING EDGE ASSY, OUTBOARD, OUTBOARD AILERON (RH ONLY)	1	
7	66-14038-1	.	.	.	.	.	.	.	RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY)	1	
	66-14038-2	.	.	.	.	.	.	.	RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY)	1	
8	69-6177-1	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (LH ONLY)	1	
	69-6177-2	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (RH ONLY)	1	
9	69-6177-3	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (LH ONLY)	1	
	69-6177-1	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (RH ONLY)	1	
10	9-64577-135	.	.	.					HINGE-HALF, TRAILING EDGE, OUTBOARD AILERON (LH ONLY) (WHEN EXHAUSTED USE 9-64577-169)	1	
	9-64577-136	.	.	.					HINGE-HALF, TRAILING EDGE, OUTBOARD AILERON (RH ONLY) (WHEN EXHAUSTED USE 9-64577-170)	1	
11	69-6177-3	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (LH ONLY)	1	
	69-6177-4	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (RH ONLY)	1	
12	69-6177-4	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (LH ONLY)	1	
	69-6177-3	.	.	.					HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (RH ONLY)	1	



FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	QS ON COI
		1	2	3	4	5	6	7		
25 - 13	69-6177-5	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (LH ONLY)							1	
	69-6177-6	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (RH ONLY)							1	
14	69-6177-6	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (LH ONLY)							1	
	69-6177-5	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (RH ONLY)							1	
14A	NAS1503-3	. . . . . BOLT, 100° CSK HD . . . . .							1	
14B	NAS1503-3	. . . . . BOLT, 100° CSK HD . . . . .							6	
14C	BACS40B10-29	. . . . . SHIM, LAM, 0.062 THK . . . . .							2	
14D	BACS40B10-57	. . . . . SHIM, LAM, 0.062 THK . . . . .							2	
14E	AN960PD10L	. . . . . WASHER . . . . .							7	
14F	NAS679A3W	. . . . . NUT (FOR REPLACEMENT ORDER 96-02 (156878) (80539) H10-3BAC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))							7	
15	69-33850-7	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-33850-8	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
15A	69-33850-8	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-33850-7	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
16	9-64577-169	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY) (USE 9-64577-135 UNTIL EXHAUSTED)							1	
	9-64577-170	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY) (USE 9-64577-136 UNTIL EXHAUSTED)							1	
16A	69-33850-12	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-33850-11	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
17	69-33850-11	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-33850-12	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
17A	69-33850-10	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-33850-9	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
18	69-33850-9	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-33850-10	. . . . . HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
18A	69-6177-5	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-6177-6	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
19	69-6177-6	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)							1	
	69-6177-5	. . . . . RETAINER, HINGE-HALF, TRAILING EDGE BEAM, . . . . . OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)							1	
19A	NAS1503-3	. . . . . BOLT, 100° CSK HD . . . . .							17	
19B	BACS40B9-72	. . . . . SHIM, LAM, 0.062 THK (FOR SPARES ONLY) (MAKE FROM 9535 BACS40B 9/16 X 4 1/2 INCH)							2	
19C	BACS40B10-57	. . . . . SHIM, LAM, 0.062 THK (FOR SPARES ONLY)							1	
19D	AN960PD10L	. . . . . WASHER (FOR SPARES ONLY)							17	
19E	BACN10P41AL	. . . . . WASHER, PLAIN (FOR SPARES ONLY)							1	
19F	NAS679A3W	. . . . . NUT (FOR SPARES ONLY) (FOR REPLACEMENT ORDER 96-02 (156878) (80539) H10-3BAC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))							17	
20	(S)166-10402	. . . . . PIN ASSY, TAB HINGE, OUTBOARD AILERON . . . . .							2	
21	(S)NAS517-3-2	. . . . . SCREW (FOR REPLACEMENT ORDER BACB30LU3-2)							2	
22	(S)BACN10P41AL	. . . . . WASHER, PLAIN . . . . .							2	
23	(S)NAS679A3W	. . . . . NUT (FOR REPLACEMENT ORDER 96-02 (156878) (80539) H10-3BAC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))							2	

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
25	(S)69-8929-1	..	..	..	..	..	..	..	2	
	(S)69-8929-2	..	..	..	..	..	..	..	2	
	69-8929-5	..	..	..	..	..	..	..	1	C
	69-8929-6	..	..	..	..	..	..	..	1	C
23A	69-8929-9	..	..	..	..	..	..	..	1	C
	NAS603-8P	..	..	..	..	..	..	..	2	C
23B	69-8929-7	..	..	..	..	..	..	..	1	C
	69-8929-8	..	..	..	..	..	..	..	1	C
24	69-8929-3	..	..	..	..	..	..	..	1	D
	69-8929-4	..	..	..	..	..	..	..	1	D
	(S)5-97849-1	..	..	..	..	..	..	..	1	
	(S)5-97849-2	..	..	..	..	..	..	..	1	
25	5-97849-3	..	..	..	..	..	..	..	1	
	5-97849-4	..	..	..	..	..	..	..	1	
	NAS514P1032-12	..	..	..	..	..	..	..	5	
26	(S)5-84190-107	..	..	..	..	..	..	..	4	
27	(S)66-14032-1	..	..	..	..	..	..	..	2	
	(S)66-14032-2	..	..	..	..	..	..	..	2	
28	(S)66-14032-2	..	..	..	..	..	..	..	2	
	(S)66-14032-1	..	..	..	..	..	..	..	2	
29	(S)60-2078-1	..	..	..	..	..	..	..	2	
	(S)60-2078-2	..	..	..	..	..	..	..	2	
30	(S)60-2078-2	..	..	..	..	..	..	..	1	
	(S)60-2078-1	..	..	..	..	..	..	..	1	
	(S)AN3-5A	..	..	..	..	..	..	..	10	
	(S)AN3-11A	..	..	..	..	..	..	..	11	
	(S)BAC10P43AL	..	..	..	..	..	..	..	10	
	(S)NAS620-10	..	..	..	..	..	..	..	3	
	(S)NAS679A3W	..	..	..	..	..	..	..	5	
	66-14032-7	..	..	..	..	..	..	..	1	
	60-2078-5	..	..	..	..	..	..	..	1	
31	60-2077-7	..	..	..	..	..	..	..	4	A
31	(S)60-2077-11	..	..	..	..	..	..	..	4	B
	60-2077-8	..	..	..	..	..	..	..	4	A
	(S)60-2077-12	..	..	..	..	..	..	..	4	B
32	60-2077-8	..	..	..	..	..	..	..	4	A
32	(S)60-2077-12	..	..	..	..	..	..	..	4	B
	60-2077-7	..	..	..	..	..	..	..	4	A
	(S)60-2077-11	..	..	..	..	..	..	..	4	B
	(S)AN3-4A	..	..	..	..	..	..	..	24	A
	AN960D10	..	..	..	..	..	..	..	12	A
	BAC10P43AL	..	..	..	..	..	..	..	12	A
	(S)NAS679A3W	..	..	..	..	..	..	..	24	A

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE
		1	2	3	4	5	6	7		
25	60-2077-5	. . . SEAL, HINGE, TYPICAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-13 X 5.2) (FOR I/W INFO SEE 60-2077-13)							1	A
	60-2077-13	. . . SEAL, HINGE, TYPICAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-13N X 5.2) (I/W 60-2077-5) (USE 60-2077-5 UNTIL EXHAUSTED)							1	B
33	(S)60-1593-3000	. . . SEAL ASSY, OUTBOARD AILERON . . . . .							3	
	60-1593-2002	. . . SEAL, OUTBOARD AILERON (MAKE FROM 8305 O.125 X 3.7 X 3.8 FELT TYPE 3 PER MIL-F-5656 100% NEUTRALIZED)							1	
34	60-1469-1	. . . SEAL ASSY, OUTBOARD AILERON (FOR I/W INFO SEE . . . 60-1469-7) (LH ONLY)							1	A
34	(S)60-1469-7	. . . SEAL ASSY, OUTBOARD AILERON (I/W 60-1469-1) (USE 60-1469-1 UNTIL EXHAUSTED) (LH ONLY)							1	B
	60-1469-2	. . . SEAL ASSY, OUTBOARD AILERON (FOR I/W INFO SEE . . . 60-1469-8) (RH ONLY)							1	A
	(S)60-1469-8	. . . SEAL ASSY, OUTBOARD AILERON (I/W 60-1469-2) (USE 60-1469-2 UNTIL EXHAUSTED) (RH ONLY)							1	B
	(S)AN3-4A	. . . BOLT (FOR REPLACEMENT ORDER BACB3ONE3-2) . . . . .							2	
	(S)AN960D10	. . . WASHER . . . . .							2	
	60-1469-5	. . . SEAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17 X 4.6) (FOR I/W INFO SEE 60-1469-6)							1	A
	60-1469-6	. . . SEAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17N X 4.6) (I/W 60-1469-5) (USE 60-1469-5 UNTIL EXHAUSTED)							1	B
35	(S)NAS561P4-7	. . . PIN, (FOR REPLACEMENT ORDER MS16562-32) . . . . .							8	
36	(S)BACP18G2-2517	. . . PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)							1	
37	(S)BACP18G2-2425	. . . PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)							2	
38	(S)BACP18G2-5210	. . . PIN, SEAL RET . . . . .							2	
39	(S)BACP18G2-4823	. . . PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)							1	
40	(S)BACP18G2-5460	. . . PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)							1	
41	(S)BACP18G2-5453	. . . PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)							1	
42	(S)60-2099	. . . SEAL, FABRIC, OUTBOARD AILERON (MAKE FROM . . . . . BMS1-17A TYPE 2 GRADE B, 8305-24.50 LG X 2.50 WIDE)							1	
43	(S)60-2099-1	. . . SEAL, FABRIC, OUTBOARD AILERON (MAKE FROM . . . . . BMS1-17A TYPE 2 GRADE B, 8305-48.48 LG X 2.50 WIDE)							2	
44	(S)60-2099-2	. . . SEAL, FABRIC, OUTBOARD AILERON (MAKE FROM . . . . . BMS1-17A TYPE 2 GRADE B, 8305-54.72 LG X 2.50 WIDE)							1	
45	(S)AN3-11A	. . . BOLT (FOR REPLACEMENT ORDER BACB3ONE3-12) . . . . .							4	
46	(S)BACW10P43AL	. . . WASHER, PLAIN . . . . .							4	
47	(S)NAS679A3M	. . . NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539) H10-3BAC (15653) T6S1032J (71087) RMLM9075-3M (72962) (BACN10JC3))							2	
48	(S)60-3656-4	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY) . . .							1	
	(S)60-3656-3	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY) . . .							1	
49	(S)60-3656-2	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY) . . .							1	
	(S)60-3656-1	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY) . . .							1	
50	(S)60-3655-1	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY) . . .							2	
	(S)60-3655-2	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY) . . .							2	
51	(S)60-3655-1	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY) . . .							2	
	(S)60-3655-2	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY) . . .							2	
52	(S)60-3656-1	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY) . . .							1	
	(S)60-3656-2	. . . RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY) . . .							1	
	(S)65-27063-14	. . . HINGE ASSY, OUTBOARD AILERON . . . . .							1	
	(S)65-27063-17	. . . HINGE ASSY, OUTBOARD AILERON (LH ONLY) . . . . .							2	
	(S)65-27063-18	. . . HINGE ASSY, OUTBOARD AILERON (RH ONLY) . . . . .							2	
	(S)65-27063-15	. . . HINGE ASSY, OUTBOARD AILERON (LH ONLY) . . . . .							1	
	(S)65-27063-16	. . . HINGE ASSY, OUTBOARD AILERON (RH ONLY) . . . . .							1	
	69-1893-6	. . . HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-14)							1	
	5-96763-23	. . . HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-17, -18)							2	
	5-96763-19	. . . HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-15)							1	
	5-96763-20	. . . HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-16)							1	
53	69-1893-5	. . . PIN, HINGE, NOSE, OUTBOARD AILERON (USED ON 69-1893-6)							1	

Section II  
Group Assembly Parts List

TO 1C-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON CODE	
			1	2	3	4	5	6	7			
25 -												
54	69-1893-2	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 69-1893-6)									1	
55	69-1893-7	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 69-1893-6)									1	
56	MS20257-2-4882	PIN (USED ON 5-96763-23)									1	
57	5-96763-10	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-23)									1	
58	5-96763-9	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-23)									1	
59	MS20257-2-5449	PIN (USED ON 5-96763-19, 20)									1	
60	5-96763-11	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-19)									1	
	5-96763-12	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-20)									1	
61	5-96763-17	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-19)									1	
	5-96763-18	HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-20)									1	
62	90-1417-10	DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR I/W INFO SEE 90-1417-13)									3	A
62	90-1417-13	DOOR ASSY, ACCESS, OUTBOARD AILERON (I/W 90-1417-10) (USE 90-1417-10 UNTIL EXHAUSTED)									3	B
62	90-1417-16	DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY)									3	
63	90-2866-3	DOOR ASSY, ACCESS, OUTBOARD AILERON									3	
63	90-2866-5	DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY)									3	
64	90-1417-1	DOOR ASSY, ACCESS, OUTBOARD AILERON (LH ONLY)									1	
64	90-1417-14	DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)									1	
	90-1417-2	DOOR ASSY, ACCESS, OUTBOARD AILERON (RH ONLY)									1	
64	90-1417-15	DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY) (ATTACHING PARTS)									1	
	NAS517-3-2	SCREW (FOR REPLACEMENT ORDER BACB30LU3-2)									106	
64A	90-1417-9	SEAL, DOOR, ACCESS, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17 X 2.1) (FOR I/W INFO SEE 90-1417-12) (USED ON 90-1417-10)									1	A
64A	90-1417-12	SEAL, DOOR, ACCESS, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17N X 2.1) (I/W 90-1417-9) (USE 90-1417-9 UNTIL EXHAUSTED) (USED ON 90-1417-13, -16)									1	B
64B	5-88190-73	SKIN, AILERON, OUTBOARD WING, UPPER (MAKE FROM ALUM 2024-T6)									1	
64B	5-88190-3095	SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY)									1	
64C	5-88190-55	SKIN, AILERON, OUTBOARD WING, UPPER (ALTERED FROM 5-88190-62) (MAKE FROM ALUM 2024-T6) (FOR REPLACEMENT ORDER 65-17640-105) (LH ONLY)									1	
64C	5-88190-3077	SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (LH ONLY)									1	
	5-88190-56	SKIN, AILERON, OUTBOARD WING, UPPER (ALTERED FROM 5-88190-62) (MAKE FROM ALUM 2024-T6) (RH ONLY)									1	
	5-88190-3078	SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (RH ONLY)									1	
64D	5-88190-61	SKIN, AILERON, OUTBOARD WING, UPPER (ALTERED FROM 5-88190-62) (MAKE FROM ALUM 2024-T6) (FOR REPLACEMENT ORDER 65-17640-107) (LH ONLY)									1	
64D	5-88190-3079	SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (LH ONLY)									1	
	5-88190-62	SKIN, AILERON, OUTBOARD WING, UPPER (MAKE FROM ALUM 2024-T6) (RH ONLY)									1	
	5-88190-3080	SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (RH ONLY)									1	
64E	5-88190-71	SKIN, AILERON, OUTBOARD WING, LOWER (ALTERED FROM 5-88190-72) (LH ONLY)									1	
64E	5-88190-3093	SKIN, AILERON, OUTBOARD WING, LOWER (FOR SPARES ONLY) (LH ONLY)									1	
	5-88190-72	SKIN, AILERON, OUTBOARD WING, LOWER (RH ONLY)									1	
	5-88190-3094	SKIN, AILERON, OUTBOARD WING, LOWER (FOR SPARES ONLY) (RH ONLY)									1	
64F	5-88190-69	SKIN, AILERON, OUTBOARD WING, LOWER (ALTERED FROM 5-88190-72) (MAKE FROM ALUM 2024-T6) (LH ONLY)									1	
64F	5-88190-3091	SKIN, AILERON, OUTBOARD WING, LOWER (FOR SPARES ONLY) (LH ONLY)									1	
	5-88190-70	SKIN, AILERON, OUTBOARD WING, LOWER (ALTERED FROM 5-88190-72) (MAKE FROM ALUM 2024-T6) (RH ONLY)									1	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNI PEI ASS	
		1	2	3	4	5	6	7		
23 -	5-88190-3092	••	••	••	••	••	••	••	••	
64C	5-88190-67	••	••	••	••	••	••	••	••	
64G	5-88190-3085	••	••	••	••	••	••	••	••	
64H	5-88190-57	••	••	••	••	••	••	••	••	1
64H	5-88190-3087	••	••	••	••	••	••	••	••	1
	5-88190-58	••	••	••	••	••	••	••	••	1
	5-88190-3088	••	••	••	••	••	••	••	••	1
64J	5-88190-59	••	••	••	••	••	••	••	••	1
64J	5-88190-3099	••	••	••	••	••	••	••	••	1
	5-88190-60	••	••	••	••	••	••	••	••	1
	5-88190-3090	••	••	••	••	••	••	••	••	1
64K	5-88190-49	••	••	••	••	••	••	••	••	1
64K	5-88190-3071	••	••	••	••	••	••	••	••	1
	5-88190-50	••	••	••	••	••	••	••	••	1
	5-88190-3072	••	••	••	••	••	••	••	••	1
64L	DELETED									
64M	5-88190-51	••	••	••	••	••	••	••	••	1
64M	5-88190-3073	••	••	••	••	••	••	••	••	1
	5-88190-52	••	••	••	••	••	••	••	••	1
	5-88190-3074	••	••	••	••	••	••	••	••	1
64N	5-88190-53	••	••	••	••	••	••	••	••	1
64N	5-88190-3075	••	••	••	••	••	••	••	••	1
	5-88190-54	••	••	••	••	••	••	••	••	1
	5-88190-3076	••	••	••	••	••	••	••	••	1
65	(S)5-88190-1651	••	••	••	••	••	••	••	••	4
66	(S)6-84526	••	••	••	••	••	••	••	••	1
67	(S)6-84526-2	••	••	••	••	••	••	••	••	1
	(S)NAS464P5A15	••	••	••	••	••	••	••	••	2
	(S)NAS464P5A16	••	••	••	••	••	••	••	••	2
	(S)AN960D516	••	••	••	••	••	••	••	••	4
	(S)NAS679A5W	••	••	••	••	••	••	••	••	4
	6-83219-2	••	••	••	••	••	••	••	••	7
68	(S)NAS1104-35M	••	••	••	••	••	••	••	••	10
69	(S)NAS1104-41M	••	••	••	••	••	••	••	••	2
70	(S)NAS1104-61M	••	••	••	••	••	••	••	••	2
71	(S)AN960D416	••	••	••	••	••	••	••	••	16
72	(S)NAS679A4W	••	••	••	••	••	••	••	••	14
73	NAS516-1	••	••	••	••	••	••	••	••	1
74	BR5	••	••	••	••	••	••	••	••	1
75	6-83219-3	••	••	••	••	••	••	••	••	1
	(S)9-64578-41	••	••	••	••	••	••	••	••	1
	(S)9-64578-42	••	••	••	••	••	••	••	••	1

Section II  
Group Assembly Parts List

TO IC-135A-4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE	
		1	2	3	4	5	6	7			
25 -											
75A	5-96181									1	
	(S)16-83592-4									1	
76	(S)NAS1104-33W									1	
77	(S)NAS1104-35W									1	
78	(S)AN960D416									2	
79	(S)NAS679A4W									2	
80	NAS516-1									1	
81	BR5									1	
82	6-83592-3									1	
83	DELETED										
84	69-1898-1									1	
84	69-1898-11									1	
84	69-1898-14									1	
	69-1898-2									1	
	69-1898-12									1	
	69-1898-15									1	
	(S)NAS517-3-2									16	
85	69-1898-6									1	
85	(S)69-1898-13									1	
86	(S)50-2477-17									14	
87	(S)50-2477-18									2	
88	(S)50-2477-19									1	
89	(S)50-2477-20									1	
90	(S)50-2477-21									1	
91	(S)65-2312-5									1	
92	(S)65-2312-6									1	
93	(S)65-2312-7									1	
94	(S)65-2312-8									1	
94A	(S)66-9900-1									AR	
94B	(S)66-9900									AR	
95	(S)65-8405-1									1	
	(S)65-8405-2									1	
96	(S)69-5650-3									5	
	(S)69-5650-4									5	
97	(S)9-64574-9									1	
	(S)9-64574-10									1	

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	1 2 3 4 5 6 7							UNITS PER ASSY	USE ON COD
25 -											
98	(S)169-5650-21	• • RIB INSTL, OUTBOARD AILERON (STATION 816.60) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
	(S)169-5650-22	• • RIB INSTL, OUTBOARD AILERON (STATION 816.60) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
99	(S)169-5652-1	• • RIB INSTL, OUTBOARD AILERON (STATION 799.00, 766.18) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								2	
	(S)169-5652-2	• • RIB INSTL, OUTBOARD AILERON (STATION 799.00, 766.18) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								2	
100	DELETED										
101	(S)169-5652-1	• • RIB INSTL, OUTBOARD AILERON (STATION 780.96) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
	(S)169-5652-2	• • RIB INSTL, OUTBOARD AILERON (STATION 780.96) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
102	(S)169-5652-2	• • RIB INSTL, OUTBOARD AILERON (STATION 778.96) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
	(S)169-5652-1	• • RIB INSTL, OUTBOARD AILERON (STATION 778.96) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
103	(S)169-5650-3	• • RIB INSTL, OUTBOARD AILERON (STATION 753.40) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
	(S)169-5650-4	• • RIB INSTL, OUTBOARD AILERON (STATION 753.40) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
104	(S)169-5650-4	• • RIB INSTL, OUTBOARD AILERON (STATION 751.40) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
	(S)169-5650-3	• • RIB INSTL, OUTBOARD AILERON (STATION 751.40) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
105	DELETED										
106	(S)19-64571-5	• • RIB INSTL, OUTBOARD AILERON, WING STATION 732.60 (LM ONLY) (FOR BREAKDOWN SEE FIG. 33)								1	
	(S)19-64571-6	• • RIB INSTL, OUTBOARD AILERON, WING STATION 732.60 (RM ONLY) (FOR BREAKDOWN SEE FIG. 33)								1	
107	(S)19-64570-11	• • RIB INSTL, OUTBOARD AILERON, WING STATION 729.00 (LM ONLY) (FOR BREAKDOWN SEE FIG. 34)								1	
	(S)19-64570-12	• • RIB INSTL, OUTBOARD AILERON, WING STATION 729.00 (RM ONLY) (FOR BREAKDOWN SEE FIG. 34)								1	
108	(S)169-5650-1	• • RIB INSTL, OUTBOARD AILERON, WING STATION 713.887 (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
	(S)169-5650-2	• • RIB INSTL, OUTBOARD AILERON, WING STATION 718.887 (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)								1	
109	(S)19-67025-17	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								1	
	(S)19-67025-18	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								1	
110	(S)19-67025-1	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								1	
	(S)19-67025-2	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								1	
111	(S)19-67066-1	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								1	
	(S)19-67066-2	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								1	
112	(S)19-67025-1651	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								7	
	(S)19-67025-1652	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								7	
113	(S)19-67066-3	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								7	
	(S)19-67066-4	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								7	
114	(S)19-67025-1652	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								6	
	(S)19-67025-1651	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								6	
115	(S)19-67066-4	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								6	
	(S)19-67066-3	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								6	
116	(S)19-67025-7	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								3	
	(S)19-67025-8	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								3	
117	(S)19-67066-13	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								3	
	(S)19-67066-14	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								3	
118	(S)19-67025-8	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								3	
	(S)19-67025-7	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								3	
119	(S)19-67066-14	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								3	
	(S)19-67066-13	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								3	
120	(S)19-67025-5	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								2	
	(S)19-67025-6	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								2	
121	(S)19-67066-5	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								2	
	(S)19-67066-6	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								2	
122	(S)19-67025-6	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								2	
	(S)19-67025-5	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								2	
123	(S)19-67066-6	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								2	
	(S)19-67066-5	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								2	
124	(S)19-67025-21	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								1	
	(S)19-67025-22	• • WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY)								1	
125	(S)19-67066-21	• • RIB, NOSE, OUTBOARD AILERON (LM ONLY)								1	
	(S)19-67066-22	• • RIB, NOSE, OUTBOARD AILERON (RM ONLY)								1	
126	(S)19-67025-22	• • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY)								1	

Section II  
Group Assembly Parts List

T.O. 1C-125A 4

FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION							UNITS PER ASSY	USE ON CODE	
		1	2	3	4	5	6	7			
25 -											
127	(S)9-67025-21	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67066-22	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67066-21	• •	• •	• •	• •	• •	• •	• •	• •	1	
128	(S)9-67025-19	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67025-20	• •	• •	• •	• •	• •	• •	• •	• •	1	
129	(S)9-67066-3	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67066-4	• •	• •	• •	• •	• •	• •	• •	• •	1	
130	(S)9-67025-19	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67025-20	• •	• •	• •	• •	• •	• •	• •	• •	1	
131	DELETED										
132	(S)9-67066-15	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67066-16	• •	• •	• •	• •	• •	• •	• •	• •	1	
133	DELETED										
134	DELETED										
135	(S)9-67025-19	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67025-20	• •	• •	• •	• •	• •	• •	• •	• •	1	
136	(S)9-67066-17	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67066-18	• •	• •	• •	• •	• •	• •	• •	• •	1	
137	(S)9-67025-11	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67025-12	• •	• •	• •	• •	• •	• •	• •	• •	1	
138	(S)9-67066-19	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67066-20	• •	• •	• •	• •	• •	• •	• •	• •	1	
139	(S)9-67025-13	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)9-67025-14	• •	• •	• •	• •	• •	• •	• •	• •	1	
140	(S)66-5296-1	• •	• •	• •	• •	• •	• •	• •	• •	1	
	(S)66-5296-2	• •	• •	• •	• •	• •	• •	• •	• •	1	
	9-64026-83	• •	• •	• •	• •	• •	• •	• •	• •	1	
	9-64026-1001	• •	• •	• •	• •	• •	• •	• •	• •	1	REF
		TAB ASSY, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (CONSISTS OF PARTS DENOTED BY (S)) (LH ONLY)									
	9-64026-84	• •	• •	• •	• •	• •	• •	• •	• •	1	
	9-64026-1002	• •	• •	• •	• •	• •	• •	• •	• •	1	REF
		TAB ASSY, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (CONSISTS OF PARTS DENOTED BY (S)) (RH ONLY)									
141	(S)740K5A5A6	• •	• •	• •	• •	• •	• •	• •	• •	2	
		JUMPER, BOND., IRRADIATED, POLYOLEFIN, INSULATED (91812) (BACJ40K5A5A6) (ATTACHING PARTS)									
141A	(S)N45517-3-2	• •	• •	• •	• •	• •	• •	• •	• •	2	
141B	9-64026-49	• •	• •	• •	• •	• •	• •	• •	• •	2	
		FILLER, HONEYCOMB TAB, OUTBOARD AILERON (FOR SPARES ONLY)									
141C	NAS679A3W	• •	• •	• •	• •	• •	• •	• •	• •	2	
		NUT (FOR SPARES ONLY) (FOR REPLACEMENT ORDER 96-02 (56878) (80539) M10-3BAC (15653) T6S1032J (71097) RMLM9075-3W (72962) (BACN10JC3))									
142	(S)60-3722-1	• •	• •	• •	• •	• •	• •	• •	• •	2	
	(S)60-3722-2	• •	• •	• •	• •	• •	• •	• •	• •	2	
142A	(S)AN7510F1	• •	• •	• •	• •	• •	• •	• •	• •	1	
142A	BACN12M30-1CD	• •	• •	• •	• •	• •	• •	• •	• •	1	
143	66-8420-3001	• •	• •	• •	• •	• •	• •	• •	• •	1	AR
		WEIGHT ASSY, BALANCE, TAB, OUTBOARD AILERON (FOR SPARES ONLY)									
	9-64026-81	• •	• •	• •	• •	• •	• •	• •	• •	1	
		CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON (LH ONLY)									
	9-64026-92	• •	• •	• •	• •	• •	• •	• •	• •	1	
		CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON (RH ONLY)									
	9-64026-87	• •	• •	• •	• •	• •	• •	• •	• •	1	
		SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON (LH ONLY)									
	9-64026-88	• •	• •	• •	• •	• •	• •	• •	• •	1	
		SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON (RH ONLY)									
144	9-64026-85	• •	• •	• •	• •	• •	• •	• •	• •	1	
		HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD AILERON (LH ONLY)									
	9-64026-86	• •	• •	• •	• •	• •	• •	• •	• •	1	
		HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD AILERON (RH ONLY)									
145	NAS1223-1L	• •	• •	• •	• •	• •	• •	• •	• •	24	
		BOLT (FOR REPLACEMENT ORDER BACB30NE3LN1) (FOR SPARES ONLY)									
146	69-33855-1	• •	• •	• •	• •	• •	• •	• •	• •	12	
		RETAINER, BOLT, TAB, OUTBOARD AILERON (FOR SPARES ONLY)									
147	BACS40A10-64	• •	• •	• •	• •	• •	• •	• •	• •	4	
		SHIM, LAM, 0.030 THK (FOR SPARES ONLY) (MAKE FROM BAC1534-62, 5/8" x 4")									
147	BACS40A10-64	• •	• •	• •	• •	• •	• •	• •	• •	4	
		SHIM, LAM, 0.030 THK (FOR SPARES ONLY)									
148	69-33849-1	• •	• •	• •	• •	• •	• •	• •	• •	1	
		HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)									
	69-33849-2	• •	• •	• •	• •	• •	• •	• •	• •	1	
		HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)									
149	69-33849-2	• •	• •	• •	• •	• •	• •	• •	• •	1	
		HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)									



FIGURE & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS	USE
			PER ASSY	ON CODE
25 -	69-33849-1	. . HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)	1	
150	69-33849-3	. . HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY)	4	
	9-64026-1009	. . CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY)	1	
	9-64026-1010	. . CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)	1	
	9-64026-1005	. . . SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY)	1	
151	9-64026-1006	. . . SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)	1	
	9-64026-1003	. . . . HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY)	1	
	9-64026-1004	. . . . HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)	1	
152	BACS40A10-72	. . . . SHIM, LAM, 0.030 THK (FOR SPARES ONLY) (MAKE FROM BAC1534-62, 5/8" x 4 1/2")	2	
		A 3001 THRU 3001 B 2201 THRU 2299, 3002 THRU 3099 C 2201 THRU 2299 D 3001 THRU 3099		

**FLOW PROCESS CHART**

SUBJECT AILERON ASSY OUTBOARD KC-135

DATE 4/5/89

PCN: 15250A WCD: 15249A WCD DATE: 88055

CHART BEGINS 15249A

PAGE 1 OF 1

CHART ENDS \_\_\_\_\_

PREPARED BY: LARRY

NO OF OP	SYMBOLS	DESCRIPTION	NO OF OP	SYMBOLS	DESCRIPTION
010	● ◊ □ ▽	REMOVE / LACRATE 2122- MBPCA	270	● ◊ □ ▽	CORROSION WORK
	● ◊ □ ▽	DELAY PASTE TO PAINT DELAY	275	● ◊ □ ▽	REMOVE SKIN PANELS
020	● ◊ □ ▽	STRIP PAINT 2122- MBPCA	280	● ◊ □ ▽	LAYOUT/FABRICATE NEW SKINS
	○ ◊ □ ▽	DELAY	285	● ◊ □ ▽	REPLACE FN/OUT TRAILING EDGES
030	● ◊ □ ▽	TREAT FOR CORROSION 2122- MBPCA	290	● ◊ □ ▽	ALIGNMENT CHECK/INSTALL FN FITTING
	○ ◊ □ ▽	DELAY	300	● ◊ □ ▽	REPLACE OUT/IN HONEYCOMB TRAILING EDGE
	○ ◊ □ ▽	MOVE TO 95	310	● ◊ □ ▽	INSTALL NEW SKIN PANELS/ PAIRINGS
	○ ◊ □ ▽	DELAY	320	● ◊ □ ▽	REPAIR TAB HINGE SPAR
040	● ◊ □ ▽	REMOVE ACCESS PANELS 95 MBPCA	330	● ◊ □ ▽	INSPECT FOR & REMOVE FOD
050	● ◊ □ ▽	REMOVE SKIN PANELS	340	● ◊ □ ▽	INSTALL FN/OUT SKIN PANELS
055	● ◊ □ ▽	ACCOMPLISH SINKDOWN INSPECTION	350	● ◊ □ ▽	PERFORM ALIGNMENT CHECK/ REMOVE FROM JIG
	○ ◊ □ ▽	DELAY	360	● ◊ □ ▽	INSTALL SPAR HINGE HAWES
060	● ◊ □ ▽	REPAIR CYCLE - REPLACE WIPAN'S GALS MBPCA	370	● ◊ □ ▽	REPLACE DAMAGED ACCESSORY DOOR
070	● ◊ □ ▽	REPLACE CRACKED RIBS	380	● ◊ □ ▽	INSTALL ACCESS DOORS
075	● ◊ □ ▽	REPAIR HINGE ASSY	395	● ◊ □ ▽	REMOVE DENTS, SCRATCHES ETC IN OUTER SURFACES
076	● ◊ □ ▽	INSTALL SKIN PANELS	400	● ◊ □ ▽	APPLY AERO SEALANT
077	● ◊ □ ▽	REPLACE CRACKED BEARING CASTINGS		○ ◊ □ ▽	DELAY
080	● ◊ □ ▽	CLEAN/TREAT CORROSION		○ ◊ □ ▽	MOVE TO 2280
085	● ◊ □ ▽	REPLACE BALANCE HINGE HAWES		○ ◊ □ ▽	DELAY
090	● ◊ □ ▽	REPLACE CAPS	410	● ◊ □ ▽	FINAL WASH / CORROSION TREAT 2280 MBPCA
100	● ◊ □ ▽	REP/REP NOSE SKINS	420	● ◊ □ ▽	PAINT AILERON 2280 MBPCA
110	● ◊ □ ▽	REP/REP IN/OUT NOSE SKINS		○ ◊ □ ▽	DELAY
115	● ◊ □ ▽	CLEAN/TREAT INTERNAL CORROSION		○ ◊ □ ▽	MOVE TO 95
120	● ◊ □ ▽	INSTALL SKIN PANEL / ALON DOORS		○ ◊ □ ▽	DELAY
170	● ◊ □ ▽	REPLACE BAD FASTENERS EXTERIOR	430	● ◊ □ ▽	BALANCE AILERON 95 MBPCA
180	● ◊ □ ▽	SERVICE/REP BEARING SUPPORT	440	● ◊ □ ▽	INSTALL DEAL WITH CURRENT WEIGHT
190	● ◊ □ ▽	REPLACE DAMAGED SMALL PARTS	450	● ◊ □ ▽	WORK COMPLETE / CONTAIN TAG
250	● ◊ □ ▽	REPLACE BAD FASTENERS INTERIOR		○ ◊ □ ▽	
260	● ◊ □ ▽	REMOVE TAB HINGE SPAR		○ ◊ □ ▽	

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 | 15249A \* WORK CONTROL DOCUMENT \* 1. DATE 80055 PAGE 1 OF 4 PAGES |  
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12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 | | | MBPAB | | 89093 | |

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 | | | | 1. SOW C/N: UC-1560FL/  
 | | | | 28-1-32, DTD / AUG 78,  
 10. MODEL/DESIGN/SERIES 11. STOCK NR | 2. REVISION NO 2 DTD  
 | 10-135 | | | 20 FEB 79.  
 | | | | 3. WRITE IN ANY ADD'L  
 13. NOUN 14. NOUN/END ITEM NOUN | NOUN REQ'D.  
 | MICHAEL TYTANIC/MADLBD/65261 | 4. SERIAL PREFIX CONTROL  
 | | | | NO.)  
 | | | | 5. " MARKLY DASHET "

P/N	NOUN	C/N
5-88170-103	1560007230007 L	15222A
5-88170-117 (M)	1560008722400FL	15249A ✓
5-88170-93	1560006566184FL	15190A
5-88170-118 (M)	1560008722401FL	15250A ✓
5-88170-104	1560007230010 L	15223A

15. DISP-16. PDN/ STATION/UP NO.	17. WORK TO BE ACCOMPLISHED	18. MCH 19. P 20. Q
2122 010 MBPCD	RECEIVE & UNCRATE MOVE TO WASH RACK - MBPCA	CU / /
2122 020 MBPCA	STRIP EXTERIOR PAINT IAW 10-135(K)A-3 4, SEC X1 (PLUG ALL DRAIN HOLES IAW PARA 2 OF S.O.W.)	4U / /
2122 030 MBPCA	TREAT FOR CORROSION IAW 10-135(K) A 3 4, SECT. IV. MOVE TO MABPAB BLDG 95	4U / /
95 040 MBPAB	REMOVE ALL ACCESS DOORS FOR INSPECTION AND REPAIR	ES / /
95 050 MBPAB	REMOVE UPPER INBD & OUTBD SKIN PANELS FOR INSPECTION & REPAIR OBSERVE CAUTION	ES / /
95 055 MBPAB	ACC. SHAKEDOWN INSPECTION IAW S.O.W.	ES / /
95 060 MBPAB	REPLACE WORN OR DAMAGED SEALS WITH NEW SEALS. REQ'D _____ NOT REQ'D _____	ES / /
95 070 MBPAB	REPLACE CRACKED RIBS AND WEBS, ETC REF S.O.W. REQ'D _____ NOT REQ'D _____	ES / /
95 075 MBPAB	REPAIR LEAD WEIGHTS FROM HINGE ASSY REQD _____ NOT REQD _____	ES / /
95 076 MBPAB	INSTALL LOWER SKIN PANELS UNDER HINGES.	ES / /

15. DIGP-16. PDN/  
 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19" P" 20" M"

95	077 MBPAB	REPLACE CRACKED BEARING CASTINGS. REQD _____ NOT REQD _____	ES	/	/
95	090 MBPAB	CLEAN & TREAT CORROSION IAW 1C-135 (K)A-3-4, SLEET IV	ES	/	/
95	105 MBPAB	REPLACE BALANCE PANEL ATTACH. HINGE ASSTG REQ'D _____ NOT REQ'D _____	ES	/	/
95	108 MBPAB	REPLACE INBD AND OUTBD END CAPS REQD _____ NOT REQD _____	ES	/	/
95	110 MBPAB	REPAIR/REPLACE SHORT HOOL GRIND REQD _____ NOT REQD _____	ES	/	/
95	113 MBPAB	REPAIR OR REPLACE INBD & OUTBD HOOL SKINS. REQ'D _____ NOT REQ'D _____	ES	/	/
95	115 MBPAB	CLEAN & TREAT INTERNAL CORROSION IAW 1C-135(A)-3-4	ES	E	/
95	120 MBPAB	INSTALL LOWER SKIN PANEL & ACCESS DOORS	ES	/	/
95	170 MBPAB	REPLACE ALL LOOSE, SHEARED, OR MISS- ING FASTENERS (MARKED) REQ'D _____ NOT REQ'D _____	ES	/	/
95	190 MBPAB	SERVICE/REPLACE BEARING SUPPORTS REQ'D _____ NOT REQ'D _____	ES	/	/
95	190 MBPAB	REPLACE DAMAGED HINGE RETAINERS, ANGLES, CLIPS & CHANNELS REQ'D _____ NOT REQ'D _____	ES	/	/
95	250 MBPAB	REPLACE LOOSE, SHLARED, OR MISSING INTERNAL FASTENERS 1C-135(E)C-2-11-1, FIG 1 2. REQ'D _____ NOT REQ'D _____	ES	/	/
95	260 MBPAB	REMOVE TAB HINGE SPAR REQD _____ NOT REQD _____	ES	/	/
95	270 MBPAB	CLEAN & TREAT INTERNAL CORROSION IAW 1C-135(K)A-3-4, SLEET IV.	ES	/	/
95	275 MBPAB	REMOVE OLD SKIN PANELS REQD _____ NOT REQD _____	ES	/	/

