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 contact@mtm.org

MTM-UAS

Standard Operations
 Assembly

Use of these table values without training in MTM-1 and UAS will lead to erroneous results.

Fasten		Code	TMU	EH	ET	Supplementary values			
						Tool			Part
						M-EH			M-ET
						1	2	3	3
Fasten by hand						20	40	55	15
insert and search for thread	one hand	M-SAA	85		+				
	two hands	M-SBA	125		+				
insert and turn on	one hand	M-SCA	145		+				
	two hands	M-SDA	185		+				
Metric Screw (M2,5 to M14) turn on and tighten with tool, per connection point									
power screwdriver		M-SHS	60	+					
drill screwdriver (Yankee)		M-SJS	85	+					
screwdriver		M-SKS	135	+					
ratchet		M-SLS	140	+					
open-end wrench, box wrench or Allen wrench, (with re-position)		M-SMS	210	+					
Self-tapping Screw (≤ 6 mm) place, turn on and tighten with tool, per connection point									
power screwdriver		M-SNS	125	+	+				
drill screwdriver (Yankee)		M-SOS	170	+	+				
screwdriver		M-SPS	320	+	+				
Additions									
additional tightening		M-SHA	55	+					
2 nd screw part (bolt or nut with tool)		M-SGA	95	+	+				
place locking wrench to 2 nd screw part		M-SZA	30	+					
additional parts (washer, spring washer)	one hand	M-SZB	55		+				
	two hands	M-SZC	85		+				



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Adhesive Items				Code	TMU	EH	ET	Supplementary values				
								Tool			Part	
								M-EH			M-ET	
								1	2	3	3	
Label or sticker	individual	approximate		M-KAA	130		+	20	40	55	15	
		exact	without template		M-KAB	150						+
			with template		M-KAC	175	+					+
	from dispenser	approximate		M-KBA	100		+					
		exact	without template		M-KBB	120						+
			with template		M-KBC	155	+					+
	from card	approximate		M-KCA	130		+					
		exact	without template		M-KCB	150						+
			with template		M-KCC	170	+					+
Insulating mat	without protective film		≤ 10 x 10 cm	M-KHB	75		+					
			≤ 20 x 20 cm	M-KHC	120		+					
			≤ 50 x 50 cm	M-KHD	180		+					
	with protective film		≤ 10 x 10 cm	M-KJB	155		+					
			≤ 20 x 20 cm	M-KJC	200		+					
			≤ 50 x 50 cm	M-KJD	310		+					
Adhesive tape	individual or from dispenser		length ≤ 20 cm	M-KKA	140		+					
			length ≤ 50 cm	M-KKB	185		+					
	hand-held dispenser		first 50 cm	M-KKC	75	+						
			additional 50 cm	M-KKD	45							



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Assemble Standard Parts		Code	TMU	EH	ET	Supplementary values			
						Tool			Part
						M-EH			M-ET
						1	2	3	3
With one tool	clamping sleeve, pin, nail, split pin, clamp, plastic binder, spring, gib-head key	M-NAA	170	+	+	20	40	55	15
With two tools	split pin, pin, rivet, double split pin	M-NBA	245	+	+				
Special tool	E-Ring, Seeger ring, blind rivet	M-NCA	135	+	+				
O-Ring	without tool	M-NFO	100		+				
	with tool	M-NFE	75	+	+				
Angle joint	without tool	M-NLO	75		+				
	with tool	M-NLE	100	+	+				
Retaining ring with 2 tools		M-NEZ	255	+	+				



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Clamp and Loosen			Code	TMU	EH	Supplementary values			
						Tool			
						M-EH			
						1	2	3	
Portable clamping devices						20	40	55	
clamping pliers			M-FAA	220	+				
screw clamp			M-FCA	240	+				
Stationary clamping devices									
clamping claw			M-FLA	650	+				
toggle clamp	manual	M-FMA	85	+					
	pneumatic	M-FNA	135	+					
vise	approximate	M-FPA	370	+					
	exact	M-FQA	610	+					
jaw chuck			M-FRA	475	+				
magnetic disc			M-FSA	45	+				
Additions									
Clamp & Loosen with additional tool			M-FZA	175	+				
Insert & Remove vise jaw pads									

