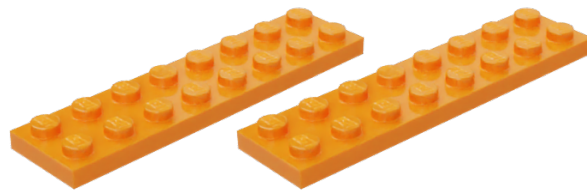


# Workstation-1

Instructions for Phases 1-2-3

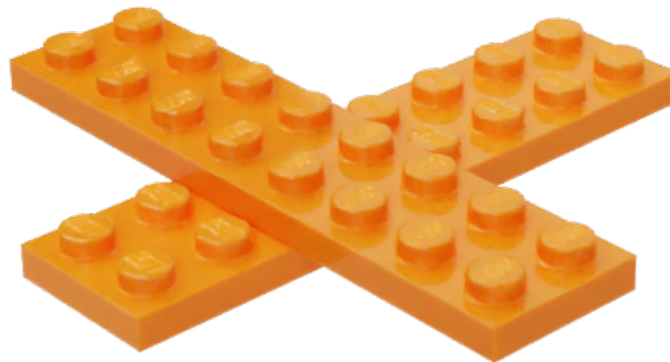
1: Assemble the primary wing/airframe section using:  
Two 16-Pin Blocks



Front View



Side View



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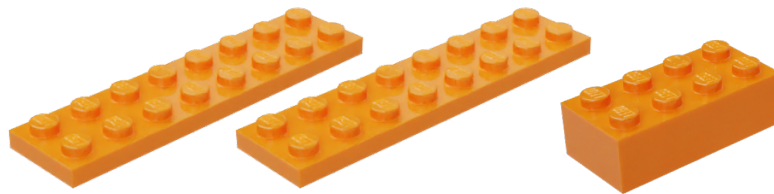
# Workstation-1

Instructions for Phases 4

1: Assemble the primary wing/airframe section using:

Two 16-Pin Blocks

2: Add nose section using: One 8-Pin Blocks



Front View



Side View

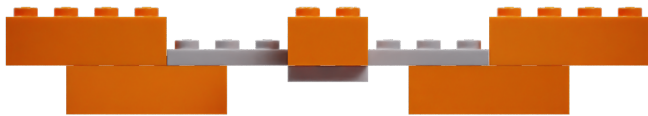


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# Workstation-2

Instructions for Phases 1-2-3

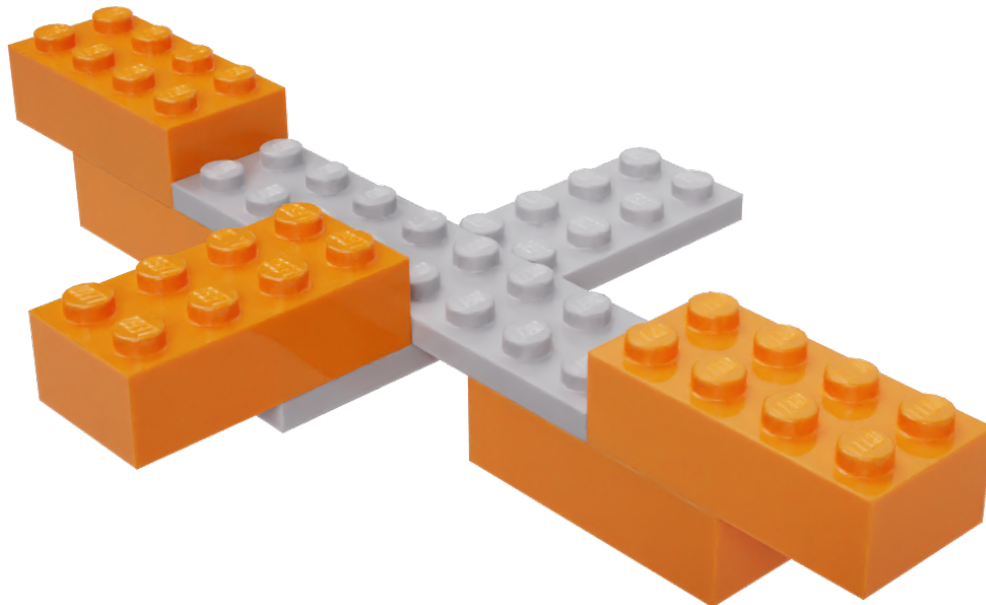
1: Assemble the nose and two wing sections using: Five 8-Pin Blocks



