APPENDIX D
COUPON OVERHAUL PROCESS DOCUMENTATION

DATE PRINTED: 2001/05/30
DATE LAST ACT: 2001-150
DOC ID NBR: XXX
RANAE J. EGGETT

WORK DOCUMENT
FMOPSR
ITN: 99999999

DPC:

* * * * * * UNOFFICIAL DOCUMENT * * * * * *

S1A COUPONS

99999999

TRACK LVL D / -AIR FORCE

WORK TO BE ACCOMPLISHED:

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

P/N NSN C/N

NOUN:

TECH DATA:

COORDINATION/INITIATING RCC SIGNATURE/DATE

PRODUCTION:_____ DATE:_____

PLANNER:_____ DATE:_____

SCHEDULER:_____ DATE:_____

QUALITY: REVIEW

MASTER COPY ON FILE WITH PRODUCTION PLANNER, NO SIGNATURES REQUIRED UNTIL NEXT TRIENNIAL REVIEW. LAST PRODUCTION PLANNING TEAM REVIEW DATE WAS:_____

GOVERNING DIRECTIVES:

	AFMCI 21-110
	LIOI 21-110
FMPI	ASTM-E-1444
BLAST	MIL-STD-1504
SHOT PEEN	AMS-S-13165
STRIP	MIL-STD-871A
CHROME PLATE	MIL-STD-1501C

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
		## 4 ##			

	QQ-C-320
	P/O: N41001
FLAME SPRAY	MIL-STD-869C
SULFAMATE NICKEL	MIL-STD-868
	P/O: N62541
	P/O: N41001
IVD PLATE	MIL-DTL-83488D
CADMIUM PLATE	MIL-STD-870B
	QQ-P-416
	P/O: N41001
ELECTROLESS NICKEL	MIL-C-26074E

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

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

**********************WARNING********************************

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

REFERENCE 29 CFR 1910.1200 AND OO-ALC HAFB INSTRUCTION 32-7001, HAZARDOUS MATERIAL MANAGEMENT PROGRAM, REQUIREMENTS FOR THE USE OF PERSONAL PROTECTIVE EQUIPMENT IS LOCATED IN BIO SURVEYS POSTED IN THE WORKER-RIGHT-TO-KNOW-GUIDEBOOK AT THE WORK SITE. INSTRUCTIONS FOR LOCATING INFORMATION ON THE SAFE HANDLING OF HAZARDOUS MATERIAL IS ALSO LOCATED IN THE WORKER-RIGHT-TO-KNOW-GUIDEBOOK.

REQD (MANDATORY REQUIREMENT) IN THE SUB OP DESCRIPTION IS EQUIVALENT TO DELTA STAMP.

ALL WARNINGS AND CAUTIONS IN T.O. PERTINENT TO PRODUCT INTEGRITY WILL REQUIRE A SECONDARY PAC

N7ML MDVNA ## 10 ## TND01 I05 DB

PAC/CD	MGT/CD
N 009	SP
	S1A-05
JUN 04 2001	6/4/01
DATE	DATE

REQD FLUORESCENT MAGNETIC PARTICLE INSPECT PER ASTM E1444

A. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED.

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
N7ML	MDVNA	## 10 ##	TND01	105	DB

THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION WILL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURES DEVELOPED BY A LEVEL III AS SPECIFIED IN NAS-410.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
N7ML	MDVNA	## 15 ##		C01	DB	QC 6/4/01 DATE	S1A-05 6/4/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WBP	MNPWD	## 20 ##	WH008	T10	3S	7086 DATE	S1A-05 6/4/01 DATE

REQD PAINT PER MIL-STD-7179
A. ONE COAT PRIMER PER MIL-P-85582 TYPE I, CLASS 2, TWO TOP COATS PER MIL-C-85285, TYPE I

JUN 06 2001

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WBP	MNPWD	## 25 ##		T10	3S	QC 6/6/01 DATE	S1A-05 6/7/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 30 ##	SE001	C01	KI	7296 DATE	S1A-05 6/6/01 DATE

