

100 # 149 GEARS

		Mtl	Labor	O.H.	Tot. Lab. Cost,	
100 Sets 1-1/8 X 7 P.P.S. Axles @ 2.40		240.00				240.00
Form 400 arms @ 65			2.60	65%	4.29	4.29
Weld 100 sets @ 9-1/4			9.25	"	15.26	15.26
Set 100 " @ 4			4.00	"	6.60	6.60
Grind " " @ 1			1.00	"	1.65	1.65
<u>AXLE BEDS</u>						
200 pcs. H.W. 1-3/4 X 2-1/2 X 50,						
464' @ 4-1/2		20.88	7.00	50%	10.50	31.38
Fit & Glue Beds, 100 @ 2-1/2			2.50	"	3.75	3.75
Glue 1 lb. @ 18		.18				.18
Sand & Finish 100 @ 2-1/2			2.50	50%	3.75	3.75
Priming Axles, 200 pcs. 2 Gal. @ 95		1.90	.50	55%	.78	2.68
Forge Irons complete, 100 sets @ 1.00			100.00	65%	165.00	16.500
<u>Reach Plates</u>						
100 pcs. 1-1/4 X 5/16 X 68-1/2 Tire,						
850 lbs. @ 2.15		18.27				18.27
200 " 1 X 1/4 X 64" Tire,						
1000 lbs. @ 2.00		20.00				20.00
Cut off 300 pcs. @ 7			.21	65%	.35	.35
Punch 3300 holes @ 4			1.32	"	2.18	2.18
<u>Stay Braces.</u>						
200 pcs. 9/16 X 32" Rd.						
450 lbs. @ 15		96.75				96.75
Cut off 200 pcs. @ 7			.14	"	.23	.23
Forge 100 pr. @ 10			10.00	"	16.50	16.50
Drill 400holes, @ 14			.56	"	.92	.92
" 400 " @ 9			.36	"	.59	.59
<u>Head Block Plate</u>						
100 pcs. 1-1/8 X 35-1/2 H.O.						
250 lbs. @ 2.20		5.50				5.50
200 pcs. 1 X 4 H.O. 50 lbs. @ 2.20		1.10				1.10
100 " 1, X 1/4 X 8-3/4 H.R.E.						
50 lbs. @ 2.30		1.15				1.15
Cut off 400 pcs. @ 7			.28	"	.46	.46

100 # 149 GEARS

MTL LABOR O.H. TOT. LAB. COST.

Drill 1200 holes, @ 9 1.08 65% 1.78 1.78

Rub Irons

200 pcs. 1-1/8 X 5/16 X 19" Tire,
212 lbs. @ 2.15 4.56 4.56

Cut off 200 pcs @ 7 .14 " .23 .23

Punch 400 holes @ 3 .12 " .20 .20

Spring Hangers

200 pcs. 1-3/4 X 1/4 X 7" S.E.
162 lbs. @ 2.05 3.32 3.32

Cut off 200 pcs. @ 7 .14 " .23 .23

Thread 200 ends @ 25 .50 " .83 .83

100 prs # 567D. 47 lbs. @ 11 5.17 5.17

400 pcs. # 6860 D. 97 lbs. @ 7 6.51 6.51

200 " # 6865 D. 100 lbs. @ 7 7.00 7.00

100 sets Fifth Wheel # 184 A.
184 B.
184 C.
184 D.

913 lbs @ 6-1/2 59.35 59.35

100 pr. # 149 Springs,
7800 lbs. @ 5 390.00 390.00

Priming 200 springs, 1-1/2 Gal. @ 95 1.43 1.50 55% 2.33 3.76

100 pcs. Centre Reaches,
101' @ 4-1/2 4.54 1.90 50% 2.85 7.39

200 " Outside Reaches,
225' @ 4-1/2 10.13 3.80 50% 5.70 15.83

Priming 300 reaches,
1-1/2 Gal. @ 95 1.43 .45 55% .70 2.13

7 pcs. Head Block,
187' @ 4-1/2 8.42 4.75 50% 7.12 15.54

3 100 head Blocks.
1/4 Gal. @ 95 .24 .15 55% .23 .47

100 # 149 GEARS

	MTL	LABOR	O.H.	TOT.LAB.	COST.
200 pcs. Spring Bars,					
389' @ 4-1/2	17.50	4.30	50%	6.45	23.95
Priming 200 spg. bars,					
1 Gal. @ 95	.95	.30	55%	.47	1.42
400 pcs. # 1005 X 4-1/2 X 3/8 Axle Clips,					
@ 2.38	9.52				9.52
400 " # 1005 X 7-1/2 X 3/8 Axle Clips,					
@ 4.09	16.36				16.36
2000 " # 1001 X 4 X 5/16 @ 1.62	3.24				3.24
100 pr. # 1047 # 3-1/2 Couplings & Bolts,					
@ .22	22.00				22.00
200 pcs. # 2159 B. 1-1/8 X 3/8 yokes,					
16-2/3 lbs. @ 497/8	.81				.81
400 " # 2159 F. 1-3/4 X 3/8 Yokes,					
63 lbs. @ 4-7/8	3.07				3.07
1000 " # 2153 C. 1-1/4 X 3/8 Yokes,					
83 lbs. @ 5-1/5	4.32				4.32
400 pcs. 3/8 X 4-1/2 Plow Bolts @ 1.06	4.24				4.24
200 " 5/16 X 2-1/2 Mech. Bolts @ 57	1.14				1.14
200 " 3/8 X 3 " " @ 71	1.42				1.42
200 " 5/16 X 3 Tire Bolts @ 38	.76				.76
400 " 3/8 X 3 " " @ 56	2.24			1/4	2.24
2000 " 1/4 X 1-3/4 Cge. Bolts @ 27	5.40				5.40
700 " 1/4 X 2 " " @ 27	1.89				1.89
100 " 1/4 X 3-1/2 " " @ 35	.35				.35
200 " 5/16 X 3-1/4 " " @ 47	.94				.94
200 " 3/8 X 2-1/2 " " @ 55	1.10				1.10
Assemble complete 100	@ 42	42.00	65%	69.30	69.30
	1005.08	203.35		331.23	1336.31