

SERVICE

MEMO

Service Memo No. 16

ACTUAL LABOR BREAK-DOWN, IN HOURS, OF FACTORY TIME REQUIRED TO COVER AND FINISH ONE HUNDRED (100) OF EACH ASSEMBLY OF THE PA-18, PA-18A AND PA-22

Part No.	Description-Each	Model	Cover	Sew	First Dope	Tape & Patch	Dry Sand	Build-up Dope	Silver	Wet Sand	Paint	Total Hrs. Per 100 Assys.	Total Hrs. Per Each Assembly
12573 14773	Rudder Assembly	All	38.97	12.63	2.70	54.58	8.03	5.03	3.14	11.09	4.46	140.63	1.41
12790 12790-1	Stabilizer Assy.	18-18A	18.18	24.14	2.94	38.90	9.15	4.90	3.09	7.04	5.06	113.40	1.13
12648 12648-1	Stabilizer Assy.	22	14.65	17.43	2.86	34.32	4.76	4.95	2.75	11.31	3.70	96.73	.97
12789 12789-1	Elevator Assy.	18-18A	25.03	10.42	2.91	33.10	8.39	4.91	2.94	11.03	4.75	103.48	1.03
12650 12650-1	Elevator Assy.	22	24.40	7.58	2.85	24.65	7.15	5.03	3.14	12.17	3.92	90.89	.91
10550-5 10550-6	Vee Assy - L. G.	18-18A	15.93		2.06	19.29	3.58	3.08	1.33	6.48	3.55	55.30	.55
13124 13124-5	Vee Assy - L. G.	22	20.13 29.63		2.03 2.03	29.73 31.74	3.90 3.90	3.32 3.32	2.06 2.06	8.04 8.04	5.15 5.15	74.36 85.87	.74 .86
12773 12773-1	Flap Assy.	18-18A	26.96	15.11	2.55	29.22	13.97	2.80	2.27	28.24	6.18	127.30	1.27
12484 12484-1	Flap Assy.	22	21.56	13.48	2.23	24.85	12.11	2.21	1.57	18.75	3.54	100.30	1.00
42592 42592-1	Aileron Assy.	18-18A	46.85	23.25	4.37	39.83	21.17	3.58	3.80	39.90	7.47	190.22	1.90
12475 72475-1	Aileron Assy.	22	30.17	15.43	2.43	30.63	19.58	3.48	2.43	25.21	4.66	134.02	1.34
14400 14400-1	Wing Assy.	18-18A	70.19	187.63	18.48	150.79	102.81	20.68	11.02	123.02	31.52	716.14	7.16
14413 14413-1	Wing Assy.	22	68.95	171.03	15.25	133.43	61.39	18.73	10.03	115.60	25.56	619.97	6.20
14486 13255	Fuselage Assy	18 18A	173.77 228.27		22.06 24.17	198.92 261.79	81.29 92.04	23.91 28.08	12.58 11.89	88.56 85.61	379.03* 379.03*	980.12 1110.88	9.80 11.11
14696	Fuselage Assy	22	325.58		31.59	226.63	102.63	31.32	12.44	96.24	325.03*	1151.46	11.51

NOTE: Hours time for painting fuselages (*) includes masking and taping.

NOTE: Total factory time, in hours, required for each complete plane - PA-18 37.33; PA-18A 38.64; PA-22 33.47

NOTE: For approximate hours time use PA-18 figures for J-3, J-4, J-5, PA-11, PA-12 and PA-14; PA-22 figures for PA-15, PA-16, PA-17 and PA-20.

NOTE: FOR FIELD ESTIMATION PURPOSES MULTIPLY ALL INDICATED FIGURES BY TWO (2).