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15. DISP-16. PDN/					
STATION	OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19. P	20. Q
95	280 MBFAB	LAYOUT & FABRICATE NLW SKIN PANELS REQD _____ NOT REQD _____	LS	/	/
95	285 MBFAB	REMOVE & REPLACE INBD AND OUTBD TRAILING EDGES REQD _____ NOT REQD _____	ES	/	
95	290 MBFAB	INSTALL AILERON IN JIG 590CJ1000 FOR ALIGNMENT CHECK. EDGE IAW 10-135(K)A-3-1 REQ'D _____ NOT REQ'D _____	ES	/	/
95	295 MBFAB	REPLACE I. B. HONEYCOMB TRAILING EDGE IAW 10-135(K)A-3-1 REQD _____ NOT REQD _____	ES	/	/
95	300 MBFAB	REPLACE O. B. HONEYCOMB TRAILING EDGE IAW 10-135(K)A-3-1 REQ'D _____ NOT REQ'D _____	ES	/	/
95	310 MBFAB	INSTALL NEW SKIN PANELS AND FAIRINGS REQD _____ NOT REQD _____	ES	/	/
95	320 MBFAB	REPAIR TAB HINGE SPAR IAW AC 135(K)A-3-1 FIG 2-103 REQ'D _____ NOT REQ'D _____	ES	/	/
95	330 MBFAB	REMOVE FOD. ACCOMP CLOSEOUT INSP.	ES	E	/
95	340 MBFAB	INSTALL INBOARD AND OUTBOARD SKIN PANELS	ES	/	/
95	350 MBFAB	PERFORM ALIGNMENT CHECK AND REMOVE AILERON FROM JIG	ES	E	/
95	360 MBFAB	INSTALL SPAR HINGE HALVES REQD _____ NOT REQD _____	ES	/	/
95	380 MBFAB	REPLACE DAMAGED OR CRACKED ACCESSORY DOOR. REQD _____ NOT REQD _____	ES	/	/
95	390 MBFAB	INSTALL ACCESS DOORS	ES	/	/
95	395 MBFAB	REPAIR DENTS, SCRATCHES & COUGES IN OUTR SURFACES IAW 10-135(K)A-3-1 C-2-11-1 REQD _____ NOT REQD _____	ES	E	/

STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH 12"0" 120"0"

75	400 MBFAB	FILL ALL SKIN, TRAILING EDGE, & SKIN PANEL ACCESS COVER GAPS WITH ENVIRONMENTAL SEALANT.	ES	E	/
2200	410 MBPCB	FINAL WASH & CORROSION TREAT MOVE TO PAINT, BLDG 2200, MBPCB		/	/
150	420 MBPCB	PAINT AILERON IAW T.O. 10-135(K) 3-3-1, 1-1-4, 10-135(K)A-3-4, OR SPECIAL REQUIREMENT. MOVE TO BLDG 25 MBPAB	B	/	/
75	430 MBPAB	BALANCE AILERON ASSEMBLY IAW T.O. 10-135(K)A-3-3, FIG 1-3,	ES	/	/
	440 MBPAB	INSPECT NEW METAL CHL OR DICAL WITH CURRENT WEIGHT AND DATA AND DATE. SERVICE BEARINGS & WRAP WITH BARRIER PAPER.	ES	/	/
75	450 MBPAB	WORK COMPLETED, CONDITION IAW IAW AFM 67-1. DATE MOVE TO CRATING. NOTE: PART WILL HAVE EITHER OC, ALD, FORM 386, 587, OR 588 IDENTIFICATION LABELS APPLIED TO COMPLETED ITEM IAW AFLLR 66-51, CHG 1. ACCEPTABLE DATE ON THE LABEL ALONG WITH "N" STAMP OF PERSON PERFORMING THE OVERHAUL CAUTION: SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTA- MINATION. " MARKET BAGNET "	ES	E	/

COORDINATION

- MABEFS NIKE TYTANIC 23 FEB 88
- MAQBF TLD HAYES 23 FEB 88
- MABPAB GARY HART 23 FEB 88
- MAQBSF PAT HANLUCK 23 FEB 88

# MABPAB

# L A B O R S T A N D A R D S

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RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MABPAB F 15025A 00810 REPAIR SIDE COM L/H AS 1.00 E 150.33 W
MABPAB F 15025A 00010 SIDE COM PANEL C135 AS 1.00 N 1.20 E
MABPAB F 15025A 00J10 L.H. SIDE COM FS 1.00 N 8.00 E
MABPAB F 15025A 00R10 EDS CLEANUP AS 1.00 N 3.96 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->
?MABPAB15113A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MABPAB F 15113A 00B10 PANEL S/COML R/H C 135 BS 1.00 E 142.74 W
MABPAB F 15113A 00D10 SHAKEDOWN INSPECTION BS 1.00 N 1.22 E
MABPAB F 15113A 00J10 SIDE COM L.H. FS 1.00 N 8.00 E
MABPAB F 15113A 00R10 EDS CLEANUP BS 1.00 N 3.76 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->
?MABPAB15119A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MABPAB F 15119A 00B10 REPAIR DOOR ASSY MLG FS 1.00 E 83.40 W
MABPAB F 15119A 00D10 INSPECT DOOR ASSY 003N FS 1.00 N 3.08 E
MABPAB F 15119A 00R10 EDS CLEANUP FS 1.00 N 3.28 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->
?MABPAB15321A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MABPAB F 15321A 00B10 REPAIR DOOR ASSY MLG FS 1.00 E 84.21 W
MABPAB F 15321A 00D10 INSPECT DOOR ASSY 111N FS 1.00 N 2.75 E
MABPAB F 15321A 00R10 EDS CLEANUP FS 1.00 N 3.28 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->
?MABPAB15136A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MABPAB F 15136A 00B10 REPR INBOARD AILERON ES 1.00 E 76.34 W
MABPAB F 15136A 00D10 INSPECT AILERON ES 1.00 N .90 E
MABPAB F 15136A 00R10 EDS CLEANUP ES 1.00 N 1.94 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->
?MABPAB15137A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MABPAB F 15137A 00B10 REPR INBOARD AILERON ES 1.00 E 76.34 W
MABPAB F 15137A 00D10 INSPECT AILERON ES 1.00 N .90 E
MABPAB F 15137A 00R10 EDS CLEANUP ES 1.00 N 1.94 E
ENTER DATA AS NEEDED
  
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7MBPAB15152A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15152A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15152A 00B20 REPAIR FOREFLAP DS 1.00 N 16.50 T
MBPAB F 15152A 00D10 INSPECT FLAP DB 1.00 N .51 E
MBPAB F 15152A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
7MBPAB15236A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15236A 00B10 REPAIR SLEEVE ASSY CS 1.00 E 117.08 W
MBPAB F 15236A 00B20 REPAIR AFT FAIRING FS 1.00 N 28.00 E
MBPAB F 15236A 00R10 EOS CLEANUP FS 1.00 N 4.50 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
7MBPAB15237A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15237A 00B10 REPAIR FAIRING AFT 004N FS 1.00 N 28.00 E
MBPAB F 15237A 00D10 SHAKEDOWN INSP FRNG AFT 004N FS 1.00 N .60 E
MBPAB F 15237A 00J10 FAIRING ASSY.AFT MFG K235 FS 1.00 N 2.00 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
7MBPAB15249A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15249A 00B10 REPR AILERON OB ES 1.00 E 107.16 W
MBPAB F 15249A 00D10 INSPECT AILERON K262 ES 1.00 N .84 E
MBPAB F 15249A 00R10 EOS CLEANUP ES 1.00 N 2.53 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
7MBPAB15250A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15250A 00B10 REPR AILERON OB ES 1.00 E 107.16 W
MBPAB F 15250A 00D10 INSPECT AILERON K262 ES 1.00 N 1.30 E
MBPAB F 15250A 00R10 EOS CLEANUP ES 1.00 N 2.53 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
7MBPAB15126A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15126A 00B10 REPAIR DOOR ASSY MLG FS 1.00 E 82.59 W
MBPAB F 15126A 00D10 INSPECT DOOR ASSY 003N FS 1.00 N 2.88 E
MBPAB F 15126A 00R10 EOS CLEANUP FS 1.00 N 3.26 E
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
7MBPAB15300A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15300A 00B10 REPAIR DOOR ASSY MLG FS 1.00 E 92.30 W
MBPAB F 15300A 00D10 INSPECT DOOR ASSY FS 1.00 N 3.75 E

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*Disney 15236A*

*121.58*

*28.60*

*110.53*

*110.97*

*98.75*

*11*



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MBPAB F 15189A 00B10 REPAIR WING FLAP OTBD.
MBPAB F 15189A 00B20 REPAIR WING FOREFLAP
MBPAB F 15189A 00D10 INSPECT FLAP
MBPAB F 15189A 00J10 MFG MISC PARTS
MBPAB F 15189A 00K10 707 CONVERSION
MBPAB F 15189A 00R10 EDS CLEANUP

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---X--->
?MBPAB15189A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15189A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15189A 00B20 REPAIR WING FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15189A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15189A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
MBPAB F 15189A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15189A 00R10 EDS CLEANUP DS 1.00 N 3.17 E

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TA AS NEEDED  
'END'

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MBPAB F 15154A 00B10 REPAIR WING FLAP OTBD.
MBPAB F 15154A 00B20 REPAIR WING FOREFLAP
MBPAB F 15154A 00D10 INSPECT FLAP
MBPAB F 15154A 00J10 MFG MISC PARTS

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---X--->
?MBPAB15151A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15154A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15154A 00B20 REPAIR WING FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15154A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15154A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E

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ENTER DATA AS NEEDED  
'END'

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MBPAB F 15191A 00B10 REPAIR WING FLAP INBD.
MBPAB F 15191A 00B20 REPAIR WING FOREFLAP
MBPAB F 15191A 00D10 INSPECT
MBPAB F 15191A 00J10 MFG MISC PARTS
MBPAB F 15191A 00K10 707 CONVERSION
MBPAB F 15191A 00R10 EDS CLEANUP

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---X--->
?MBPAB15191A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15191A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15191A 00B20 REPAIR WING FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15191A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAB F 15191A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E

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ENTER DATA AS NEEDED  
'END'

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MBPAB F 15192A 00B10 REPAIR WING FLAP INED.
MBPAB F 15192A 00B20 REPAIR WING FOREFLAP
MBPAB F 15192A 00D10 INSPECT
MBPAB F 15192A 00J10 MFG MISC PARTS
MBPAB F 15192A 00K10 707 CONVERSION
MBPAB F 15192A 00R10 EDS CLEANUP

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---X--->
?MBPAB15192A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15192A 00B10 REPAIR WING FLAP INED. DS 1.00 E 117.72 W
MBPAB F 15192A 00B20 REPAIR WING FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15192A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAB F 15192A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E
MBPAB F 15192A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15192A 00R10 EDS CLEANUP DS 1.00 N 3.12 E

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ENTER DATA AS NEEDED  
'END'

```

MBPAB F 15189A 00B10 REPAIR WING FLAP OTBD.
MBPAB F 15189A 00B20 REPAIR WING FOREFLAP
MBPAB F 15189A 00D10 INSPECT FLAP
MBPAB F 15189A 00J10 MFG MISC PARTS
MBPAB F 15189A 00K10 707 CONVERSION
MBPAB F 15189A 00R10 EDS CLEANUP

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---X--->
?MBPAB15189A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15189A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15189A 00B20 REPAIR WING FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15189A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15189A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
MBPAB F 15189A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15189A 00R10 EDS CLEANUP DS 1.00 N 3.17 E

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ENTER DATA AS NEEDED  
'END'

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MBPAB F 15154A 00B10 REPAIR WING FLAP OTBD.
MBPAB F 15154A 00B20 REPAIR WING FOREFLAP
MBPAB F 15154A 00D10 INSPECT FLAP
MBPAB F 15154A 00J10 MFG MISC PARTS

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---X--->
?MBPAB15151A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15154A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15154A 00B20 REPAIR WING FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15154A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15154A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E

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ENTER DATA AS NEEDED  
'END'

```

?MBPAB15140A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15140A 00B10 REPAIR FAIRING 004N FS 1.00 E 49.80 W
MBPAB F 15140A 00D10 SHAKEDOWN INSPECTION 312N FS 1.00 N .80 E
MBPAB F 15140A 00J10 MFG SUPP FAIRING 004N FS 1.00 N 7.04 E
MBPAB F 15140A 00R10 EDS CLEANUP 00R10 FS 1.00 N 1.05 E
51.65

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ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----->
?MBPAB15150A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15150A 00B10 REPAIR NOSE COWL KC135 312E CS 1.00 E 82.09 W
MBPAB F 15150A 00D10 SHAKEDOWN INSPECTION 312N CS 1.00 N 1.14 E
MBPAB F 15150A 00J10 MFG SUPP NOSE COWL 401N FS 1.00 N 7.20 E
MBPAB F 15150A 00R10 EDS CLEANUP 00R10 CS 1.00 N 1.92 E
85.15

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ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----->
?MBPAB15175A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15175A 00B10 REPAIR BOOM TAIL CONE FS 1.00 E 70.18 W
MBPAB F 15175A 00D10 SHAKEDOWN FS 1.00 N .67 E
MBPAB F 15175A 00J10 MFG SPLICES FS 1.00 N 1.00 E
MBPAB F 15175A 00R10 EDS CLEANUP FS 1.00 N 3.01 E
79.86

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ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----->
?MBPAB15178A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15178A 00B10 REPAIR OIL COOLER FS 1.00 E 17.94 W
MBPAB F 15178A 00D10 SHAKEDOWN FS 1.00 N .56 E
MBPAB F 15178A 00J10 MFG PRTS SUPP O\COOLER FS 1.00 N 4.99 E
MBPAB F 15178A 00R10 EDS CLEANUP FS 1.00 N .47 E
19.97

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ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----->
?MBPAB15153A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15153A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15153A 00B20 REPAIR FORE FLAP DS 1.00 N 15.00 T
MBPAB F 15153A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15153A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
135.73

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ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----->
?MBPAB15188A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15188A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15188A 00B20 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15188A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15188A 00J10 MFG MISC PARTS DS 1.00 N 13.00 E
MBPAB F 15188A 00R10 EDS CLEANUP DS 1.00 N 42.00 E
180.78

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?MBPAB15153A

RCC	FAC	PROD	NO	OPER	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPAB	F	15153A	00B10	REPAIR WING FLAP OTBD.	DS	1.00	E	119.73	W	
MBPAB	F	15153A	00B20	REPAIR FORE FLAP	DS	1.00	N	15.00	T	
MBPAB	F	15153A	00D10	INSPECT FLAP	DS	1.00	N	1.00	E	
MBPAB	F	15153A	00J10	MFG MISC PARTS	FS	1.00	N	13.00	E	

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

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

?MBPAB15154A

RCC	FAC	PROD	NO	OPER	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPAB	F	15154A	00B10	REPAIR WING FLAP OTBD.	DS	1.00	E	119.73	W	
MBPAB	F	15154A	00B20	REPAIR FOREFLAP	DS	1.00	N	15.00	T	
MBPAB	F	15154A	00D10	INSPECT FLAP	DS	1.00	N	1.00	E	
MBPAB	F	15154A	00J10	MFG MISC PARTS	FS	1.00	N	13.00	E	

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

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

?MBPAB15188A

RCC	FAC	PROD	NO	OPER	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPAB	F	15188A	00B10	REPAIR WING FLAP OTBD.	DS	1.00	E	119.73	W	
MBPAB	F	15188A	00B20	REPAIR FOREFLAP	DS	1.00	N	15.00	T	
MBPAB	F	15188A	00D10	INSPECT FLAP	DS	1.00	N	1.00	E	
MBPAB	F	15188A	00J10	MFG MISC PARTS	FS	1.00	N	13.00	E	
MBPAB	F	15188A	00K10	707 CONVERSION	DS	1.00	N	42.00	E	
MBPAB	F	15188A	00R10	EDS CLEANUP	DS	1.00	N	3.17	E	

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

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

?MBPAB15189A

RCC	FAC	PROD	NO	OPER	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPAB	F	15189A	00B10	REPAIR WING FLAP OTBD.	DS	1.00	E	119.73	W	
MBPAB	F	15189A	00B20	REPAIR FOREFLAP	DS	1.00	N	15.00	T	
MBPAB	F	15189A	00D10	INSPECT FLAP	DS	1.00	N	1.00	E	
MBPAB	F	15189A	00J10	MFG MISC PARTS	FS	1.00	N	13.00	E	
MBPAB	F	15189A	00K10	707 CONVERSION	DS	1.00	N	42.00	E	
MBPAB	F	15189A	00R10	EDS CLEANUP	DS	1.00	N	3.17	E	

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

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

T

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?15153A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15153A 00810 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15153A 00820 REPAIR FORE FLAP DS 1.00 N 15.00 T
MBPCA B 15153A 00C10 STRIP & WASH WL 1.00 N 8.91 E
MBPCB D 15153A 00C20 PAINT & FINAL WASH B3 1.00 N 4.05 E
MBPCD B 15153A 00C30 UNCRATE CQ 1.00 N 1.53 E
MBPAB F 15153A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15153A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
MQCIA 1 15153A CIX10 5-87851-145 OB FLAP 506N AI 1.00 N .87 E

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

```

?15154A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15154A 00810 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15154A 00820 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPCA B 15154A 00C10 STRIP & WASH WL 1.00 N 8.00 E
MBPCB D 15154A 00C20 PRIME & PAINT B3 1.00 N 3.06 E
MBPCD B 15154A 00C30 UNCRATE CQ 1.00 N 1.53 E
MBPAB F 15154A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15154A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
MQCIA 1 15154A CIX10 5-87851-146 OB FLAP 506N AI 1.00 N .87 E

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

```

?15188A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15188A 00810 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15188A 00820 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPCA B 15188A 00C10 STRIP & WASH WL 1.00 N 8.91 E
MBPCB D 15188A 00C20 PAINT & FINAL WASH B3 1.00 N 4.05 E
MBPCD B 15188A 00C30 UNCRATE CQ 1.00 N 1.53 E
MBPAB F 15188A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAE A 15188A 00F10 MOVE END ITEMS CQ 1.00 N 1.10 E
MBPAB F 15188A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
MBPAB F 15188A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPCB D 15188A 00P10 OPERATE TOOL CRIB B3 1.00 N .45 E
MBPAB F 15188A 00R10 EDS CLEANUP DS 1.00 N 3.17 E
MBPAB F 15188A 00S15 MIC POOL CQ 1.00 N 1.42 E
MBPAE A 15188A 00T10 OPERATE TOOL CRIB DQ 1.00 N 1.10 E
MBPCA B 15188A 00X10 OPERATE TOOL CRIB WL 1.00 N .62 E
MBPCB D 15188A 00Y10 EDS CLEANUP WL 1.00 N .61 E
MBPCD B 15188A 00Z10 EDS CLEANUP B3 1.00 N .61 E
MQCIA 1 15188A CIX10 5-87851-155 OB FLAP 506N AI 1.00 N .43 E

```

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

COMMAND- 15025A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH  
 MBPCA B 15025A SIDE COM LHM C-135 AB 1.00 E 150.33 M  
 MBPCB D 15025A SIDE COM LH PRIME/PT WL 1.00 N 13.19 T  
 MBPCD B 15025A UNCRATE NOSE COM L/H B3 1.00 N 6.60 E  
 MBPCE A 15025A UNCRATE NOSE COM L/H CQ 1.00 N .64 E  
 MBPFE A 15025A MOVE END ITEM AB 1.00 N 1.20 E  
 MBPFA 15025A MOVE END ITEM CQ 1.00 N 1.17 E  
 MBPFB 15025A OPERATE TOOL CRIB FB 1.00 N 8.00 E  
 MBPFC D 15025A OPERATE TOOL CRIB B3 1.00 N .48 E  
 MBPFD F 15025A MIC POOL AB 1.00 N 3.96 E  
 MBPFE A 15025A OPERATE TOOL CRIB CQ 1.00 N 1.17 E  
 MBPFA 15025A OPERATE TOOL CRIB DQ 1.00 N .66 E  
 MBPCA B 15025A EDS CLEANUP WL 1.00 N .76 E  
 MBPCB D 15025A EDS CLEANUP B3 1.00 N .76 E  
 MBPCD 9 15025A EDS CLEANUP CQ 1.00 N .54 E  
 MBPBA 6 15025A HEAT TREAT B0BN AK 1.00 N .20 E  
 MBPBB 6 15025A RIVETS P/N M820470 B11N AK 1.00 N .12 E  
 MBPBB 3 15025A C135/E3A MISTR BACKSHOP O11N CR 1.00 N .17 E  
 MBPCA B 15025A BLAST COML O11N WL 1.00 N 3.12 E  
 MBPFB 6 15025A 35-32371-1 PANEL 15025A 601N AM 1.00 N .29 E  
 MBPFA 6 15025A 5-85637-62 FIRE SEAL FRAME AM 1.00 N .50 E  
 MBPFB 6 15025A 5-85637-38 FIRE SEAL FRAME AM 1.00 N .50 E

DOB10 REPAIR  
 00 C10 WASH/STRIP  
 00 C30 PAINT  
 00 C50 REC/UNCRATE  
 00 D10 SHC/N/INSP.  
 SAYN30 ABRASIVE BLAST

(150.33/2) + 13.19 + 6.6 + .64 + 1.2 + 3.12  
 75.17+  
 99.915

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715113A

MBPCA B 15113A 00B10, PANEL, BAKING TRAY C. 135 AB 1.00 E 442.74 M  
 MBPCB D 15113A 00C10 SIDE COML C-135 WL 1.00 N 12.73 E  
 MBPCD B 15113A 00C30 PAINT SIDE COML KC135 B3 1.00 N 6.60 E  
 MBPCD 8 15113A 00C40 FINAL WASH B3 1.00 N .70 E  
 MBPFA 15113A 00C50 UNCRATE SIDE COML CQ 1.00 N .75 E  
 MBPFB 15113A 00D10 SHAKEDOWN/INSPECTION B3 1.00 N 1.22 E  
 MBPFC A 15113A 00F10 MOVE END ITEM CQ 1.00 N 1.12 E  
 MBPFD 15113A 00J10 SIDE COML L/H FB 1.00 N 8.00 E  
 MBPFE D 15113A 00P10 OPERATE TOOL CRIB B3 1.00 N .45 E  
 MBPFB 15113A 00R10 EDS CLEANUP BA B0BN AK 1.00 N 3.76 E  
 MBPFA 15113A 00S15 MIC POOL CQ 1.00 N 1.69 E  
 MBPAE A 15113A 00T10 OPERATE TOOL CRIB DQ 1.00 N 1.12 E  
 MBPCA B 15113A 00M10 OPERATE TOOL CRIB WL 1.00 N .63 E  
 MBPCA 8 15113A 00X10 EDS CLEANUP WL 1.00 N .73 E  
 MBPCB D 15113A 00Y10 EDS CLEANUP B3 1.00 N .73 E  
 MBPCD 9 15113A 00Z10 EDS CLEANUP CQ 1.00 N .51 E  
 MBPBA 6 15113A HCM10 C135/E3A B0BN AK 1.00 N .20 E  
 MBPBB 6 15113A HCM20 RIVETS P/N M820426 B11N AK 1.00 N .12 E  
 MBPBB 3 15113A PCM10 C135/E3A MISTR BACKSHOP O11N CR 1.00 N .17 E  
 MBPCA B 15113A SAM30 BLAST COML KC-135 O11N WL 1.00 N 3.17 E  
 MBPFB 6 15113A MTP10 772-7042-10 PANEL 15113A601N AM 1.00 N .73 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715119A

MBPBA F 15119A 00B10 REPAIR DOOR ASSY NLR FB 1.00 E 83.40 M  
 MBPCA B 15119A 00C10 STRIP AND WASH DOOR O03N WL 1.00 N 3.69 E  
 MBPCB'D 15119A 00C20 PAINT DOOR ASSY J247 B3 1.00 N 10.00 E

MB	PROD	NO	OPER	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPCB B	15119A	00C10	STRIP AND WASH DOOR	003N WL	1.00	N	3.59	E	
MBPCB D	15119A	00C20	PAINT DOOR ASSY	J247 B3	1.00	N	10.00	E	
MBPCB E	15119A	00C50	UNCRATE DOOR ASSY	003N CQ	1.00	N	.37	E	
MBPCB F	15119A	00B10	INSPECT DOOR ASSY	003N F8	1.00	N	3.08	E	
MBPCB G	15119A	00B10	EDS CLEANUP	003N F8	1.00	N	3.28	E	
MBPCB H	15119A	00B15	MIC POOL	CQ	1.00	N	1.47	E	
MBPCB A	15119A	00X10	EDS CLEANUP	WL	1.00	N	.63	E	
MBPCB B	15119A	00X10	EDS CLEANUP	B3	1.00	N	.63	E	
MBPCB C	15119A	00Y10	EDS CLEANUP	B3	1.00	N	.63	E	
MBPCB D	15119A	00Z10	EDS CLEANUP	CQ	1.00	N	.45	E	

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'

715321A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCB A	15321A	00C10	WASH DOOR ASSY	111N WL	1.00	N	84.21	E	
MBPCB B	15321A	00C20	PAINT DOOR ASSY	111N B3	1.00	N	4.14	E	
MBPCB C	15321A	00C50	UNCRATE DOOR ASSY	111N B3	1.00	N	10.00	E	
MBPCB D	15321A	00C50	UNCRATE DOOR ASSY	CQ	1.00	N	.41	E	
MBPCB E	15321A	00F10	MOVE PARTS	111N F8	1.00	N	2.73	E	
MBPCB F	15321A	00F10	TOOL CRIB ATTENDANT	CQ	1.00	N	.92	E	
MBPCB G	15321A	00F10	TOOL CRIB ATTENDANT	B3	1.00	N	.37	E	
MBPCB H	15321A	00B15	MIC POOL	111N F8	1.00	N	3.28	E	
MBPCB A	15321A	00B15	MIC POOL	CQ	1.00	N	1.47	E	
MBPCB B	15321A	00T10	TOOL CRIB ATTENDANT	DQ	1.00	N	.92	E	
MBPCB C	15321A	00M10	TOOL CRIB ATTENDANT	WL	1.00	N	.52	E	
MBPCB D	15321A	00X10	EDS CLEANUP	WL	1.00	N	.63	E	
MBPCB E	15321A	00Y10	EDS CLEANUP	B3	1.00	N	.63	E	
MBPCB F	15321A	00Z10	EDS CLEANUP	CQ	1.00	N	.45	E	

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'

715136A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCB A	15136A	00B10	STRIP/WASH AILERON	ES	1.00	N	76.34	E	
MBPCB B	15136A	00C10	STRIP/WASH AILERON	WL	1.00	N	6.00	E	
MBPCB C	15136A	00C20	PRIME & PAINT AILERON	B3	1.00	N	2.64	E	
MBPCB D	15136A	00C50	UNCRATE AILERON	CQ	1.00	N	1.32	E	
MBPCB E	15136A	00B10	STRIP/WASH AILERON	ES	1.00	N	.90	E	
MBPCB A	15136A	00F10	MOVE PARTS	CQ	1.00	N	.57	E	
MBPCB B	15136A	00F10	TOOL CRIB ATTENDANT	B3	1.00	N	.23	E	
MBPCB C	15136A	00B10	STRIP/WASH AILERON	ES	1.00	N	1.94	E	
MBPCB D	15136A	00B15	MIC POOL	CQ	1.00	N	.87	E	
MBPCB A	15136A	00T10	TOOL CRIB ATTENDANT	DQ	1.00	N	.57	E	
MBPCB B	15136A	00M10	TOOL CRIB ATTENDANT	WL	1.00	N	.32	E	
MBPCB C	15136A	00X10	EDS CLEANUP	WL	1.00	N	.37	E	
MBPCB D	15136A	00Y10	EDS CLEANUP	B3	1.00	N	.37	E	
MBPCB E	15136A	00Z10	EDS CLEANUP	CQ	1.00	N	.26	E	
MBPCB F	15136A	TCZ10	5-86072-169 AILERON	105N BJ	1.00	N	9.30	E	

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'

715137A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCB A	15137A	00B10	STRIP/WASH AILERON	ES	1.00	N	76.34	E	
MBPCB B	15137A	00C10	WASH/STRIP AILERON	WL	1.00	N	6.00	E	
MBPCB C	15137A	00C20	PRIME & PAINT AILERON	B3	1.00	N	2.64	E	
MBPCB D	15137A	00C50	UNCRATE AILERON	CQ	1.00	N	1.32	E	
MBPCB E	15137A	00B10	STRIP/WASH AILERON	ES	1.00	N	.90	E	
MBPCB A	15137A	00F10	MOVE PARTS	CQ	1.00	N	.57	E	
MBPCB B	15137A	00F10	TOOL CRIB ATTENDANT	B3	1.00	N	.23	E	
MBPCB C	15137A	00B10	STRIP/WASH AILERON	ES	1.00	N	1.94	E	
MBPCB D	15137A	00B15	MIC POOL	CQ	1.00	N	.87	E	
MBPCB E	15137A	00T10	TOOL CRIB ATTENDANT	DQ	1.00	N	.57	E	
MBPCB F	15137A	00M10	TOOL CRIB ATTENDANT	WL	1.00	N	.32	E	
MBPCB G	15137A	00X10	EDS CLEANUP	WL	1.00	N	.37	E	
MBPCB H	15137A	00Y10	EDS CLEANUP	B3	1.00	N	.37	E	
MBPCB I	15137A	00Z10	EDS CLEANUP	CQ	1.00	N	.26	E	
MBPCB J	15137A	TCZ10	5-86072-169 AILERON	105N BJ	1.00	N	9.30	E	

MBF	15137A	00P10	TOOL	CHISEL	ATTEND	ES	1.00	N	1.94	E
MBPCB F	15137A	00R10	EDS	CLEANUP	EQ	1.00	N	.87	E	
MBSCM A	15137A	00B15	MIC	POOL	DQ	1.00	N	.57	E	
MBPAE A	15137A	00T10	TOOL	CRIB	WL	1.00	N	.32	E	
MBPCA B	15137A	00M10	TOOL	CRIB	WL	1.00	N	.37	E	
MBPCB B	15137A	00X10	EDS	CLEANUP	B3	1.00	N	.37	E	
MBPCB D	15137A	00Y10	EDS	CLEANUP	B3	1.00	N	.26	E	
MBPCD 9	15137A	00Z10	EDS	CLEANUP	CQ	1.00	N	.75	E	
HTPIM 1	15137A	MCZ10	69-1353-6	PPOR 35A006	610N	AJ	1.00	N	9.30	E
HTPII 1	15137A	TCZ10	5-86072-170	AILERON	105N	BJ	1.00	N		E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715140A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B	15140A	00B10	WASH	STRIP	NOSE	COML	312E	WL	1.00	N	49.80	W
MBPCB D	15140A	00C20	FINAL	WASH	PAINT	FAIRING	004N	WL	1.00	N	1.35	E
MBPCD B	15140A	00C50	UNCRATE	FAIRING			004N	CQ	1.00	N	.54	E
MBPAE A	15140A	00F10	MOVE	PARTS			012N	FB	1.00	N	.80	E
MBPCB D	15140A	00R10	TOOL	CRIB	ATTENDANT		004N	FB	1.00	N	7.04	E
MBPCB F	15140A	00R10	EDS	CLEANUP			B3	1.00	N	.14	E	
MBSCM A	15140A	00S15	MIC	POOL			CQ	1.00	N	1.05	E	
MBPAE A	15140A	00T10	TOOL	CRIB	ATTENDANT		DQ	1.00	N	.35	E	
MBPCA B	15140A	00W10	TOOL	CRIB	ATTENDANT		WL	1.00	N	.02	E	
MBPCA 9	15140A	00X10	EDS	CLEANUP			WL	1.00	N	.20	E	
MBPCB D	15140A	00Y10	EDS	CLEANUP			B3	1.00	N	.20	E	
MBPCD 9	15140A	00Z10	EDS	CLEANUP			CQ	1.00	N	.14	E	

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715150A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B	15150A	00C10	WASH	STRIP	NOSE	COML	312E	WL	1.00	N	82.09	W
MBPCB D	15150A	00C40	F/WASH	NOSE	COML		401E	B3	1.00	N	1.25	E
MBPCD B	15150A	00C50	UNCRATE	NOSE	COML		401N	CQ	1.00	N	.29	T
MBPAE A	15150A	00F10	MOVE	END	ITEM		012N	FB	1.00	N	1.14	E
MBPCA B	15150A	00W10	TOOL	CRIB	ATTENDANT		004M	FB	1.00	N	7.20	E
MBPCB D	15150A	00Y10	EDS	CLEANUP			B3	1.00	N	.28	E	
MBPCD 9	15150A	00Z10	EDS	CLEANUP			CQ	1.00	N	1.92	E	
MBSCM A	15150A	00B15	MIC	POOL			CQ	1.00	N	.86	E	
MBPAE A	15150A	00T10	OPERATE	TOOL	CRIB		DQ	1.00	N	.70	E	
MBPCA B	15150A	00M10	OPERATE	TOOL	CRIB		WL	1.00	N	.39	E	
MBPCA 8	15150A	00X10	EDS	CLEANUP			WL	1.00	N	.37	E	
MBPCB D	15150A	00Y10	EDS	CLEANUP			B3	1.00	N	.37	E	
MBPCD 9	15150A	00Z10	EDS	CLEANUP			CQ	1.00	N	.26	E	
MQCIA 1	15150A	C1X10	5-85635-150	NOSE	COML		506N	AI	1.00	N	.83	E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715175A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAA 6	15175A	00A20	REPR	135	BOOM	TAIL	CONE	AE	1.00	N	12.14	E
MBPAB 6	15175A	00B10	REPAIR	BOOM	TAIL	CONE	FB	1.00	E	70.18	W	
MBPCA B	15175A	00C10	STRIP	WASH	BOOM	CONE	0197	WL	1.00	N	4.00	E
MBPCB D	15175A	00C20	FIN	WASH	PAINT		0197	B3	1.00	N	3.40	E
MBPCD 8	15175A	00C50	UNCRATE	BOOM	TAIL	CONE	0197	CQ	1.00	N	1.11	E

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MBF 3 15175A 00C50 UNCRATE ROOM TAILCONE 0197 CQ 1.00 1.11 E
MBPAB A 15175A 00D10 SHAKEDOWN FB 1.00 .67 E
MBPAB A 15175A 00F10 MOVE PARTS CQ 1.00 .67 E
MBPAB B 15175A 00J10 MFG OIL COOLER FB 1.00 1.00 E
MBPCB D 15175A 00J10 MFG CRIB ATTENDANT B3 1.00 .28 E
MTPAB 4 15175A 00G10 CYLINDER ASSY S-96715-5 DH 1.00 4.00 E
MBPAB A 15175A 00S15 MIC POOL FB 1.00 1.01 E
MBPAB A 15175A 00S15 MIC POOL CQ 1.00 1.35 E
MBPAB A 15175A 00T30 CHECK, TEST & PURGE SYS M257 DQ 1.00 .67 E
MBPCA B 15175A 00M10 TOOL CRIB ATTENDANT WL 1.00 4.00 E
MBPCA B 15175A 00Y10 EDS CLEANUP WL 1.00 .38 E
MBPCB D 15175A 00Y10 EDS CLEANUP B3 1.00 .58 E
MBPCD 9 15175A 00Z10 EDS CLEANUP CQ 1.00 .41 E
MTPAB 3 15175A ACV10 S-96715-1 RMV SCREWS CM 1.00 .15 E

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

715178A

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RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
715178A
MBPAB F 15178A 00B10 REPAIR OIL COOLER FS 1.00 E 17.94 M
MBPCA B 15178A 00C10 STRIP/WASH OIL COOLER WL 1.00 N 1.03 E
MBPCB D 15178A 00C20 FIN WASH/PAINT B3 1.00 N 1.24 E
MBPCD 8 15178A 00C50 UNCRATE CQ 1.00 N .44 E
MBPAB F 15178A 00D10 SHAKEDOWN FB 1.00 .56 E
MBPAB F 15178A 00J10 MFG PRTS SUPP O/C COOLER CQ 1.00 N .26 E
MBPCA B 15178A 00O10 OPERATE TOOL CRIB FS 1.00 N 4.99 E
MBPCA B 15178A 00R10 EDS CLEANUP B3 1.00 N .11 E
MBPCA B 15178A 00S15 MIC POOL FS 1.00 N .47 E
MBPCA B 15178A 00T10 OPERATE TOOL CRIB CQ 1.00 N .21 E
MBPCA B 15178A 00W10 OPERATE TOOL CRIB WL 1.00 N .26 E
DOX10 EDS CLEANUP WL 1.00 N .09 E
MBPCB D 15178A 00Y10 EDS CLEANUP WL 1.00 N .06 E
MBPCA B 15178A SAMS ABRASIVE E
601N AW 1.00 N .44 E

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

715178A

15178A  
 RECORD NOT FOUND \15178

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

715178A

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RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
715178A
MBPAB F 15178A 00B10 REPAIR OIL COOLER FS 1.00 E 17.94 M
MBPCA B 15178A 00C10 STRIP/WASH OIL COOLER WL 1.00 N 1.03 E
MBPCB D 15178A 00C20 FIN WASH/PAINT B3 1.00 N 1.24 E
MBPCD 8 15178A 00C50 UNCRATE CQ 1.00 N .44 E
MBPAB F 15178A 00D10 SHAKEDOWN FB 1.00 .56 E
MBPAB F 15178A 00J10 MFG PRTS SUPP O/C COOLER CQ 1.00 N .26 E
MBPCA B 15178A 00O10 OPERATE TOOL CRIB FS 1.00 N 4.99 E
MBPCA B 15178A 00R10 EDS CLEANUP B3 1.00 N .11 E
MBPCA B 15178A 00S15 MIC POOL FS 1.00 N .47 E
MBPCA B 15178A 00T10 OPERATE TOOL CRIB WL 1.00 N .26 E

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B 15178A 00W10 OPERATE TOOL CRIB WL 1.00 N .14 E  
 MBPCA B 15178A 00X10 EDS CLEANUP WL 1.00 N .09 E  
 MBPCB D 15178A 00Y10 EDS CLEANUP B3 1.00 N .09 E  
 MBPCD 9 15178A 00Z10 EDS CLEANUP CQ 1.00 N .06 E  
 MBPCA B 15178A 5AW30 ABRASIVE BLAST OIL COOLER TA WL 1.00 N .40 E  
 MTPIN 6 15178A W0Z11 50-2458-41 COOLE 35A002 60IN AW 1.00 N .44 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

?15153A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B 15153A 00B10 REPAIR MAIN FLAP CRIB DB 1.00 E 119.73 M  
 MBPCB D 15153A 00C20 PAINT & FINAL WASH DB 1.00 N 15.00 N  
 MBPCD 8 15153A 00C50 UNCRATE WL 1.00 N 8.91 E  
 MBPCA B 15153A 00C20 PAINT & FINAL WASH B3 1.00 N 4.05 E  
 MBPCD 8 15153A 00C50 UNCRATE CQ 1.00 N 1.53 E  
 MBPCA I 15153A C1X10 5-87851-145 OB FLAP 506N AI 1.00 N .87 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

?15188A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B 15188A 00C10 STRIP & WASH WL 1.00 N 8.91 E  
 MBPCB D 15188A 00C20 PAINT & FINAL WASH B3 1.00 N 4.05 E  
 MBPCD 8 15188A 00C50 UNCRATE CQ 1.00 N 1.53 E  
 MBPAE A 15188A 00F10 MOVE END ITEMS CQ 1.00 N 1.10 E  
 MBPAB F 15188A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E  
 MBPAB F 15188A 00K10 707 CONVERSION DS 1.00 N 42.00 E  
 MBPCD D 15188A 00P10 OPERATE TOOL CRIB B3 1.00 N .45 E  
 MBSCM A 15188A 00S15 MIC POOL CQ 1.00 N 8.45 E  
 MBPAE A 15188A 00T10 OPERATE TOOL CRIB DQ 1.00 N 1.42 E  
 MBPCA B 15188A 00W10 OPERATE TOOL CRIB WL 1.00 N 1.10 E  
 MBPCA B 15188A 00X10 EDS CLEANUP WL 1.00 N .62 E  
 MBPCD 9 15188A 00Y10 EDS CLEANUP B3 1.00 N .61 E  
 MBPCD 9 15188A 00Z10 EDS CLEANUP CQ 1.00 N .43 E  
 MBPCA I 15188A C1X10 5-87851-155 OB FLAP 506N AI 1.00 N .87 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
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?15189A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B 15189A 00C10 STRIP & WASH WL 1.00 N 8.91 E  
 MBPCB D 15189A 00C20 PAINT & FINAL WASH B3 1.00 N 4.05 E  
 MBPCD 8 15189A 00C50 UNCRATE CQ 1.00 N 1.53 E  
 MBPAE A 15189A 00F10 MOVE END ITEMS CQ 1.00 N 1.10 E  
 MBPAB F 15189A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E  
 MBPAB F 15189A 00K10 707 CONVERSION DS 1.00 N 42.00 E  
 MBPCD D 15189A 00P10 OPERATE TOOL CRIB B3 1.00 N .45 E  
 MBSCM A 15189A 00S15 MIC POOL CQ 1.00 N 8.45 E  
 MBPAE A 15189A 00T10 OPERATE TOOL CRIB DQ 1.00 N 1.42 E  
 MBPCA B 15189A 00W10 OPERATE TOOL CRIB WL 1.00 N .62 E

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M. 151898 00M10 OPERATE TOOL CRIB WL 1.00 N .62 E
MBPCA B 15189A 00X10 EDS CLEANUP WL 1.00 N .61 E
MBPCB D 15189A 00Y10 EDS CLEANUP B3 1.00 N .61 E
MBPCD 9 15189A 00Z10 EDS CLEANUP CQ 1.00 N .43 E
MQCIA 1 15189A CIX10 5-87851-156 OB FLAP 506N AI 1.00 N .87 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'

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?15154A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

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MBPCA B 15154A 00C10 STRIP & WASH WL 1.00 N 118.72 E
MBPCB D 15154A 00C20 PRIME & PAINT WL 1.00 N 15.00 E
MBPCD 8 15154A 00C30 UNCRATE B3 1.00 N 8.00 E
MBPCD 9 15154A 00C40 UNCRATE CQ 1.00 N 3.06 E
MQCIA 1 15154A CIX10 3-87851-146 OB FLAP 506N AI 1.00 N 13.60 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'

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?15151A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

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MBPCA B 15151A 00C10 STRIP & WASH WL 1.00 N 117.72 E
MBPCB D 15151A 00C20 PRIME & PAINT WL 1.00 N 9.90 T
MBPCD 8 15151A 00C30 UNCRATE B3 1.00 N 3.06 E
MBPCD 9 15151A 00C40 UNCRATE CQ 1.00 N 1.53 E
MQCIA 1 15151A CIX10 5-86892-119 FLAP IB 506N AI 1.00 N 1.00 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'

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?15191AS
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

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MBPCA B 15191A 00C10 STRIP & WASH WL 1.00 N 117.72 E
MBPCB D 15191A 00C20 PAINT & FINAL WASH WL 1.00 N 15.00 E
MBPCD 8 15191A 00C30 UNCRATE B3 1.00 N 8.91 E
MBPCD 9 15191A 00C40 UNCRATE CQ 1.00 N 4.05 E
MBPAE A 15191A 00F10 MOVE END ITEMS CQ 1.00 N 1.00 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'

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?15192A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

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MBPCA B 15192A 00C10 OPERATE TOOL CRIB WL 1.00 N 1.40 E
MBPCB D 15192A 00C20 OPERATE TOOL CRIB WL 1.00 N 1.16 E
MBPCD 8 15192A 00C30 EDS CLEANUP WL 1.00 N .65 E
MBPCD 9 15192A 00C40 EDS CLEANUP WL 1.00 N .60 E
MQCIA 1 15192A CIX10 5-86892-129 FLAP IB 506N AI 1.00 N .43 E
MTPIT 1 15192A TCZ10 9-62569-2&4 TRK KC-135 210N BJ 1.00 N .87 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'

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RCC   C PROD NO OPER   DESCRIPTION-----> SK   OCC   T/S   HOURS   TECH
MBPAB E 15192A 00810 REPAIR WING FLAP INRD 1.00 E 117.72 M
MBPCA B 15192A 00C10 STRIP & WASH ML 1.00 N 8.91 E
MBPCB D 15192A 00C20 PAINT & FINAL WASH B3 1.00 N 4.05 E
MBPCD B 15192A 00C50 UNCRATE CG 1.00 N 1.53 E
MBPAB F 15192A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAE A 15192A 00S10 MOVE END ITEMS CQ 1.00 N 1.16 E
MBPCA D 15192A 00P10 OPERATE TOOL CRIB B3 1.00 N .47 E
MBPCA A 15192A 00S15 MIC POOL CQ 1.00 N 1.40 E
MBPCA B 15192A 00M10 OPERATE TOOL CRIB DQ 1.00 N 1.16 E
MBPCA C 15192A 00X10 EDS CLEANUP WL 1.00 N .65 E
MBPCA D 15192A 00Y10 EDS CLEANUP B3 1.00 N .60 E
MBPCD 9 15192A 00Z10 EDS CLEANUP CQ 1.00 N .43 E
MQCIA 1 15192A CIX10 5-86892-130 FLAP IB 506N AI 1.00 N .87 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'
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?15152A

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RCC   FAC PROD NO OPER   DESCRIPTION-----> SK   OCC   T/S   HOURS   TECH
MBPAB E 15192A 00810 REPAIR WING FLAP INRD 1.00 E 117.72 M
MBPCA B 15192A 00C10 STRIP & WASH ML 1.00 N 8.91 E
MBPCB D 15192A 00C20 PRIME & PAINT B3 1.00 N 3.06 E
MBPCD B 15192A 00C50 UNCRATE CG 1.00 N 1.53 E
MBPAB F 15192A 00D10 INSPECT DS 1.00 N .51 E
MQCIA 1 15192A CIX10 5-86892-120 RH IB FLAP 506N AI 1.00 N .87 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'
<----->
?15236A

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RCC   FAC PROD NO OPER   DESCRIPTION-----> SK   OCC   T/S   HOURS   TECH
MBPAB E 15237A 00810 REPAIR WING FLAP INRD 1.00 E 117.09 M
MBPCA B 15236A 00C10 STRIP/WASH/ANODIZE ML 1.00 N 9.00 E
MBPCD B 15236A 00C20 FIN WASH/PNT SLEEVE B3 1.00 N 4.25 E
MBPAB F 15236A 00R10 UNCRATE SLEEVE CG 1.00 N 2.00 E
MBPCM A 15236A 00S10 EDS CLEANUP FS 1.00 N 4.50 E
MBPCA B 15236A 00X10 EDS CLEANUP CQ 1.00 N 2.02 E
MBPCD D 15236A 00Y10 EDS CLEANUP WL 1.00 N .87 E
MBPCD 9 15236A 00Z10 EDS CLEANUP B3 1.00 N .61 E
MTPIA C 15236A ACZ10 65-10526 LINK ASSY 35A045 AI 1.00 N .06 E
MQCIA 1 15236A CIX10 65-10505-269 BLEEVE AY 004N WL 1.00 N 3.00 E
MTPIT 1 15236A SAM30 65-10505-269 SLV ASSY 004N WL 1.00 N 4.68 E
MTPIW 6 15236A TCZ10 65-10526 LINK ASSY 35A045 BJ 1.00 N .13 E
MTPIW 6 15236A WCZ10 65-10505-269 135 AFT THR SLE AW 1.00 N 1.50 E
MTPIW 6 15236A WCZ11 65-10505-5 HAT RING SECTION AW 1.00 N .63 E
MTPIW 6 15236A WCZ12 65-10505-122 HAT RING SECT AW 1.00 N .63 E

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ENTER DATA AS NEEDED
PROD ...ELSE 'END'
<----->
?15237A

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RCC   FAC PROD NO OPER   DESCRIPTION-----> SK   OCC   T/S   HOURS   TECH
MBPAB F 15237A 00B10 REPAIR FAIRING AET 1.00 N 1.50 E

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MB J F 15237A 00B10 REPAIR FAIRING AFT 004N FS 1.00 1 1.00 1.00 1.00 1.00
MBPCA B 15237A 00C10 WASH&STRIP,FAIRING AFT 004N WL 1.00 N 1.00 1.00 1.00 1.00
MBPCB D 15237A 00C20 FINAL WASH&PAINT FRNG AF004N B3 1.00 N 1.00 1.00 1.00 1.00
MBPCD B 15237A 00C50 UNCRATE FAIRING AFT 004N CQ 1.00 N .40 1.00 1.00 1.00 1.00
MBPAE A 15237A 00F10 UNCRATE FAIRING AFT 004N FS 1.00 N .60 1.00 1.00 1.00 1.00
MBPCB D 15237A 00C50 UNCRATE FAIRING AFT 004N B3 1.00 N 2.00 1.00 1.00 1.00 1.00

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'

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715249A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
-----
MBPCA B 15249A 00C10 STRIP & WASH AILERON K262 WL 1.00 N 107.16 M
MBPCB D 15249A 00C20 PRIME & PAINT AILERON K262 B3 1.00 N 10.00 E
MBPCD B 15249A 00C50 UNCRATE AILERON K262 CQ 1.00 N 5.04 E
MBPAE A 15249A 00F10 UNCRATE AILERON K262 FS 1.00 N 2.52 E
MBPCB D 15249A 00C50 UNCRATE AILERON K262 B3 1.00 N .84 E
MBPAE A 15249A 00F10 MOVE PARTS CQ 1.00 N .71 E
MBPCB D 15249A 00P00 TOOL CRIB ATTENDANT B3 1.00 N .29 E
MBPCA B 15249A 00C10 UNCRATE AILERON K262 WL 1.00 N 2.53 E
MBPCD B 15249A 00C50 UNCRATE AILERON K262 CQ 1.00 N 1.14 E
MBPAE A 15249A 00F10 UNCRATE AILERON K262 FS 1.00 N .71 E
MBPCB D 15249A 00C20 TOOL CRIB ATTENDANT B3 1.00 N .49 E
MBPCD B 15249A 00C50 UNCRATE AILERON K262 CQ 1.00 N .49 E
MBPCD B 15249A 00C50 UNCRATE AILERON K262 CQ 1.00 N .35 E
MTPIM 1 15249A MC210 6-83219-2 SUPPORT 35A003 AJ 1.00 N .79 E

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'

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715250A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
-----
MBPAB F 15250A 00B10 REPR AILERON OB ES 1.00 E 107.16 W
MBPCA B 15250A 00C10 STRIP & WASH AILERON K262 WL 1.00 N 10.00 E
MBPCB D 15250A 00C20 PRIME & PAINT AILERON K262 B3 1.00 N 5.04 E
MBPCD B 15250A 00C50 UNCRATE AILERON K262 CQ 1.00 N 2.52 E
MBPAB F 15250A 00D10 INSPECT AILERON K262 ES 1.00 N 1.30 E
MBPAE A 15250A 00F10 MOVE PARTS CQ 1.00 N .71 E
MBPCB D 15250A 00P10 TOOL CRIB ATTENDANT B3 1.00 N .40 E
MBPAB F 15250A 00R10 EDS CLEANUP ES 1.00 N 2.53 E
MBSCM A 15250A 00S15 MIC POOL CQ 1.00 N 1.14 E
MBPAE A 15250A 00T10 TOOL CRIB ATTENDANT DQ 1.00 N .71 E
MBPCA B 15250A 00W10 TOOL CRIB ATTENDANT WL 1.00 N .40 E
MBPCA B 15250A 00X10 EDS CLEANUP WL 1.00 N .49 E
MBPCB D 15250A 00Y10 EDS CLEANUP B3 1.00 N .49 E
MBPCD B 15250A 00Z10 EDS CLEANUP CQ 1.00 N .35 E
MTPIM 1 15250A MC210 6-83219-2 SUPPORT 35A003 AJ 1.00 N .79 E

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ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'

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715126A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
-----
MBPAB F 15126A 00B10 REPAIR DOOR ASSY MLG FS 1.00 E 82.59 W
MBPCA B 15126A 00C10 STRIP AND WASH DOOR 003N WL 1.00 N 3.45 E
MBPCB D 15126A 00C20 PAINT DOOR ASSY 003N B3 1.00 N 10.00 E
MBPCD B 15126A 00C50 UNCRATE DOOR ASSY 003N CQ 1.00 N .35 E
MBPAE A 15126A 00D10 INSPECT DOOR ASSY 003N FS 1.00 N 2.88 E
MBPCA B 15126A 00F10 MOVE PARTS CQ 1.00 N .92 E
MBPCB D 15126A 00P10 TOOL CRIB ATTENDANT B3 1.00 N .37 E
MBPCA B 15126A 00R10 EDS CLEANUP FS 1.00 N 3.26 E
MBSCM A 15126A 00S15 MIC POOL CQ 1.00 N 1.47 E
MBPAE A 15126A 00T10 TOOL CRIB ATTENDANT DQ 1.00 N .92 E
MBPCA B 15126A 00W10 TOOL CRIB ATTENDANT WL 1.00 N .52 E
MBPCD B 15126A 00Y10 EDS CLEANUP CQ 1.00 N .27 E

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JOB	DATE	TIME	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPCA B	15126A	00X10	EDS CLEANUP	WL	1.00	N	.63	E
MBPCB D	15126A	00Y10	EDS CLEANUP	B3	1.00	N	.63	E
MBPCD 9	15126A	00Z10	EDS CLEANUP	CQ	1.00	N	.45	E

RCC	FAC	PROD	NO	OPER	DESCRIPTION	SK	OCC	T/S	HOURS	TECH
MBPAB	F	15300A	00R10	REPAIR DOOR ASSY	M.L.	FS	1.00	E	92.30	W
MBPCA	B	15300A	00C10	STRIP & WASH DOOR ASSY	A340	WL	1.00	N	3.30	E
MBPCB	D	15300A	00C20	PAINT DOOR ASSY	A340	B3	1.00	N	10.00	E
MBPCD	B	15300A	00C50	UNCRATE DOOR ASSY	A340	CQ	1.00	N	.33	E
MBPAB	F	15300A	00D10	INSPECT DOOR ASSY	FS	FS	1.00	N	2.75	E
MBPAE	A	15300A	00F10	MOVE PARTS	CQ	CQ	1.00	N	.92	E
MBPCB	D	15300A	00F10	TOOL CRIB ATTENDANT	B3	B3	1.00	N	.37	E
MBPAB	F	15300A	00R10	EDS CLEANUP	FS	FS	1.00	N	3.26	E
MBSCM	A	15300A	00S15	MIC POOL	CQ	CQ	1.00	N	1.47	E
MBPAE	A	15300A	00T10	TOOL CRIB ATTENDANT	DQ	DQ	1.00	N	.92	E
MBPCA	B	15300A	00W10	TOOL CRIB ATTENDANT	WL	WL	1.00	N	.52	E
MBPCA	B	15300A	00X10	EDS CLEANUP	WL	WL	1.00	N	.63	E
MBPCB	D	15300A	00Y10	EDS CLEANUP	B3	B3	1.00	N	.63	E
MBPCD	9	15300A	00Z10	EDS CLEANUP	CQ	CQ	1.00	N	.45	E

ENTER DATA AS NEEDED

PROD ...ELSE 'END'

<----->

?15300A

RCC FAC PROD NO OPER

<-----DESCRIPTION-----> SK

ENTER DATA AS NEEDED

PROD ...ELSE 'END'

<----->