REQD PAINT STRIP PER MIL-STD-871A (T.O. 4S-1-182)

C/P MOVE

JUN 07 2001

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 35 ##		C01	KI	QC 6/8/01 DATE	S1A-05 6/8/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 40 ##	SE001	C01	KI	711764 JUN 11 2002 DATE	S1A-05 6/8/01 DATE

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA (PLASTIC MEDIA) PER MIL-P-85891

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 45 ##		C01	KI	QE 6/11/01 DATE	S1A-05 6/17/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

* PERFORM SUB OP 40A AND 45A - PAGE: REVA *

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
N5TE	MDVNA	## 50 ##	TND06	I25	DB	011 JUN 13 2001 DATE	S1A-05 6/12/01 DATE

REQD TEMPER ETCH PER MIL-STD-867A
~~A. MASK MARKS~~
~~B. TEMPER ETCH EDGES~~ QC 6/13/01

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
N5TE	MDVNA	## 55 ##		125	DB	QC 6/13/01 DATE	S1A-05 6/13/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
N5TE	MDVNA	## 55 ##		125	DB

CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPSP MNPBP ## 60 ## BP011 P17 UP — PAC/CD M 70170 JUN 18 2001 DATE — MGT/CD SP S1A-05 6/13/01 DATE

REQD SHOT PEEN PER AMS-S-13165, INTENSITY 0.006A TO 0.010A, SHOT S-230 TO S-330
A. MASK MARKS
B. SHOT PEEN EDGES.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPSP MNPBP ## 65 ## P17 UP — PAC/CD M JC 6/13/01 DATE — MGT/CD SP S1A-05 6/13/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCR MNPBP ## 70 ## BP006 P01 UP — PAC/CD M 70170 14 JUN 2001 DATE — MGT/CD SP S1A-05 6/14/01 DATE

REQD CHROME PLATE PER MIL-STD-1501, TYPE II, CLASS 2, THICKNESS 0.001 INCH - 0.003 INCH
A. MASK MARKS.
B. CHROME PLATE EDGES.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCR MNPBP ## 75 ## P01 UP — PAC/CD N JC 6/15/01 DATE — MGT/CD SP S1A-05 6/15/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPCR	MNPBP ##	75 ##		P01	UP

CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPCS	MNPBP	## 80 ##	BP010	P12	UP	M	SP
REQD	CHROME PLATE STRIP PER MIL-STD-871A						S1A-05
					C/P MOVE	DATE	6/18/01 DATE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPCS	MNPBP	## 85 ##		P12	UP	M	SP
REQD	STOP PROCESSING COUPONS						S1A-05
	CONTACT: JOHN COATES / LILE ENGINEERING DESK: 586-3052 CELL: 556-9274					6/22/01 DATE	6/22/01 DATE

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPNP	MNPBP	## 90 ##	BP016	P12	UP	M	SP
REQD	NICKEL PLATE PER MIL-STD-868, TYPE II, THICKNESS 0.001 INCH - 0.003 INCH A. MASK MARKS. B. NICKEL PLATE EDGES.					JUN 28 2001 DATE	S1A-05 6/25/01 DATE

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPNP	MNPBP	## 95 ##		P12	UP	N	SP
REQD	STOP PROCESSING COUPONS						S1A-05
	CONTACT: JOHN COATES / LILE ENGINEERING DESK: 586-3052 CELL: 556-9274					7/2/01 DATE	7/2/01 DATE

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPNP	MNPBP	## 95 ##		P12	UP

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPNS MNPBP ## 100 ## BP015 P10 UP — PAC/CD M: IO 071628 DATE — MGT/CD SP: S1A-05 7/2/01 DATE