Front View



Side View

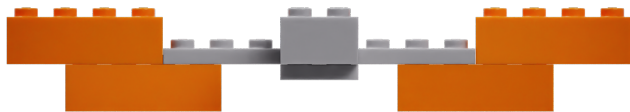
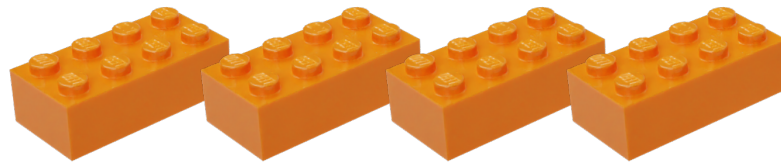


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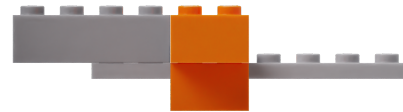
# Workstation-2

Instructions for Phases 4

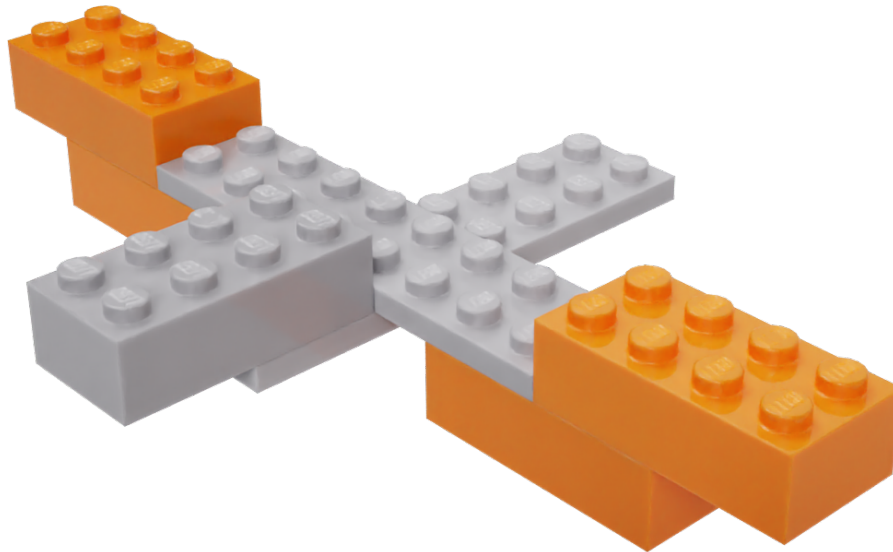
1: Assemble the two wing sections using: Four 8-Pin Blocks



Front View



Side View

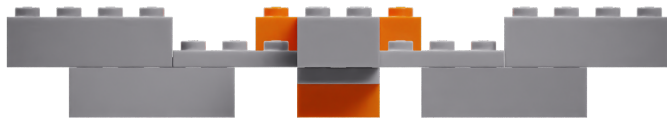


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# Workstation-3

Instructions for Phases 1-2-3

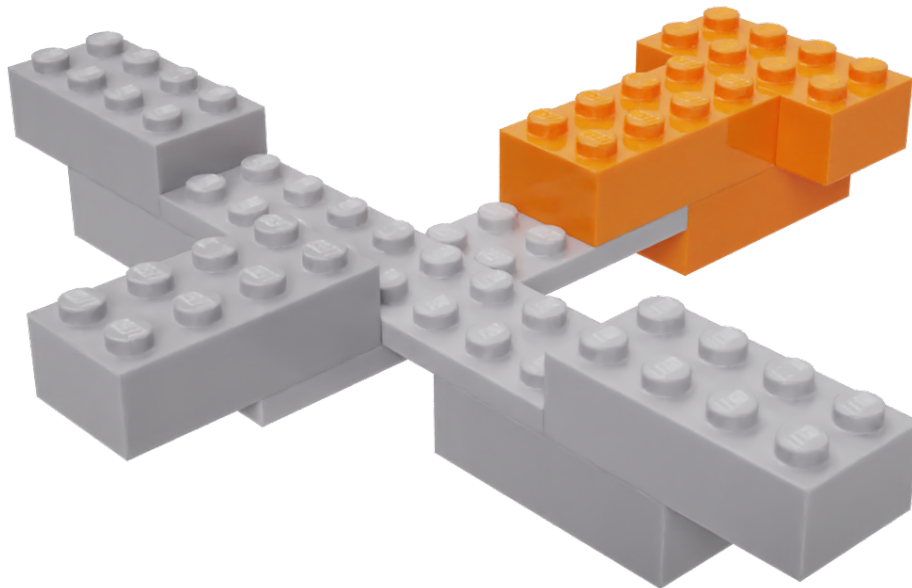
1: Assemble the large section of the tail using: Three 8-Pin Blocks