```

?MBPAB15151A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15151A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15151A 00B20 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15151A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15151A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><----->

```

```

?MBPAB15152A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15152A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15152A 00B20 REPAIR FOREFLAP DS 1.00 N 16.50 T
MBPAB F 15152A 00D10 INSPECT FLAP DS 1.00 N .51 E
MBPAB F 15152A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><----->

```

```

?MBPAB15191A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15191A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15191A 00B20 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15191A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAB F 15191A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E
MBPAB F 15191A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15191A 00R10 EOS CLEANUP DS 1.00 N 3.12 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><----->

```

```

?MBPAB15192A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15192A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15192A 00B20 REPAIR FORE FLAP DS 1.00 N 15.00 E
MBPAB F 15192A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAB F 15192A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E
MBPAB F 15192A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15192A 00R10 EOS CLEANUP DS 1.00 N 3.12 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><----->

```

INPUT AT

AS TO BE MADE

<u>URL#</u>	<u>FL#</u>	<u>INT#</u>	<u>URL#</u>	<u>FL#</u>	<u>INT#</u>
15132A	15136A	88205	15136A	15137A	88055
15132A	15136A	88205	15136A	15137A	88055
15154A	15158A	88059	15154A	"	" (same)
15154A	# 401	"	"	"	" (same)

only one word meant on the 13<sup>th</sup>.

(Sincerely, MAPPA's) embedded in the...  
 intended use of MAP by students. If found  
 this after searching for some secret series  
 there's no way to retrieve or edit info. How  
 only let me know so that you will be  
 able to ~~retrieve~~ ~~retrieve~~ ~~info~~. Hope  
 this doesn't cause a problem. ) I've

Found it nec. to use PRINTER.FIL to

—hope my last day's work to the original  
 disk.  
 Bye, PEGGY

ACC.	TOTAL	WCD #	PCN #	WCD DATE	TOTAL
	1	15025A	15025A	88054	1
	1	15113A	15113A	"	1
	39	15119A	15119A	88074	19
		"	"	88072	1
		"	15321A	88074	19
	2	15126A	15126A	"	1
		"	15300A	"	1
	28	15136A	15136A	87223	1
		"	"	88205	14
		"	"	88055	2
		"	15137A	"	1
		"	"	88205	10
		"	"	87223	1
	1	15137A	15137A	88205	1
	1	15140A	15140A	88067	1
	1	15150A	15150A	88054	1
	1	15151A	15191A	87198	1
	2	15153A	15188A	88055	1
		"	15189A	"	1
	3	15154A	"	87059	1
		"	15188A	88055	2
	23	15175A	15175A	88069	19
		"	"	88203	4
	1	15178A	15178A	88054	1
	11	15222A	15249A	87258	1
		"	15249A	88055	5
		"	15250A	87258	1
		"	"	88055	4
	1	15244A	15244A	88205	1
	1	15245A	15245A	88055	1
	11	15249A	15249A	"	4
		"	15250A	"	7
	33	15178A	15178A	88054	
	25	15151A	15192A		
	43	15152A	15191A		23
		"	15192A		20



DISK 1

OC15113A.DAT	15113A	88054
OC MABPAB.DAT	15113A	88054
	15119A	88074
OCMBPAB.DAT	15236A	88054
	15025A	88054
OCMBPBA.DAT	15025A	88054

DISK 2

OC MABPAB.DAT	15113A	88054
	15119A	88074

DISK 3

OC MABPAB.DAT	15119A	88074
---------------	--------	-------

+

4-19-88

9999

<u>WCD</u>	<u>PCN</u>	<u>LAST OP.</u>	<u>DATE COMP</u>
15151A	15192A	06-23-88	06-23-88
"	"	06-28	06-28
"	"	08-10	08-10
"	"	08-17	08-16 → 17 or 18
"	"	08-22	08-22
"	"	"	"
"	"	08-24	08-24
"	"	08-25	08-24
"	"	08-26	08-26
"	"	09-07	09-06
"	"	09-13	09-13
"	"	09-17	09-17
"	"	09-21	09-21
"	"	09-29	09-28
"	"	"	09-27
15152A	15192A	06-23-88	06-23-88
"	"	06-28	06-28
"	"	08-10	
"	"	08-17	08-17
"	"	08-22	08-22
"	"	"	"
"	"	08-24	08-24
"	"	08-26	08-26
"	"	09-06	09-07
"	"	09-13	09-13
"	"	09-17	09-17
"	"	09-21	09-21
"	"	09-29	09-29
"	"	09-27	"
15152A	15191A	06-28-88	06-28-88
"	"	08-10	
"	"	08-16	08-17
"	"	08-22	08-22
"	"	"	"
"	"	08-24	08-24
"	"	"	08-25
"	"	08-26	08-26

<u>WCD</u>	<u>ACN</u>	<u>LAST DP</u>	<u>DATE COMP</u>
15152A	15192A	09.06.88	09.07.88
"	"	09.13	09.13
"	"	09.21	09.21
"	"	09.27	09.29
"	"	09.29	09.29

4-18-88

15151A	15192A	07.18.88	07.18.88
"	"	07.25	07.26
"	"	01.11.89	01.11.89
"	"	01.30	01.30
"	"	01.31	01.31
"	"	02.09	02.09
"	"	02.15	02.16
"	"	03.13	03.14
"	"	03.24	03.27
"	"	04.04	03.30
- 15152A	15151A	07.18.88	07.18.88
"	"	07.25	07.26
"	"	01.11.89	01.11.89
