DEFENSE WORK MEASUREMENT STANDARD TIME DATA
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OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP-ATION	DWMSTDP ELEMENT	PAGE
APPLY ERUNEL BY DIPPING	VARIABLE	50X	SDPEAXX	2
APPLY ERUNEL WITH APPLICATOR(TOUCH UP)	VARIABLE	50X	SPAEAXX	4
APPLY MICROMASK TO PART WITH BRUSH	TABLE	500	SPAMAXX	6
APPLY PLATER PUTTY TO PLUG UP HOLE	723	50X	SJPPA01	2
BAKE PART	1109	504	SOHPB01	16
BLAST PART(ABRASIVE)IN BOOTH	VARIABLE	503	SCLPBXX	10
BLAST PARTS CLEAN WITH GLASS-SMALL PARTS	2922	503	SCLPB04	11
BLAST PARTS CLEAN WITH GLASS-VERY SMALL PARTS	3478	503	SCLPB03	11
BLAST(WET OR VAPOR)PART AND RINSE	VARIABLE	503	MCLPBXX	7
BRUSH PAINT OFF PART IN THINNER	VARIABLE	599	SCLPBXX	18
CLAMP COMPRESSED GAS CYLINDER IN VISE	758	549	MVSCC01	17
CLEAN COMPONENT WITH VACUUM	VARIABLE	599	SCLCCXX	18
CLEAN PART AND AIR DRY	TABLE	503	TCLPCXX	8
CLEAN PART IN ULTRASONIC CLEANING VAT	6991	503	SCLPC03	12
CLEAN PART OR BASKET OF PARTS AND DRY-SPRAY BOOTH	3483	503	SCLPC04	12
CLEAN PART WITH PRESSURE SPRAY OF CLEANING AGENT	1800	599	SCLPC07	19
CLEAN PART WITH SOLVENT AND BRUSH	VARIABLE	599	SCLPCXX	18
CLEAN PART WITH SOLVENT IN SPRAY BOOTH	3634	503	SCLPC01	11
CLEAN ULTRASONIC PARTS	6235	503	SCLPC02	12
COAT METAL SURFACE AND RINSE	679	505	SSTSC01	16
CONNECT COMPRESSED GAS-EMPTY CYLINDER TO VACUUM MACHINE	1537	549	MCLCC01	16
CONNECT ELECTRIC PLATING LEAD TO ANODE	268	500	SJPLC01	5
DEGREASE COMPONENTS	VARIABLE	503	SCLCDXX	9
DEGREASE PART OR BASKET OF PARTS	4238	503	SCLPD01	12
DIP PART IN SOLUTION(PAINT REMOVER)	VARIABLE	599	SDPPDXX	20
DIP PART IN SOLVENT TO CLEAN,WEIGHT-LESS THAN 2.5 POUNDS	223	503	MDPPD01	13
DIP PART IN WAX TO MASK FOR PLATING	VARIABLE	50X	SJPPDXX	2
DIP PART TO CLEAN	1240	503	SCLDP03	10
DIP PART TO CLEAN	VARIABLE	503	SCLDPXX	9
DIP PARTS IN BASKET AFTER SONIC CLEAN	2023	503	SCLPD02	13
DISASSEMBLE COMPRESSED GAS CYLINDER (AUTOMATIC WRENCH/HAND WRENCH)	VARIABLE	549	SCACDXX	17
DRAIN PARTS(IN BASKET)	582	503	MCLPD01	7
ENTER OR EXIT SAND BLAST BOOTH	427	500	SJPBE01	5
ETCH PART(NITAL)	4400	500	SCPPE01	5
HANG DIP BASKET ON SUSPENSION BAR	92	5XX	MOMBH01	1