Front View



Side View



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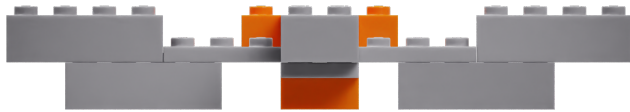
# Workstation-3

Instructions for Phase 4

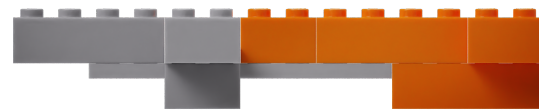
1: Assemble the large section of the tail using: Three 8-Pin Blocks



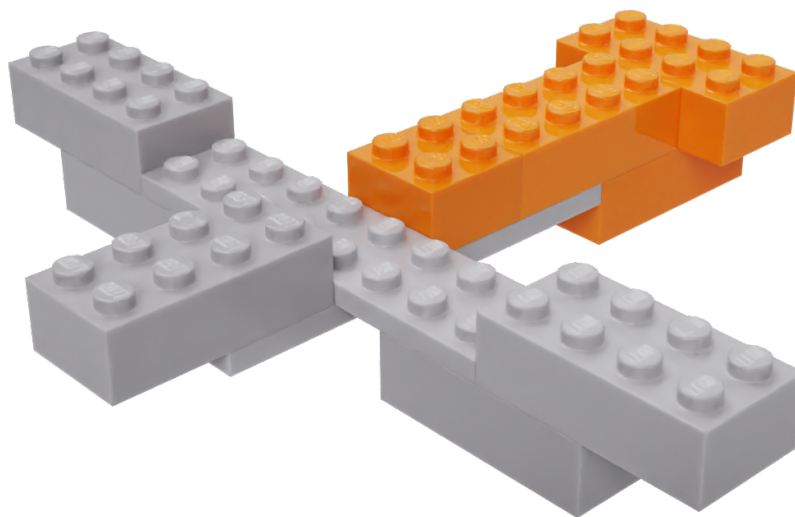
2: Add the fuselage using: One 4-Pin Block



Front View



Side View

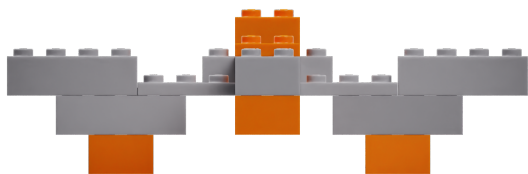
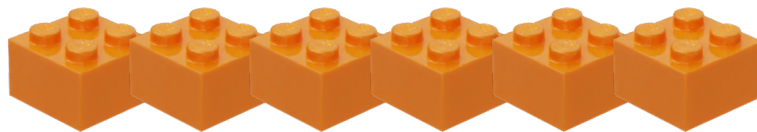


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# Workstation-4

Instructions for Phase 1-2-3

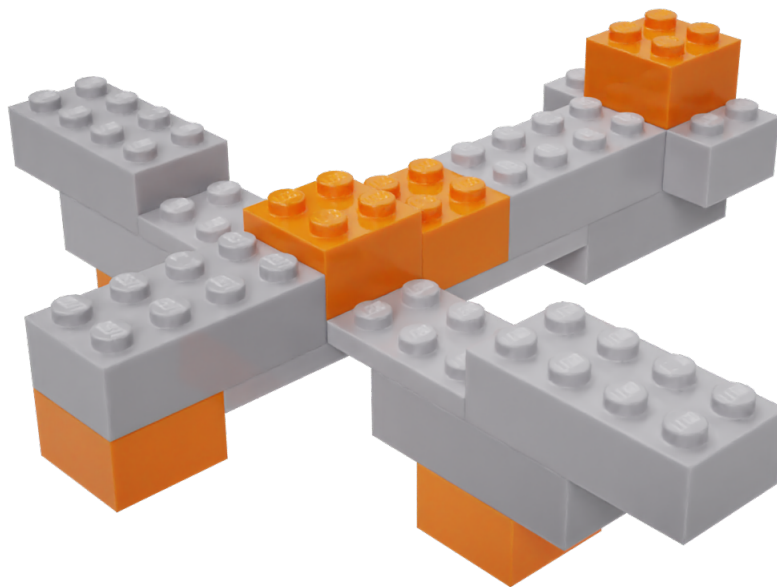
1: Assemble the nose, fuselage, cockpit, tail, and wheels using:  
Six 4-Pin Blocks