"	"	01.30	01.30
"	"	01.31	
"	"	02.01	
"	"	02.09	
"	"	02.16	
"	"	03.24	
"	"	04.04	
15152A	15152A	07.18.88	07.18.88
"	"	07.25	07.26
"	"	01.11.89	
"	"	01.30.	01.30.89
"	"	01.31	
"	"	02.09	
"	"	03.24	

<u>WCD</u>	<u>PCN</u>	<u>LAST OP</u>	<u>DATE COMP</u>
15126A	15126A	10-19-88	10-20-88
"	"	10-25	10-26
"	"	10-28	10-28
"	"	10-02	11-03
"	"	11-07	11-07
"	"	11-14	11-14
"	"	11-18	11-18
"	"	11-22	11-25
"	"	11-28	11-28
"	"	11-28	11-28
"	"	11-30	11-29
"	"	12-05	12-05
"	"	12-07	12-07
"	"	12-09	12-09
"	"	12-13	12-13
"	"	12-15	12-15
"	"	12-28	12-28
"	"	12-29	12-29
"	"	12-30	12-30 (PAPERWORK LOST - NO DATES)
15126A	15300A	10-03-88	10-07-88 (CONDEMNED)
"	"	10-19	10-20
"	"	10-25	10-26
"	"	10-28	10-28
"	"	10-02	11-03
"	"	11-07	11-07
"	"	11-14	11-14
"	"	11-18	11-18
"	"	11-22	11-25
"	"	11-28	11-28
"	"	11-28	11-28
"	"	11-30	11-29
"	"	12-05	12-05
"	"	12-07	12-07
"	"	12-09	12-09
"	"	12-13	12-13
"	"	12-28	12-28
"	"	12-29	12-29
"	"	12-30	12-30

<u>WCA</u>	<u>PCN</u>	<u>LAST OP</u>	<u>DATE COMP</u>
15140A	15140A	12-01-88	12-01-88
"	"	12-05	12-05
"	"	"	"
"	"	12-07	12-07
"	"	"	"
"	"	12-09	12-09
"	"	12-13	12-13
"	"	"	"
"	"	12-15	12-15
"	"	"	"
"	"	12-16	12-16
"	"	12-19	12-20
"	"	12-22	12-23
"	"	12-23	12-23
"	"	"	"
"	"	12-28	12-29
"	"	12-28	"
"	"	"	12-28
"	"	12-16	12-15
"	"	"	"
"	"	"	"
15025A	15025A	09-21	09-21
"	"	09-27	09-27
"	"	09-27	09-27
"	"	09-27	09-27
"	"	09-27	09-29
"	"	09-30	09-30
"	"	10-03	10-03
"	"	"	"
"	"	"	"
"	"	"	"
"	"	"	"
"	"	01-12-89	01-12-89
"	"	01-18-	01-18
"	"	"	"
"	"	01-23	01-23
"	"	01-26	01-26

(PAPERWORK LOST - NO DATES)

<u>WCD</u>	<u>PCN</u>	<u>LAST OP</u>	<u>DATE COMP</u>
15025A	15025A	N-30-89	01-27-89
"	"	02-07	02-07
"	"	02-09	02-09
"	"	02-10	02-17
"	"	"	"
"	"	03-01	02-27
"	"	02-27	03-01
"	"	02-27	03-01
"	"	03-03	03-03
"	"	03-13	03-14
"	"	"	"
"	"	03-20	03-20
"	"	03-24	03-24
"	"	03-27	03-27
"	"	"	"
15150A	15150A	09-09-88	09-09-88
"	"	09-13	09-13
"	"	09-14	09-14
"	"	09-21	09-26
"	"	09-30	09-30
"	"	01-11-89	01-12-89
"	"	01-18	01-19
"	"	"	01-30 (CONDEMNED)
"	"	01-31	01-31
"	"	02-03	02-03
"	"	"	"
"	"	"	"
"	"	02-21	02-21
"	"	02-23	02-23
"	"	03-09	03-09
"	"	03-15	03-15
"	"	"	"
"	"	03-17	03-17
"	"	"	"
"	"	"	"
"	"	03-22	03-22
"	"	03-27	03-27
"	"	"	"

<u>WCD</u>	<u>PCN</u>	<u>LAST DP</u>	<u>DATE COMP</u>
15150A	15150A	03-28-89	03-27-89
"	"	"	"
"	"	03-29-	03-29
"	"	"	"
"	"	"	"
"	"	03-30	03-30
"	"	"	03-30
"	"	03-29	"
15113A	15113A		02-21-89 (CONDEMNED)
"	"	09-12-88	09-12-88
"	"	09-21-	09-21
"	"	09-22	09-22
"	"	09-29	09-29
"	"	10-01	10-03
"	"	01-13-89	01-12-89
"	"	"	"
"	"	01-20	01-20
"	"	01-23	01-23
"	"	"	"
"	"	01-26	01-26
"	"	01-30	01-27
"	"	02-07	02-07
"	"	"	"
"	"	02-08	02-08
"	"	02-09	02-09
"	"	02-21	02-21
"	"	03-01	03-01
"	"	03-13	03-14
"	"	"	"
"	"	"	"
"	"	"	"
"	"	03-16	03-16
"	"	03-21	03-21
"	"	"	"
"	"	03-24	03-24
"	"	"	"
"	"	03-27	03-27

<u>WCD</u>	<u>PCN</u>	<u>LAST OP</u>	<u>DATE CAMP</u>
15113A	15113A	03-31-89	03-30-89
"	"	"	"
15313A		01-19-89	01-19-89
15236A		12-20-88	12-20-88
"		"	12-20
"	15236A	01-20-89	01-20-89
"		02-02-89	02-02-89
"		02-22	02-22
"	"	02-24	03-01-
"		03-01	"
"		03-02	03-02
"		03-10	03-13
"		03-14	03-14
"		03-22	03-22
"		03-30	03-30
15178A	15178A	10-11-88	10-11-88
"	"	"	"
"	"	10-21-88	10-19-88
"	"	10-19.	"
"	"	"	"
"	"	11-14	11-14
"	"	"	11-14
"	"	"	"
"	"	11-15	11-15
"	"	"	"
"	"	11-29	11-29
"	"	"	"
"	"	"	"
"	"	12-13	12-13
"	"	12-15	12-15
"	"	12-16	12-16
"	"	"	"
"	"	12-22	12-22
"	"	12-23	12-23
"	"	12-28	12-27
"	"	01-06-89	01-06-89
"	"	"	"
"	"	01-09	01-09-



<u>WCD</u>	<u>PCN</u>	<u>LAST OP</u>	<u>DATE COMP</u>
15178A	15178A	01-09-89	01-09-89
"	"	01-11-	01-11-
"	"	01-19	01-19
"	"	01-20	01-24
"	"	02-03	02-03
"	"	02-13	02-15
"	"	02-21	02-21
"	"	"	"
"	"	02-22	02-22
"	"	03-03	03-03
15237A	15237A	12-28-88	12-27-88
"	"	12-01	12-01 (PAPERWORK LOST)

TOTALS -

- 15178A - 33
- 15237A - 2 → 4
- 15315A - 1
- 15236A - 12 → 6
- 15025A - 31 (1 CONDEMNED) → 27 + 9.
- 15150A - 31 (1 CONDEMNED) → 35
- 15113A - 31 (1 CONDEMNED) → 53.
- 15126A - 38 (2 - NO DATES) → 35
- 15140A - 21 (3 - NO DATES) → 18
- 15151A - 25
- 15152A - 44
- 15119A - → 25

178  
151  
152 ✓

237  
236 }

113. ✓

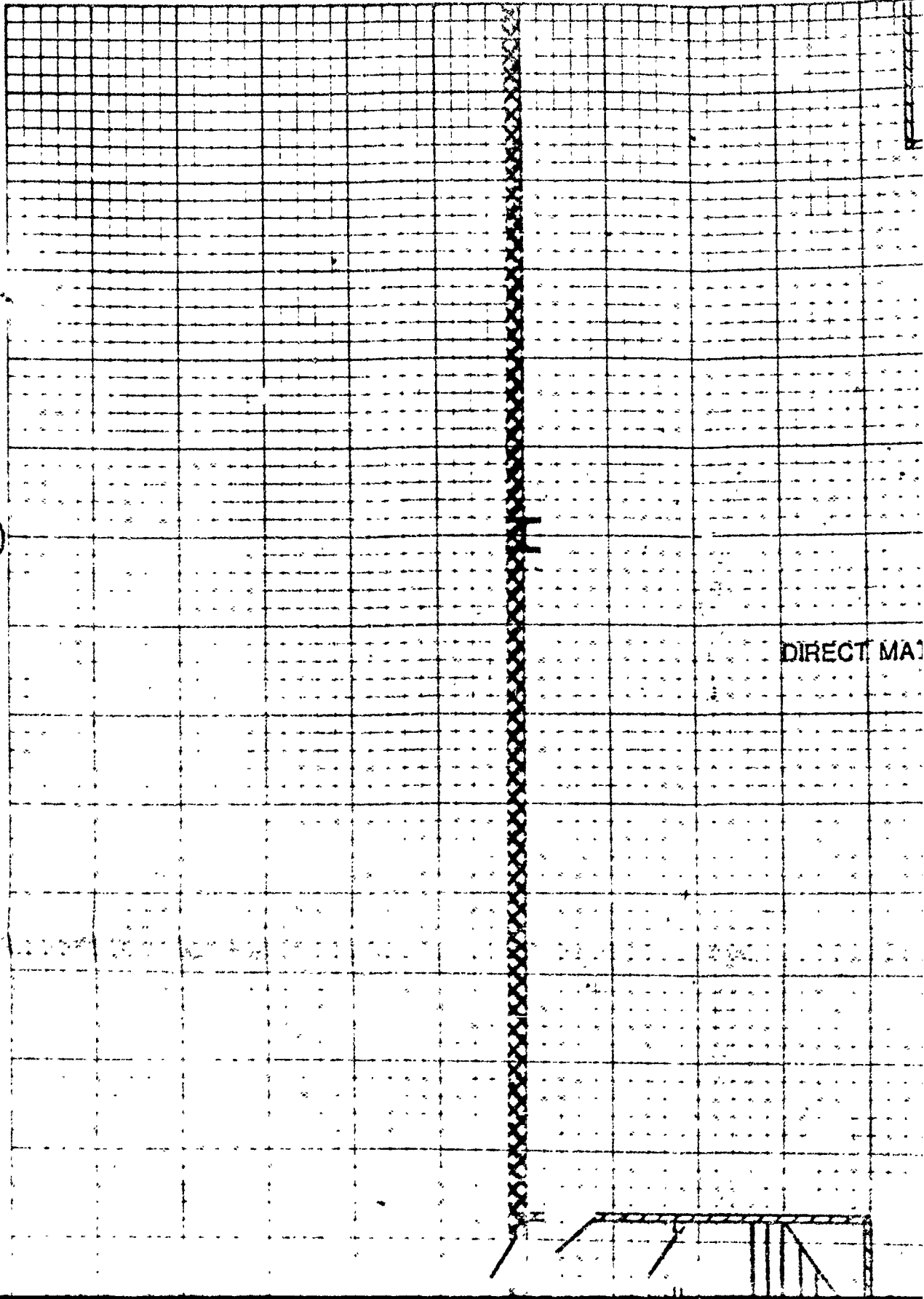
OC -- MABPAB

PCN	WCD
*****	*****
15025A	15025A
15113A	15113A
15119A	15119A
15126A	15126A
15136A	15136A
15137A	15136AA
15140A	15140A
15150A	15150A
15175A	15175A
15178A	15178A
15188A	15153A
15188ASUB1	15154A
15189ASUB1	15154AA
15189A	15153AA
15191A	15151A
15191ASUB1	15152A
15192A	15151AA
15192ASUB1	15152AA
15236A	15236A
15237ASUB1	15236B
15237A	15237A