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OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP-ATION	CWMSTDP ELEMENT	PAGE
INSTALL AND REMOVE ANODE	1561	500	SJPAI01	5
INSTALL MASKING-LEAD PLUG	TABLE	50X	SJPPIXX	2
INSTALL SEALANT IN CAVITY	VARIABLE	50X	SJPSIXX	4
INSTALL WIRE RUBBER	605	500	SJPRI01	6
LOAD AND UNLOAD COBEHN CLEANER(SMALL PART)	VARIABLE	503	SJPCLXX	14
LOAD SONIC CLEANER	532	503	SJPCL03	14
LOCK OR UNLOCK TUMBLER DOOR	105	599	MNFDL01	21
MAKE PREPARATION FOR CLEANING PARTS IN SPRAY BOOTH	643	503	SJPPC01	15
MOUNT PART ON SPRING HOOK RACK	VARIABLE	5XX	MOHPRXX	1
MOVE PARTS(IN BASKET)FROM SONIC CLEANER TO RINSE TANK	1234	503	SJPPM01	15
MOVE ROCKS/COMPOUND FROM DRUM TO CONTAINER	VARIABLE	599	SJPRMXX	21
OPEN AND CLOSE BASKET-HINGED,DOUBLE, SWINGING DOORS	VARIABLE	599	SJPDOXX	20
OPEN AND CLOSE SPECIAL CYLINDER VISE	76	549	MVSV001	17
PLACE PART IN PLATING TANK	VARIABLE	50X	SOHPPXX	4
PLACE PARTS IN BASKET IN CLEANING TANK	167	503	MJPPP01	13
PLACE PARTS(IN BASKET) IN DRYER	228	503	SJPPP01	15
PLACE SMALL PART ON TREE RACK	52	5XX	MOHPP01	1
POSITION TUMBLER DOOR ON TUMBLER	49	599	POHDP01	21
PREPARE BLAST CLEAN(AGACITE OR AIR HONE)	2182	503	SJPBP01	14
PREPARE PART TO CLEAN TANK	787	599	SJPMP02	21
PREPARE PARTS TO CLEAN WITH VARSOL	537	599	SJPPP01	20
PREPARE TO LOAD PART FOR PLATING	VARIABLE	50X	SJPPPXX	3
PREPARE TO USE SPRAY,RINSE GUN	311	599	SJPGP01	20
PREPARE TO USE STEAM GUN	440	599	SJPGP02	20
PURGE COMPRESSED GAS CYLINDER WITH OXYGEN	3242	549	SCLCP01	16
PUT ON AND REMOVE SANDBLAST HELMET	470	503	SJPHP01	15
REMOVE BASKET WITH PARTS FROM SUSPENSION	141	5XX	MCMBR01	1
REMOVE HOOK OR RACK FROM SUSPENSION BAR	81	5XX	MOHMR01	1
REMOVE LARGE PART FROM SPRING RACK	80	5XX	MOHPR03	1
REMOVE MASKING PLUG	VARIABLE	50X	SJPPRXX	3
REMOVE PART FROM RACK	VARIABLE	5XX	MOHPRXX	1
REMOVE PLATERS PUTTY FROM HOLE	522	50X	SJPRP01	4
REMOVE SEALANT	VARIABLE	50X	SJPSRXX	4
REMOVE TUMBLER DOOR	35	599	MOHDR01	21
REMOVE WIRE RUBBER	VARIABLE	500	SJPRFXX	6
RINSE PART WITH PRESSURE SPRAY	VARIABLE	599	MCLPRXX	17
RINSE PARTS IN BASKET	2059	503	SCLPR01	13

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OPERATION/ELEMENT DESCRIPTION	TMU VALUE	OCCUP-ATION	DWMSTDP ELEMENT	PAGE
RINSE PARTS(IN BASKET),SPRAY	7327	599	SCLPR01	15
RINSE PARTS(IN BASKET)DIP	1158	503	SCLPR02	13
RINSE PARTS(IN BASKET)IN MACHINE	256	503	MCLPR01	7
SEAT MASKING PLUG IN HOLE	VARIABLE	50X	SJPPSXX	3
SET UP STEAM UNIT AND SECURE	1518	599	SJPSS01	21
SPRAY RINSE PARTS(IN BASKET)	1710	599	SCLPR02	15
STEAM PARTS CLEAN(PROCESS TIME)	VARIABLE	595	MCLPSXX	17
STRING OBJECTS ON WIRE FOR CLEANING	VARIABLE	503	SJPOSXX	15
STRIP PAINT FROM INSTRUMENT CASE	1452	599	SCLPS03	19
STRIP PAINT FROM PART	VARIABLE	599	SCLPSXX	15
TAKE OUT RUBBER MASKING PLUG	VARIABLE	50X	SJPPTXX	4
TRIM EROXEL FROM PERIMETER PLATE AREA	TABLE	500	SJPETXX	5
UNLOAD DRYER	414	503	SJPDU01	14
UNLOAD SONIC CLEANER(BASKET)	865	503	SJPCU01	14
VACU-BLAST HARDWARE	16792	503	SCLHV01	10
WASH PART IN TANK WITH BRUSH	555	599	SCLPW01	20
WET BLAST PARTS(IN BASKET)	9350	503	MCLPB06	7

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