Front View



Side View

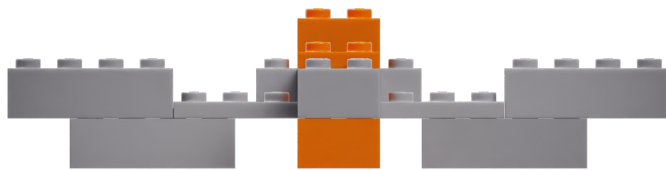


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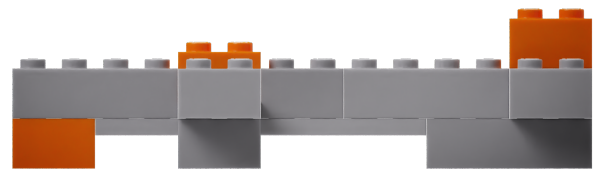
# Workstation-4

Instructions for Phase 4

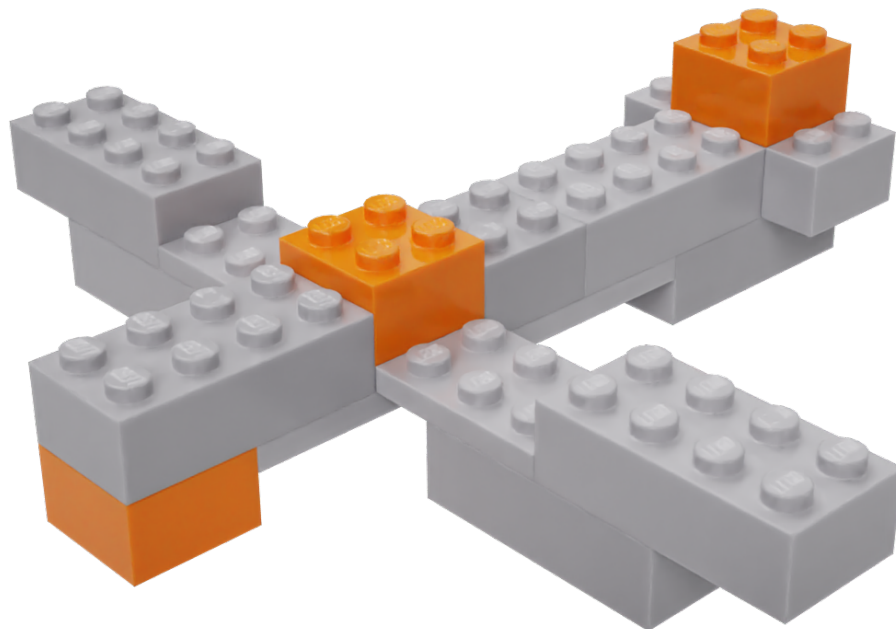
1: Assemble the nose, cockpit, and tail using: Three 4-Pin Blocks



Front View



Side View



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# Workstation-5

## Instructions for Phase 1-2-3

1: Complete QC Checklist for each plane.

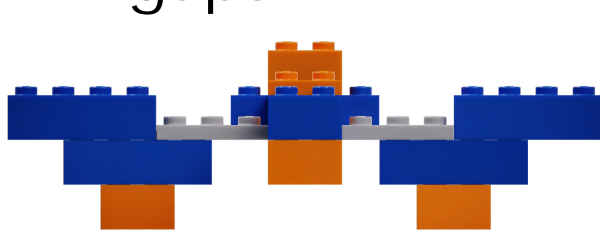
- All components in place and properly installed

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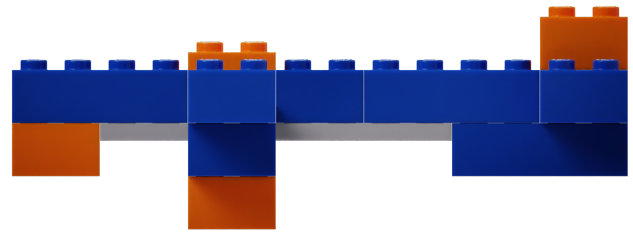
- No horizontal gaps between blocks/assemblies