15249A	15249A
15250A	15249AA
15300A	15126AA
15321A	15119AA

1

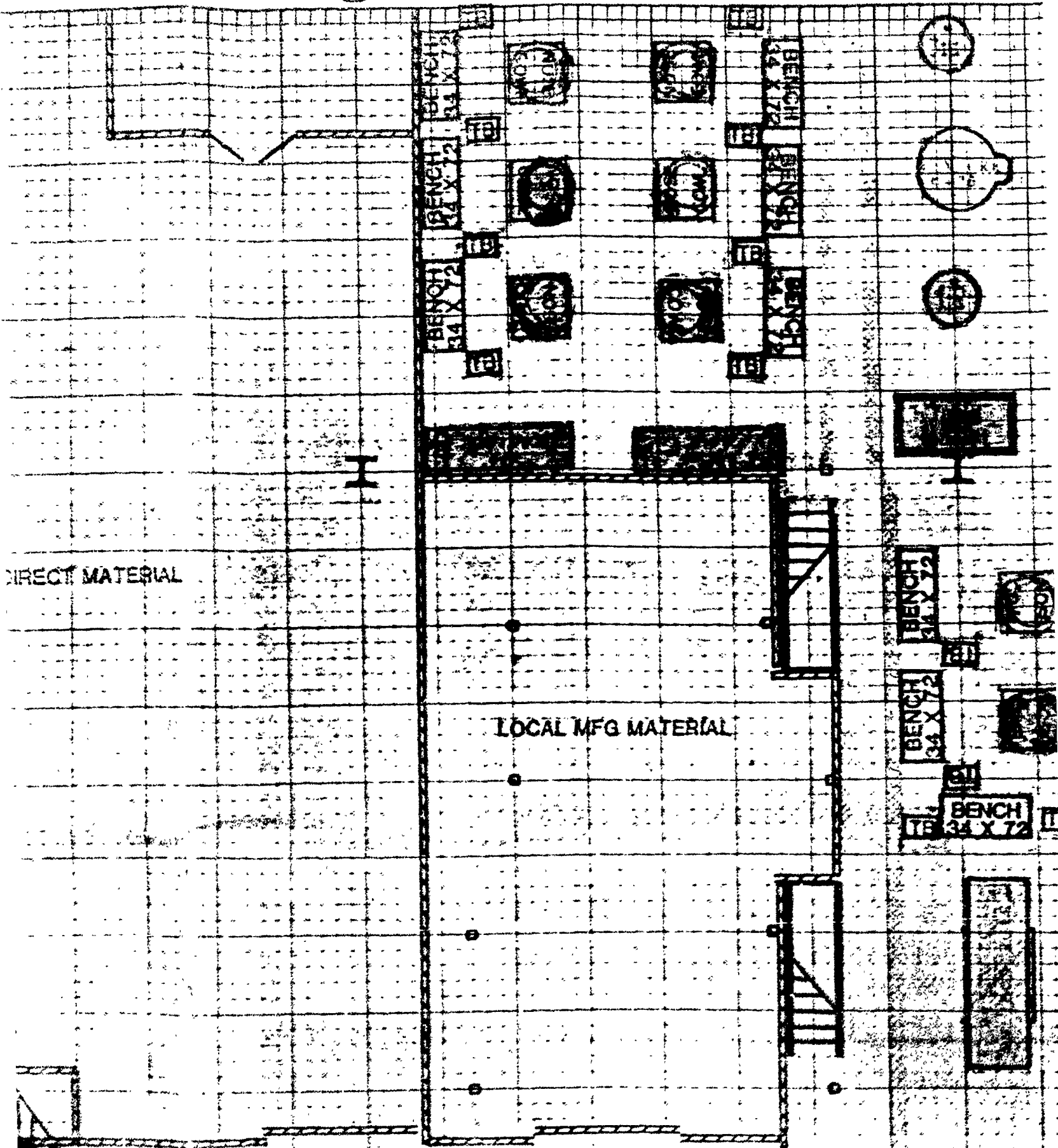
D

DIRECT MA



2

3

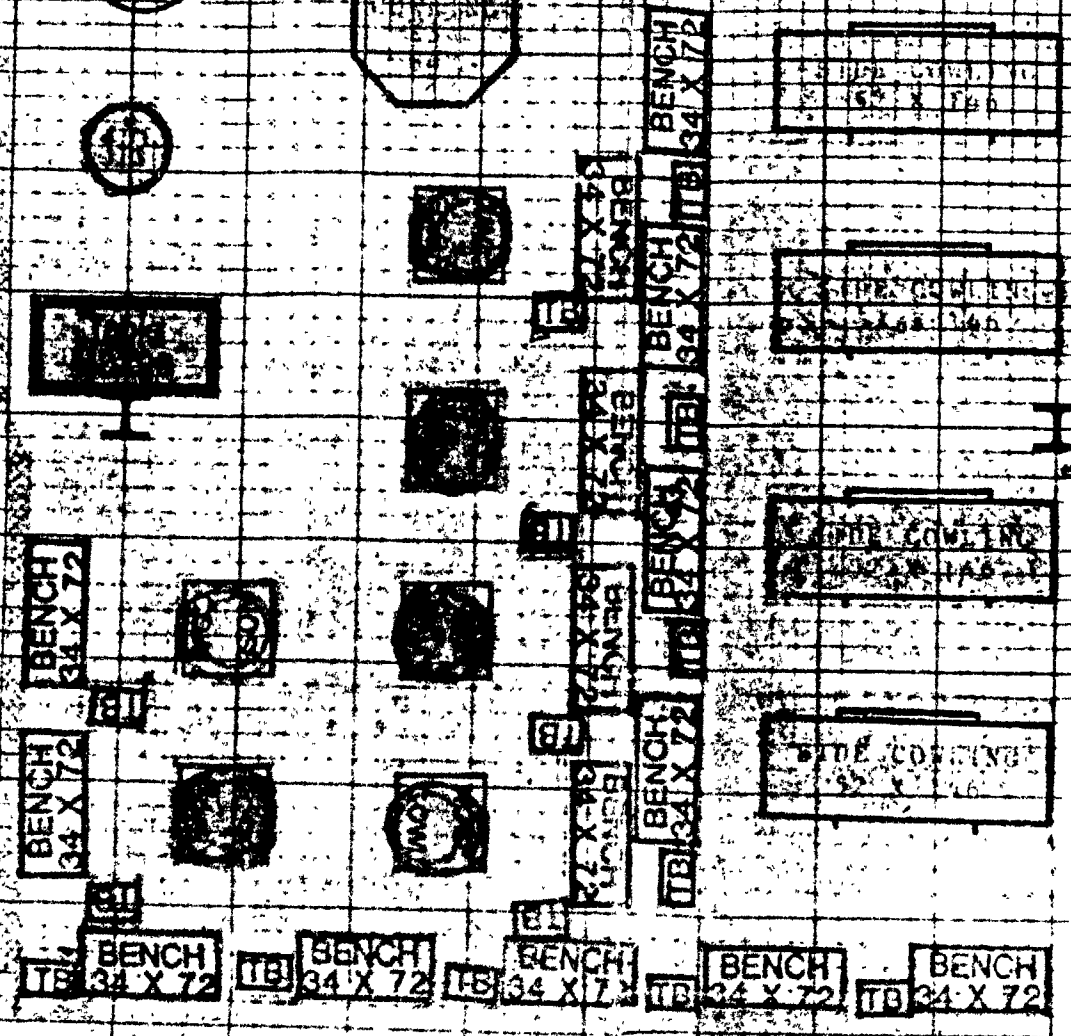
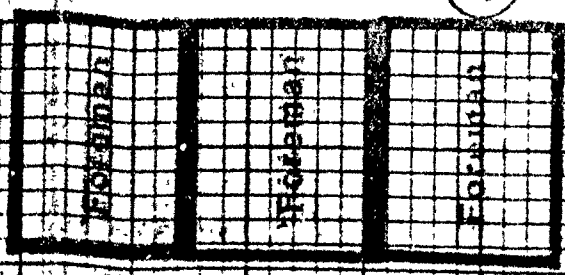


DIRECT MATERIAL

LOCAL MFG MATERIAL

3

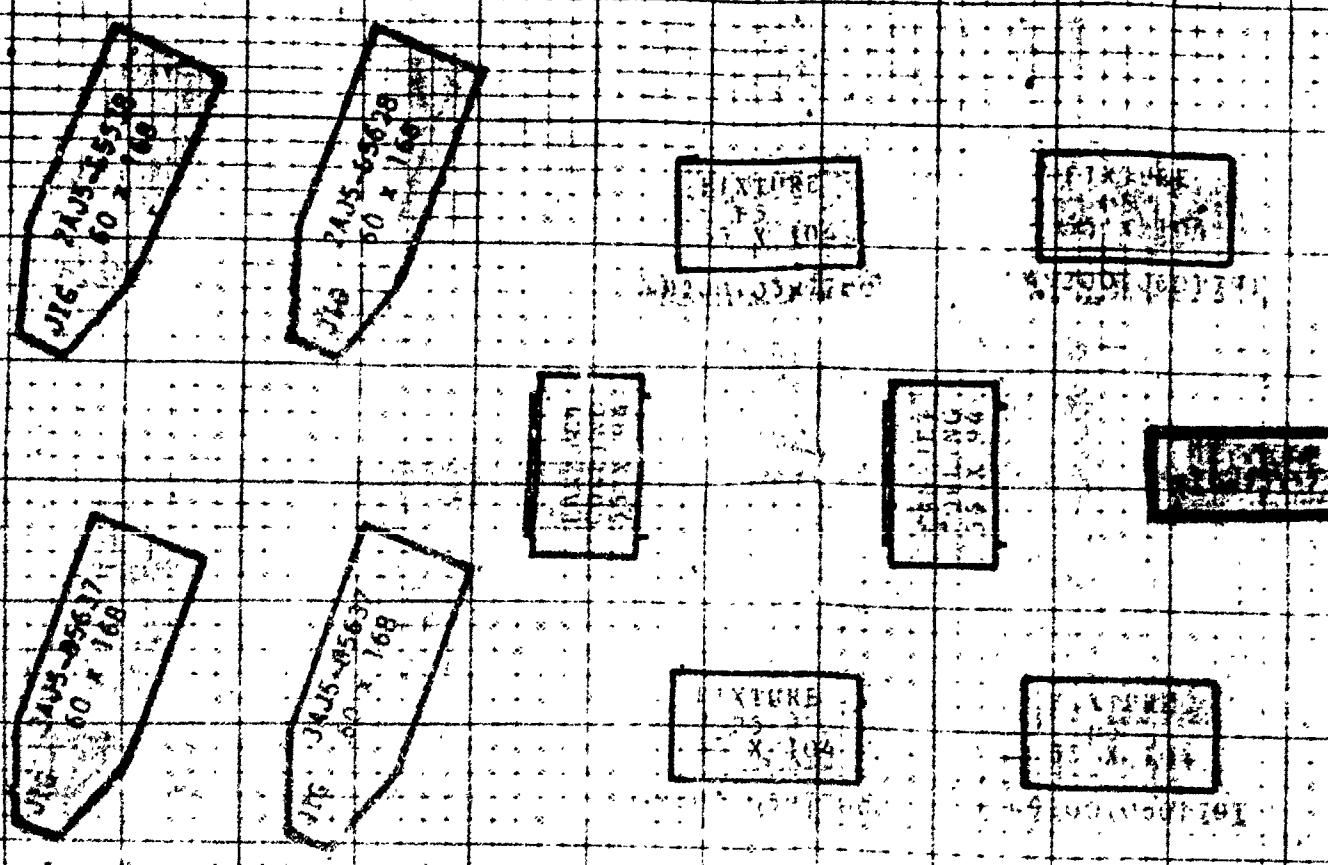
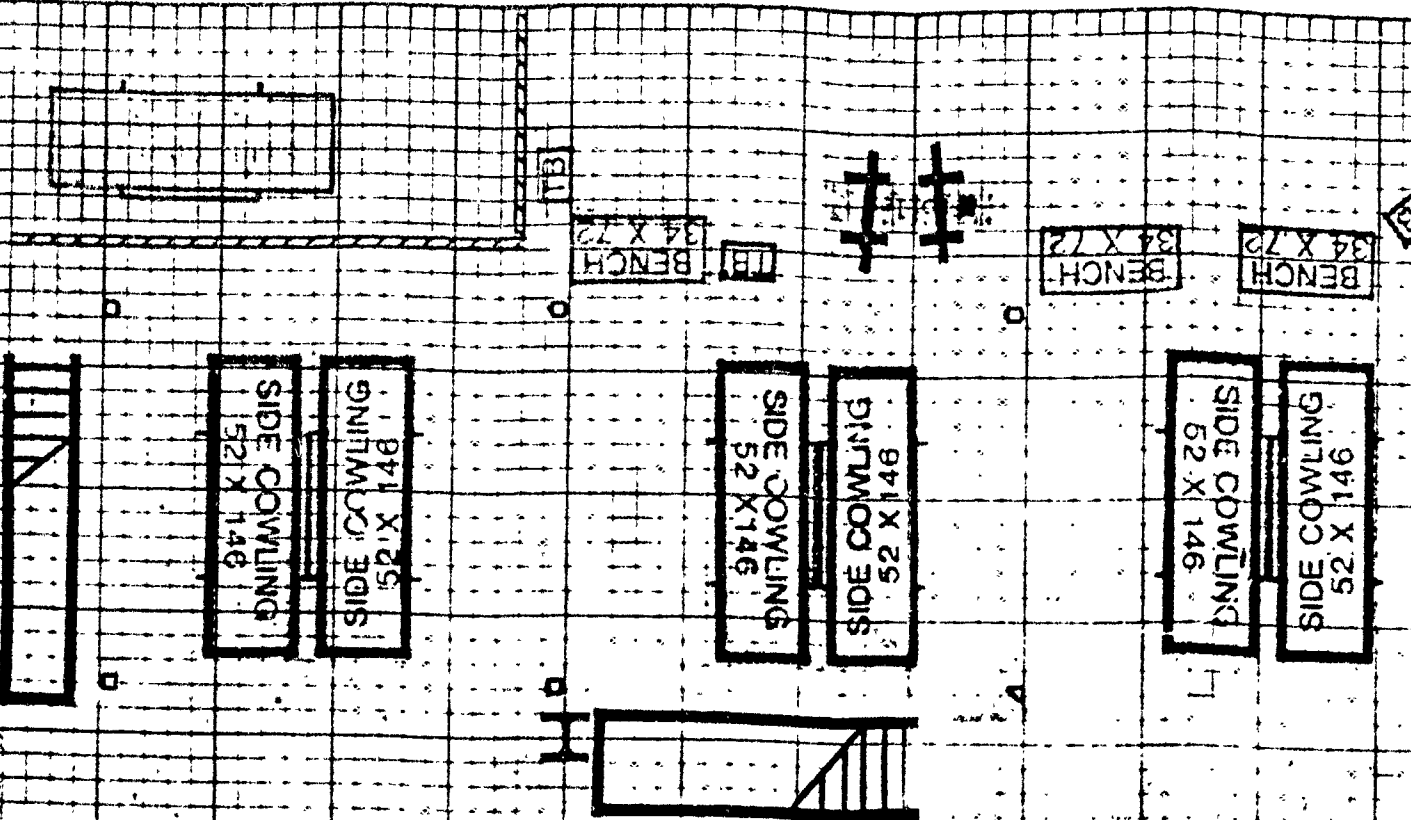
4



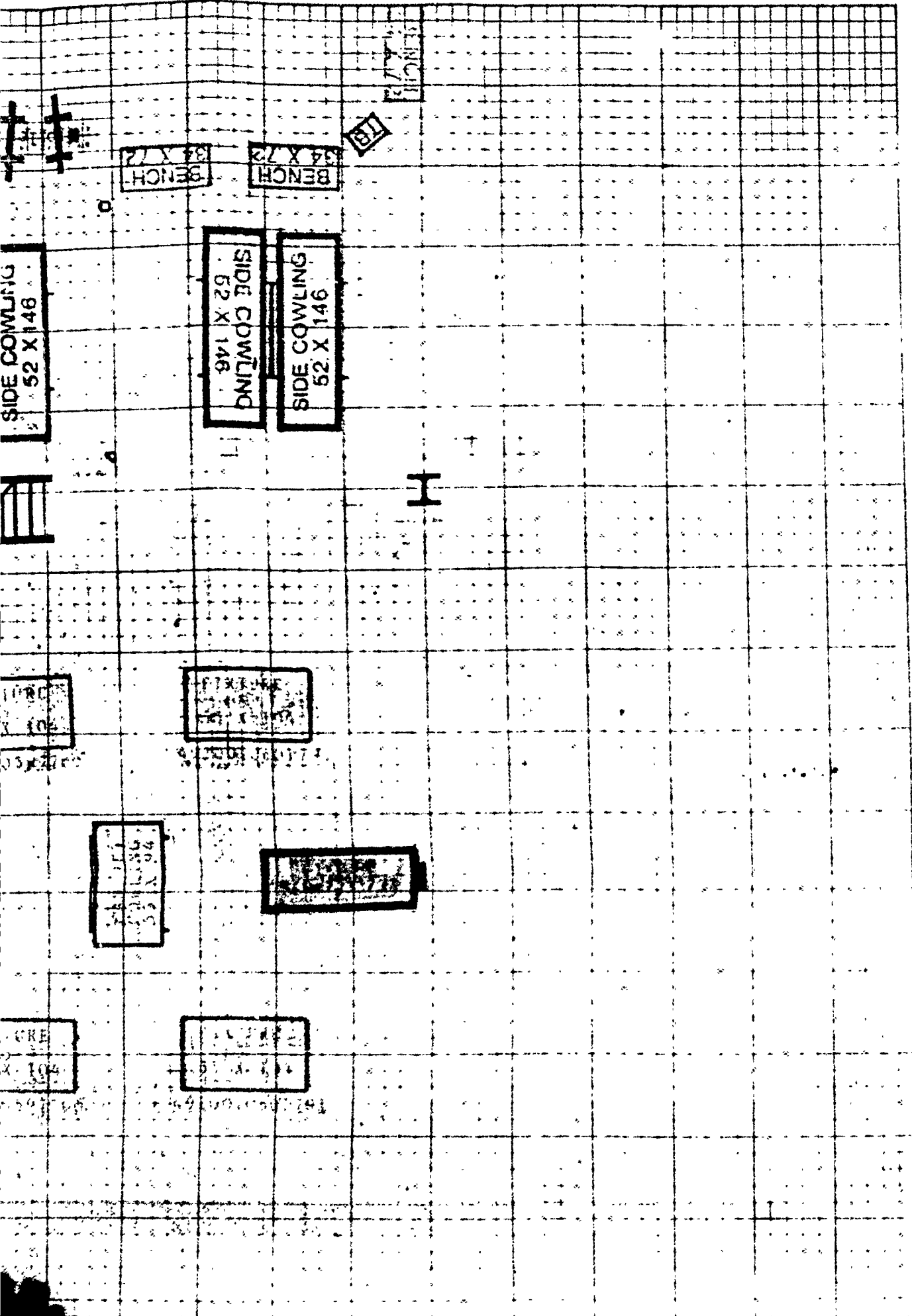
JIC 21

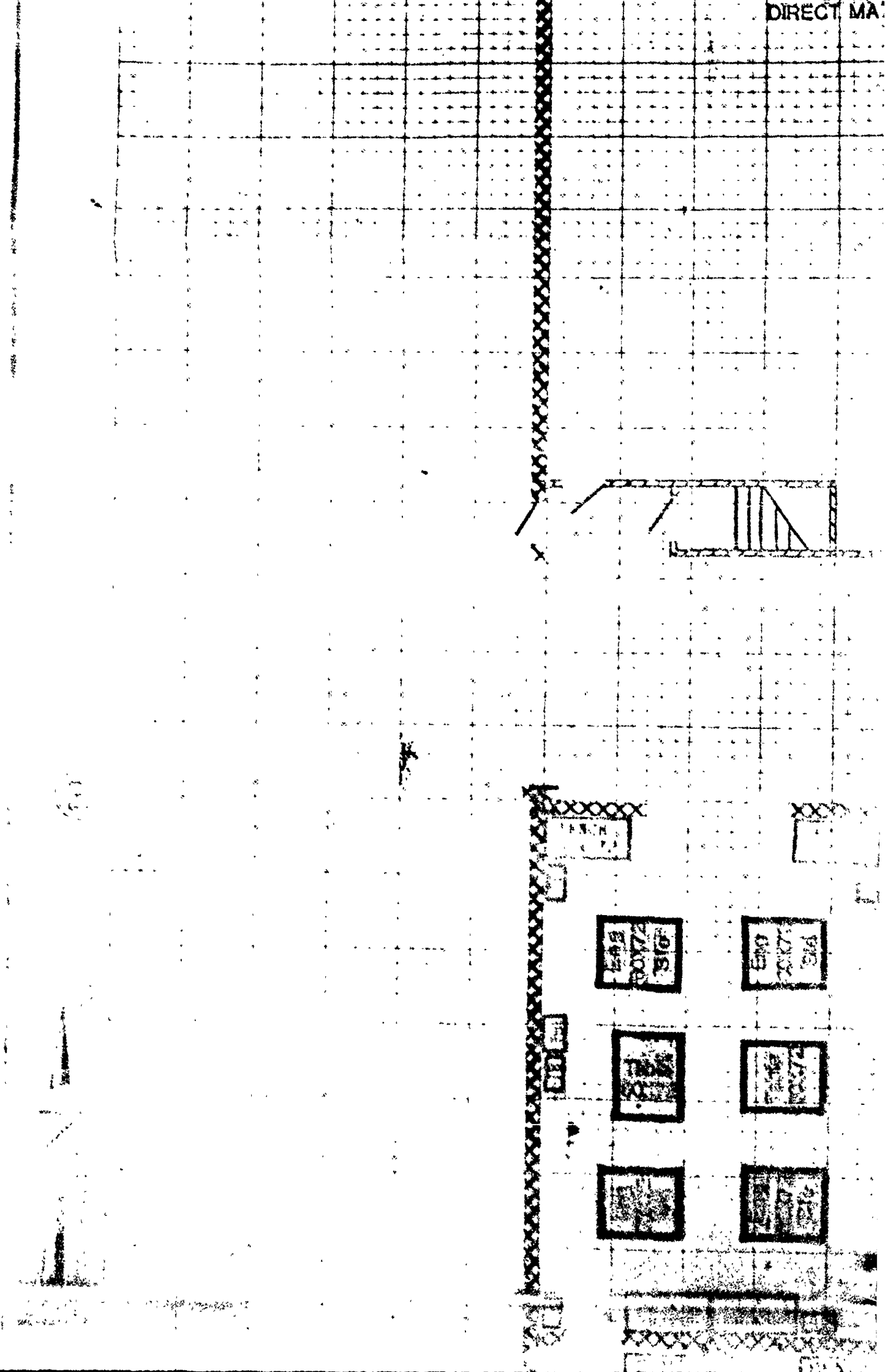
JIG 1405

5



6

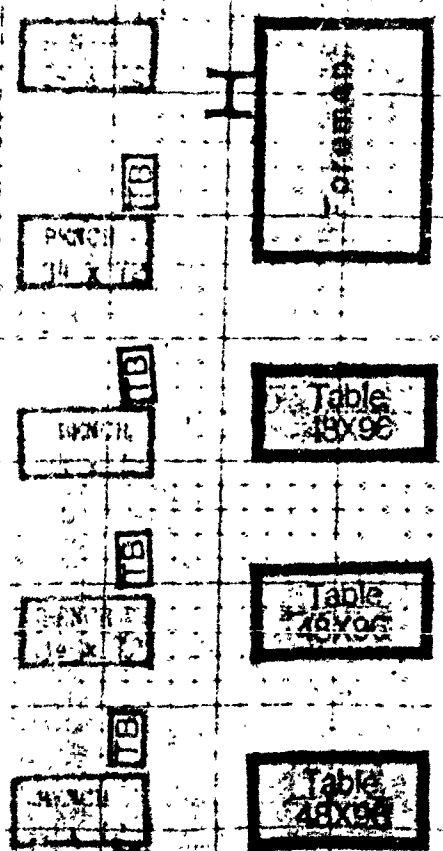
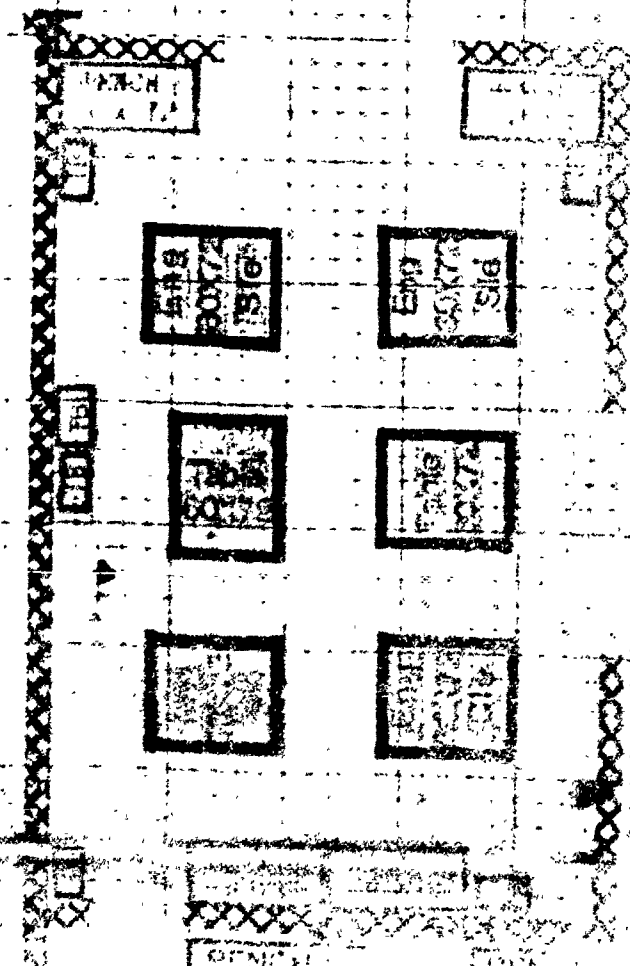
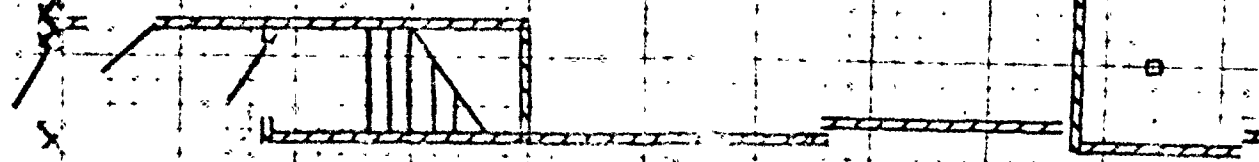






DIRECT MATERIAL

LOCAL



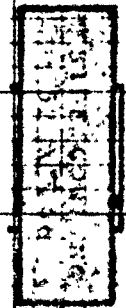
GENERAL

LOCAL MFG MATERIAL

BENCH 34 X 72  
BENCH 34 X 72

BENCH 34 X 72

BENCH 34



BENCH 34 X 72



BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

Table 48 X 96

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

Table 48 X 96

BENCH 34 X 72

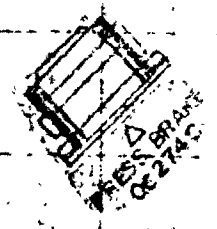
BENCH 34 X 72

BENCH 34 X 72

Table 48 X 96

BENCH 34 X 72

BENCH 34 X 72



MATERIAL

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

SIDE CONTAINER

SIDE CONTAINER

SIDE CONTAINER

SIDE CONTAINER

SIDE CONTAINER

SIDE CONTAINER

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

PRESS BRAKE  
A8724C

PRESS BRAKE  
A87032

8274

BENCH  
34 X 72

BENCH  
34 X 72

TB

BIN  
46 X 144

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

00014

00014

COMP

JIG 3405-85617  
60 X 168

JIG 3405-85617  
60 X 168

FIXTURE  
45 X 108

BENCH  
34 X 72

BENCH  
34 X 72

FIXTURE  
45 X 108

SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116

JIG 3405-85617  
60 X 168

JIG 3405-85617  
60 X 168

FIXTURE  
45 X 108

SHIELD COUPLING  
52 X 116

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

TRAILER  
4 X 10

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

TRAILER  
45 X 108

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116

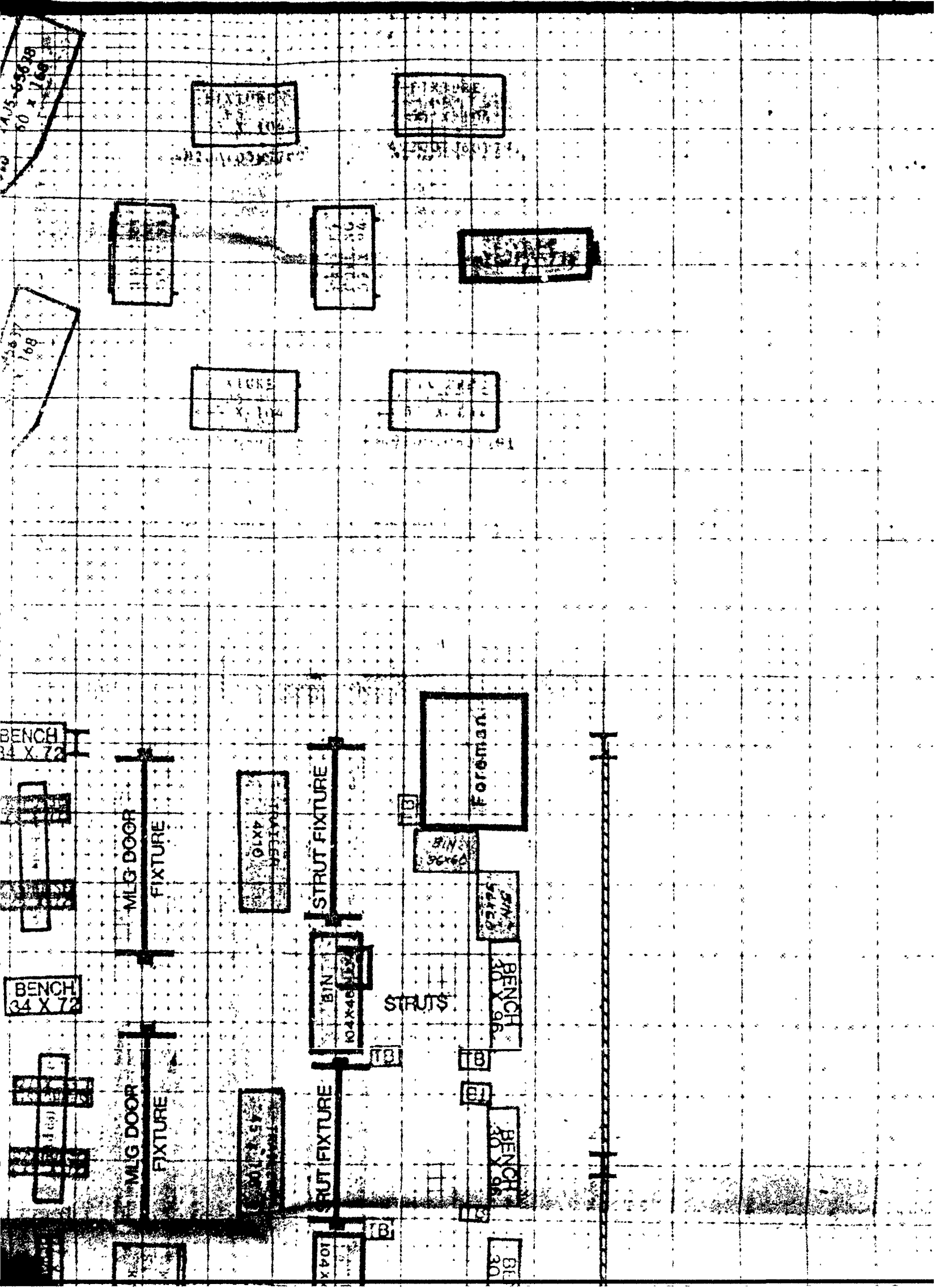
SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116

SHIELD COUPLING  
52 X 116



BENCH  
34 X 72

MIG DOOR  
FIXTURE

TABLE  
4X10

STRUT FIXTURE

BIN  
56X66

Foreman

TABLE  
30 X 66

BENCH  
30 X 66

STRAITS

BIN  
104X40

TB

TB

BENCH  
30 X 66

MIG DOOR  
FIXTURE

TABLE  
45 X 106

STRUT FIXTURE

BIN  
104 X

TB

BENCH  
30 X 66

BENCH  
34 X 72

TABLE  
30 X 66

TABLE  
30 X 66

AUS-55676  
90 X 169

TABLE  
30 X 66

TABLE  
30 X 66

TABLE  
30 X 66

TABLE  
30 X 66

TABLE  
30 X 66

TABLE  
30 X 66

TABLE  
30 X 66

TABLE  
30 X 66

FIXTURE

2001100111

11  
11  
11  
11

11  
11  
11  
11

11  
11  
11  
11

Foreman

TB

BENCH  
30 X 60

BENCH  
30 X 60

BENCH  
30 X 60

STRUTS

TB

TB

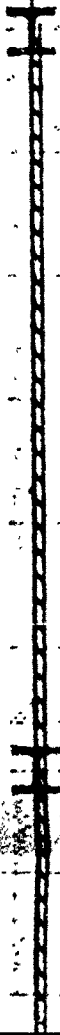
TB

BENCH  
30 X 60

TB

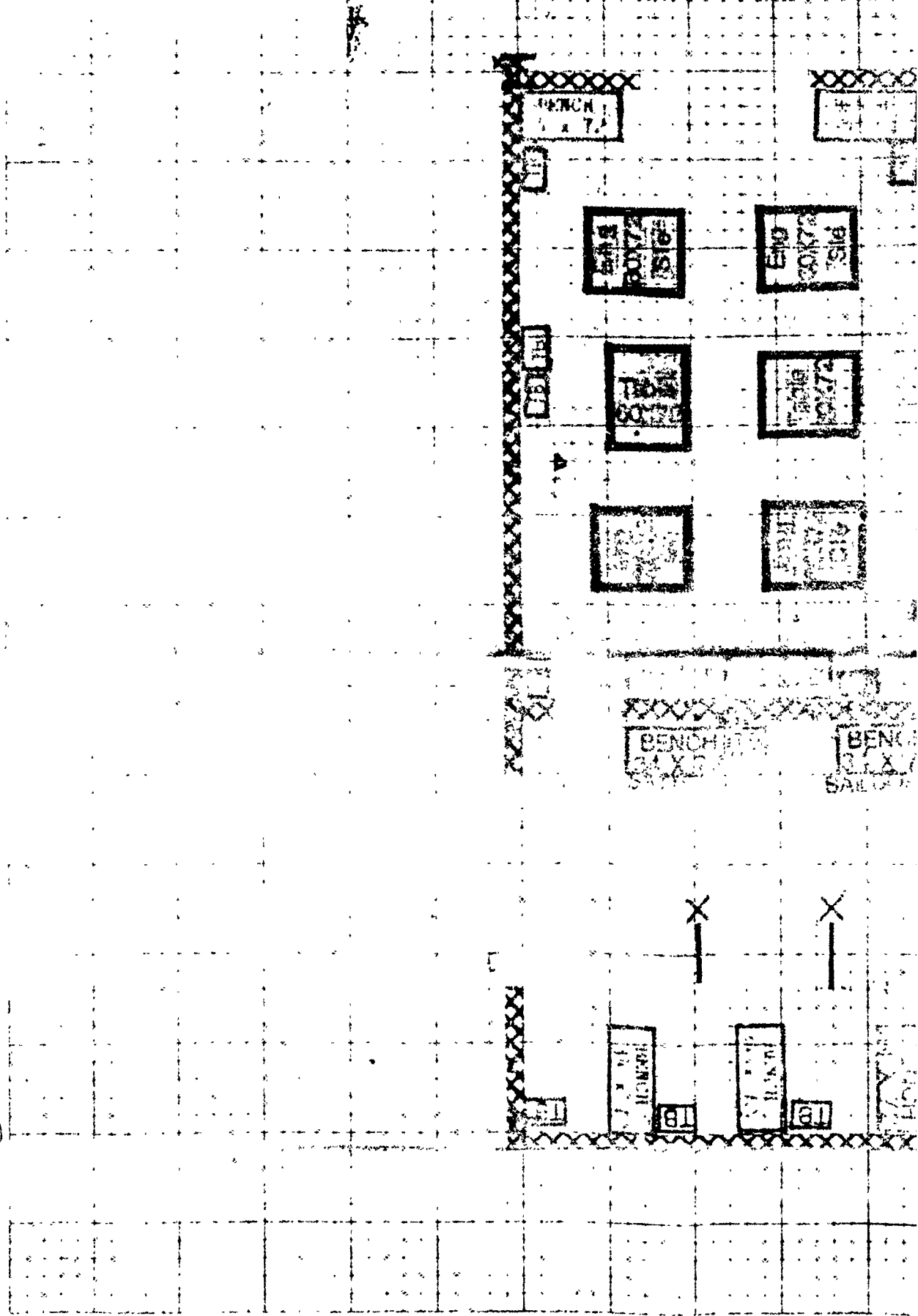
BENCH  
30 X 60

TB



(E)

(G)



2-TINKER

BLDG 2101

△N





BENCH  
34 X 72

BENCH  
34 X 72

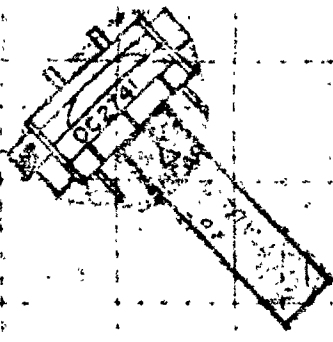
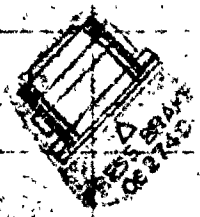
BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

FAUS  
73139-1

38137  
59111



PAINT  
MACHINE

PAINT  
MACHINE

TB

TB  
NIB  
145

OC2982

OC0145

AF800531

AF80132

PUNCH  
AF800354

OC0014

Bending  
PUNCH

PUNCH

ROHM  
RACK

OC02425

OC0083

BENCH  
36 X 72

BENCH II  
6 X 72

BENCH  
36 X 72

BENCH  
6 X 72

BENCH  
6 X 72

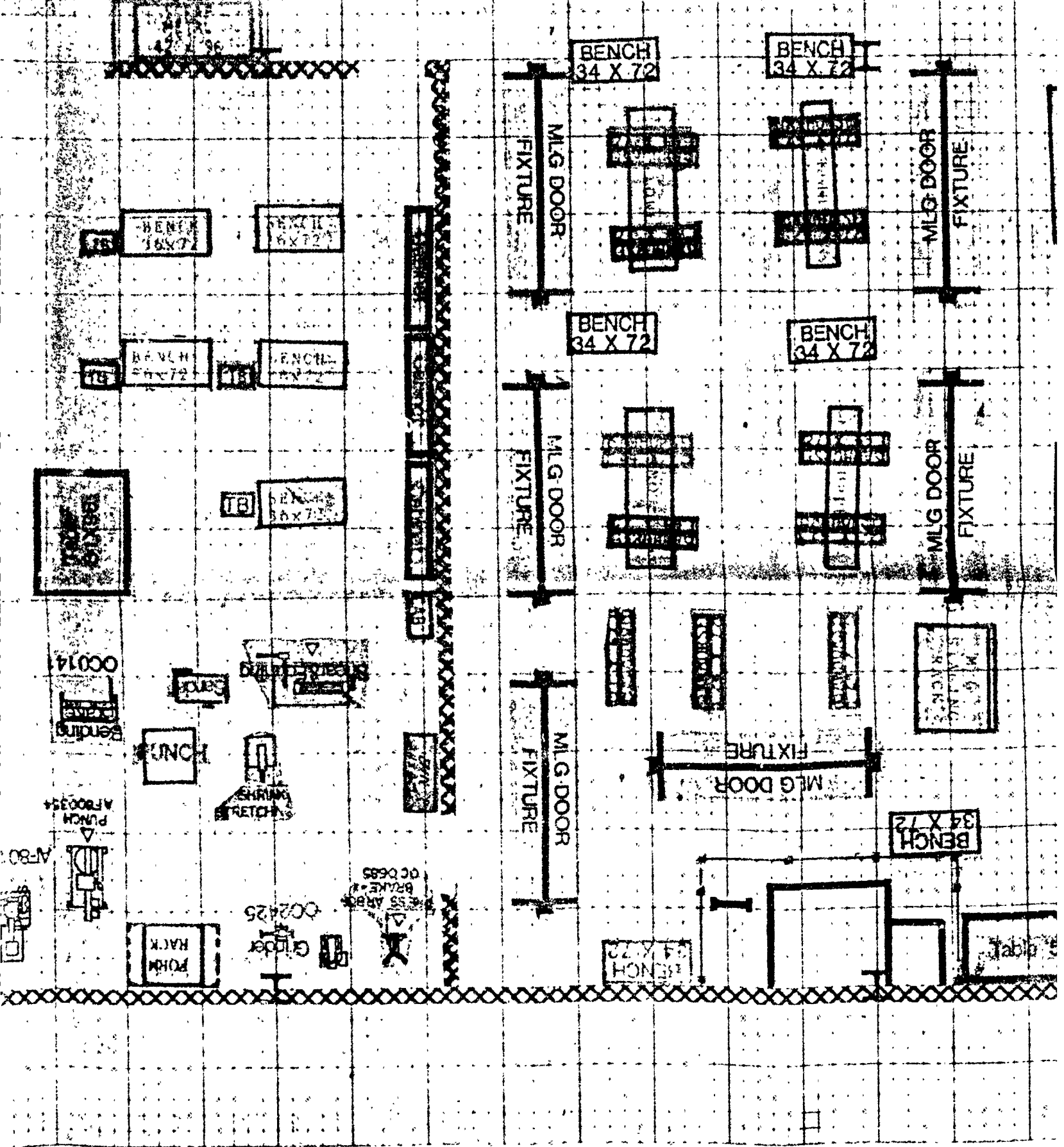
SPR



STRETCH

OC02425

OC0083



BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

OC014

Bending Machine

PUNCH AF80

PUNCH AF80

PUNCH

PUNCH

PUNCH

OC2425

GRINDER

OC0685

BRASS ARB

MLG DOOR

MLG DOOR

MLG DOOR

MLG DOOR

MLG DOOR

MLG DOOR

BENCH 34 X 72

BENCH 34 X 72

FIXTURE

FIXTURE

FIXTURE

FIXTURE

FIXTURE

FIXTURE

Table

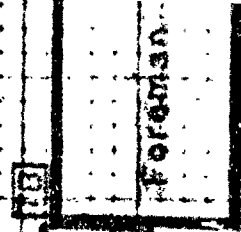
BENCH  
34 X 72



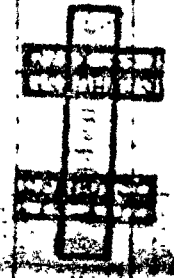
M/G DOOR  
FIXTURE

FRAMES  
45 X 106

STRUT FIXTURE



BENCH  
34 X 72



M/G DOOR  
FIXTURE

FRAMES  
45 X 106

BIN  
104 X 48

STRUTS

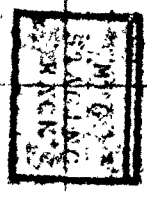
BENCH  
30 X 96

TB

TB

BENCH  
30 X 96

TB



BIN  
104 X 48

BENCH  
30 X 96

TB

M/G DOOR  
FIXTURE

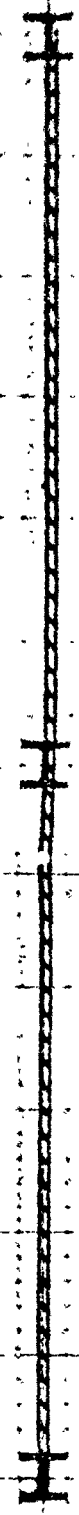
BENCH  
34 X 72

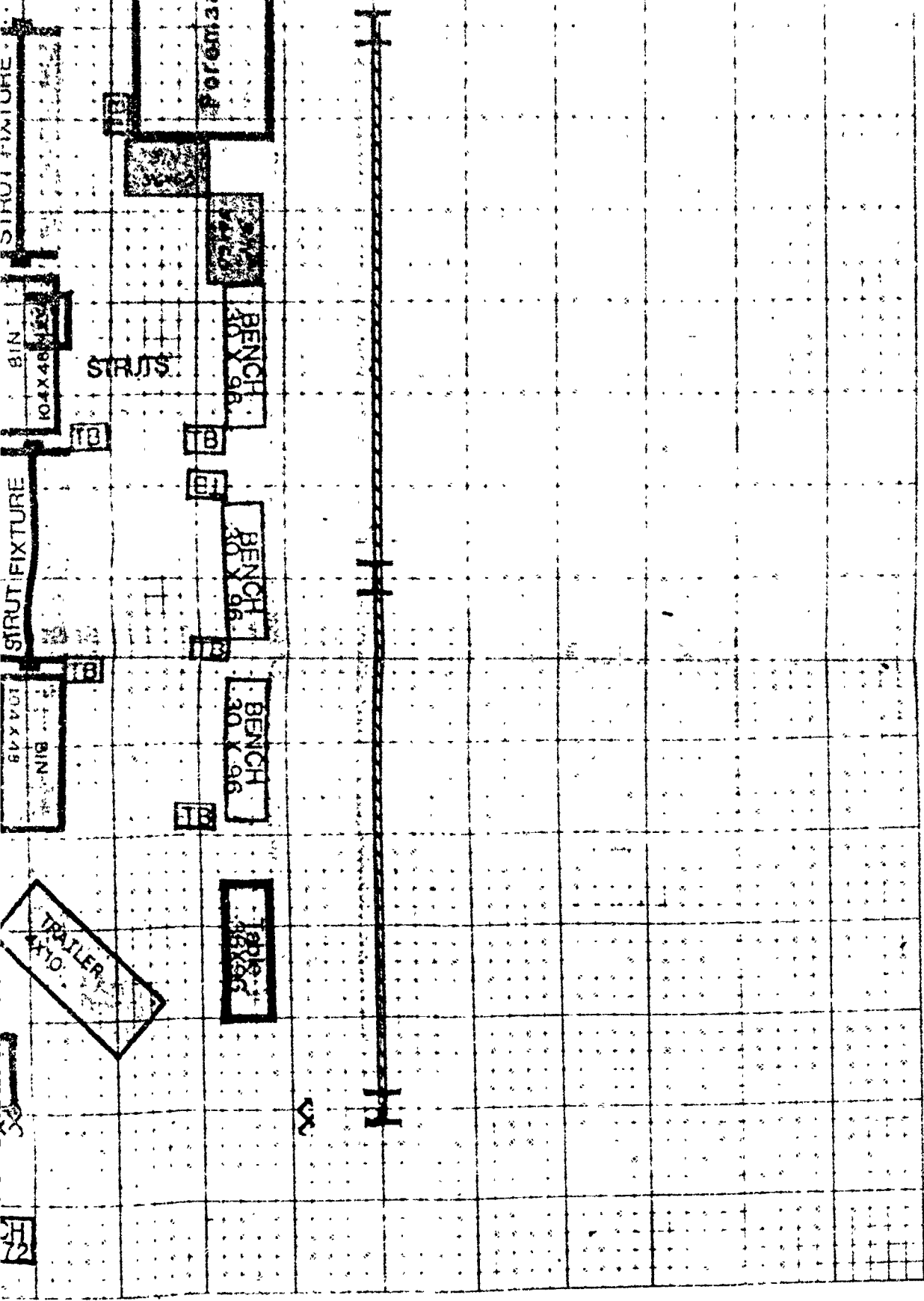
TRAILER  
4 X 10

Table  
80 X 96

Table  
80 X 96

BENCH  
34 X 72

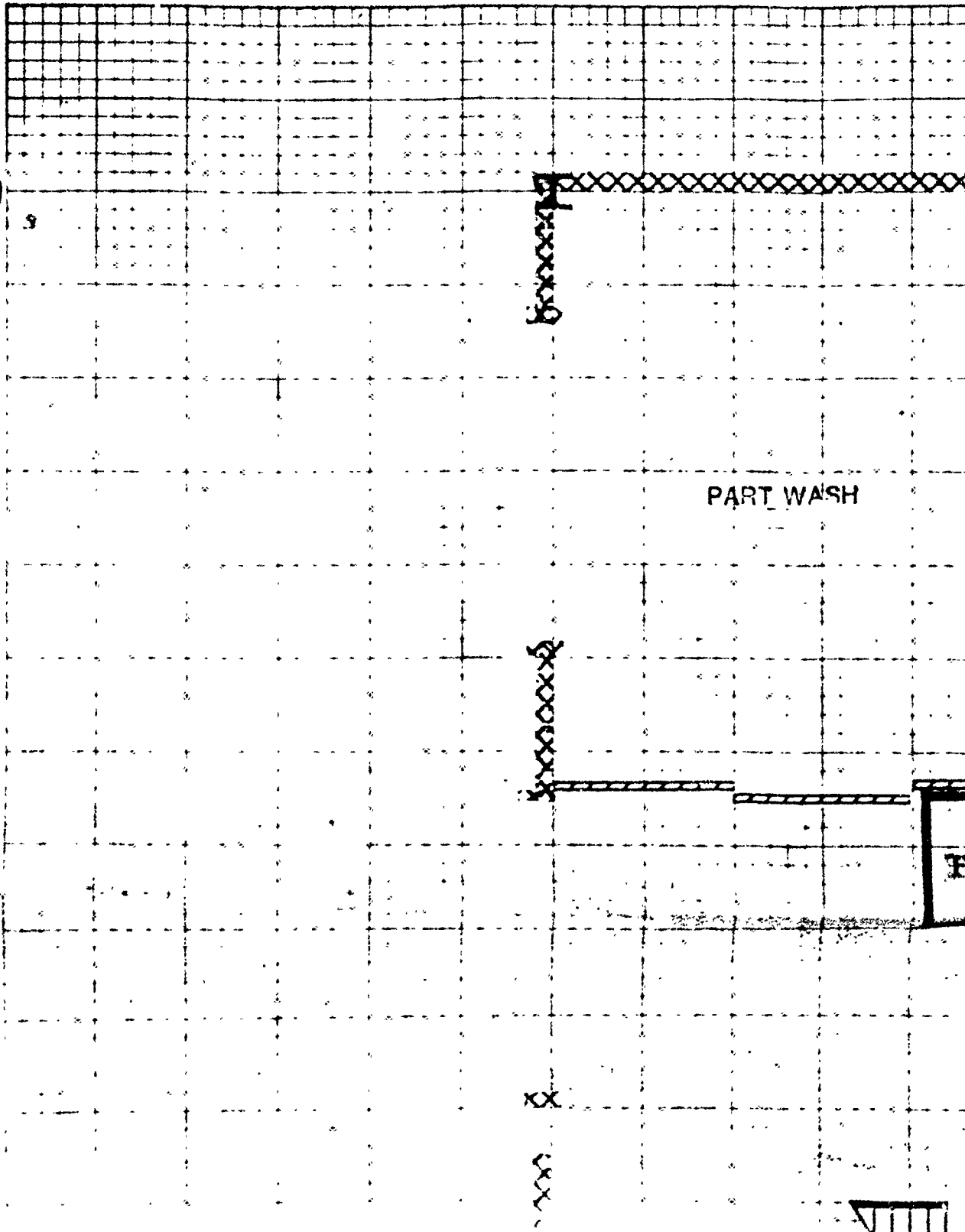




CH  
72

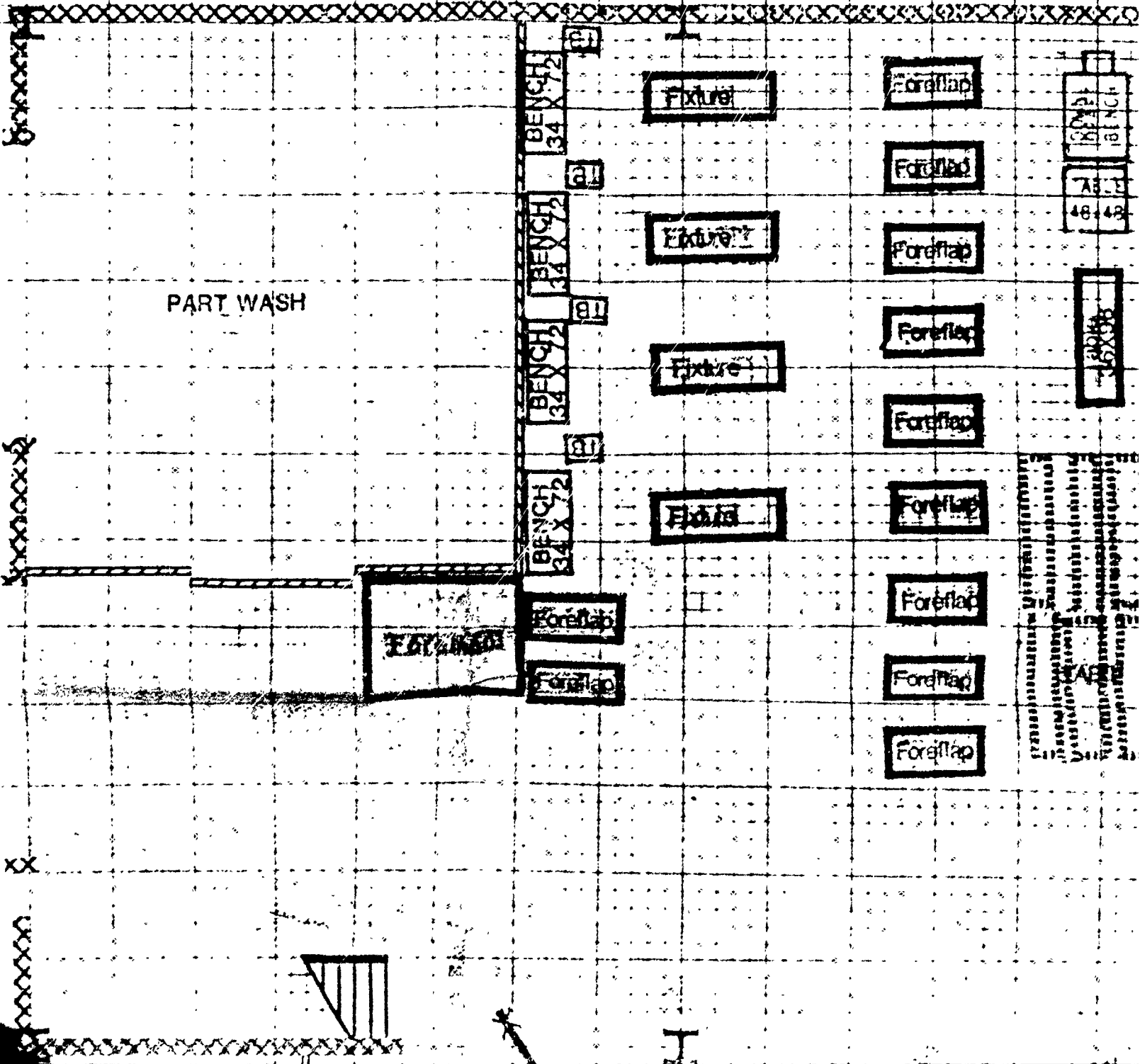
1

A



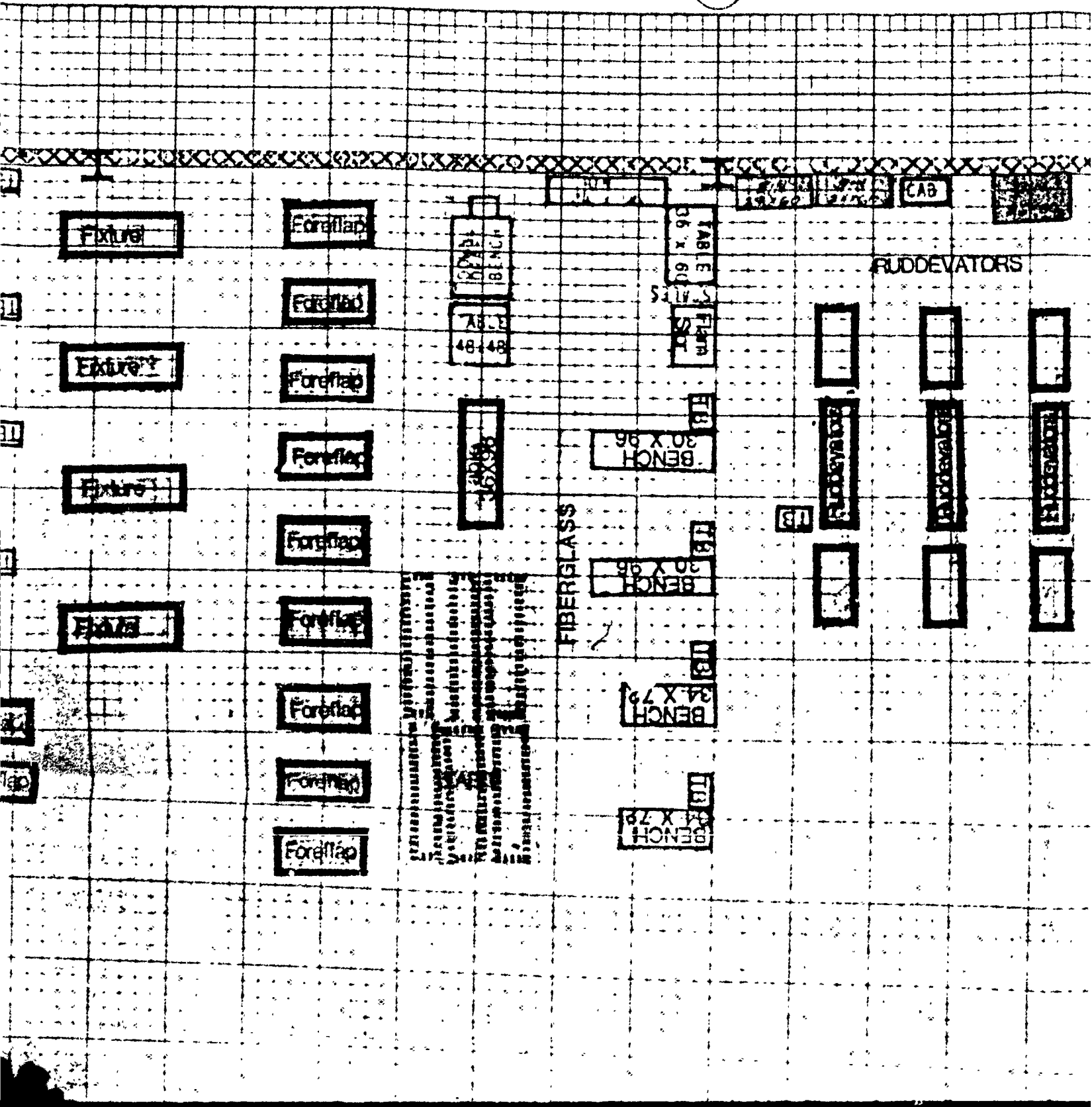
1

2

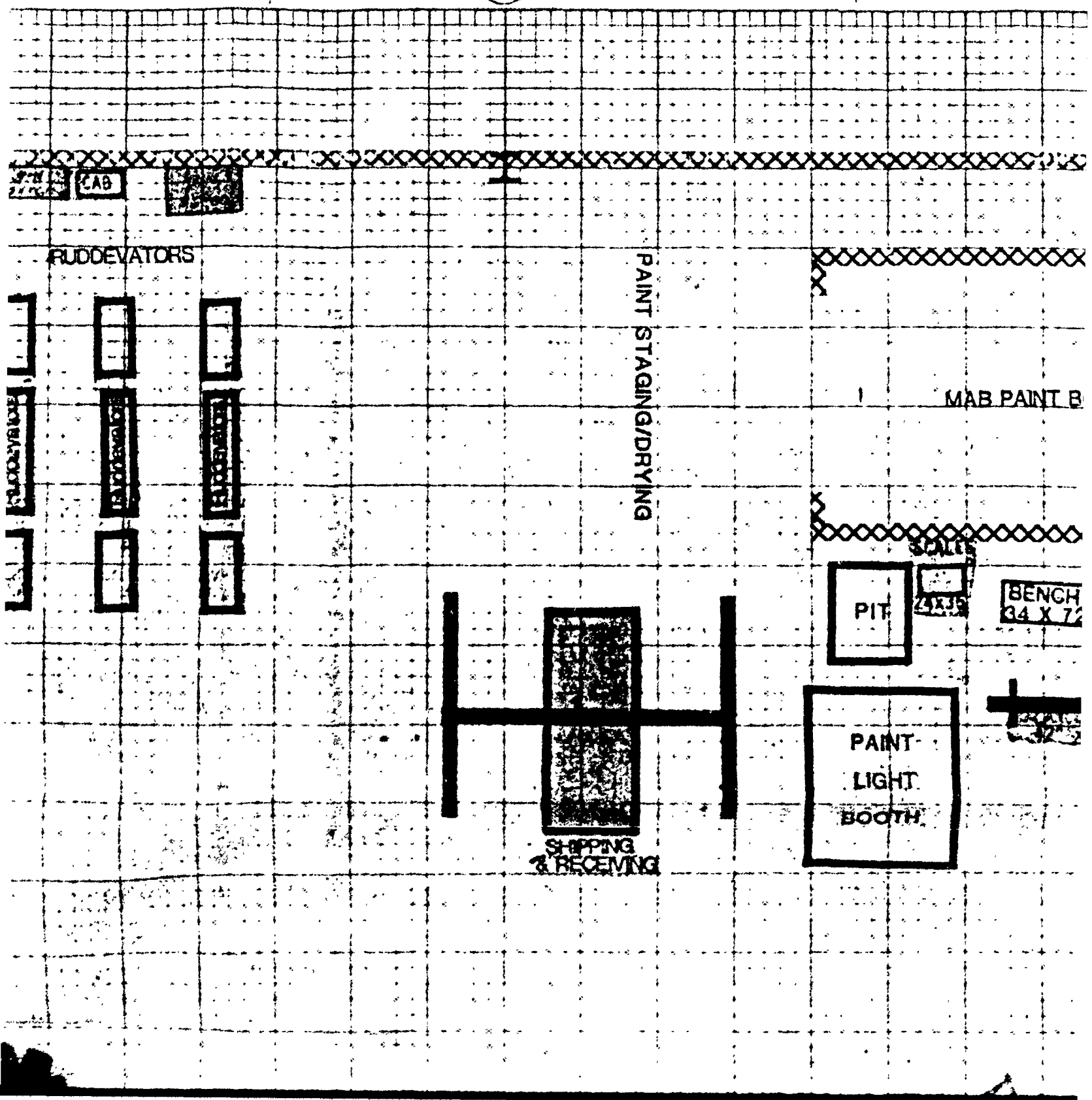


2

3



