

# 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			Build-up			Wet			Paint	Per 100 Assys.	Total Hrs. Per Each Assembly
					Dope	Tape & Patch	Dry Sand	Dope	Silver	Sand	Sand					
12573	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			
14773																
12790	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			
12790-1																
12648	Stabilizer Assy.	22	14.65	17.43	2.86	34.32	4.76	4.95	2.75	11.31	3.70	96.73	.97			
12648-1																
12789	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			
12789-1																
12650	Elevator Assy.	22	24.40	7.58	2.85	24.65	7.15	5.03	3.14	12.17	3.92	90.89	.91			
12650-1																
10550-5	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			
10550-6																
13124	Vee Assy - L.G.	22	20.13		2.03	29.73	3.90	3.32	2.06	8.04	5.15	74.36	.74			
13124-5																
12773	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			
12773-1																
12484	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			
12484-1																
42592	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			
42592-1																
12475	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			
12475-1																
14400	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			
14400-1																
14413	Wing Assy.	18-18A	70.19	187.63	18.48	154.27	102.81	20.68	11.02	123.02	31.52	719.62	7.20			
14413-1																
14413	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			
14413-1																
14486	Fuselage Assy	18	173.77		22.06	198.92	81.29	23.91	12.58	88.56	379.03*	980.12	9.80			
13255	Fuselage Assy	18A	228.27		24.17	261.79	92.04	28.08	11.89	85.61	379.03*	1110.88	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).