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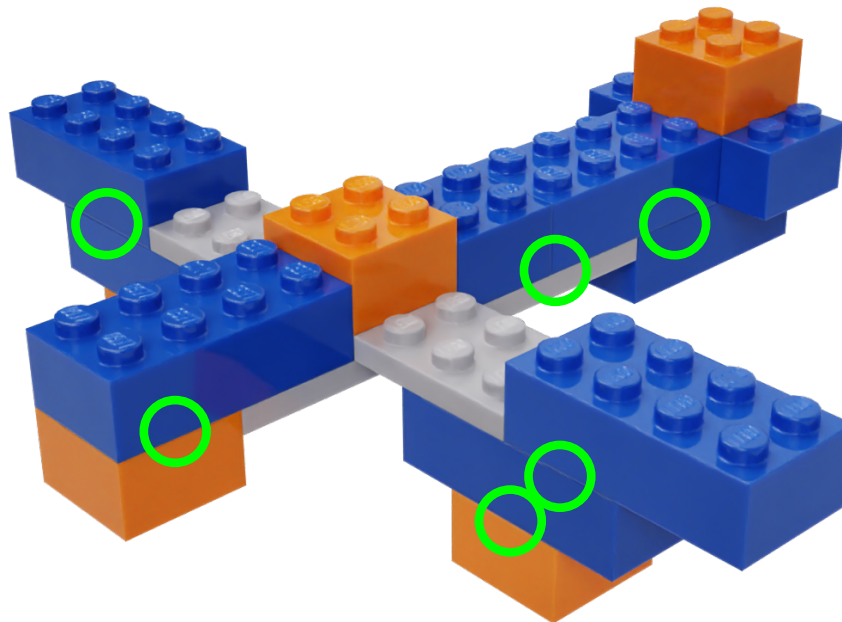
- Do not force .007 thickness gauge into gaps



Front View



Side View



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# Workstation-5

Instructions for Phase 4

1: Add wheels using  
Two 4-Pin Blocks



2. Complete QC checklist for each plane.

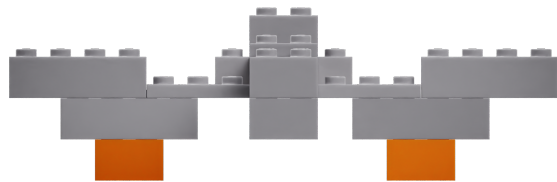
- All components in place and properly installed

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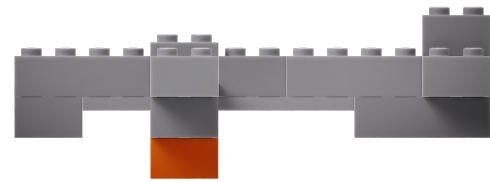
- No horizontal gaps between blocks/assemblies

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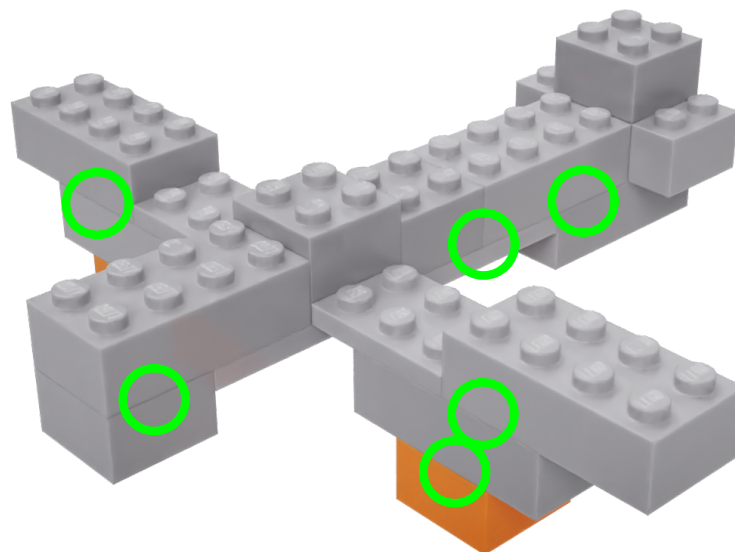
- Do not force .007 thickness gauge into gaps



Front View



Side View



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# Workstation-6

## Instructions for All Phases

- Tear down all assemblies after each phase

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- Tear down vendor-defect scrap after counting

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- Count WIP, scrap, rework, and completed airplanes

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- Report to facilitator at the end of each phase

	<b>Planes in 6 Minutes</b>	<b>Time Per Plane</b>	<b>Scrap</b>	<b>WIP</b>
<b>Phase-1</b>				
<b>Phase-2</b>				
<b>Phase-3</b>				
<b>Phase-4</b>				
<b>Phase-5</b>	Optional Bonus Round			



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