

10.

8.0

238 hours for 10 units shop

4.0 8.0 + 4

100 hours for 10 unit shop

6.0

~~225~~ 225 hours

10.0

~~225~~ hours labor

5.0

30.0

2.0 — 4.0 + 2

100^{hr} part delivery

8.0

20^{hr} parts mechanism

4.0 — 8.0 + 4

4.0

5.0 — 6.0 + 1

24.0

5.0

8.0

5.0

3.0

7.0

10.0

11.0

7.0

10.0

10.0

10.0

10.0

4.0

16.0

1227.0

300/0
1/1

210/2
1/1

250
210
375

68

227
11
238

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2.7

3.0
8/23 E

36

26

10220
220

27
8 220
16.0

2509

AUTOMATIC KEYS

TIME + MATL ESTIMATE FOR 10 + 50 UNITS

BAR, FRAME, BASE 2 REQD./UNIT.

BLANK SIZE = 1/4 x 3/8 CR. STL. STOCK X 12 1/2" LONG.

MATL { 10 UNITS REQUIRES 21 FT. = \$
50 UNITS " 105 FT. = \$

TIME { 10 UNITS MACHINING AND BENCH TIME = 18.0 HRS.
50 UNITS " " " " = 34.0 HRS.

BAR, FRAME, TOP 2 REQD./UNIT

BLANK SIZE = SAME AS ABOVE.

MATL { 10 UNITS REQUIRES 21 FT. = \$
50 " " 105 FT. = \$

TIME { 10 UNITS MACHINING AND BENCH TIME = 8.0 HRS.
50 UNITS " " " " = 34.0 HRS.

BOARD, CHASSIS 1 REQD./UNIT

BLANK SIZE = 12 7/16 x 5 7/8 x 1/16 THICK APOXY GLASS. COPPER CLAD

LOU. FLNR
MATE. { 10 UNITS REQUIRE 750 sq in = \$
50 UNITS " 3750 sq in = \$

TIME { 10 UNITS CUTTING TO SIZE + DR. ALL HOLES = 6 HRS.
50 UNITS " " " " " " = 30 HRS

BOARDS, PLUG IN (B-1, B-2, B-3, B-4, B-5, POWER SUPPLY)

Matl is figured by d. Elor + H. Salmon.

TIME { 10 UNITS CUT TO SIZE + DR. HOLES = 10 HRS
50 UNITS " " " " " " = 50 HRS

SCREWS AND NUTS FOR 10 UNITS = ?

" " " " " " 50 UNITS = ?

SPRINGS 2 PER UNIT

(10 UNITS)

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5.0

COVER, FRONT + BACK 1 REQD EACH/UNIT TOTAL 20 COVERS
+ 100 COVERS

BLANK SIZE = $7\frac{1}{4} \times 5\frac{3}{16} \times .048$ CR STL

MATEL	{	10 UNITS	REQUIRES	752 sq. in.	= \$
		50 UNITS	"	3760 sq. in.	= \$
TIME	{	10 UNITS,	TOTAL SHOP TIME =	30 HRS.	
		50 UNITS	" " "	= 150 HRS.	

COVER, CHASSIS 1 REQD / UNIT

BLANK SIZE = $11 \times 13\frac{3}{4} \times .038$ PERFORATED CR STL.

MATEL	{	10 UNITS	REQUIRES	152 sq. in.	= \$
		50 UNITS	"	760 sq. in.	= \$
TIME	{	10 UNITS	TOTAL SHOP TIME =	4.0 HRS.	
		50 UNITS	" " "	= 12.0 HRS.	

ARM 2 REQD / UNIT

BLANK SIZE = $1\frac{3}{4} \times \frac{3}{8} \times \frac{1}{4}$ FABRIC PHENOLIC

MATEL	{	10 UNITS	REQUIRES	7.50 sq. in. of $\frac{1}{4}$ " MATEL = \$
		50 UNITS	"	37.50 sq. in. of $\frac{1}{4}$ " MATEL = \$
TIME	{	10 UNITS	TOTAL SHOP TIME =	8.0 HRS.
		50 UNITS	" " "	= 40.0 HRS.