REQD NICKEL PLATE STRIP PER MIL-STD-871A

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPNS MNPBP ## 105 ## P10 UP — PAC/CD M: QC 7/6/01 DATE — MGT/CD SP: S1A-05 7/6/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS MNPWF ## 110 ## WF001 W05 WF — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD FLAME SPRAY PER MIL-STD-869, TYPE I, THICKNESS 0.025 INCH - 0.003 INCH
A. MASK MARKS.
B. FLAME SPRAY EDGES.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS MNPWF ## 115 ## W05 WF — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
WFFS	MNPWF	## 115 ##		W05	WF

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS MNPWF ## 120 ## WF001 W05 WF — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD FLAME SPRAY STRIP PER MIL-STD-871A

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS MNPWF ## 125 ## W05 WF — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS MNPWF ## 130 ## WF001 W05 WF — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD HVOF COAT, WC-CO 89-17, THICKNESS 0.004 INCH-0.006 INCH
A. MASK MARKS
B. HVOF COAT EDGES.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS MNPWF ## 135 ## W05 WF — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

BPNP MNPBP ## 140 ## BP016 P12 UP — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD HVOF STRIP PER MIL-STD-871A

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPNP MNPBP ## 145 ## P12 UP — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCA MNPBP ## 150 ## BP005 P10 UP — PAC/CD M: 10 JUL 2001 10573 DATE — MGT/CD SP: S1A-05 7/10/01 DATE

REQD CADMIUM PLATE PER MIL-STD-870, TYPE II, THICKNESS 0.001 INCH

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCA MNPBP ## 155 ## P10 UP — PAC/CD M: QC 7/12/01 DATE — MGT/CD SP: S1A-05 7/12/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPSC MNPBP ## 160 ## BP020 P10 UP — PAC/CD M: JUL 16 200 DATE — MGT/CD SP: S1A-05 7/13/01 DATE

REQD CADMIUM PLATE STRIP PER MIL-STD-871A T.O. 4S-1-182, WITH PHOSPHORIC ACID DIP

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPSC	MNPBP	## 165 ##		P10	UP	M JC 7/16/01 DATE	SP S1A-05 7/16/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPIV	MNPBP	## 170 ##	BP007	P16	UP	M O 70528 10/31/01 DATE	SP S1A-05 10/29/01 DATE

REQD IVD COAT PER MIL-DTL-83488D, TYPE II, CLASS 1
THICKNESS 0.001 INCH

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPIV	MNPBP	## 175 ##		P16	UP	M JC 10/30/01 DATE	SP S1A-05 10/30/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPIV	MNPBP	## 180 ##	BP007	P16	UP	M 71864 NOV 0 1 2001 DATE	SP S1A-05 10/31/01 DATE

REQD IVD STRIP PER MIL-STD-871A

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPIV	MNPBP	## 185 ##		P16	UP	M JC 11/1/01 DATE	SP S1A-05 11/1/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BP1V	MNPBP	## 185 ##		P16	UP

CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPEN	MNPBP	## 190 ##	BP018	P12	UP	M 70839 NOV OCT 02 2001 DATE	SP S1A-05 11/2/01 DATE

REQD ELECTROLESS NICKEL PLATE PER MIL-C-26074E, CLASS 1, GRADE A, (THICKNESS 0.001 INCH)

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPEN	MNPBP	## 195 ##		P12	UP	M JC 11/5/01 DATE	SP S1A-05 11/5/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPNS	MNPBP	## 200 ##	BP015	P10	UP	M 71669 08 NOV 2001 DATE	SP S1A-05 11/5/01 DATE

REQD ELECTROLESS NICKEL PLATE STRIP PER MIL-STD-871A

* PROCESS INCOMPLETE JC 11/8/01 *C/P MOVE*

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPNS	MNPBP	## 205 ##		P10	UP	M JC 11/9/01 DATE	SP S1A-05 11/9/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPNS	MNPBP	## 205 ##		P10	UP