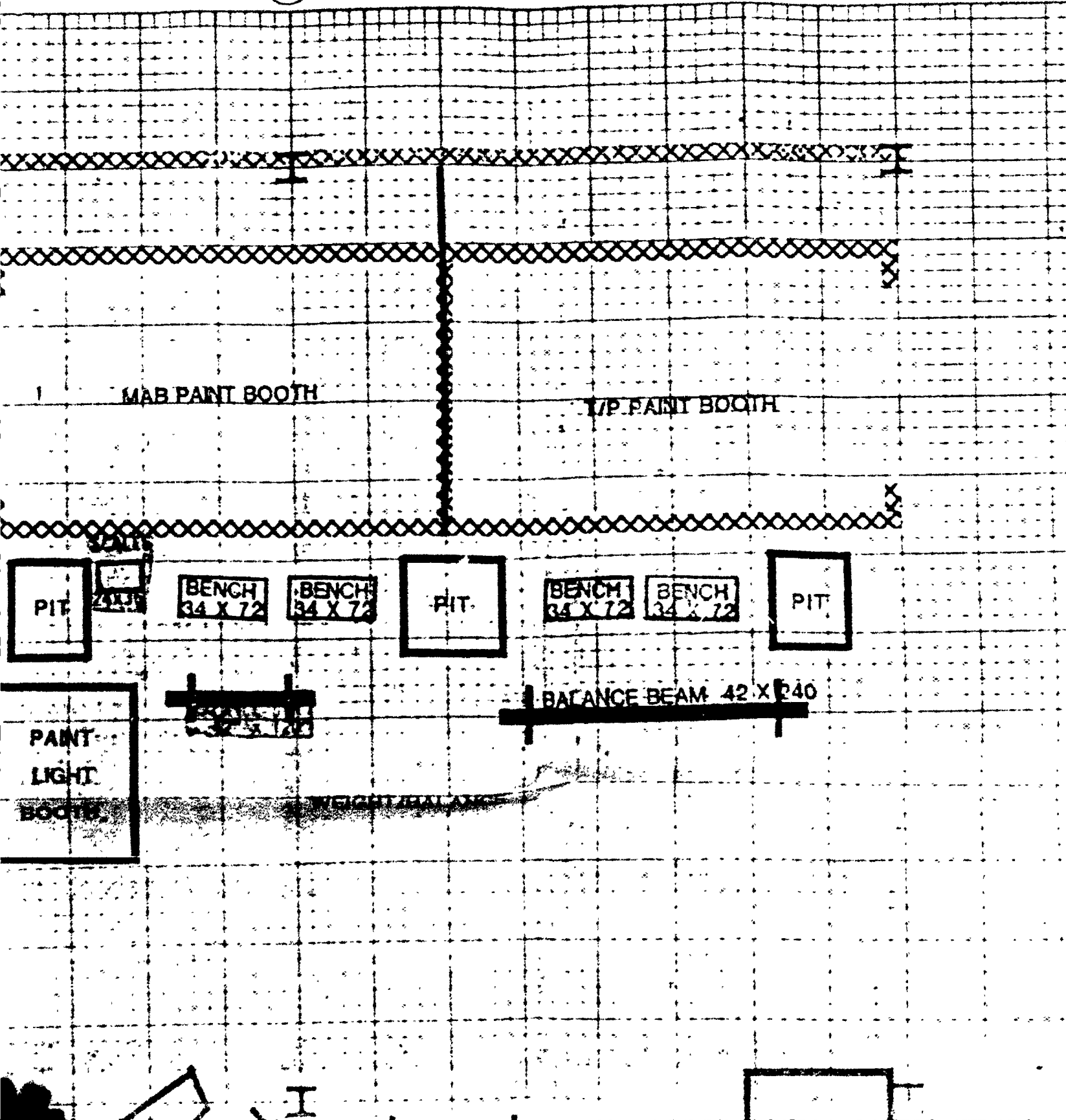
4



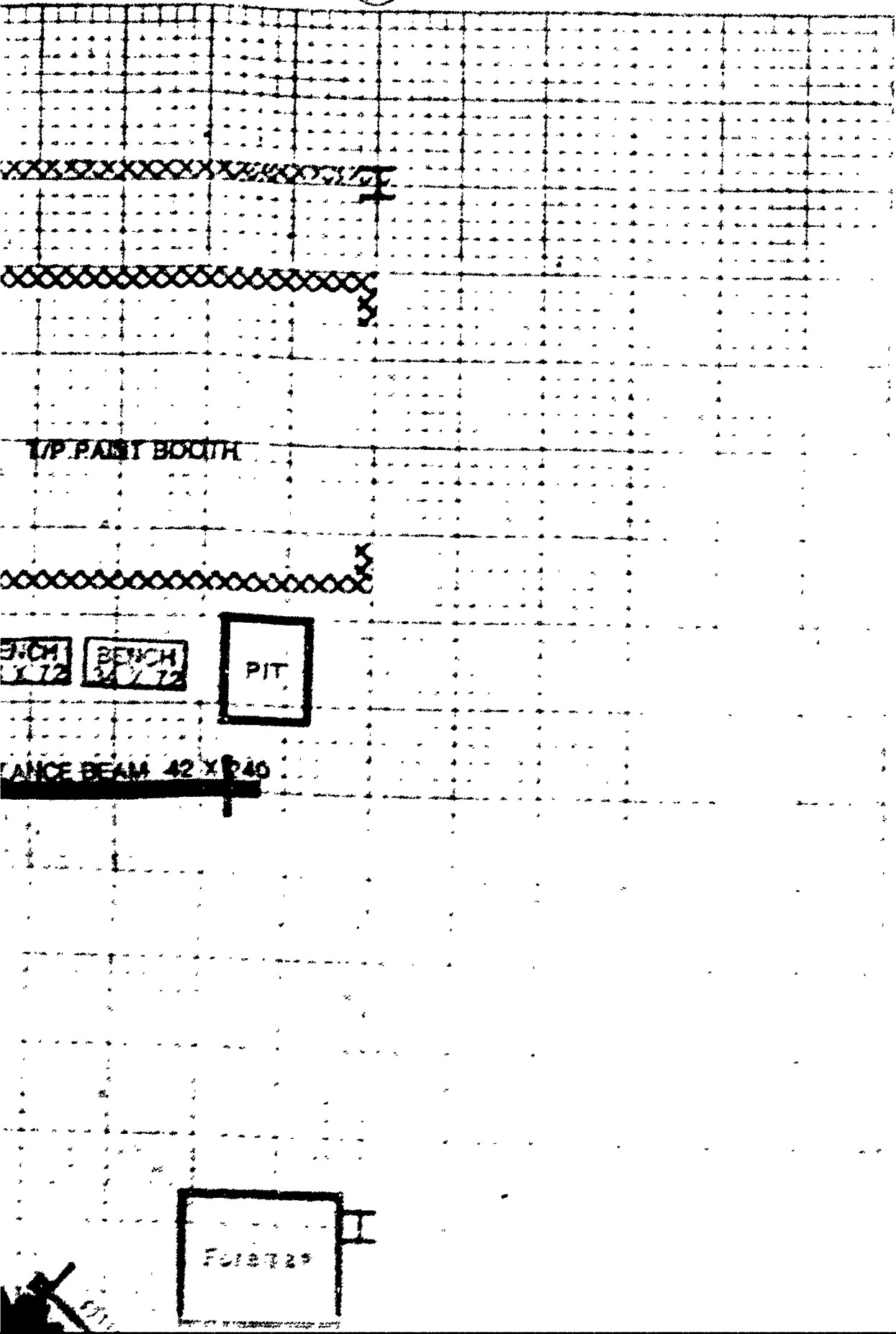


5

6



6

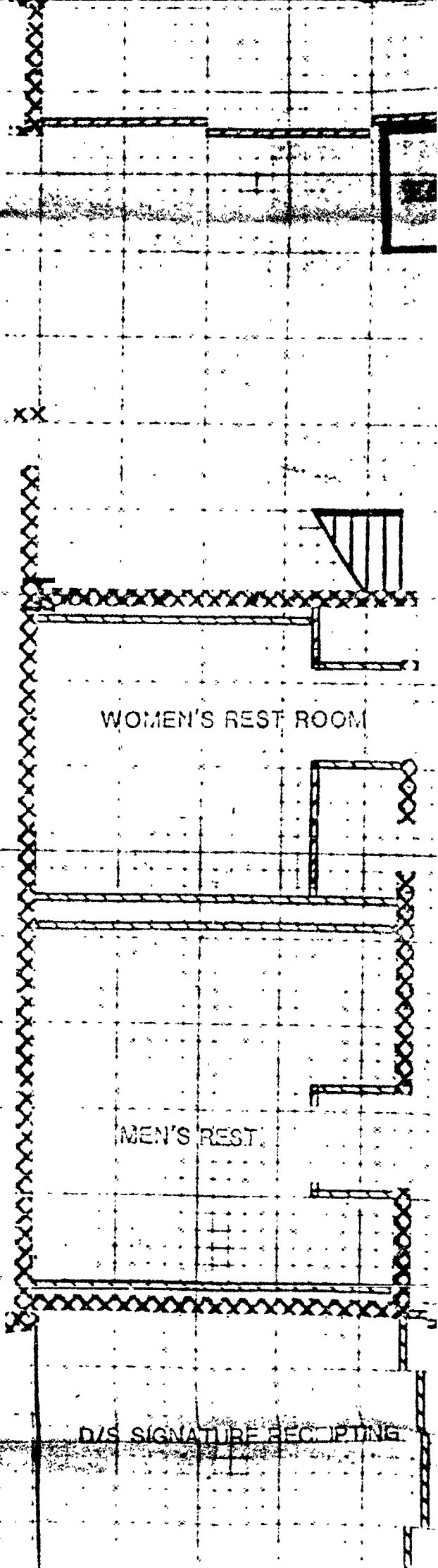


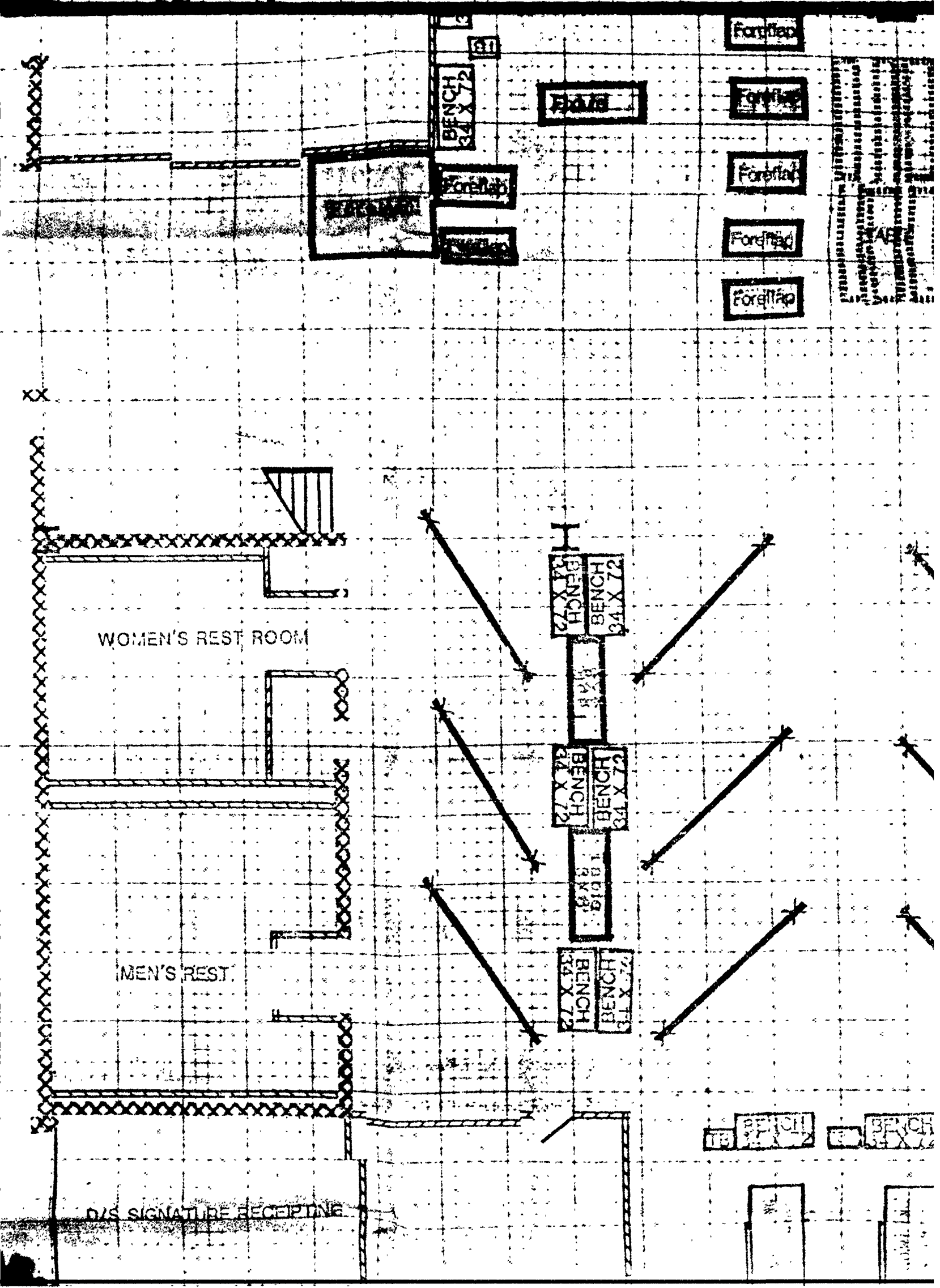
(B)

WOMEN'S REST ROOM

MEN'S REST.

D/S SIGNATURE RECEIPTING





Forellap

BENCH  
34 X 72

Forellap

Forellap

Forellap

Forellap

Forellap

Forellap

Forellap

WOMEN'S REST ROOM

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

MEN'S REST.

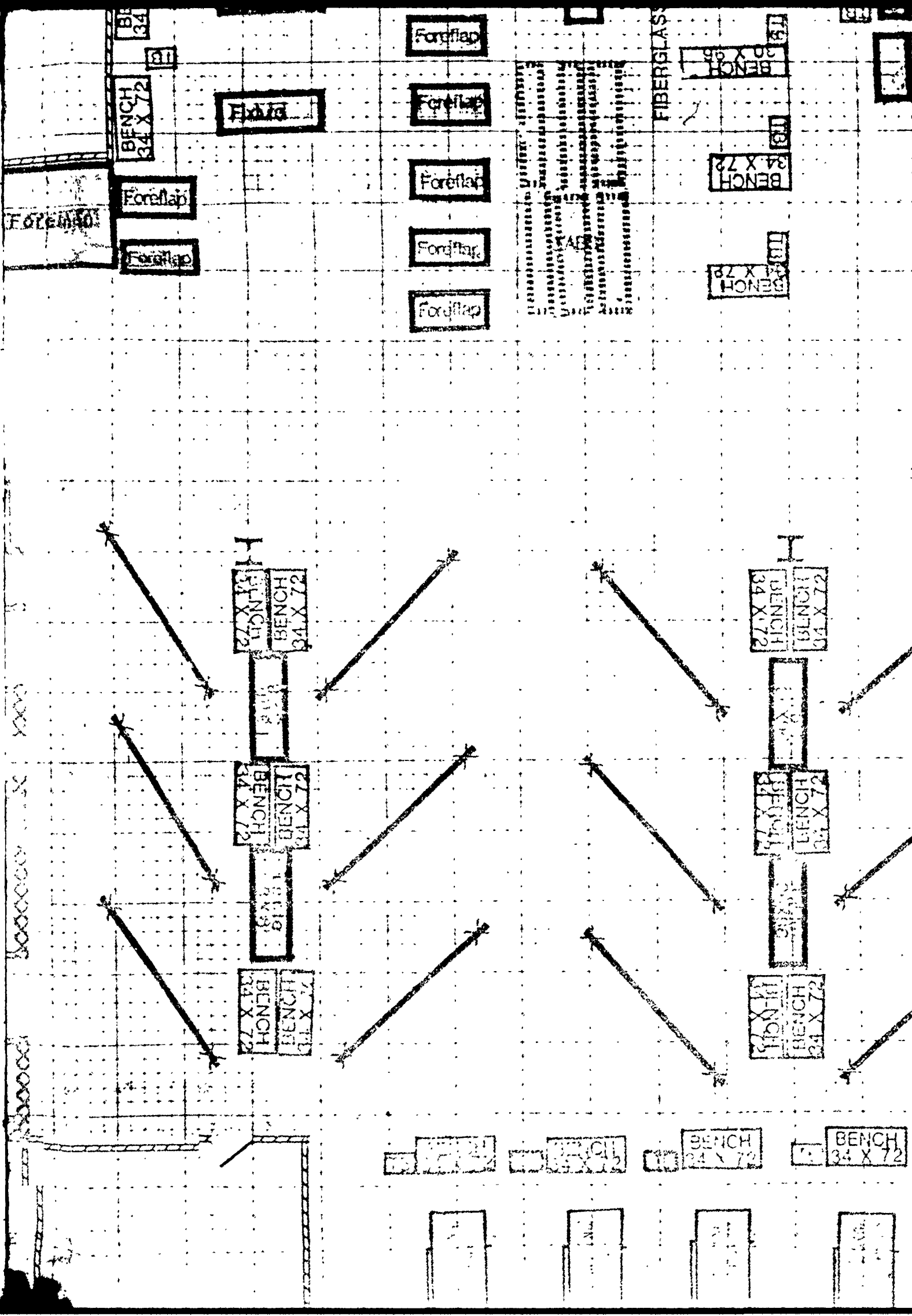
BENCH  
34 X 72

BENCH  
34 X 72

D/S SIGNATURE RECEIVING

BENCH  
34 X 72

BENCH  
34 X 72



Foreflap

Foreflap

Foreflap

Foreflap

Foreflap

134

BENCH  
34 X 72

Foreflap

Foreflap

FIBERGLASS

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

100

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

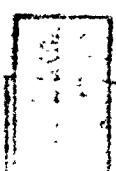
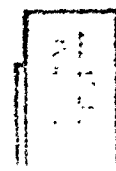
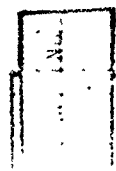
BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72



FIBERGLASS

75 BENCH 34 X 72

76 BENCH 34 X 72

77 BENCH 34 X 72

78 BENCH 34 X 72

79 BENCH 34 X 72

80 BENCH 34 X 72

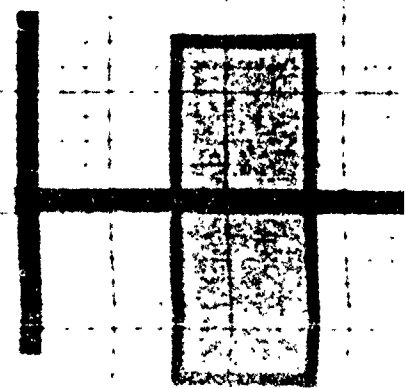
81 BENCH 24 X 72

82 BENCH 34 X 72

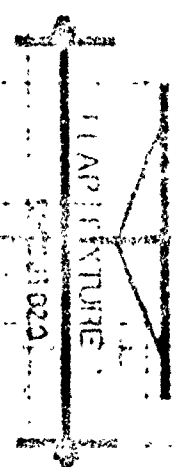
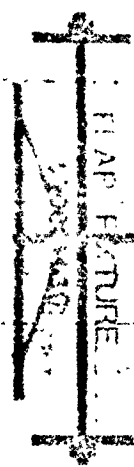
83 BENCH 34 X 72

84 BENCH 34 X 72

85 BENCH 34 X 72



SHIPPING & RECEIVING



Foreman

TRANSFORMER

FIBERGLASS

SCALE

PIT

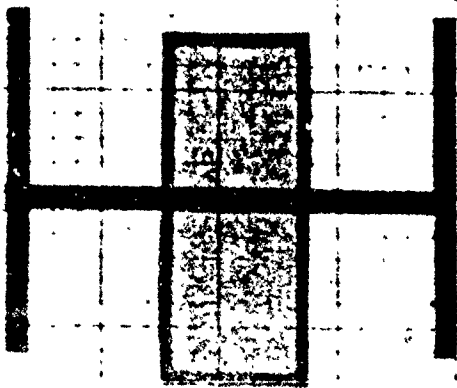
24 X 36

BENCH  
34 X 72

BENCH  
34 X 72

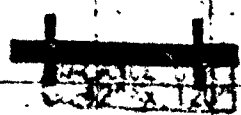
PIT

BENCH  
34 X 72



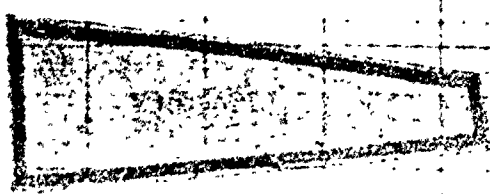
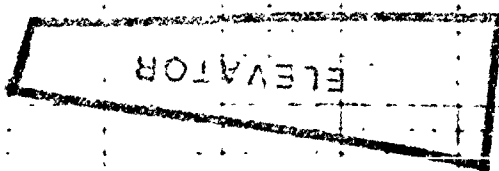
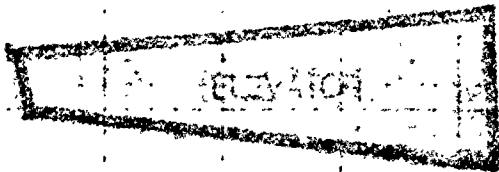
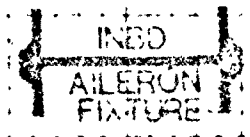
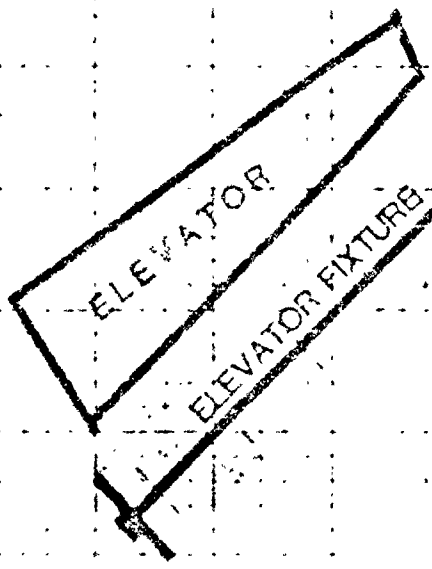
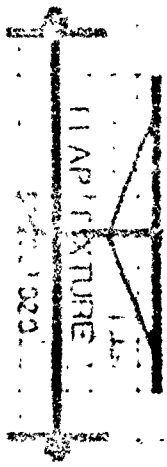
SHIPPING  
& RECEIVING

PAINT  
LIGHT  
BOOTH



WEIGHT/BALANCE

I



IB

30 X 76

IB

30 X 76

IB

30 X 76

IB

30 X 76

IB

30 X 76

IB

30 X 76

IB

30 X 76

IB

30 X 76

IB

30 X 76

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30 X 76

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30 X 76

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30 X 76

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30 X 76

IB

30 X 76

TRANSFORMER

BENCH  
34 X 72

INBD  
AILERON  
FIXTURE



BENCH  
34 X 72

BENCH  
34 X 72

PIT

BENCH  
34 X 72

BENCH  
34 X 72

PIT

BALANCE BEAM 42 X 240

WEIGHT/BALANCE

INBD  
AILERON  
FIXTURE

INBD  
AILERON  
FIXTURE

INBD  
AILERON  
FIXTURE

OTBD AILERON FIXTURE

FORTRAN

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BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72



CM  
72

BENCH  
34 X 72

PIT

ANCE BEAM 42 X 240

Foreign

OTPC AIRCRAFT FIXTURE

BENCH  
34 X 72

18

BENCH  
34 X 72

18

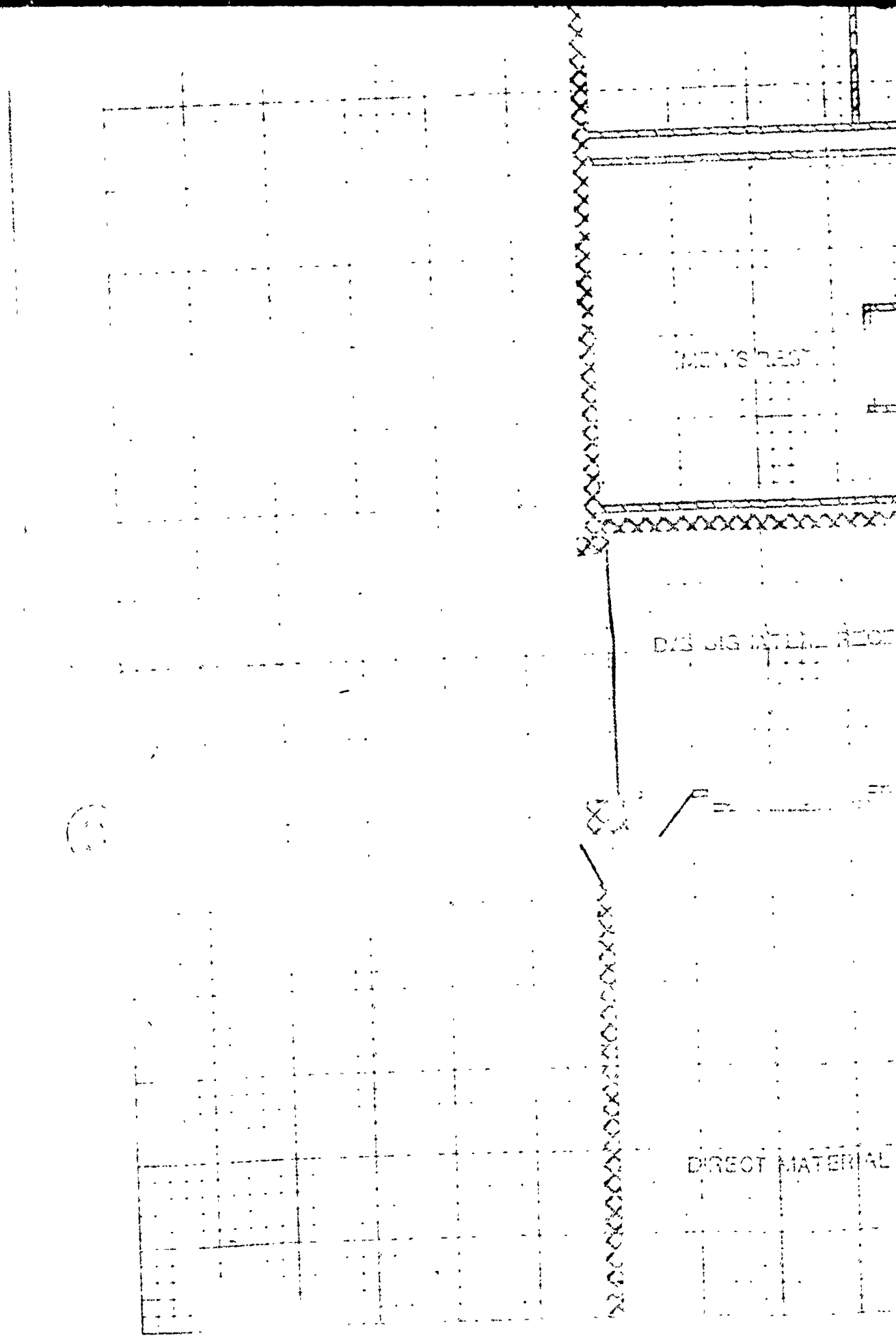
BENCH  
34 X 72

18

BENCH  
34 X 72

18

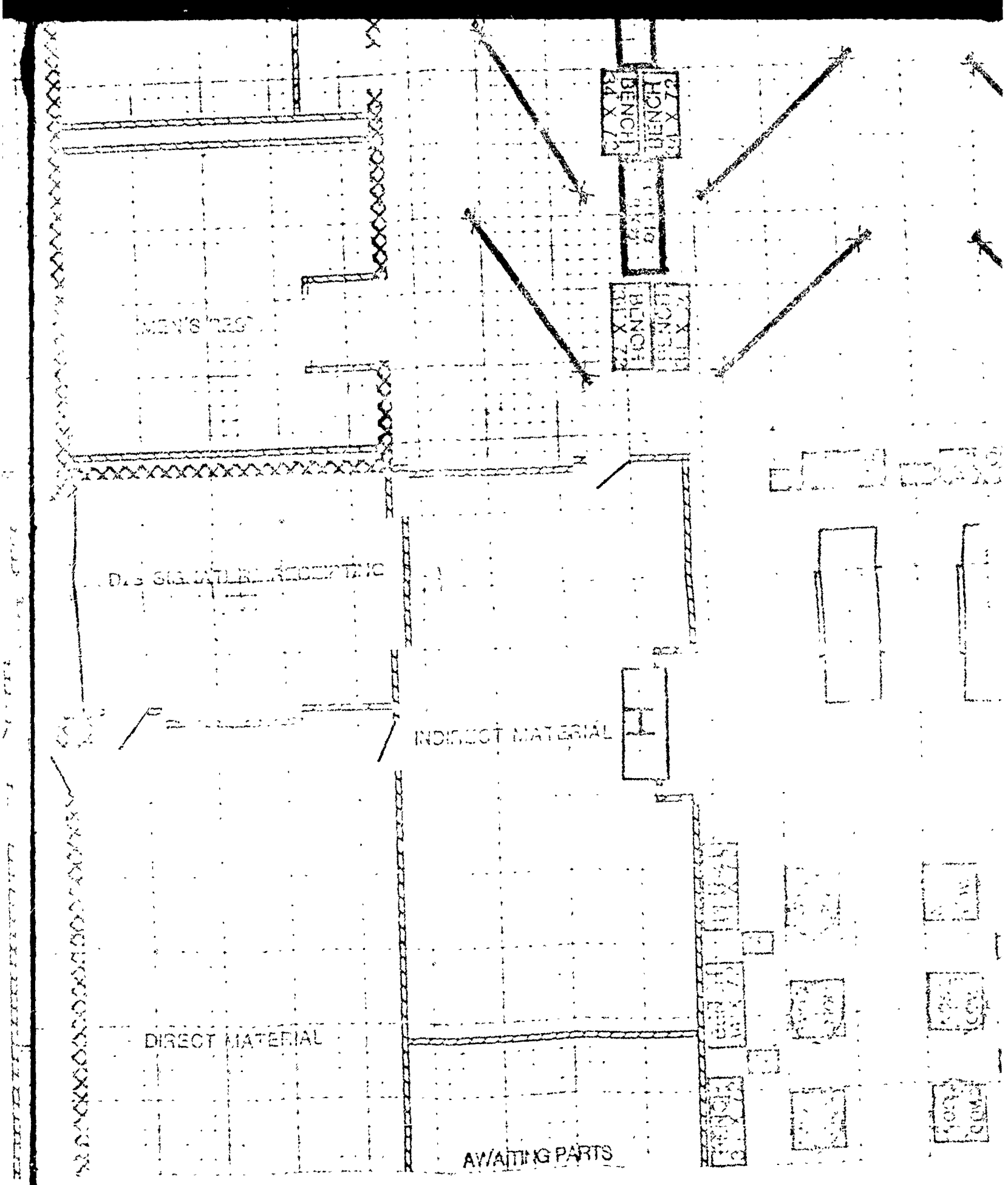
BENCH  
34 X 72



1-TL

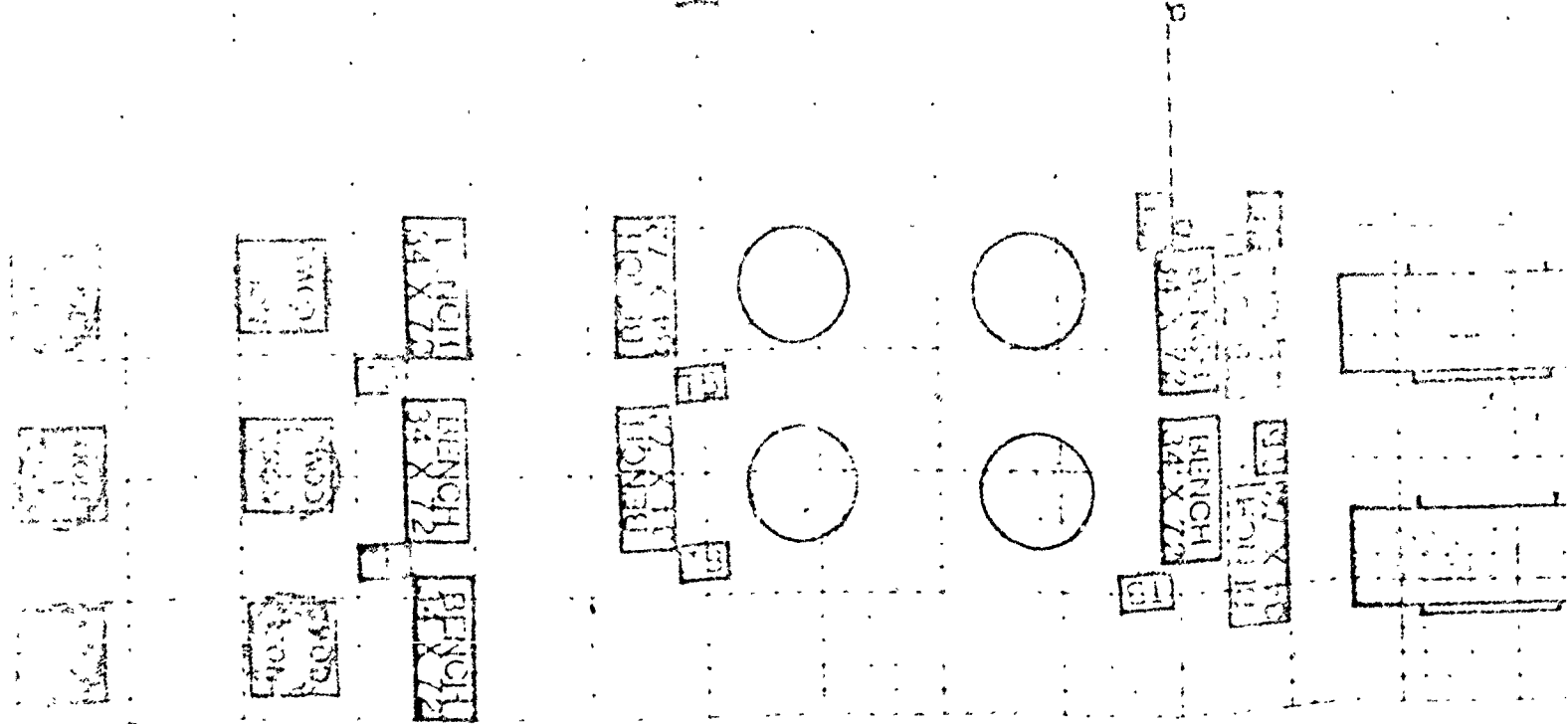
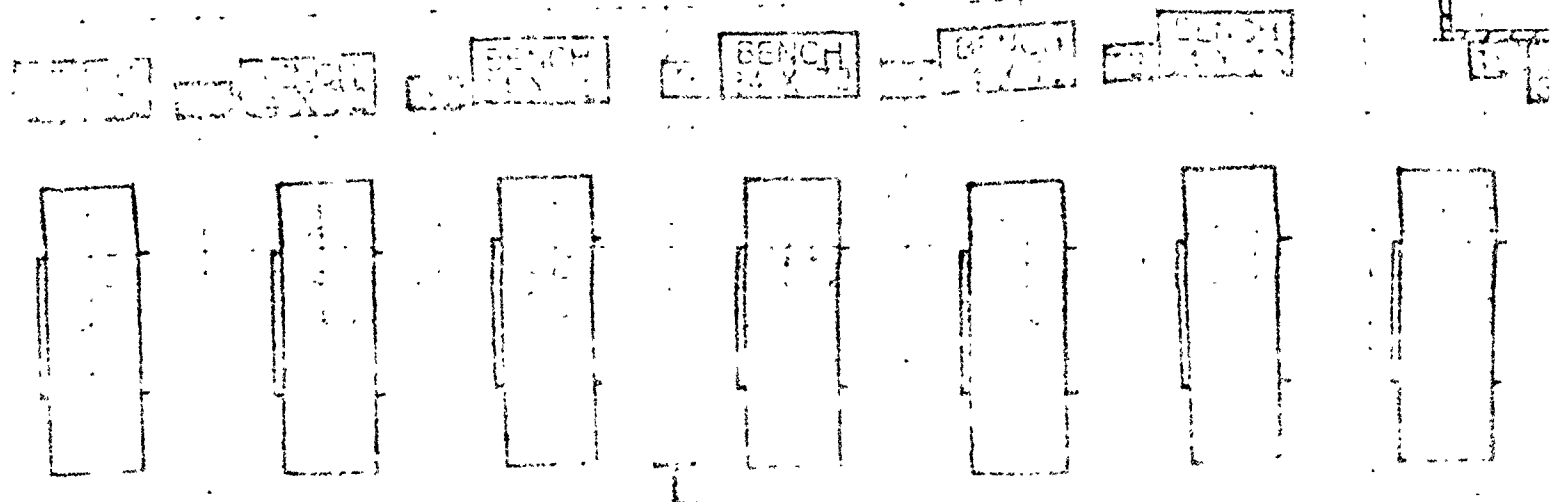
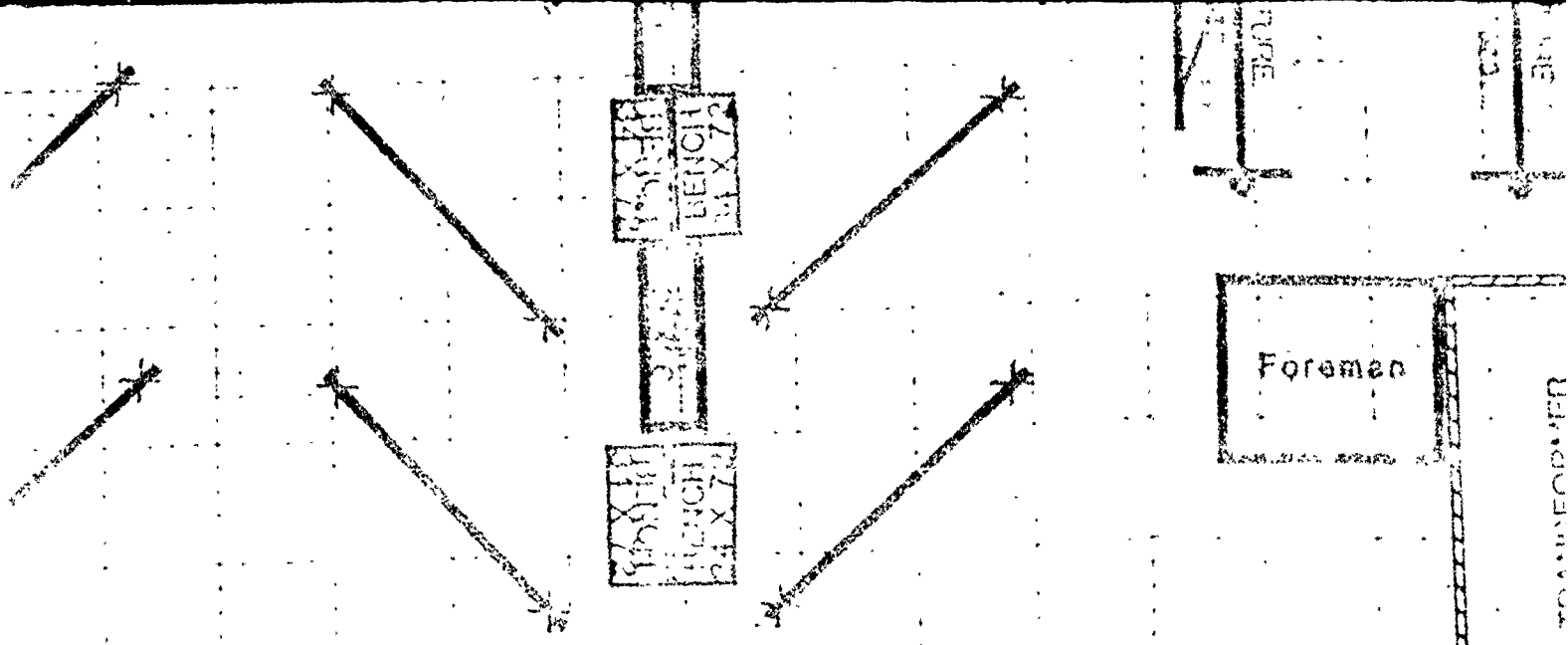
BLDG 2101

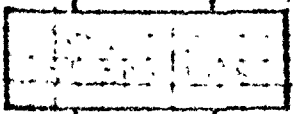
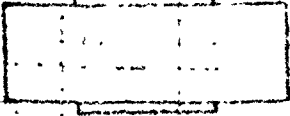
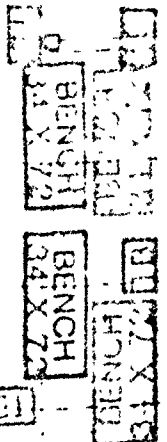
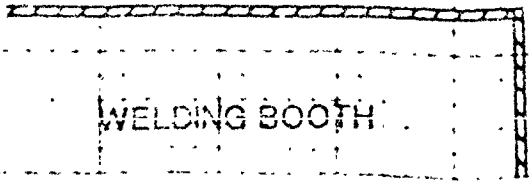
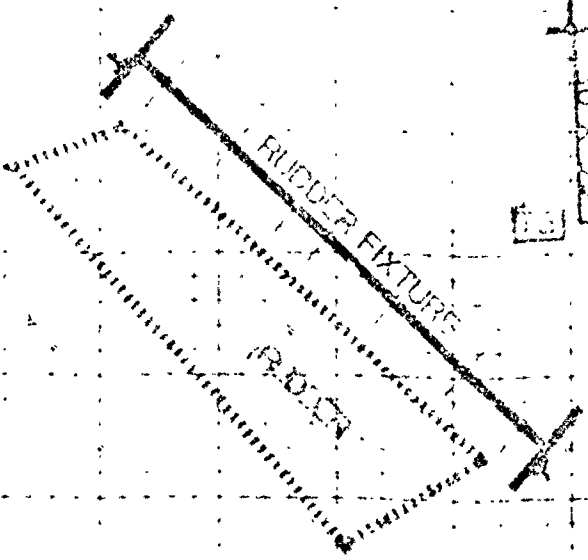
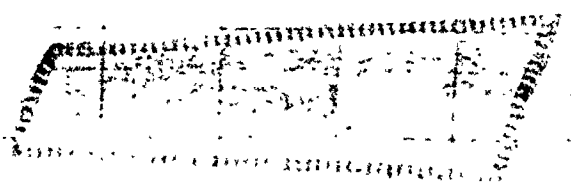
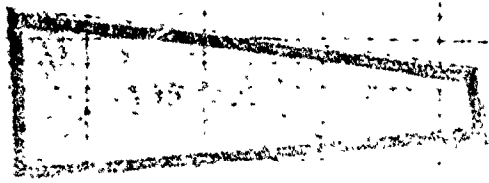
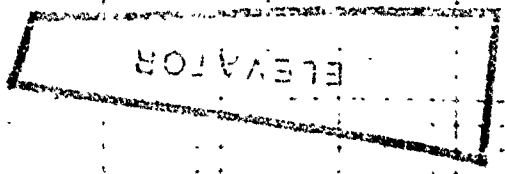
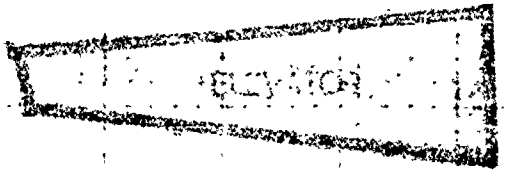
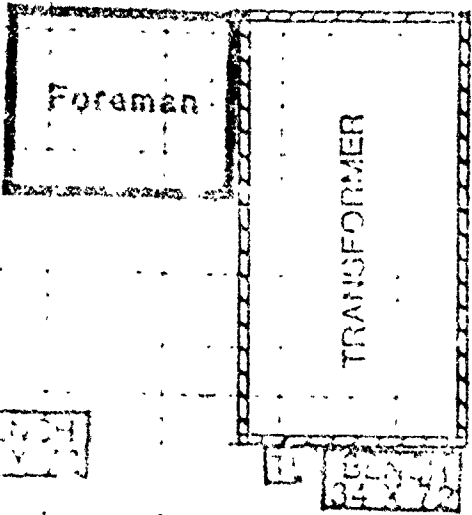
△N



2101







30 X 50 1114 30 X 90 1114 30 X 90

30 X 50

AVIATION  
FIXTURES

AVIATION  
FIXTURES

ELEVATOR

ELEVATOR

ELEVATOR

ELEVATOR

RIGGER FIXTURES  
RIGGER

WING BOOTH

BENCH  
30 X 72

BENCH  
30 X 96

BENCH  
30 X 96

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

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30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

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18

AVIATION  
FIXTURES

BENCH  
30 X 72

19

BENCH  
30 X 72

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BENCH  
30 X 72

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BENCH  
30 X 72

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BENCH  
30 X 72

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BENCH  
30 X 72

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BENCH  
30 X 72

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BENCH  
30 X 72

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BENCH  
30 X 72

27

BENCH  
30 X 72