PLATE, MOUNTING 1 REQD / UNIT

BLANK SIZE = $3\frac{7}{16} \times 3\frac{1}{16} \times .048$ C. R. STL.

MATEL	{	10 UNITS	REQUIRES	105.3 sq. in. = \$
		50 UNITS	"	526.5 sq. in. = \$
TIME	{	10 UNITS	TOTAL SHOP TIME =	8.0 HRS.
		50 UNITS	" " "	= 24.0 HRS.

SPACER, TRANSFORMER 4 REQD/UNIT

SPACER, TRANSFORMER BRACKET 2 REQD/UNIT

BLANK SIZE : $\frac{3}{8}$ " DIA. ROD X $\frac{7}{16}$ " LONG FABRIC PHENOLIC.

MATERIAL	{	10 UNITS	REQUIRES	30 in of $\frac{3}{8}$ " DIA ROD.	⌘
		50 UNITS	"	150 in of $\frac{3}{8}$ " DIA ROD.	⌘
TIME	{	10 UNITS	TOTAL SHOP TIME	= 4.0 HRS	
		50 UNITS	"	"	= 20.0 HRS

KNOB 1 REQD/UNIT

BLANK SIZE = $\frac{5}{8}$ " DIA X $\frac{7}{8}$ " LONG ALUMINUM ROD.

MATERIAL	{	10 UNITS	REQUIRES	9 in = ⌘
		50 UNITS	"	45 in = ⌘
TIME	{	10 UNITS	TOTAL SHOP TIME	= 6.0 HRS
		50 UNITS	"	= 25.0 HRS

PLATE, MOUNTING 1 REQD/UNIT

BLANK SIZE = 2 $\frac{5}{8}$ " X 2 $\frac{1}{8}$ " X $\frac{3}{8}$ " THICK FABRIC PHENOLIC.

MATERIAL	{	10 UNITS	REQUIRES	40 sq. in = ⌘
		50 UNITS	"	200 sq. in = ⌘
TIME	{	10 UNITS	TOTAL SHOP TIME	= 24.0 HRS
		50 UNITS	"	= 120.0 HRS

PLATE, BOTTOM 1 REQD/UNIT

BLANK SIZE = 11 X 5 $\frac{13}{16}$ " X $\frac{1}{16}$ " THICK FABRIC PHENOLIC.

MATERIAL	{	10 UNITS	REQUIRES	5.0 sq. ft. = ⌘
		50 UNITS	"	25.0 sq. ft. = ⌘
TIME	{	10 UNITS	TOTAL SHOP TIME	= 5.0 HRS
		50 UNITS	"	= 25.0 HRS

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PADDLE (#1 + #2) 1 EACH REQD/UNIT

BLANK SIZE = $3\frac{1}{8} \times 1\frac{1}{4} \times \frac{1}{8}$ THICK BLACK FABRIC PHENOLIC

MATERIAL	10 UNITS	REQUIRES	800.0 sq. in.	= \$
	50 UNITS	"	4000.0 sq. in.	= \$
TIME	10 UNITS	TOTAL SHOP TIME	=	8.0 HRS.
	50 UNITS	"	"	= 40.0 HRS.

CONTACT 2 EA REQD/UNIT

BLANK SIZE = $\frac{1}{8}$ DIA X $\frac{1}{4}$ LONG COIN SILVER

MATERIAL	10 UNITS	REQUIRES	5 in.	= \$
	50 UNITS	"	25 in.	= \$
TIME	10 UNITS	TOTAL SHOP TIME	=	5.0 HRS.
	50 UNITS	"	"	= 25.0 HRS.

CONTACT STRIP 2 EACH REQD/UNIT

BLANK SIZE : $1\frac{3}{4} \times \frac{1}{4} \times .006$ THICK PHOSPHOR BRONZE

MATERIAL	10 UNITS	REQUIRES	5 sq. in.	= \$
	50 UNITS	"	25 sq. in.	= \$
TIME	10 UNITS	TOTAL SHOP TIME	=	3.0 HRS.
	50 UNITS	"	"	= 15.0 HRS.