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

PERFORM SUB OP 210 AND 215 - PAGE: REV B
PERFORM SUB OP 220 AND 225 - PAGE: REV C

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S1A COUPONS – REV A

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
EWCL	MNPSE	##	40A	##	SE001	C01	KI	M 00 171686 JUN 12 2001	SP S1A-05 6/12/01
REQD	ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA (GLASS MEDIA) PER MIL-G-9954							DATE	DATE

C/P MOVE

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*** NOTE: SECONDARY PAC REQUIRED ***

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EWCL	MNPSE	##	45A	##		C01	KI	M QC 6/12/01	SP S1A-05 6/12/01
REQD	STOP PROCESSING COUPONS							DATE	DATE

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

****

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS – REV B

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD	PAC/CD – MGT/CD
WFFS	MNPWF	##	210	##	WF001	W05	JA	M00 71648 / SP S1A-05

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA, (ABRASIVE GRIT) PER MIL-G-5634
A. MASK MARKS

C/P MOVE

DATE 13 NOV 2001 DATE 11/13/01

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*** NOTE: SECONDARY PAC REQUIRED ***

****

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD	PAC/CD – MGT/CD
WFFS	MNPWF	##	215	##		W05	JA	M / SP S1A-05

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DATE 11/13/01 DATE 11/13/01

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

****

*** NOTE: SECONDARY PAC REQUIRED ***

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WORK DOCUMENT PAGE: REV C

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S1A COUPONS – REV C

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

PAC/CD – MGT/CD

220

M: JC 2/13/02 DATE | SP: S1A-05 2/13/02 DATE

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA,
(ALUMINUM OXIDE) 100 GRIT, 60 SECONDS, 60PSI

C/P MOVE

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*** NOTE: SECONDARY PAC REQUIRED ***

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PAC/CD – MGT/CD

225

M: JC 2/26/02 DATE | SP: S1A-05 2/26/02 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

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*** NOTE: SECONDARY PAC REQUIRED ***

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DATE PRINTED: 2001/05/30 | WORK DOCUMENT | PAGE: 1
DATE LAST ACT: 2001-150 | FMOPSR
DOC ID NBR: XXX | ITN: 99999999 | DPC:
RANAE J. EGGETT

* * * * * * UNOFFICIAL DOCUMENT * * * * * *

S1A COUPONS

99999999

TRACK LVL D / -AIR FORCE

WORK TO BE ACCOMPLISHED:

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

P/N NSN C/N

NOUN:

TECH DATA:

COORDINATION/INITIATING RCC SIGNATURE/DATE

PRODUCTION:_____DATE:_____

PLANNER:_____DATE:_____

SCHEDULER:_____DATE:_____

QUALITY: REVIEW

MASTER COPY ON FILE WITH PRODUCTION PLANNER,
NO SIGNATURES REQUIRED UNTIL NEXT TRIENNIAL
REVIEW. LAST PRODUCTION PLANNING TEAM REVIEW
DATE WAS:_____

GOVERNING DIRECTIVES:

	AFMCI 21-110
	LIOI 21-110
FMPI	ASTM-E-1444
BLAST	MIL-STD-1504
SHOT PEEN	AMS-S-13165
STRIP	MIL-STD-871A
CHROME PLATE	MIL-STD-1501C

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
		## 4 ##			

	QQ-C-320 P/O: N41001
FLAME SPRAY SULFAMATE NICKEL	MIL-STD-869C MIL-STD-868 P/O: N62541 P/O: N41001
IVD PLATE CADMIUM PLATE	MIL-DTL-83488D MIL-STD-870B QQ-P-416 P/O: N41001
ELECTROLESS NICKEL	MIL-C-26074E

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

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

**********************WARNING****************************

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

REFERENCE 29 CFR 1910.1200 AND OO-ALC HAFB INSTRUCTION 32-7001, HAZARDOUS MATERIAL MANAGEMENT PROGRAM, REQUIREMENTS FOR THE USE OF PERSONAL PROTECTIVE EQUIPMENT IS LOCATED IN BIO SURVEYS POSTED IN THE WORKER-RIGHT-TO-KNOW-GUIDEBOOK AT THE WORK SITE. INSTRUCTIONS FOR LOCATING INFORMATION ON THE SAFE HANDLING OF HAZARDOUS MATERIAL IS ALSO LOCATED IN THE WORKER-RIGHT-TO-KNOW-GUIDEBOOK.