28

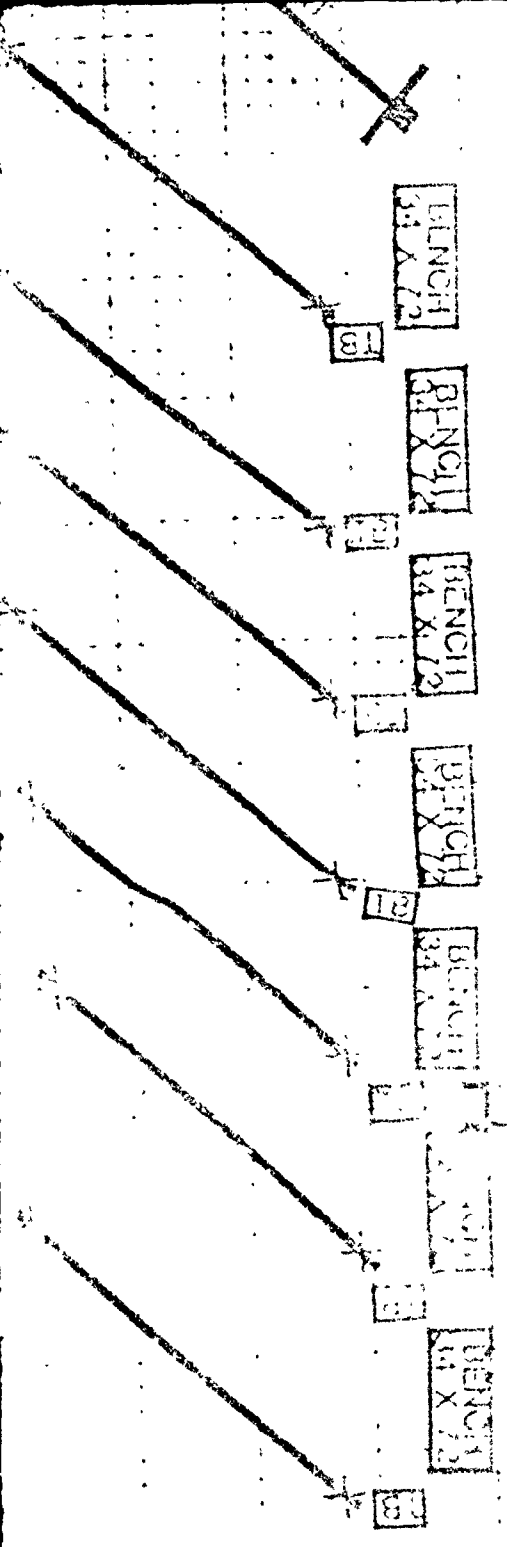
SPOLLER FIXTURE

19

SPOLLERS

SPOLLER FIXTURE

18



BENCH  
34 X 72

13

BENCH  
34 X 72

13

BENCH  
34 X 72

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BENCH  
34 X 72

13

BENCH  
34 X 72

13

BENCH  
34 X 72

13

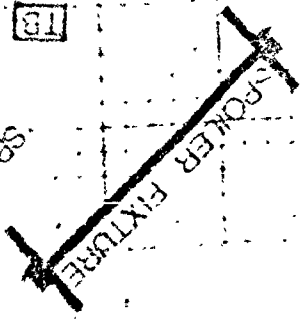
BENCH  
34 X 72

13

BENCH  
34 X 72

13

13



13

(D)

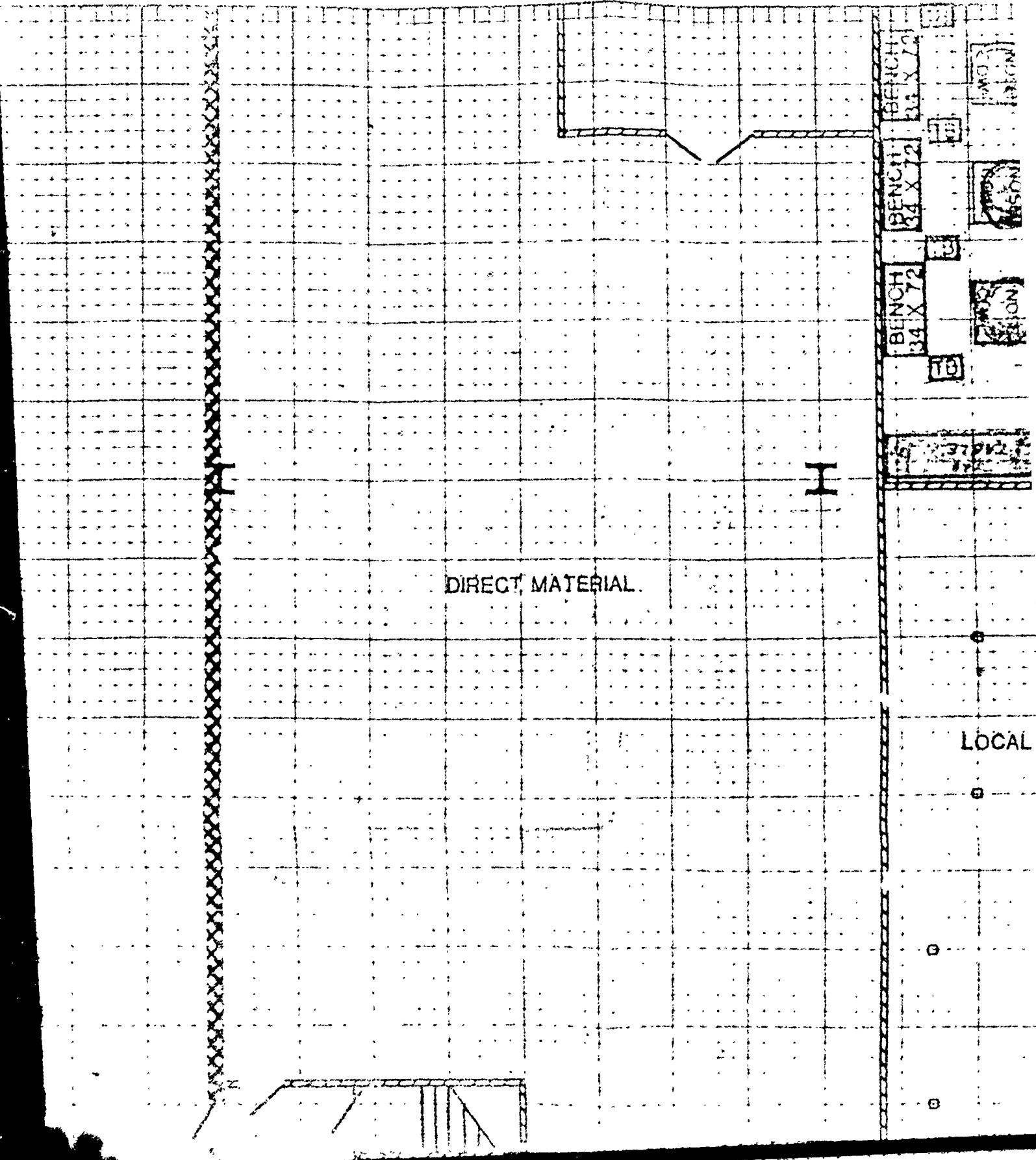
A large grid of graph paper with a vertical column of 'X' marks in the center. A circled 'D' is on the left and a circled '2' is at the top center.

DIRECT



(1)

(2)



DIRECT MATERIAL

LOCAL

BENCH  
33 X 79

BENCH  
34 X 72

BENCH  
34 X 72

T.B.

T.B.

T.B.

MASON

MASON

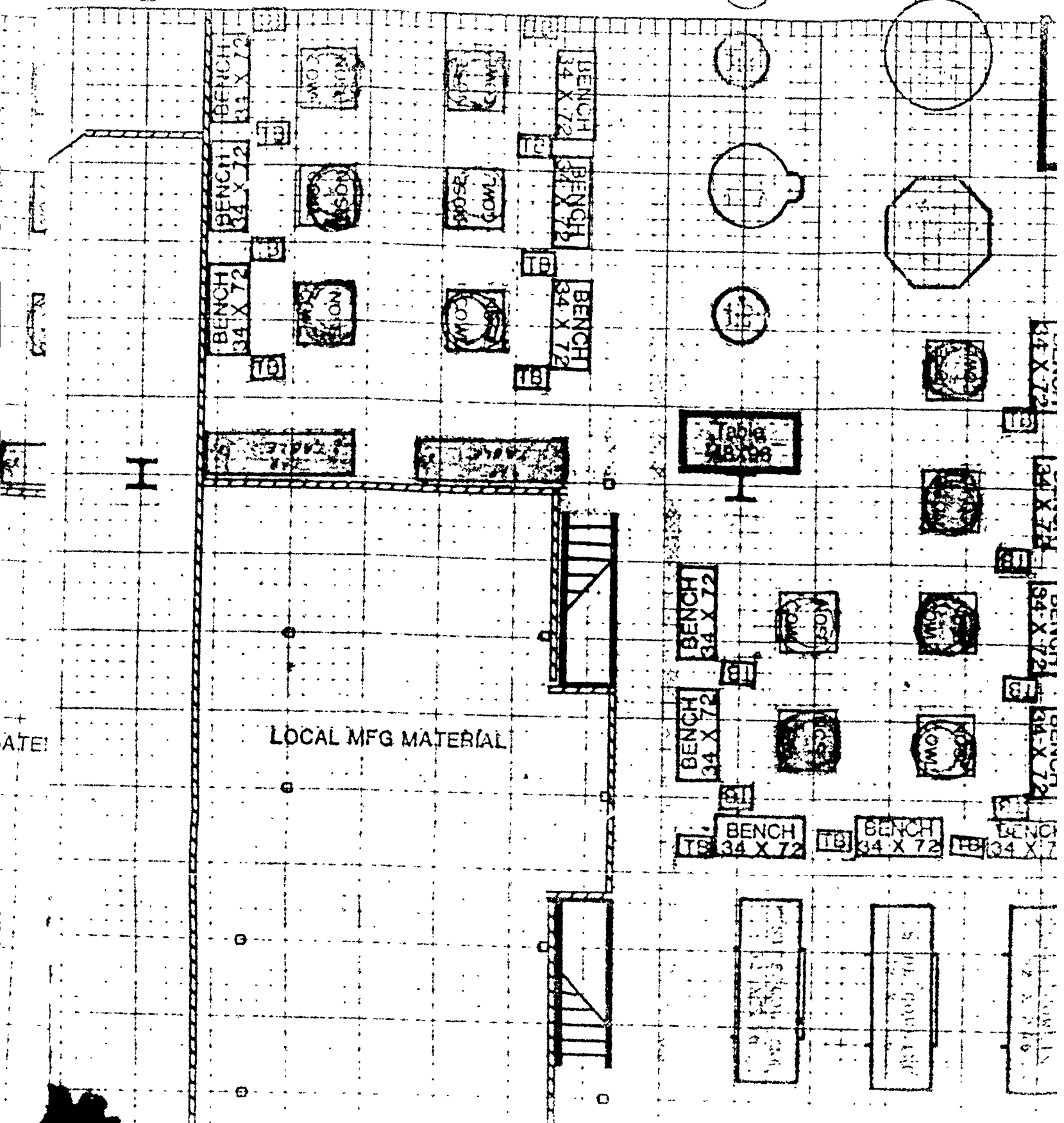
MASON

MASON

H

2

3



BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

TABLE

TABLE

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

Table 48x96

BENCH 34 X 72

BENCH 34 X 72

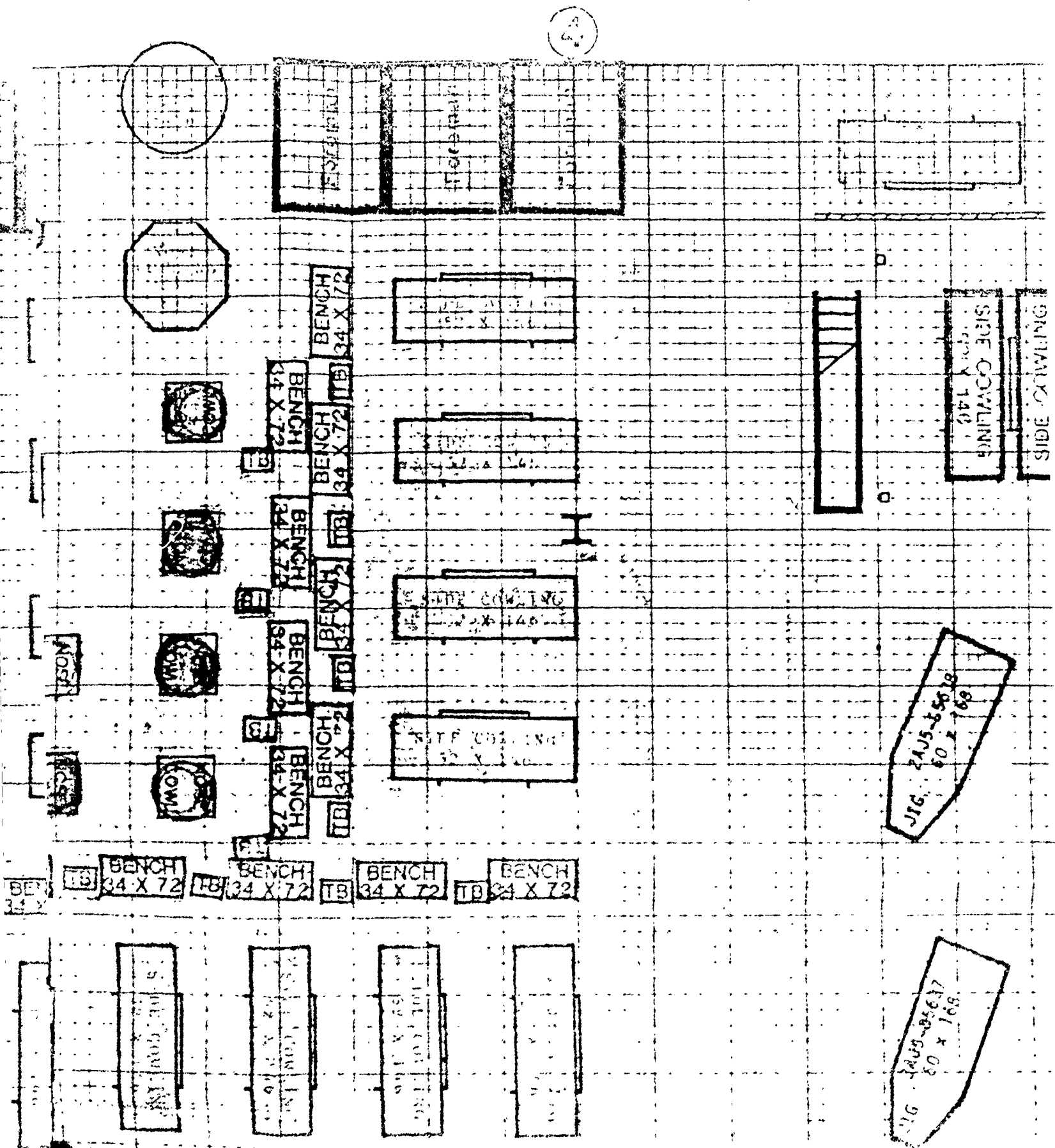
BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

LOCAL MFG MATERIAL

ATE



(2)

181

BENCH  
34 X 72

BENCH  
34 X 72

SIDE COWLING  
52 X 146

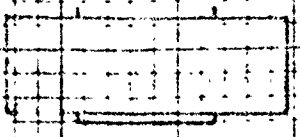
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52 X 146

SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146

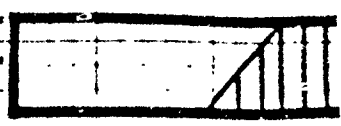
SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146



BENCH  
34 X 72

BENCH  
34 X 72

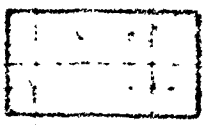
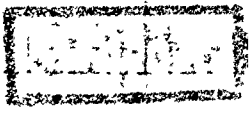
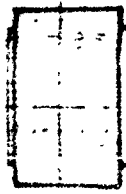
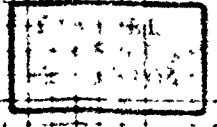
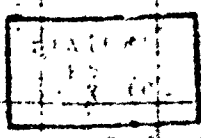


JIG 2AUS-05618  
50 X 168

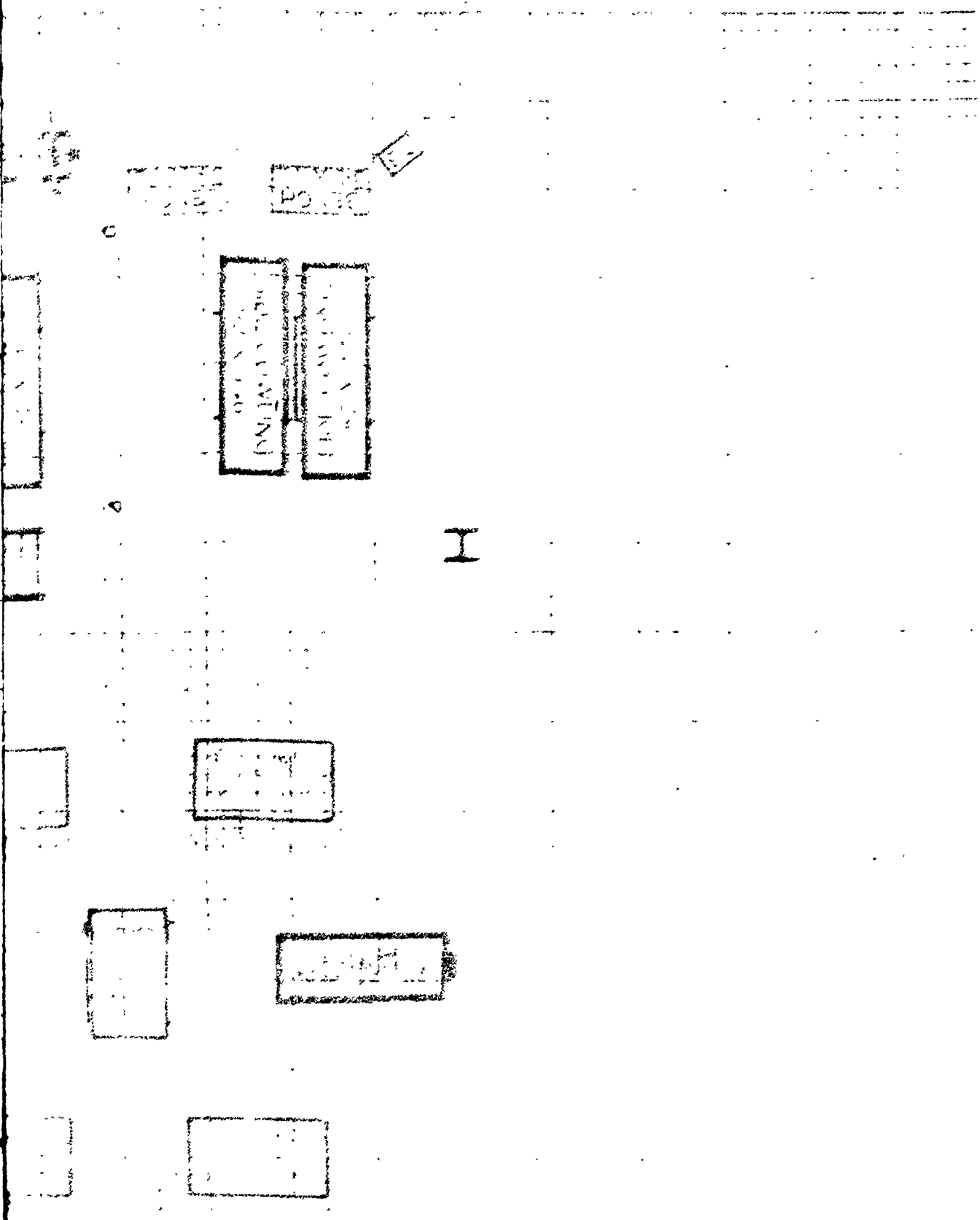
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JIG 2AUS-05617  
50 X 168

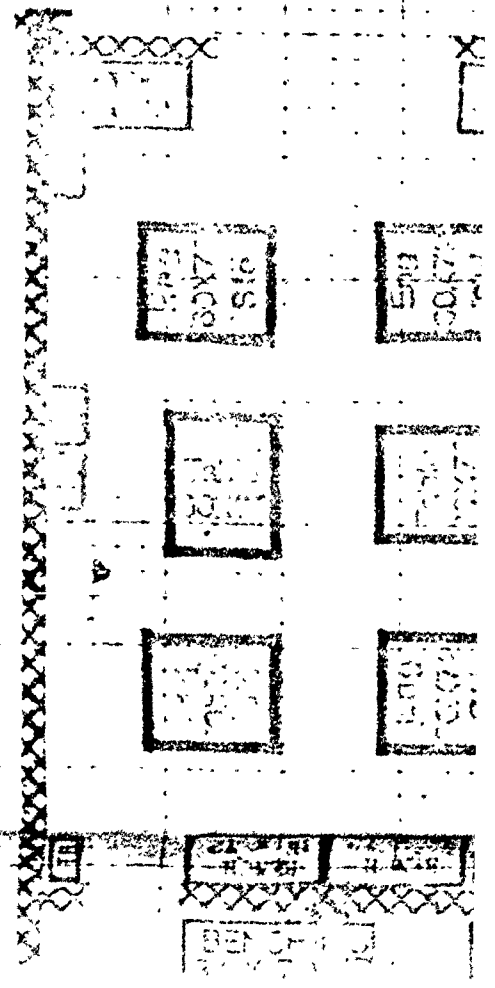
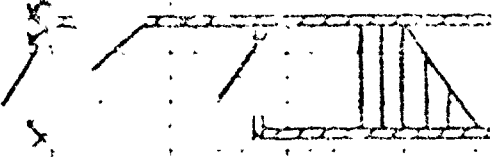
JIG 2AUS-05617  
50 X 168



68



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1007  
1008  
1009

1010  
1011  
1012

1013  
1014  
1015

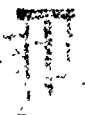
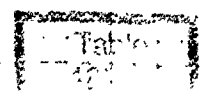
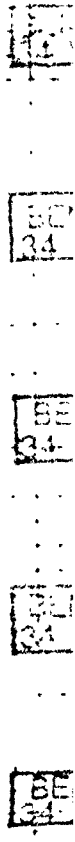
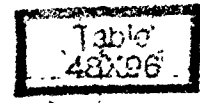
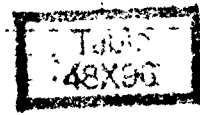
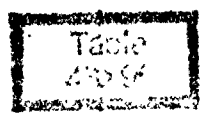
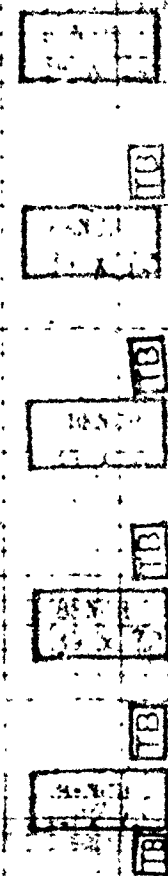
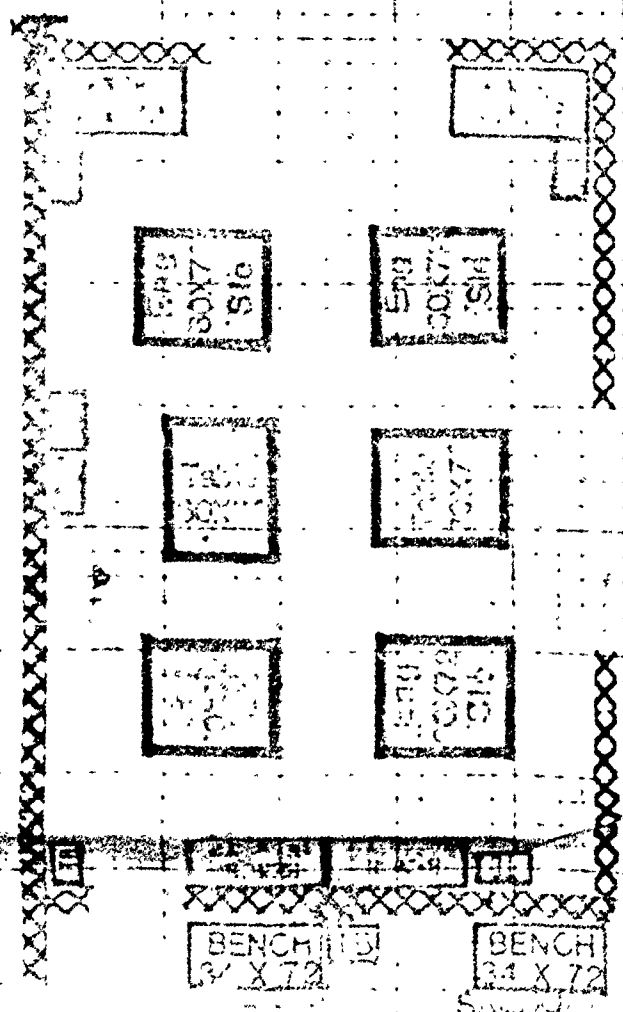
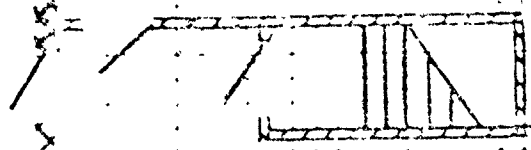
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1017  
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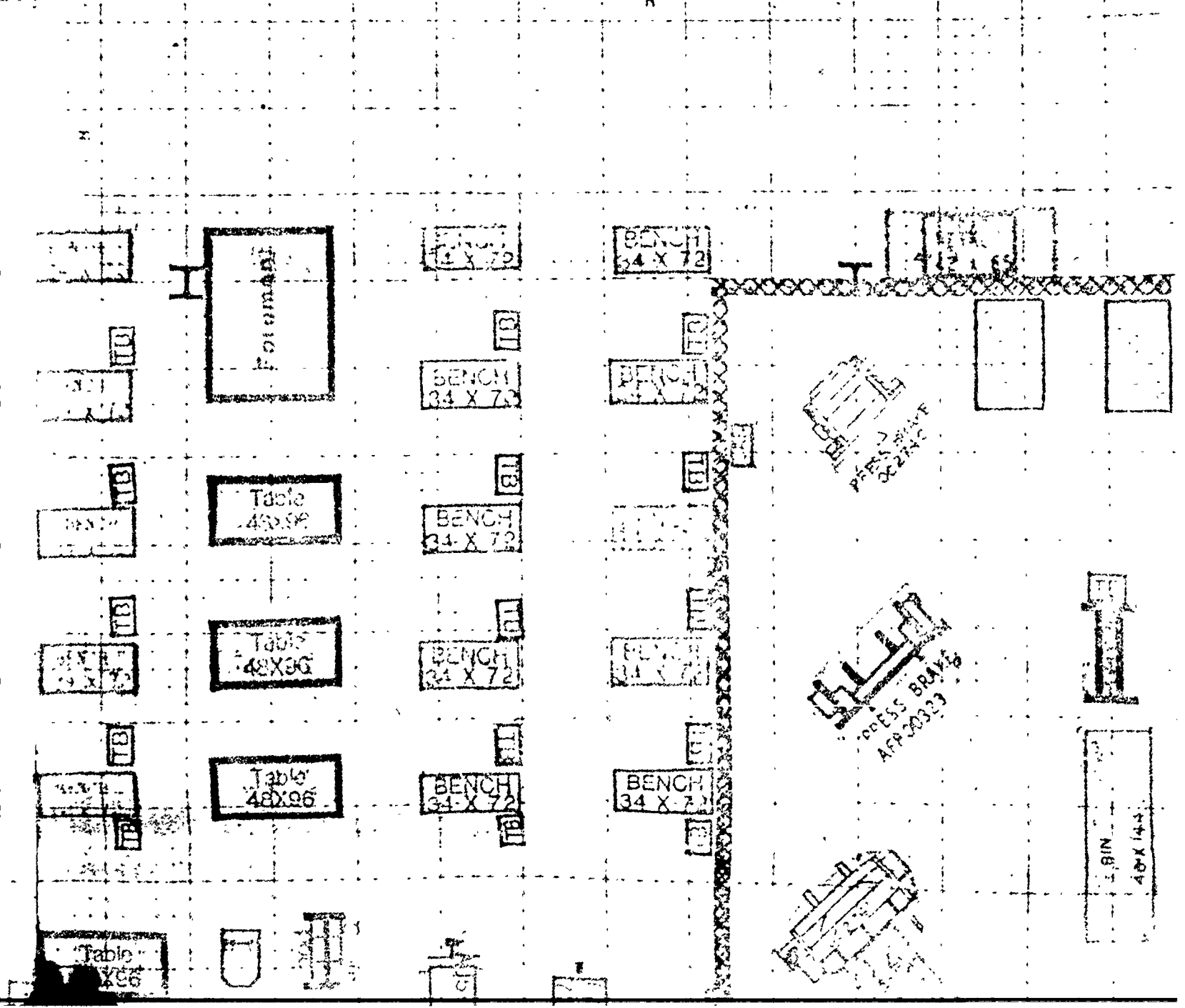
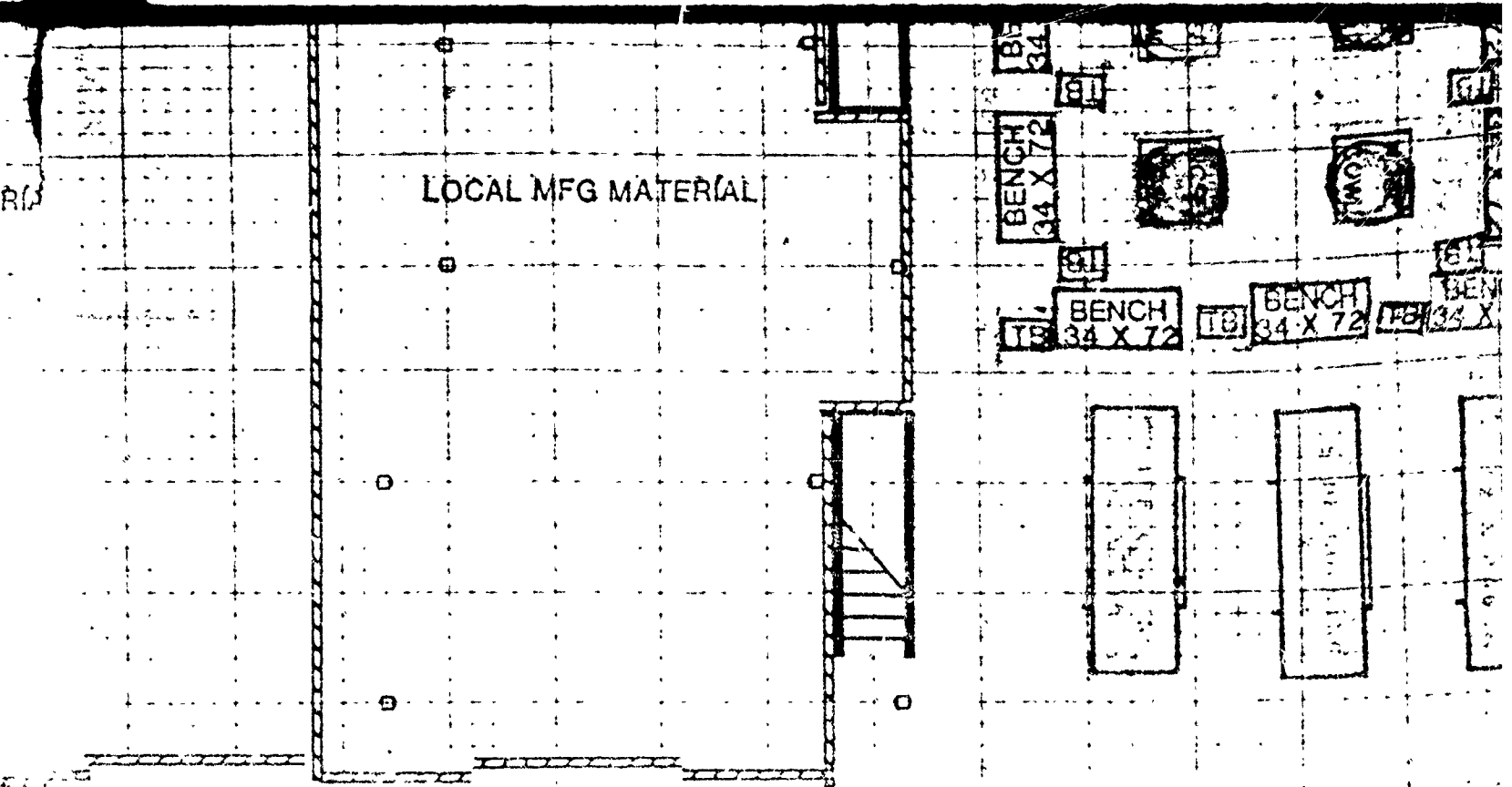
1019  
1020  
1021

1022  
1023  
1024

1025  
1026  
1027  
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1029  
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LOCAL MFG







JIG 2455

JIG 3405-8-1-1

BENCH  
34 X 72

BENCH  
34 X 72

TB BENCH  
34 X 72

TB BENCH  
34 X 72

TB BENCH  
34 X 72

TB BENCH  
34 X 72

TB BENCH  
34 X 72

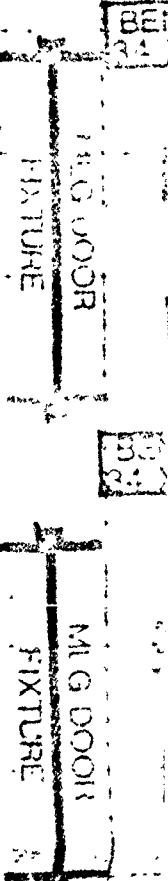
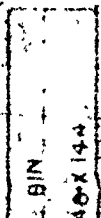
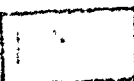
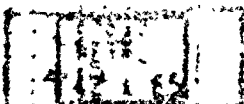
BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

STAFF CLOSET



APPROXIMATE PRESS DIBBLE

APPROXIMATE PRESS DIBBLE

00141

JIG 2405-85628  
50 X 168

JIG 2405-85628  
50 X 168

JIG 2405-91637  
50 X 168

JIG 2405-91637  
50 X 168

2405-85628  
50 X 168

2405-85628  
50 X 168

2405-85628  
50 X 168

2405-85628  
50 X 168

2405-85628  
50 X 168

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

STUT FIXTURE

STUT FIXTURE  
104 CAR

STUT FIXTURE

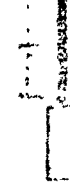
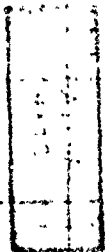
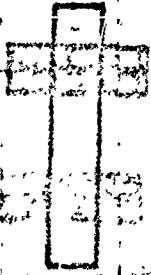
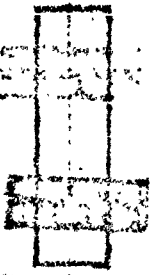
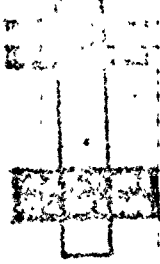
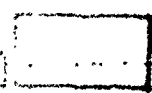
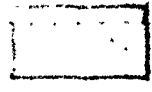
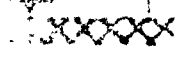
MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

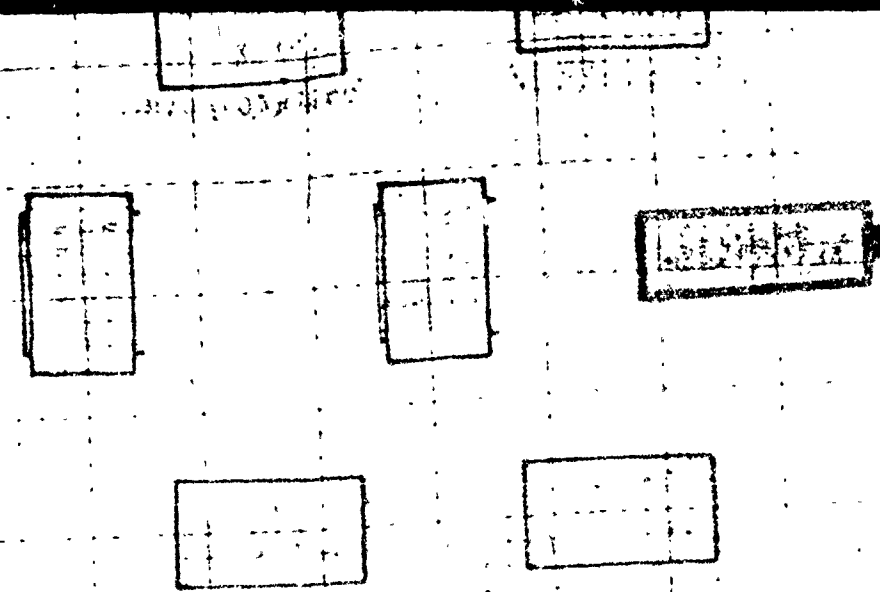
TRAILER  
45 X 108



50 X 168

50 X 168

50 X 168



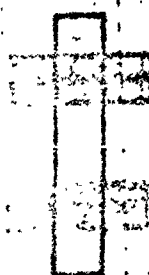
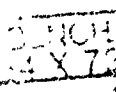
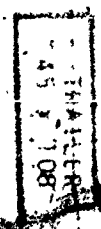
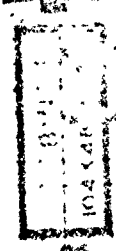
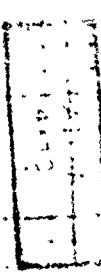
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FIXTURE

MILITARY DOOR  
FIXTURE

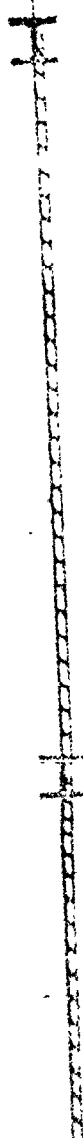
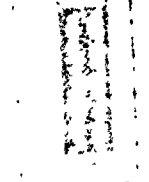
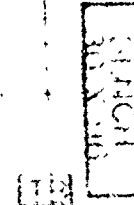