BEARING 2 EACH/UNIT

BLANK SIZE = $\frac{1}{2}$ DIA X $\frac{1}{2}$ LONG BRASS ROD

MATERIAL	10 UNITS	REQUIRES	5 in.	= \$
	50 UNITS	"	25 in.	= \$
TIME	10 UNITS	TOTAL SHOP TIME	=	7.0 HRS.
	50 UNITS	"	"	= 35.0 HRS.

BEARING BLOCK 2 EACH REQD/UNIT

BLANK SIZE = $\frac{1}{4} \times \frac{1}{2} \times \frac{9}{16}$ LONG BRASS

MATERIAL	{	10 UNITS	REQUIRES	12 in of $\frac{1}{4} \times \frac{1}{2}$ MATERIAL = \$
		50 UNITS	"	60 in " " " " = \$
TIME	{	10 UNITS	TOTAL SHOP TIME	= 10 HRS.
		50 UNITS	" " "	= 50 HRS.

CAM SHAFT 2 EACH REQD/UNIT

BLANK SIZE = $\frac{3}{8}$ DIA \times $\frac{1}{2}$ LONG BRASS ROD

MATERIAL	{	10 UNITS	REQUIRES	20 in of $\frac{3}{8}$ DIA ROD = \$
		50 UNITS	"	12 ft. of " " " " = \$
TIME	{	10 UNITS	TOTAL SHOP TIME	= 11.0 HRS
		50 UNITS	" " "	= 55.0 HRS

SPRING LOAD BLOCK 2 EACH REQD/UNIT

BLANK SIZE = $\frac{3}{8} \times \frac{3}{8} \times \frac{9}{16}$ LONG BRASS

MATERIAL	{	10 UNITS	REQUIRES	= 12 in of $\frac{3}{8} \times \frac{3}{8}$ STOCK = \$
		50 UNITS	"	= 57 in " " " " = \$
TIME	{	10 UNITS	TOTAL SHOP TIME	= 7.0 HRS.
		50 UNITS	" " "	= 35.0 HRS.

Cam 2 EACH REQD/UNIT

BLANK SIZE = $\frac{3}{4}$ DIA \times $\frac{5}{16}$ LONG BRASS ROD

MATERIAL	{	10 UNITS	REQUIRES	6 1/2 in of $\frac{3}{4}$ DIA STOCK = \$
		50 UNITS	"	32 in " " " " = \$
TIME	{	10 UNITS	TOTAL SHOP TIME	= 10.0 HRS
		50 UNITS	" " "	= 50.0 HRS

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SUPPORT 1 REQD/UNIT

BLANK SIZE = $2\frac{3}{8} \times \frac{5}{8} \times \frac{1}{8}$ THICK BLACK FABRIC PHENOLIC

MAT'L { 10 UNITS REQUIRES 15 sq in = \$
 50 UNITS " 75 sq in = \$

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS
 50 UNITS " " " = 50.0 HRS

SUPPORT POST 1 REQD/UNIT

BLANK SIZE = $\frac{3}{4}$ DIA X $1\frac{3}{8}$ LONG BRASS ROD

MAT'L { 10 UNITS REQUIRES 14 in of $\frac{3}{4}$ DIA STOCK = \$
 50 UNITS " 70 in " " " " = \$

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS.
 50 UNITS " " " = 50.0 HRS.

SPRING LOAD SCREW 2 EACH REQD/UNIT

BLANK SIZE $\frac{3}{4}$ DIA X $\frac{3}{4}$ LONG BRASS ROD

MAT'L { 10 UNITS REQUIRES 8 in of $\frac{3}{4}$ DIA STOCK = \$
 50 UNITS " 38 in " " " " = \$

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS.
 50 UNITS " " " = 50.0 HRS.

PAINT + OTHER FINISHING

MAT'L COST FOR 10 UNITS - ?

" " " 50 UNITS : ?

TIME FOR 10 UNITS = 6 HRS

" " " 50 UNITS = 16 HRS

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ASSEMBLY TIME FOR 10 UNITS = 16 HRS

" " " 50 UNITS : 80 HRS