REQD (MANDATORY REQUIREMENT) IN THE SUB OP DESCRIPTION IS EQUIVALENT TO DELTA STAMP.

ALL WARNINGS AND CAUTIONS IN T.O. PERTINENT TO PRODUCT INTEGRITY WILL REQUIRE A SECONDARY PAC

							PAC/CD	MGT/CD
N7ML	MDVNA	##	10 ##	TND01	I05	DB	N	SP

REQD FLUORESCENT MAGNETIC PARTICLE INSPECT PER ASTM E1444

A. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED.

S1A-06

JUN 04 2001 DATE

6/4/01 DATE

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
N7ML	MDVNA ##	10 ##	TND01	105	DB

THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION WILL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURES DEVELOPED BY A LEVEL III AS SPECIFIED IN NAS-410.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
N7ML	MDVNA ##	15 ##		C01	DB	QC 6/4/01 DATE	S1A-06 6/4/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WBP	MNPWD ##	20 ##	WH008	T10	3S	JUN 06 2001 7069 DATE	S1A-06 6/4/01 DATE

REQD PAINT PER MIL-STD-7179
A. ONE COAT PRIMER PER MIL-P-85582 TYPE I, CLASS 2, TWO TOP COATS PER MIL-C-85285, TYPE I

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WBP	MNPWD ##	25 ##		T10	3S	QC 6/6/01 DATE	S1A-06 6/6/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
EWCL	MNPSE ##	30 ##	SE001	C01	KI	MO 7129 DATE	S1A-06 6/6/01 DATE

REQD PAINT STRIP PER MIL-STD-871A (T.O. 4S-1-182)

C/P MOVE JUN 07 2001

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 35 ##		C01	KI	JC 6/8/01 DATE	S1A-06 6/8/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 40 ##	SE001	C01	KI	00 77764 JUN 11 2002 DATE	S1A-06 6/8/01 DATE

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA (PLASTIC MEDIA) PER MIL-P-85891

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
EWCL	MNPSE	## 45 ##		C01	KI	JC 6/11/01 DATE	S1A-06 6/11/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

* PERFORM SUB OP 40A AND 45A - PAGE: REV A *

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
N5TE	MDVNA	## 50 ##	TND06	I25	DB	00 on JUN 13 2001 DATE	S1A-08 6/12/01 DATE

REQD TEMPER ETCH PER MIL-STD-867A
~~A. MASK MARKS~~
~~B. TEMPER ETCH EDGES~~ JC 6/13/01

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD	PAC/CD M	MGT/CD SP
N5TE	MDVNA	## 55 ##		I25	DB	JC 6/13/01 DATE	S1A-08 6/13/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
N5TE	MDVNA	## 55 ##		125	DB

CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPSP MNPBP ## 60 ## BP011 P17 UP

REQD SHOT PEEN PER AMS-S-13165, INTENSITY 0.006A TO 0.010A, SHOT S-230 TO S-330
A. MASK MARKS
B. SHOT PEEN EDGES.

PAC/CD M 60 71734 JUN 13 2001 DATE
MGT/CD SP S1A-08 6/13/01 DATE

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPSP MNPBP ## 65 ## P17 UP

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

PAC/CD M JC 6/13/01 DATE
MGT/CD SP S1A-08 6/13/01 DATE

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

* PERFORM SUB OP 60A AND 65A - PAGE: REV B *

BPCR MNPBP ## 70 ## BP006 P01 UP

REQD CHROME PLATE PER MIL-STD-1501, TYPE II, CLASS 2, THICKNESS 0.001 INCH - 0.003 INCH
A. MASK MARKS.
B. CHROME PLATE EDGES.