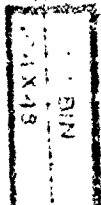
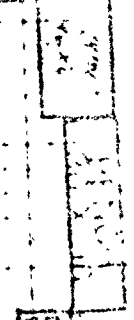
STRUT FIXTURE

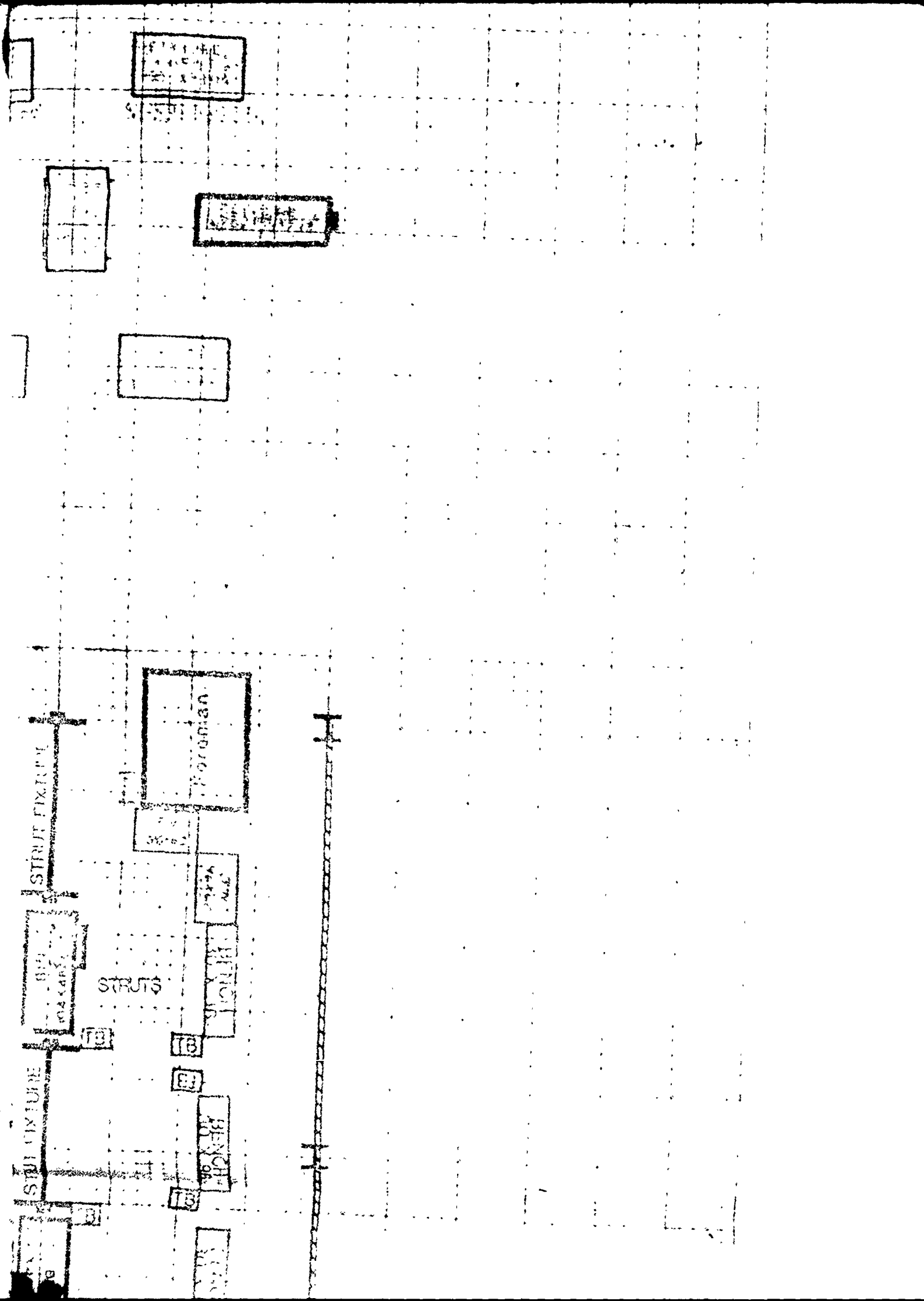
STRUT FIXTURE

PROVISION



STRUTS





MACHINE

STITCH

MACHINE

STITCH

STREET FIXTURE

MORNING

MACHINE

MACHINE

STREET

STREET FIXTURE

BENCH

MACHINE

13

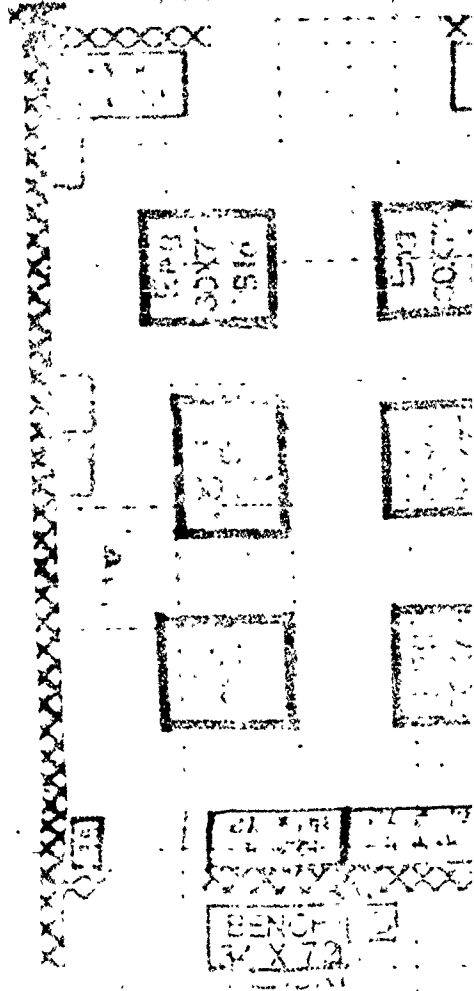
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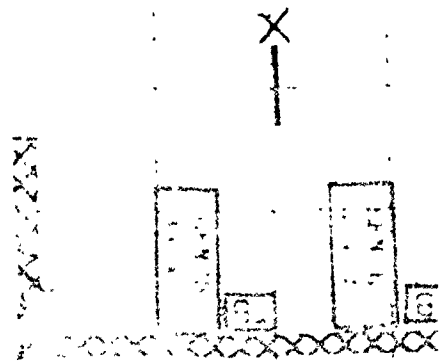
15

16

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2-TINKER

BLDG 2101

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STOVE

Formal

BENCH 34 X 72

BENCH 34 X 72

STOVE

BENCH 34 X 72

IB

BENCH 34 X 72

IB

BENCH 34 X 72

IB

STOVE

STOVE

BENCH 34 X 72

IB

Table 48X96

BENCH 34 X 72

IB

BENCH 34 X 72

IB

BENCH 34 X 72

IB

Table 48X96

BENCH 34 X 72

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BENCH 34 X 72

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BENCH 34 X 72

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Table 48X96

BENCH 34 X 72

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BENCH 34 X 72

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BENCH 34 X 72

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BENCH 34 X 72

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BENCH 34 X 72

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BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

Table 48X96

STOVE

STOVE

STOVE

STOVE

BENCH 34 X 72

BENCH 34 X 72

Table 48X96

STOVE

STOVE

STOVE

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

BENCH 34 X 72

STOVE

X

X

X

N

825-11  
64 X 72

BENCH  
64 X 72

BENCH  
64 X 72

BENCH  
64 X 72

BENCH  
64 X 72

AVS  
73100

AVS  
73100

WRENCH  
7/16 DRIVE  
OC 2745

WRENCH  
7/16 DRIVE  
OC 2745

WRENCH  
7/16 DRIVE  
OC 2745

BIN  
48 X 14

TABLE  
61 X 95

OC 0141

OC 0141

OC 0132

OC 0145

OC 0131

OC 0131

OC 0131

OC 0131

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

STRUT FIXTURE

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

STRUT FIXTURE

TRAILER  
35 X 70

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

BENCH  
34 X 72

TRAILER  
35 X 70

TRAILER  
51 X 72

BENCH  
34 X 72

Scale  
1" = 10'

CO-272  
CO-273  
CO-274



STRUT FIXTURE

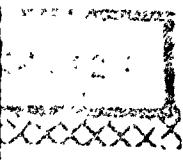
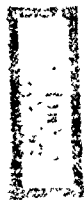
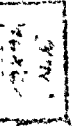
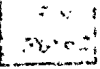
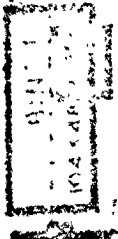
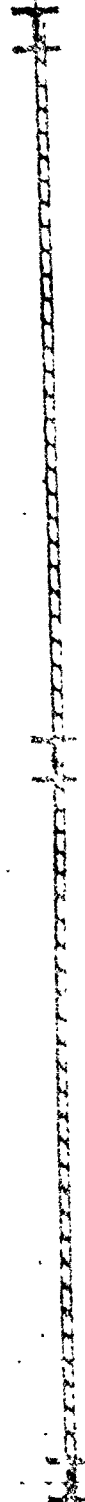
STRUT FIXTURE

FORUMIAN

STRUTS

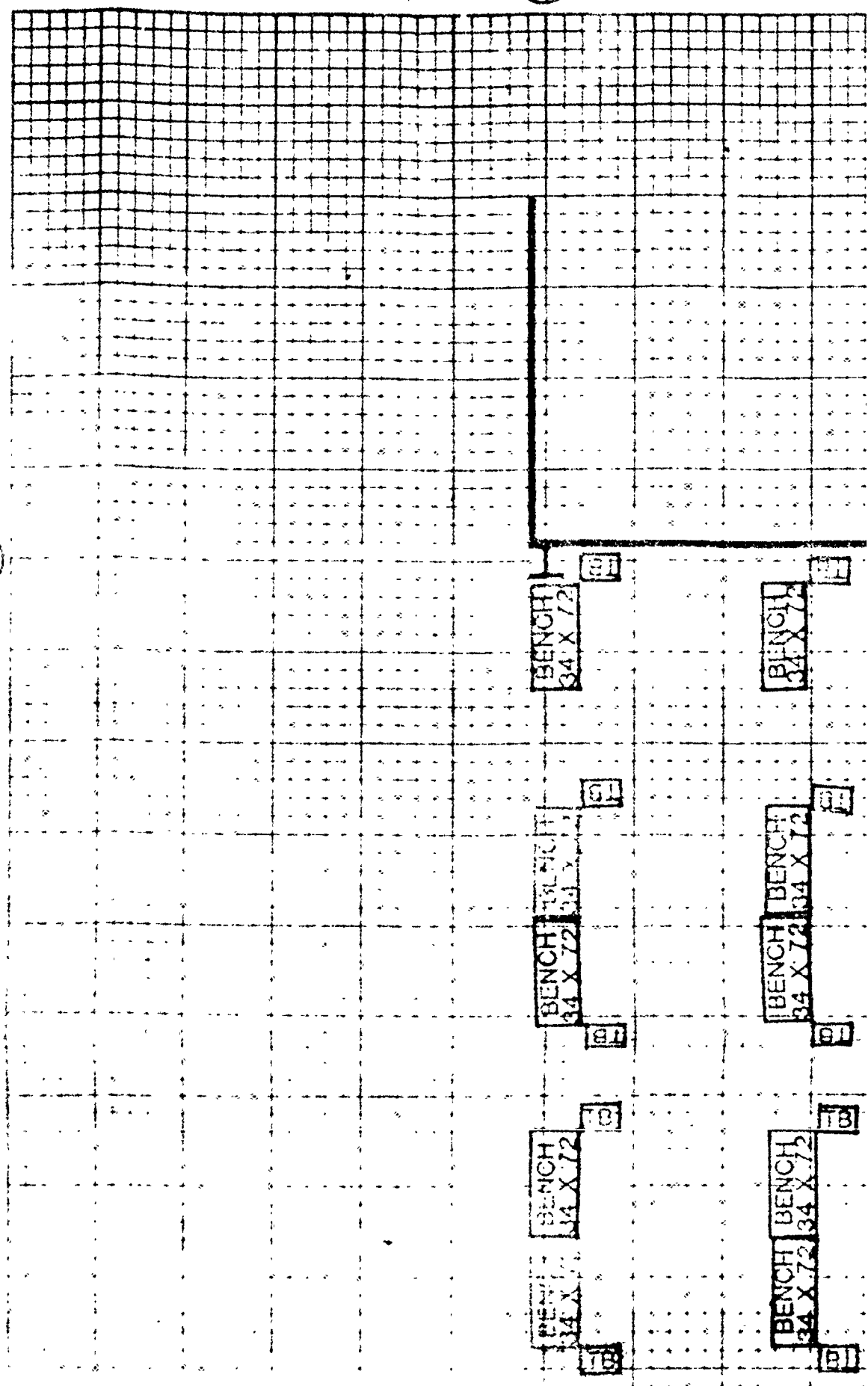
TWO LEW  
APPROX.

BENCH  
34 X 72



6

D



BENCH  
34 X 72

B

BENCH  
34 X 72

B

BENCH  
34 X 72

B

BENCH  
34 X 72

B

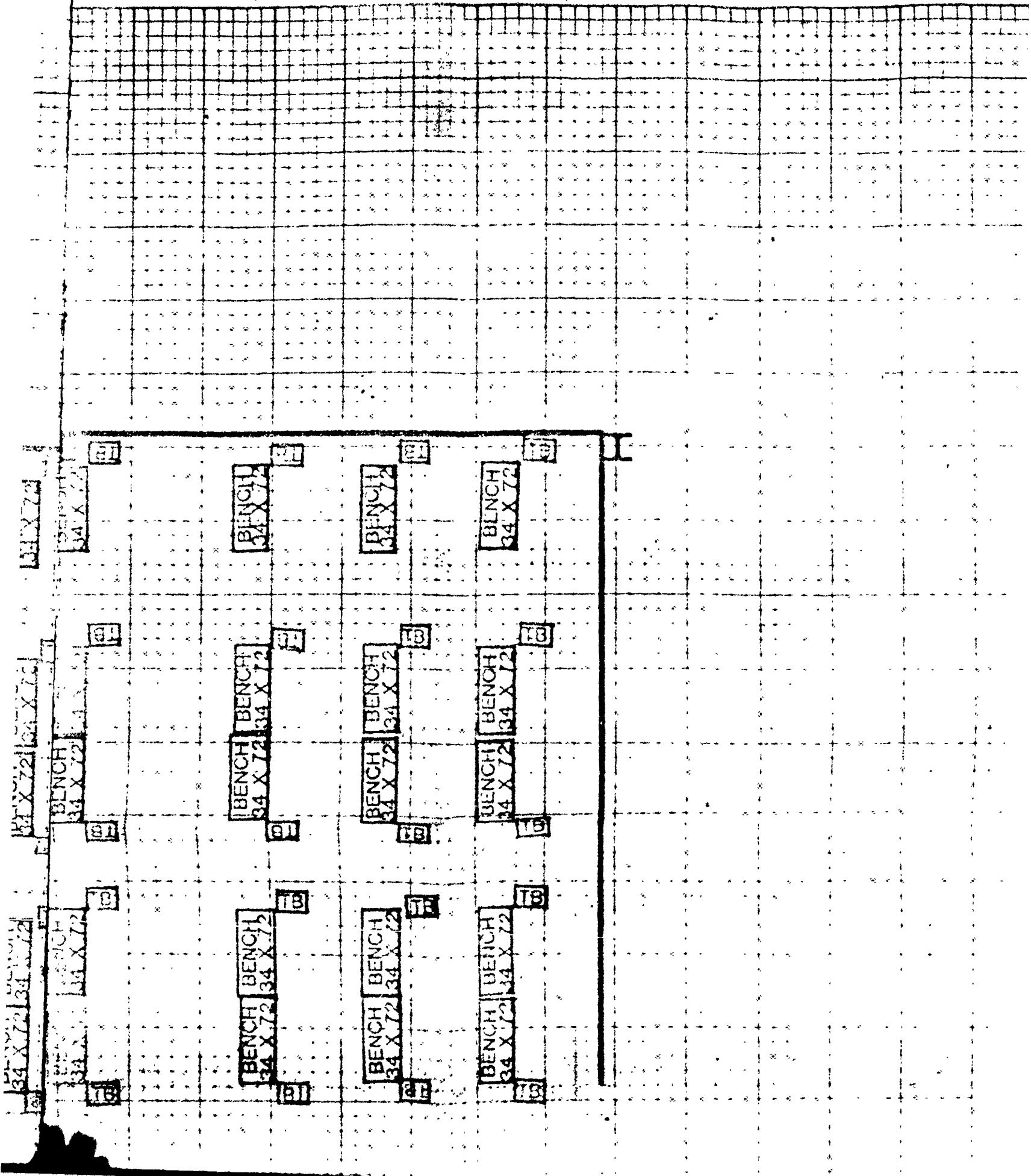
BENCH  
34 X 72

B

BENCH  
34 X 72

B

7



8

9

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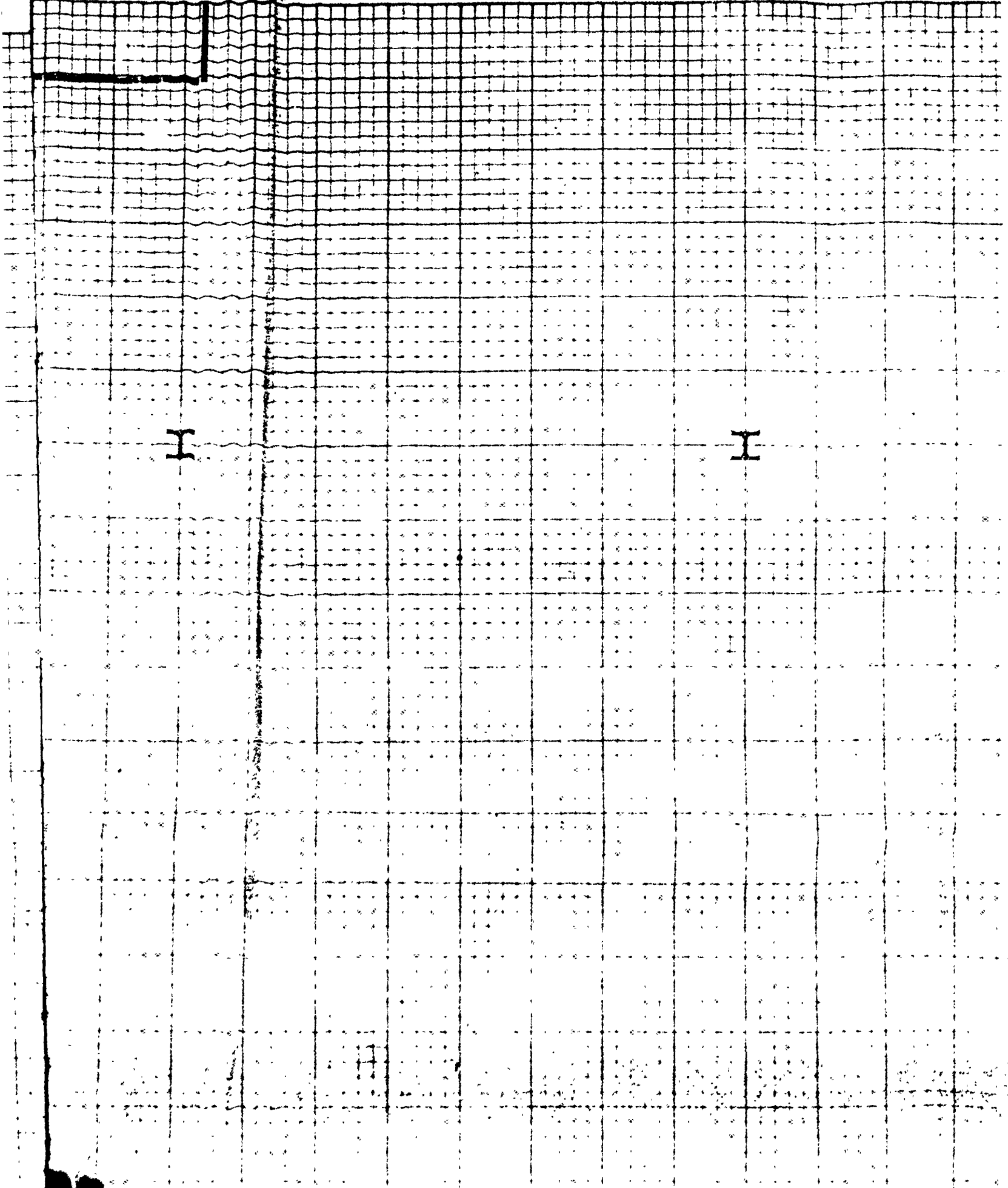
I

9

10

I

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11

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117

BENCH  
34 X 72

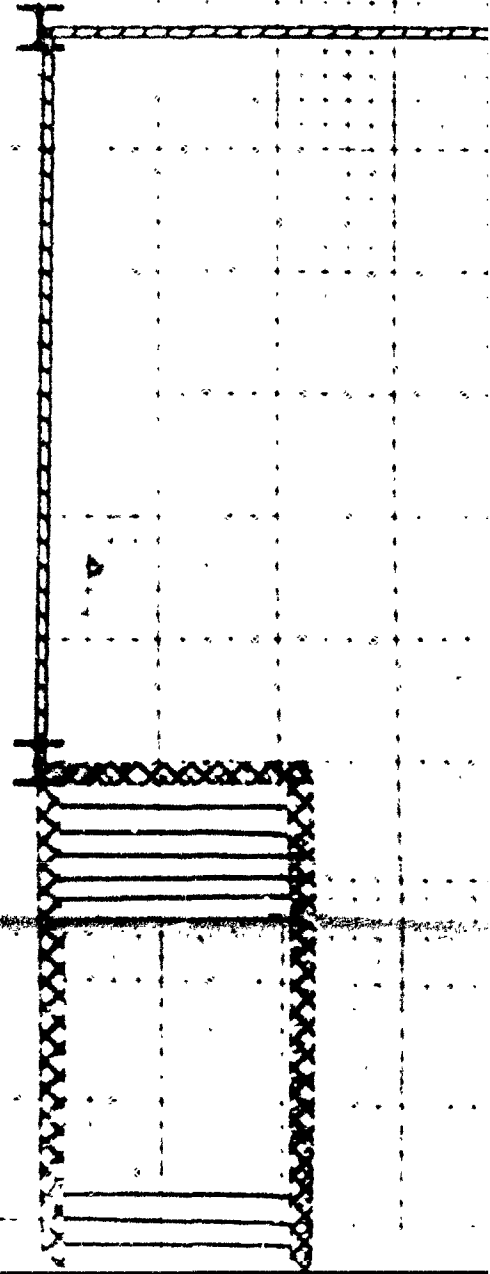
BENCH  
34 X 72

BENCH  
34 X 72

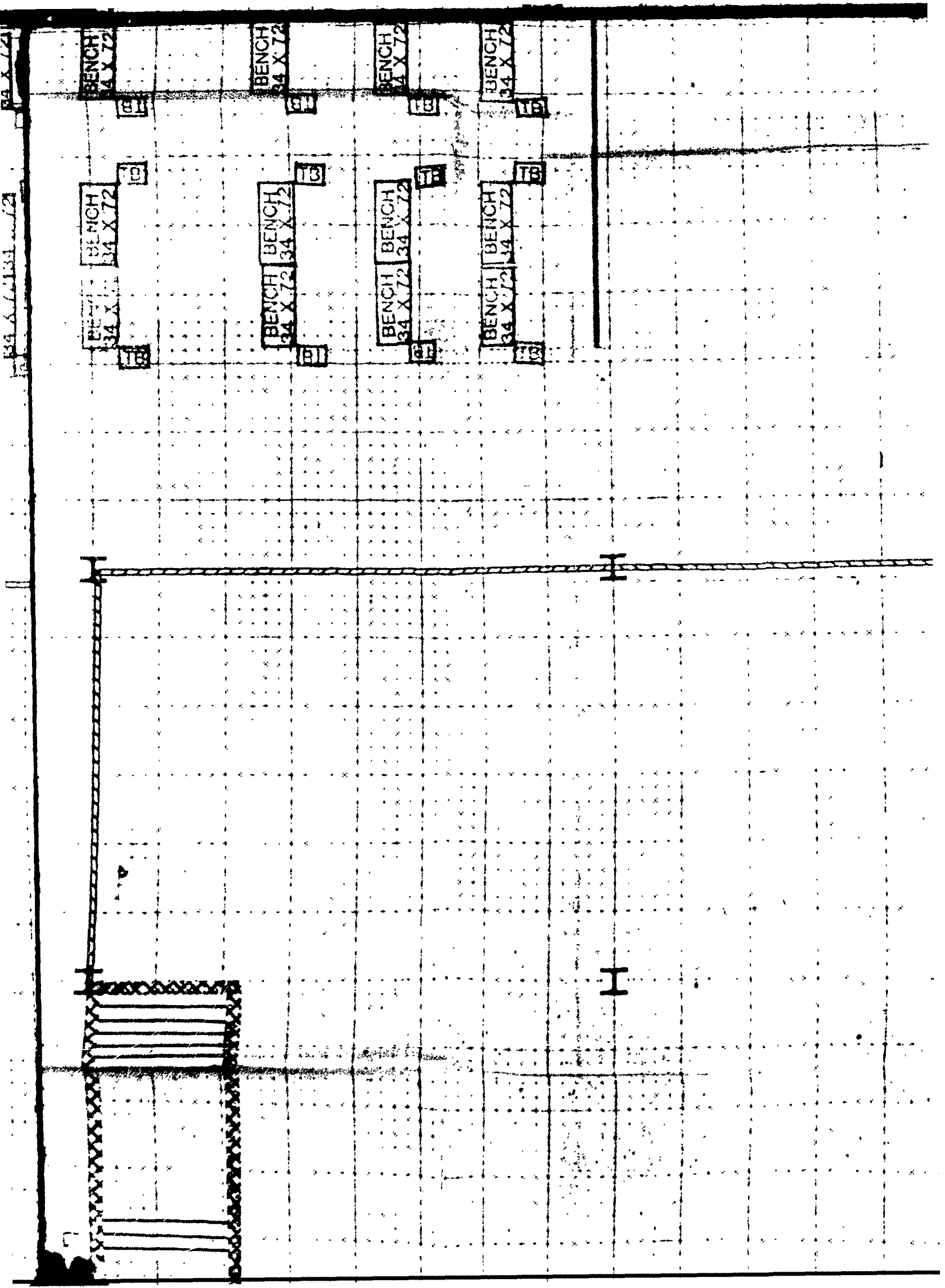
BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72







BENCH  
34 X 72

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34 X 72

BENCH  
34 X 72

TABLE

TABLE

TABLE

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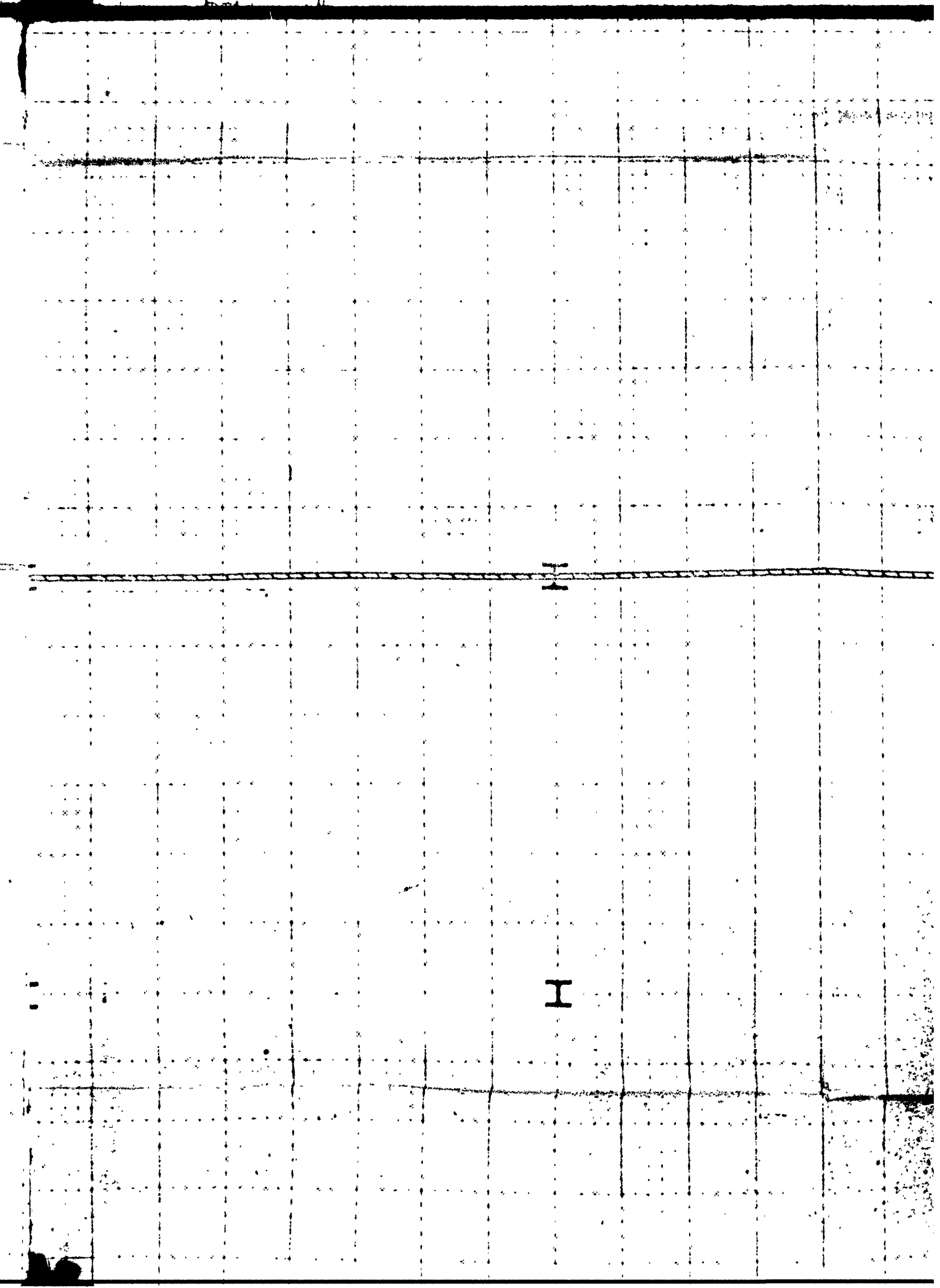
TABLE

TABLE

TABLE

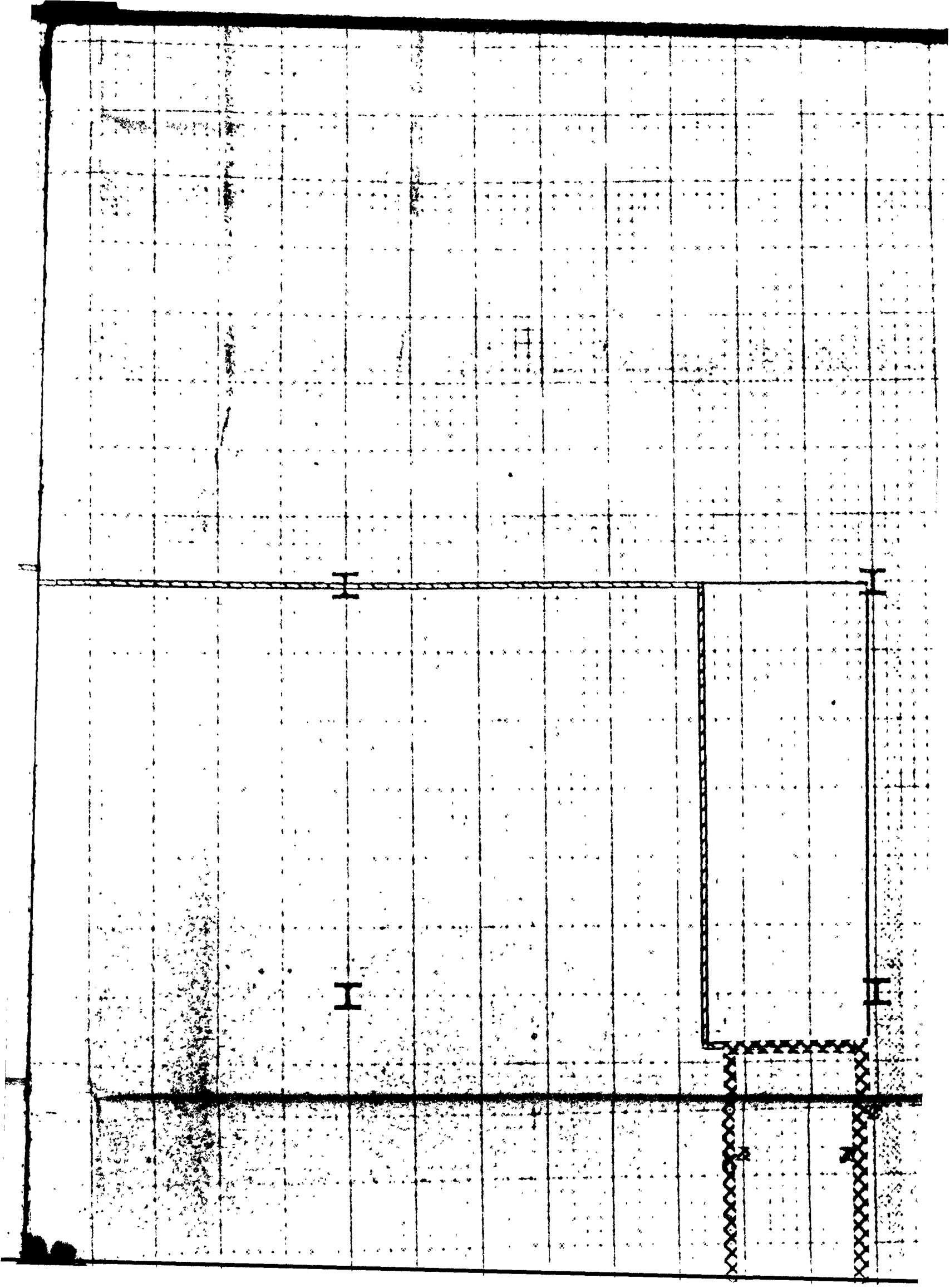
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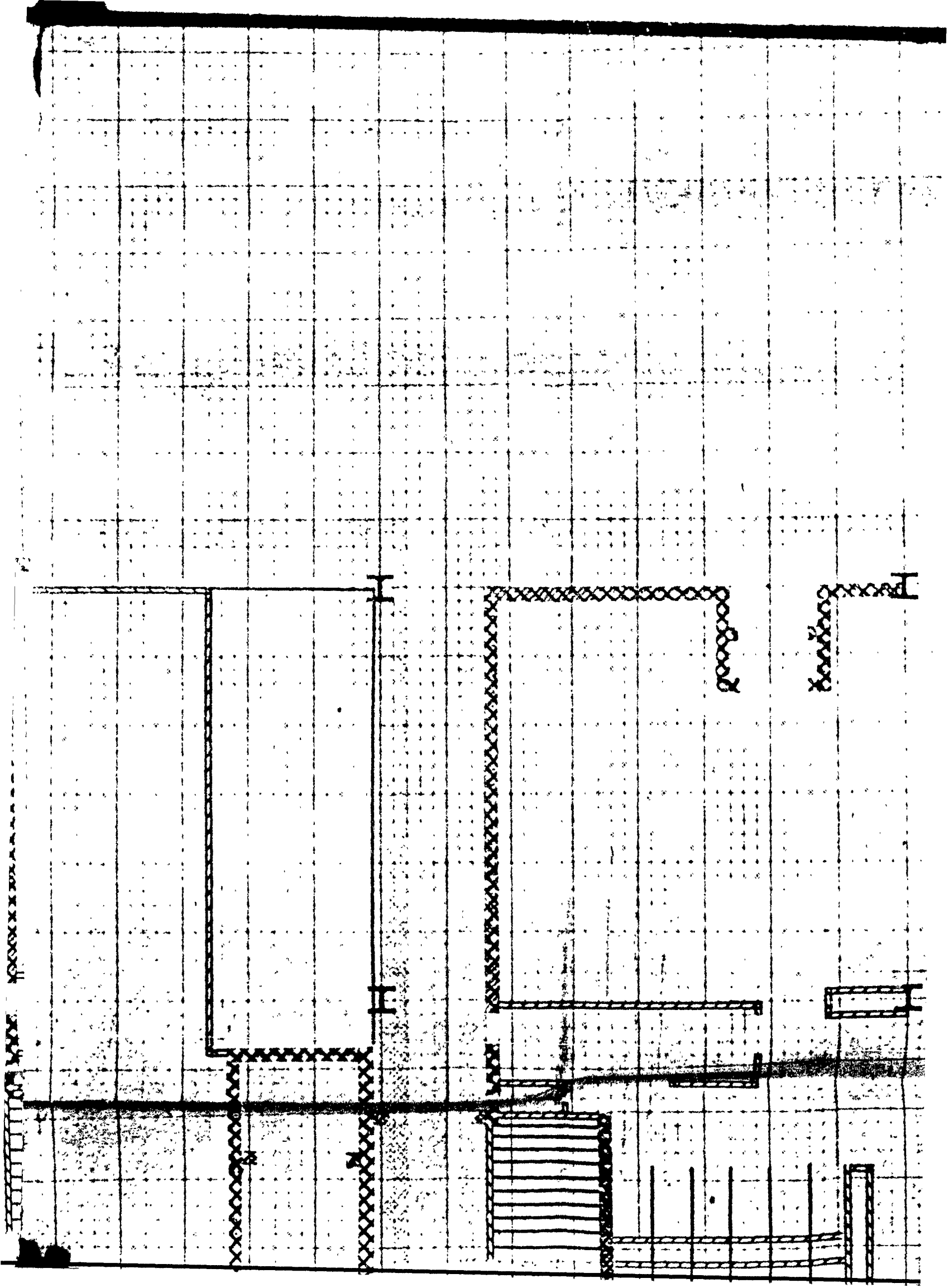
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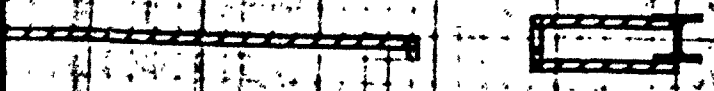
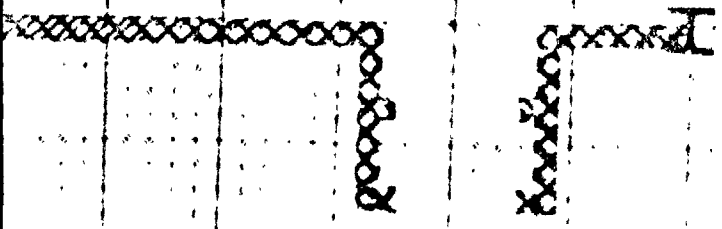


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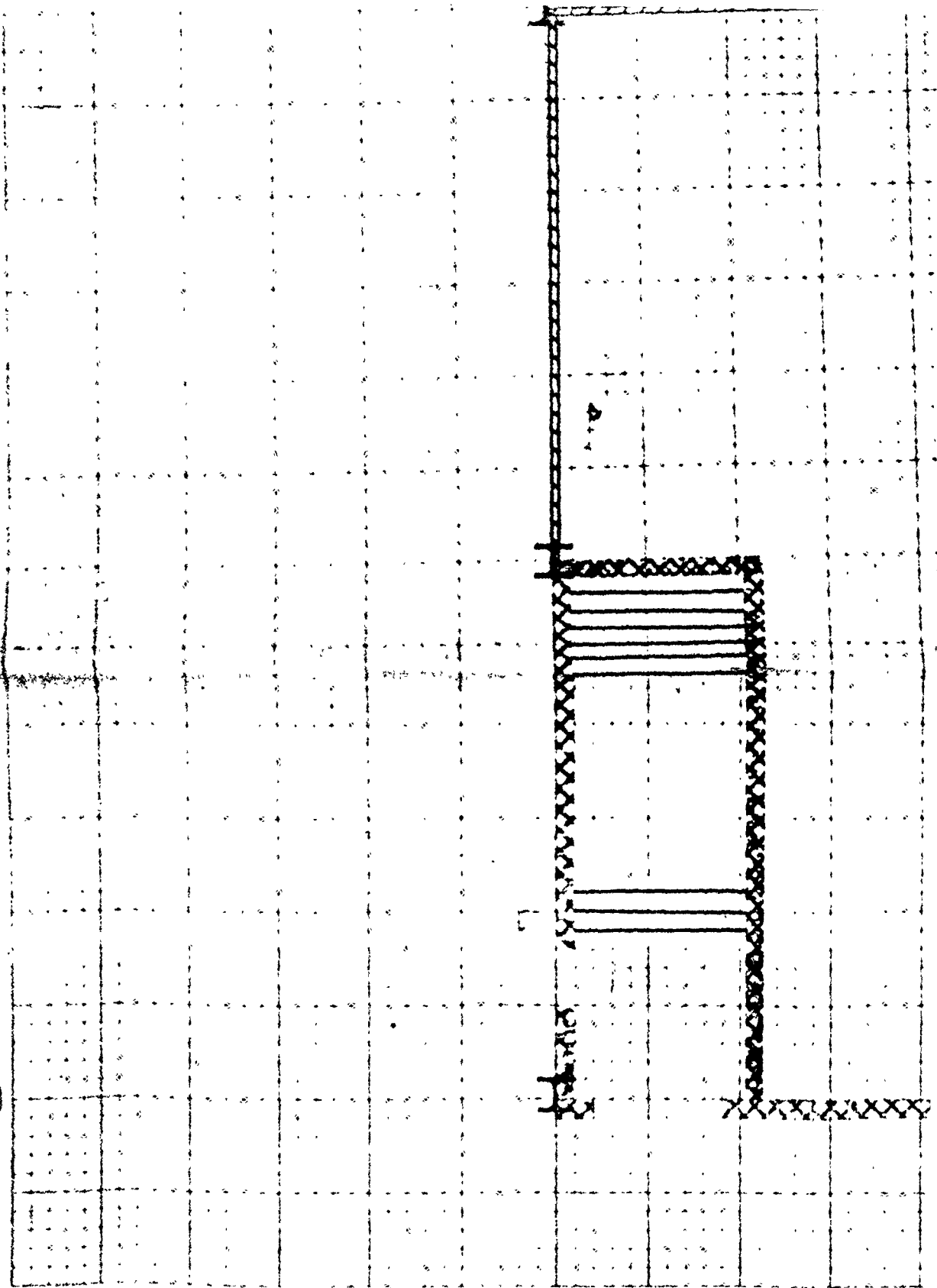
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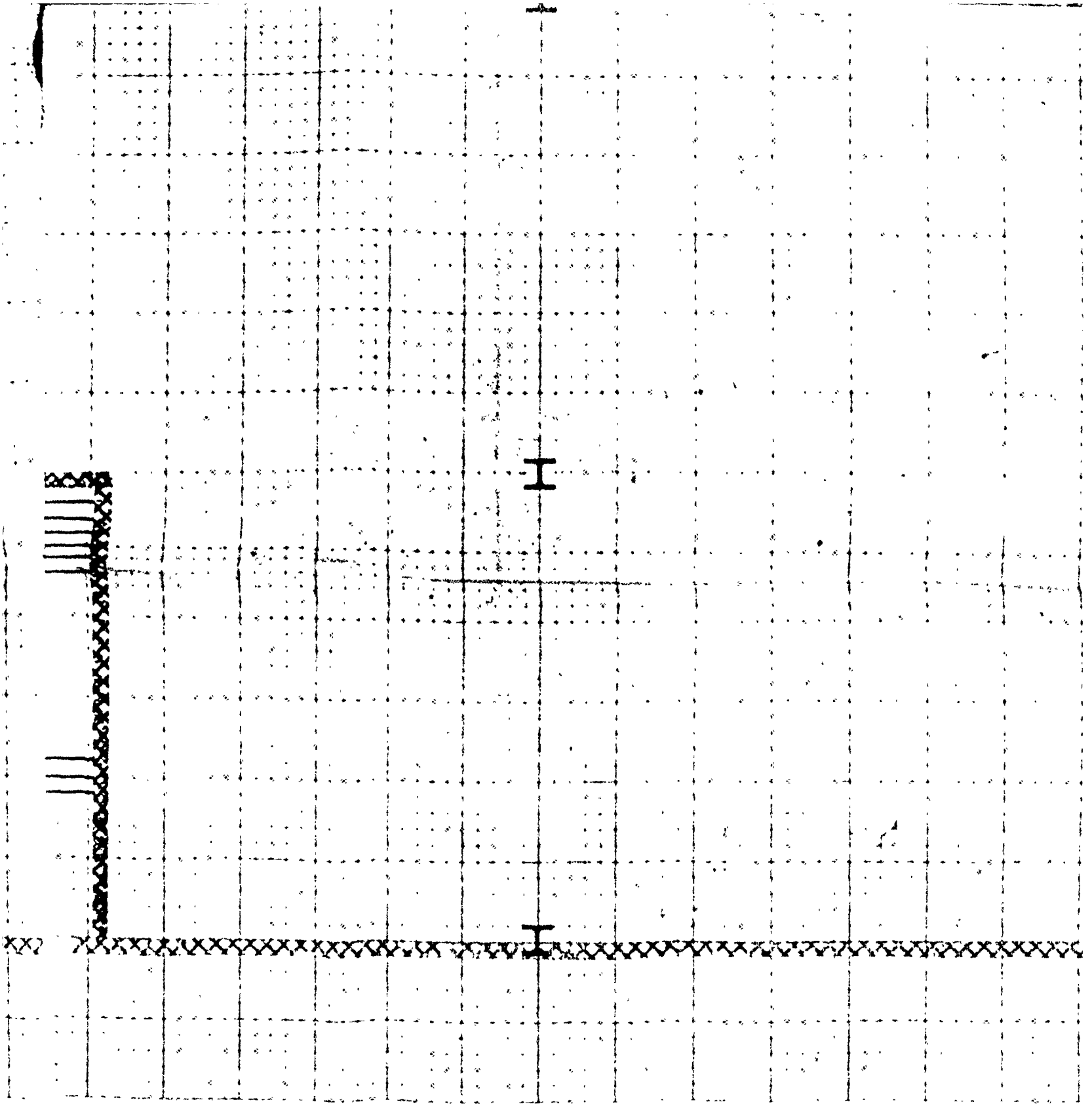
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4-TINKER

BLDG

2101

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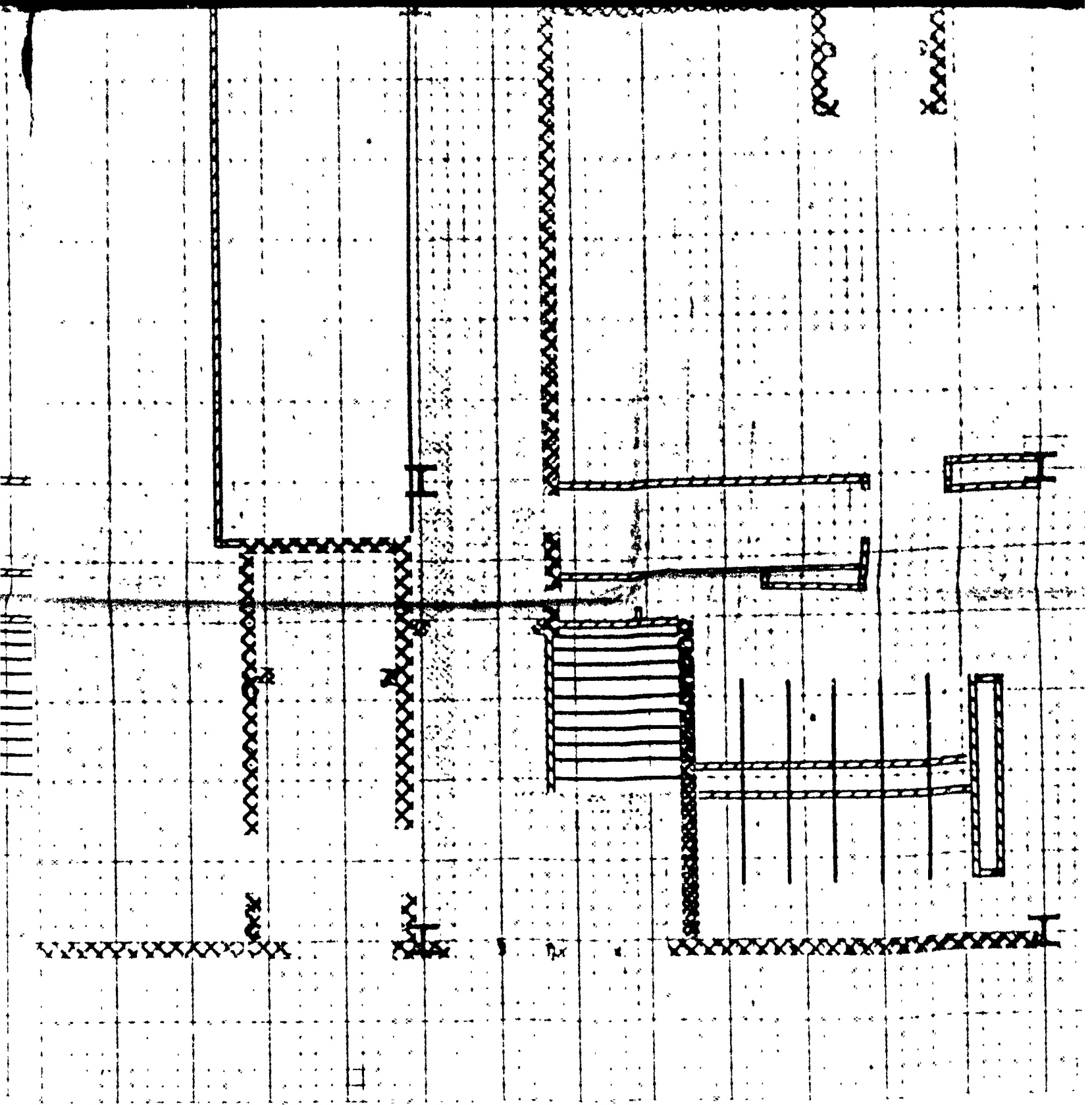


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II

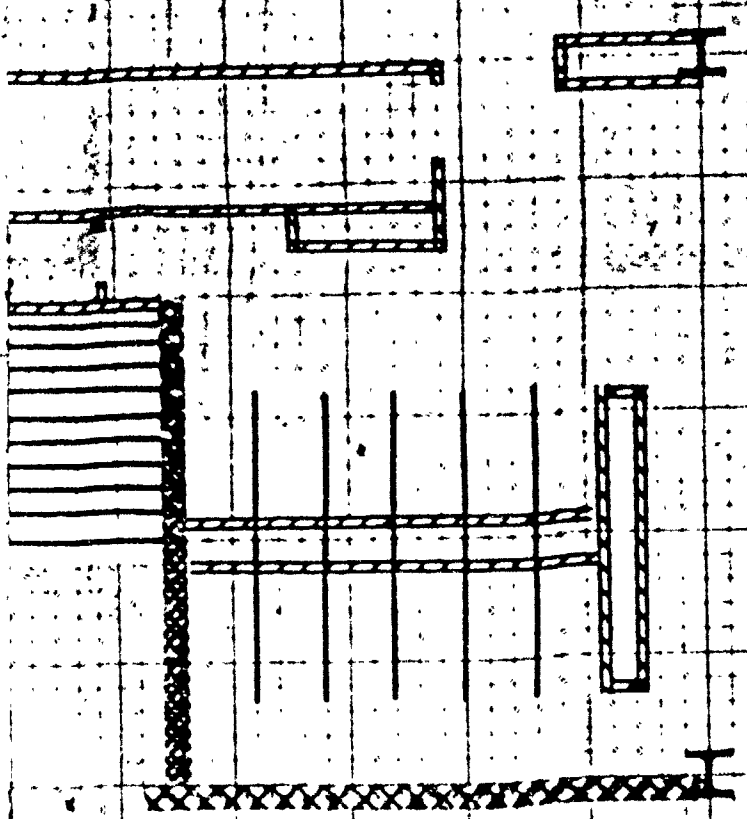
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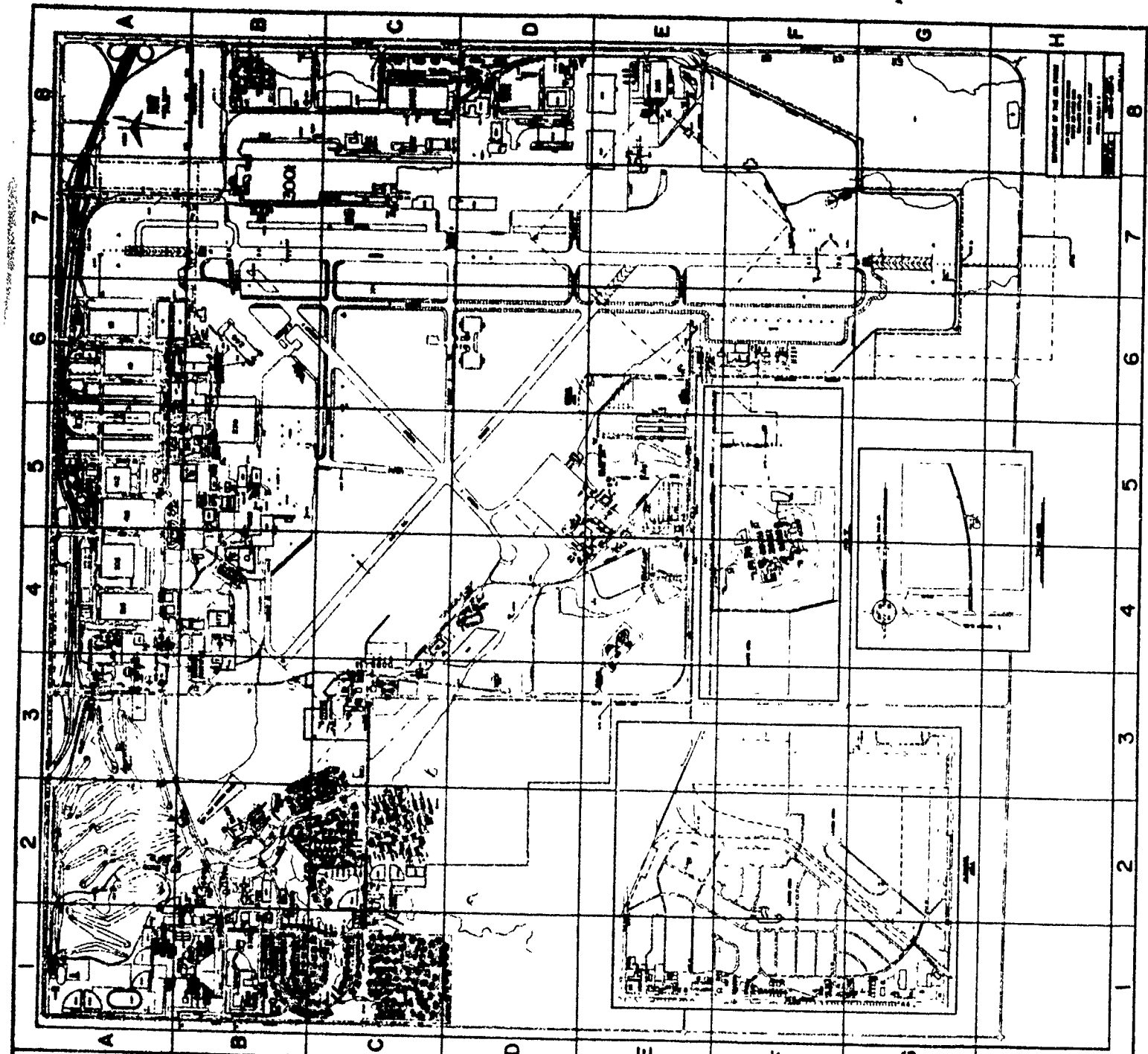
II



XX

XX





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- BASE ENGINE ZONE (11) B-5
- BASE ENGINE ZONE (12) B-5
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