



# OKLAHOMA CITY AIR LOGISTICS CENTER



## *TEAM TINKER*



## **B-1 High Velocity Maintenance (HVM)**

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*Integrity - Service - Excellence*



# High Velocity Maintenance

AFSO21  
Air Force Smart Ops For The 21st Century



- HVM is the top Air Force transformation initiative – AFSO21
- Each Air Force Air Logistics Center chose a Pilot Program
  - Warner Robins ALC - C-130
  - Ogden ALC - F-22
  - Oklahoma City ALC - B-1
- The goal of HVM - **Increase Aircraft Availability**
  - Why? Warfighter mission focus vs. revenue focus
  - Real World Short-Notice Aircraft Requirements - Libya
- Tenets of HVM – Structured after Industry best practices
  - Understand Aircraft Condition Prior to Induction
  - Ensure Supportability Prior to Work Package Execution
  - Establish a Mechanic-Centric Focus
  - Accomplish a Higher Touch-Labor Rate to Schedule



# Evolutionary Processes

AFSO21  
Air Force Smart Ops For The 21st Century



Supportability

Aircraft Condition

## Supportability & Sourcing

- Strategic
- Operational
- Tactical

## Pre-Induction Evaluation

## Engineering Analysis

Engineering Analysis

ERRP (IPT)

Engineering Requirements Review Process

HVM

Daily Standard Work

Aircraft Maintenance Support Team

Daily Standard Work

AMST

AMST

Production Cell

Production Cell

Kit Requirements List

Task Kitting

Daily Standard Work

Mechanic-Centric Focus



# Lessons Learned



- **Culture Change Takes Time**
  - Re-engineered Roles and Responsibilities for all stakeholders
- **Executing a complete sequenced script is challenging**
  - Due to stumble-ons
  - Nature of airframe
- **Timely Supportability is Critical**
  - The earlier we know of an issue the better – Pre Induction Evaluation
- **Supply Chain challenges**
  - Diminishing manufacturing sources
  - Only 66 A/C
  - Requirements to the Supply Chain providers in time to react most efficiently vs. local Manufacturing



# B-1 Results



- **9 HVM A/C Completed**
  - Flowdays reduced from 207 avg. (FY10) to 178 avg. (FY11)
  - Overall goal is 130 Flowdays (FY13)
  - Work-in-Progress – Reduced from 7.5 A/C (FY10) to 5 A/C (FY11)
- **Improved productivity with increased throughput**
  - Required weekly throughput for all inducted B-1s: 2,345 hours
  - Increased average throughput t hours/week from 1,800 to 2,700
- **Kitting**
  - 3,100+ material kits built and delivered to the PDM Production Floor
- **Cost:** Reduced B-1 Overtime by 44 percent since Oct 2011
- **Quality:** External – No change, Great! Internal/Re-work - Improving
- **Safety:** Improved - Not asking the mechanic to go faster



# HVM Gets Results