PAC/CD M 70170 14 JUN 2001 DATE
MGT/CD SP S1A-09 6/14/01 DATE

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCR MNPBP ## 75 ## P01 UP

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052

PAC/CD N JC 6/15/01 DATE
MGT/CD SP S1A-09 6/15/01 DATE

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPCR	MNPBP	## 75 ##		P01	UP

CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

							PAC/CD M	MGT/CD SP
BPCS	MNPBP	## 80 ##	BP010	P12	UP			
REQD	CHROME PLATE STRIP PER MIL-STD-871A							
						C/P MOVE	JUN 19 2001 DATE	6/18/01 DATE

*** NOTE: SECONDARY PAC REQUIRED ***

							PAC/CD M	MGT/CD SP
BPCS	MNPBP	## 85 ##		P12	UP			
REQD	STOP PROCESSING COUPONS							
	CONTACT: JOHN COATES / LILE ENGINEERING DESK: 586-3052 CELL: 556-9274						6/22/01 DATE	6/22/01 DATE

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

							PAC/CD M	MGT/CD SP
BPNP	MNPBP	## 90 ##	BP016	P12	UP			
REQD	NICKEL PLATE PER MIL-STD-868, TYPE II, THICKNESS 0.001 INCH - 0.003 INCH A. MASK MARKS. B. NICKEL PLATE EDGES.						70839	
						C/P MOVE	JUN 28 2001 DATE	6/22/01 DATE

*** NOTE: SECONDARY PAC REQUIRED ***

							PAC/CD N	MGT/CD SP
BPNP	MNPBP	## 95 ##		P12	UP			
REQD	STOP PROCESSING COUPONS							
	CONTACT: JOHN COATES / LILE ENGINEERING DESK: 586-3052 CELL: 556-9274						7/2/01 DATE	7/2/01 DATE

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPNP	MNPBP	## 95 ##		P12	UP

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
BPNS	MNPBP	## 100 ##	BP015	P10	UP	100	S1A-10
REQD	NICKEL PLATE STRIP PER MIL-STD-871A					DATE	DATE

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
BPNS	MNPBP	## 105 ##		P10	UP	QC 7/6/01	S1A-10 7/6/01
REQD	STOP PROCESSING COUPONS					DATE	DATE

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

* PERFORM SUB OP 100A AND 105A - PAGE: REV C *

						PAC/CD M	MGT/CD SP
WFFS	MNPWF	## 110 ##	WF001	W05	WF	N/A	N/A
REQD	FLAME SPRAY PER MIL-STD-869, TYPE I, THICKNESS 0.025 INCH - 0.003 INCH A. MASK MARKS. B. FLAME SPRAY EDGES.					DATE	DATE

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WFFS	MNPWF	## 115 ##		W05	WF	N/A	N/A
REQD	STOP PROCESSING COUPONS					DATE	DATE

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
WFFS	MNPWF	## 115 ##		W05	WF

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WFFS	MNPWF	## 120 ##	WF001	W05	WF	N/A	N/A
REQD	FLAME SPRAY STRIP PER MIL-STD-871A					DATE	DATE

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WFFS	MNPWF	## 125 ##		W05	WF	N/A	N/A
REQD	STOP PROCESSING COUPONS					DATE	DATE

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WFFS	MNPWF	## 130 ##	WF001	W05	WF	N/A	N/A
REQD	HVOF COAT, WC-CO 89-17, THICKNESS 0.004 INCH-0.006 INCH					DATE	DATE

A. MASK MARKS
B. HVOF COAT EDGES.

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD M	MGT/CD SP
WFFS	MNPWF	## 135 ##		W05	WF	N/A	N/A
REQD	STOP PROCESSING COUPONS					DATE	DATE

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

BPNP MNPBP ## 140 ## BP016 P12 UP — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD HVOF STRIP PER MIL-STD-871A

