

100 # 65 GEARS, D.R. FULL BED BIKE

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

FRONT AXLE

50 sets 15/16 X 6-1/2 FPS. Axles,

@ 1.87-3/4 93.88 93.88

Form 50 sets @ 5 2.50 65% 4.13 4.13

Set " " @ 2-1/2 1.25 " 2.06 2.06

Grind 50 " @ 1 .50 " .83 .83

AXLE BEDS

100 pcs. H²W. 1-1/2 X 2 X 50,

185 ft @ 4-1/2 8.33 4.00 50% 6.00 14.33

F it & Glue beds 100 @ 2 2.00 " 3.00 3.00

Glue, 1 lb. @ 18-1/2 .19 " " .19

Sand and finish 100 @ 3 - 3.00 " 4.50 4.50

Priming Axles 100, 1/2 Gal. @ 95 .48 .25 55% .39 .87

ASSEMBLE FRONT AXLE 100 @ 5 5.00 65% 8.25 8.25

100 pr. #1047 A. 2 B. Couplings @ 14-1/2 14.50 14.50

Arch Couplings 100 pr. @ 1-1/2 1.50 1.50

400 pcs. #2106 X 3 X 5/16 Oval Axle Clips,
@ 1.95 7.80 7.80

100 sets # 1931 F. Gear Sets, @ 1.10 110.00 110.00

400 pcs. #2152K. 1-1/16 X 5/16 Clip Ties
@ 5-1/5 .21 .21

200 pcs. #2152 F. 1-3/16 X 5/16 Clip Ties
@ 5-1/5 .10 .10

200 pcs. #2152 E. 1-1/4 X 5/16 Clip Ties
@ 5-1/5 .11 .11

REAR AXLE

50 sets 15/16 X 6-1/2 F.P.S. Axles,

@ 1.87-3/4 93.88 93.88

Form 50 sets @ 5 2.50 65% 4.13 4.13

Set 50 " @ 2-1/2 1.25 " 2.06 2.06

Grind 50 " @ 1 .50 " .83 .83

100 # 65 Gears, D.R. Full Bed Bike

MTL LABOR O.H. TOT.LBB. COST.

AXLE BEDS

100 pcs. H.W. 1-1/2 X 50,						
	185 @ 4-1/2	8.33	4.00	50%	6.00	14.33
Fit and Glue beds,	100 @ 2		2.00		3.00	3.00
Glue	1 lb @ 18-1/2	.19				.19
Sand and finish	100 @ 3		3.00	"	4.50	4.50
Priming axles 100, 1/2 gal @ 95		.48	.25	55%	.39	.87
<u>Assemble rear Axle 100</u>	@ 3-1/2		3.50	65%	5.77	5.77
600 pcs. # 2106 X 3 X 5/16 oval axle clips						
	@ 1.95	11.70				11.70
100 pr. # 2000 E. Stay Braces @ 11-3/4		11.75				11.75
Reshake stay braces 100 pr	@ 3		3.00	65%	4.95	4.95
100 sets # 1027 X 1-1/4 X 2-3/4 sad slips & plates						
	@ 6.37	6.37				6.37
200 pcs. #2152 K. 1-1/16 X 5/16 Clip Ties						
	@ 5-1/5	.10				.10
200 " #2152F. 1-3/16 X 5/16 Clip ties						
	@ 5-1/5	.11				.11
200 " # 2152 E. 1-1/4 X 5/16 Clip ties,						
	@ 5-1/5	.10				.10
<u>Clip loops on springs 100 pr.</u>	@ 4	4.00				4.00
100 pcs. # 63 F. springs,						
	1650 lbs. @ 5	82.50				82.50
100 " # 63 R. Springs,						
	1800 lbs. @ 5	95.00				95.00
Priming springs 200 pcs,						
	1-1/2 Gal. @ 95	1.43	1.50	55%	2.33	3.76
100 pr. # 1003 D. 21 X 3-1/2 Hangers						
	@ 75	75.00				75.00
200 pcs. #2121-1/2 X 1-1/4 X 3/4 Sht spg. clips						
	@ 3.15	6.30				6.30

100 # 65 GEARS

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200 pcs. #2121 1/2 X 1-1/4 X 1 Sht. Spg. Clips,	@ 3.15	6.30			6.30
400 " #2157 E. X 1-1/4 X 5/16 Clip yokes,	@ 4-7/8	.19			.19
<u>Clip head block to circle</u>					
& circle to spring 100 @ 3			3.00	65%	4.95 4.95
100 pcs. Head Block Hic. 1-1/2 X 1-1/4 X 18	41' @ 8	3.28	11.00	50%	16.50 19.78
Priming Head Block 100 pcs.	1/4 Gal. @ 95	.24	.15	55%	.23 .47
200 pcs. # 1027 X 1-3/4 X 1-1/4 Sad clips, no plates,	@ 2.53	5.06			5.06
200 pcs. 3/16 X 1-3/4 Tire Bolts @ 14		.28			.28
<u>Assemble Reaches 100 pr.</u>	@ 2		2.00	65%	3.30 3.30
200 pcs. Hic. 1 X 1 X 58	106' @ 8	8.48	7.50	50%	11.25 19.73
Priming Reaches 200 pcs.	1/2 Gal. @ 95	.48	.30	55%	.46 .94
200 pcs. # 2058 A. X 3/4 X 57-3/8 Chan.	450 lbs. @ 3.30	14.85			14.85
Cut off 200 pcs	@ 7		14	65%	.23 .23
Punch 2000holes	@ 3		.60	"	.99 .99
Grind 200 pcs.	@ 22		.44	65%	.73 .73
100 pr. # 253 B. Reach ends,	100 lbs. @ 6-1/2	6.50			6.50
800 pcs. 1-3/16 # 6 Rivets,	9-1/3 lbs. @ 3-1/2	.33			.33
400 " 3/16 X 1-1/2 Cge. Bolts @ 25		1.00			1.00
<u>Assemble gear complete 100</u>	@ 20		20.00	65%	33.00 33.00
200 pcs # 2113-1/2 X 3/3/4 X 5/16 Clips,	@ 2.65	5.30			5.30
100 pcs. #2061 A. Braces, @ 10		.10			.10
200 " # 1/4 X 1-1/2 Tire Bolts @ 21		.42			.42
300 " 1/4 X 1-3/4 Cge Bolts @ 27		.81			.81
800 " 3/16 X 1-1/4 " " @ 27		2.16			2.16
			690.12	85.13	134.76 824.88