Unpack			Code	TMU	EH	Supplementary values			
						Tool			
						M-EH			
						1	2	3	
Remove / Open cover	by hand	20 x 20 cm	M-AAB	145		20	40	55	
		50 x 50 cm	M-AAC	290					
		100 x 100 cm	M-AAD	530					
	with tool	20 x 20 cm	M-ABB	95	+				
		50 x 50 cm	M-ABC	190	+				
		100 x 100 cm	M-ABD	330	+				
Remove contents ≤ 8 kg	vacuum packed unit	20 x 20 cm	M-ACB	280	+				
		50 x 50 cm	M-ACC	305	+				
	foil packed item	20 x 20 cm	M-ADB	230	+				
		50 x 50 cm	M-ADC	245	+				
	carton	20 x 20 cm	M-AFB	170					
		50 x 50 cm	M-AFC	180					
	bag (foil, paper)	20 x 20 cm	M-AGB	165	+				
		50 x 50 cm	M-AGC	180	+				
	corrugated board, paper	20 x 20 cm	M-AHB	235	+				
		50 x 50 cm	M-AHC	310	+				



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Inspect or Measure			Code	TMU	EH	Supplementary values		
						Tool		
						M-EH		
						1	2	3
Gauge	dimension or shape	≤ 150 mm	M-PAA	80	+	20	40	55
		>150 ≤ 500 mm	M-PAB	150	+			
		>500 ≤ 2000 mm	M-PAC	195	+			
	thread	≤ 150 mm	M-PBA	270	+			
>150 ≤ 500 mm		M-PBB	270	+				
Dial gauge	inspect dimension	≤ 150 mm	M-PCA	80	+			
		>150 ≤ 500 mm	M-PCB	110	+			
	establish di- mension	≤ 150 mm	M-PDA	95	+			
		>150 ≤ 500 mm	M-PDB	125	+			
Direct-reading gauge	without movable parts	≤ 150 mm	M-PEA	75	+			
		>150 ≤ 500 mm	M-PEB	75	+			
		>500 ≤ 2000 mm	M-PEC	175	+			
	with movable parts	≤ 150 mm	M-PFA	190	+			
>150 ≤ 500 mm		M-PFB	205	+				
Set range	measuring range ≤ 150 mm	M-PZF	105	+				
	measuring range >150≤500 mm	M-PZG	125	+				

Mark		Code	TMU	EH	Supplementary values		
					Tool		
					M-EH		
					1	2	3
Center punch or figure stamp	without inspection	M-MAA	80	+	20	40	55
	with inspection	M-MAB	155	+			
Compass	Ø ≤ 300 mm	M-MBA	100	+			
	Addition for setting	M-MBB	90	+			
Writing implement	per character	M-MGZ	40	+			
Paintbrush	per location	M-MPS	110	+			
Rubber stamp	per location	M-MSS	65	+			



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Treat			Code	TMU	EH	Supplementary values		
						Tool		
						M-EH		
						1	2	3
Clean	compressed air nozzle, brush, broom	10 x 10 cm	M-RAB	30	+	20	40	55
		20 x 20 cm	M-RAC	45	+			
		50 x 50 cm	M-RAD	145	+			
	paintbrush	10 x 10 cm	M-RBB	45	+			
		20 x 20 cm	M-RBC	105	+			
		50 x 50 cm	M-RBD	390	+			
	rag, cloth	10 x 10 cm	M-RCB	35	+			
		20 x 20 cm	M-RCC	45	+			
		50 x 50 cm	M-RCD	195	+			
Apply oil, paint, cleaning agent	paintbrush, oil can, rag, cloth	point	M-BHA	60	+			
		10 x 10 cm	M-BHB	60	+			
		20 x 20 cm	M-BHC	75	+			
		50 x 50 cm	M-BHD	200	+			
	spray can	10 x 10 cm	M-BIB	110	+			
		20 x 20 cm	M-BIC	160	+			
		50 x 50 cm	M-BID	460	+			
	grease gun	point	M-BKA	70	+			
	roller	10 x 10 cm	M-BRB	80	+			
		20 x 20 cm	M-BRC	105	+			
		50 x 50 cm	M-BRD	220	+			
	Apply adhesive, sealing compound	paintbrush, putty knife	point	M-BNA	70			
10 x 10 cm			M-BNB	190	+			
20 x 20 cm			M-BNC	360	+			
50 x 50 cm			M-BND	700	+			
tube, twist tube		point	M-BQA	50	+			
		10 x 10 cm	M-BQB	80	+			
		20 x 20 cm	M-BQC	100	+			
		50 x 50 cm	M-BQD	340	+			
Additions	clean/wash hands		M-BZI	515				
	wipe/dry off hands		M-BZH	160	+			