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPNP MNPBP ## 145 ## P12 UP — PAC/CD M: N/A DATE — MGT/CD SP: N/A DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCA MNPBP ## 150 ## BP005 P10 UP — PAC/CD M: 70573 10 JUL 2001 DATE — MGT/CD SP: S1A-12 7/10/01 DATE

REQD CADMIUM PLATE PER MIL-STD-870, TYPE II, THICKNESS 0.001 INCH

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPCA MNPBP ## 155 ## P10 UP — PAC/CD M: JC 7/12/01 DATE — MGT/CD SP: S1A-12 7/12/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPSC MNPBP ## 160 ## BP020 P10 UP — PAC/CD M: JUL 16 2001 DATE — MGT/CD SP: S1A-12 7/13/01 DATE

REQD CADMIUM PLATE STRIP PER MIL-STD-871A T.O. 4S-1-182, WITH PHOSPHORIC ACID DIP

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

BPSC MNPBP ## 165 ## P10 UP — PAC/CD M: JC 7/16/01 DATE — MGT/CD SP: S1A-12 7/16/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPIV MNPBP ## 170 ## BP007 P16 UP — PAC/CD M: MC528 10/30/01 DATE — MGT/CD SP: S1A-06 10/29/01 DATE

REQD IVD COAT PER MIL-DTL-83488D, TYPE II, CLASS 1
THICKNESS 0.001 INCH

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPIV MNPBP ## 175 ## P16 UP — PAC/CD M: JC 10/30/01 DATE — MGT/CD SP: S1A-06 10/30/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPIV MNPBP ## 180 ## BP007 P16 UP — PAC/CD M: 71864 NOV 01 2001 DATE — MGT/CD SP: S1A-06 10/31/01 DATE

REQD IVD STRIP PER MIL-STD-871A

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

BPIV MNPBP ## 185 ## P16 UP — PAC/CD M: JC 11/1/01 DATE — MGT/CD SP: S1A-06 11/1/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPIV	MNPBP	## 185 ##		P16	UP

CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPEN	MNPBP	## 190 ##	BP018	P12	UP	M	SP
REQD	ELECTROLESS NICKEL PLATE PER MIL-C-26074E, CLASS 1, GRADE A, (THICKNESS 0.001 INCH)					DATE	S1A-07
				C/P MOVE			DATE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPEN	MNPBP	## 195 ##		P12	UP	M	SP
REQD	STOP PROCESSING COUPONS					DATE	S1A-07
	CONTACT: JOHN COATES / LILE ENGINEERING DESK: 586-3052 CELL: 556-9274						DATE

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPNS	MNPBP	## 200 ##	BP015	P10	UP	M	SP
REQD	ELECTROLESS NICKEL PLATE STRIP PER MIL-STD-871A					DATE	S1A-07
	* PROCESS INCOMPLETE JC 11/8/01			*C/P MOVE*		08 NOV 2001	DATE

*** NOTE: SECONDARY PAC REQUIRED ***

						PAC/CD	MGT/CD
BPNS	MNPBP	## 205 ##		P10	UP	M	SP
REQD	STOP PROCESSING COUPONS					DATE	S1A-07
	CONTACT: JOHN COATES / LILE ENGINEERING DESK: 586-3052 CELL: 556-9274						DATE

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

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S1A COUPONS

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
BPNS	MNPBP	## 205 ##		P10	UP

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

* PERFORM SUB OP 210 AND 215 - PAGE: REV D*

* PERFORM SUB OP 220 AND 225 - PAGE: REV E*

* PERFORM SUB OP 230 AND 235 - PAGE: REV F*

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S1A COUPONS – REV A

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD	PAC/CD	–	MGT/CD
EWCL	MNPSE	##	40A	##	SE001	C01	KI	M 00 71686 JUN 12 2001 DATE		SP S1A-07 6/12/01 DATE

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA (GLASS MEDIA) PER MIL-G-9954

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

								PAC/CD	–	MGT/CD
EWCL	MNPSE	##	45A	##		C01	KI	M JC 6/12/01 DATE		SP S1A-07 6/12/01 DATE

REQD *STOP PROCESSING COUPONS*

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS – REV B

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPSP	MNPBP	##	60A	##	BP011	P17	UP	M JO 6/7/01 JUN 14 2001 DATE	SP S1A-08 6/13/01 DATE

REQD SHOT PEEN PER AMS-S-13165, INTENSITY 0.006A TO 0.010A, SHOT S-230 TO S-330

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

								PAC/CD	MGT/CD
BPSP	MNPBP	##	65A	##		P17	UP	M JC 6/14/01 DATE	SP S1A-08 6/14/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS – REV C

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD	PAC/CD	MGT/CD
BPNP	MNPBP	##	100A	##	BP016	P12	UP	LVO 11284	SP S1A-11 7/9/01

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA (GARNET MEDIA) PER MIL-A-21380

C/P MOVE JUL 09 2001 DATE DATE

****

*** NOTE: SECONDARY PAC REQUIRED ***

****

								PAC/CD	MGT/CD
BPNP	MNPBP	##	105A	##		P12	UP	M JC 7/9/01 DATE	SP S1A-11 7/9/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

****

*** NOTE: SECONDARY PAC REQUIRED ***

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S1A COUPONS – REV D

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
WFFS	MNPWF ##	210 ##	WF001	W05	JA

PAC/CD – MGT/CD

M 00 71648 – SP S1A-09

DATE 13 NOV. 2001 – DATE 11/13/01

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA, (ABRASIVE GRIT) PER MIL-G-5634

A. MASK MARKS *C/P MOVE*

****

*** NOTE: SECONDARY PAC REQUIRED ***

****

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD
WFFS	MNPWF ##	215 ##		W05	JA

PAC/CD – MGT/CD

M JE 11/13/01 – SP S1A-09 11/13/01

DATE – DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

****

*** NOTE: SECONDARY PAC REQUIRED ***

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* * * * * * UNOFFICIAL DOCUMENT * * * * * *

S1A COUPONS – REV E

DROP STA	RCC		SUB OP		WORK STA	EQUIP CODE	SKL CD
WFFS	MNPWF	##	220	##	WF001	W05	JA

PAC/CD – MGT/CD

M 00 71648 13 NOV 2001 DATE | SP S1A-09 11/13/01 DATE

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA, (ABRASIVE GRIT) PER MIL-G-5634

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WFFS	MNPWF	##	225	##		W05	JA

PAC/CD – MGT/CD

M JC 11/13/01 DATE | SP S1A-09 11/13/01 DATE

REQD STOP PROCESSING COUPONS

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

*** NOTE: SECONDARY PAC REQUIRED ***

WORK DOCUMENT

PAGE: REV F

* * * * * * UNOFFICIAL DOCUMENT * * * * * *

S1A COUPONS REV F

DROP STA	RCC	SUB OP	WORK STA	EQUIP CODE	SKL CD

PAC/CD – MGT/CD

M SP

230

REQD ABRASIVE BLAST PER MIL-STD-1504, ABRASIVE MEDIA, (ALUMINUM OXIDE) 100 GRIT, 60 SECONDS, 60 PSI

QC 2/13/02 DATE — S1A-14 2/13/02 DATE

C/P MOVE

****

*** NOTE: SECONDARY PAC REQUIRED ***

****

PAC/CD – MGT/CD

M SP

235

REQD STOP PROCESSING COUPONS

QC 2/26/02 DATE — S1A-14 2/26/02 DATE

CONTACT: JOHN COATES / LILE ENGINEERING
DESK: 586-3052
CELL: 556-9274

DO NOT CONTINUE PROCESSING WITHOUT ENGINEERING APPROVAL

C/P MOVE

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*** NOTE: SECONDARY PAC REQUIRED ***

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