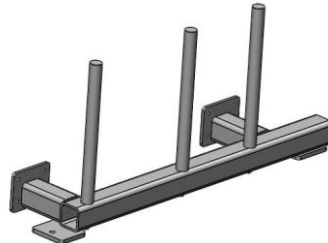

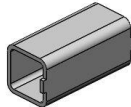
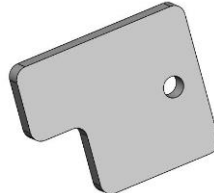

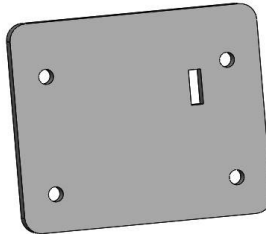
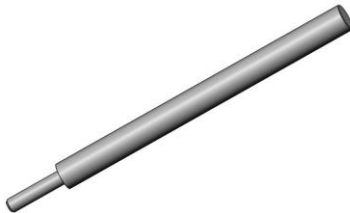
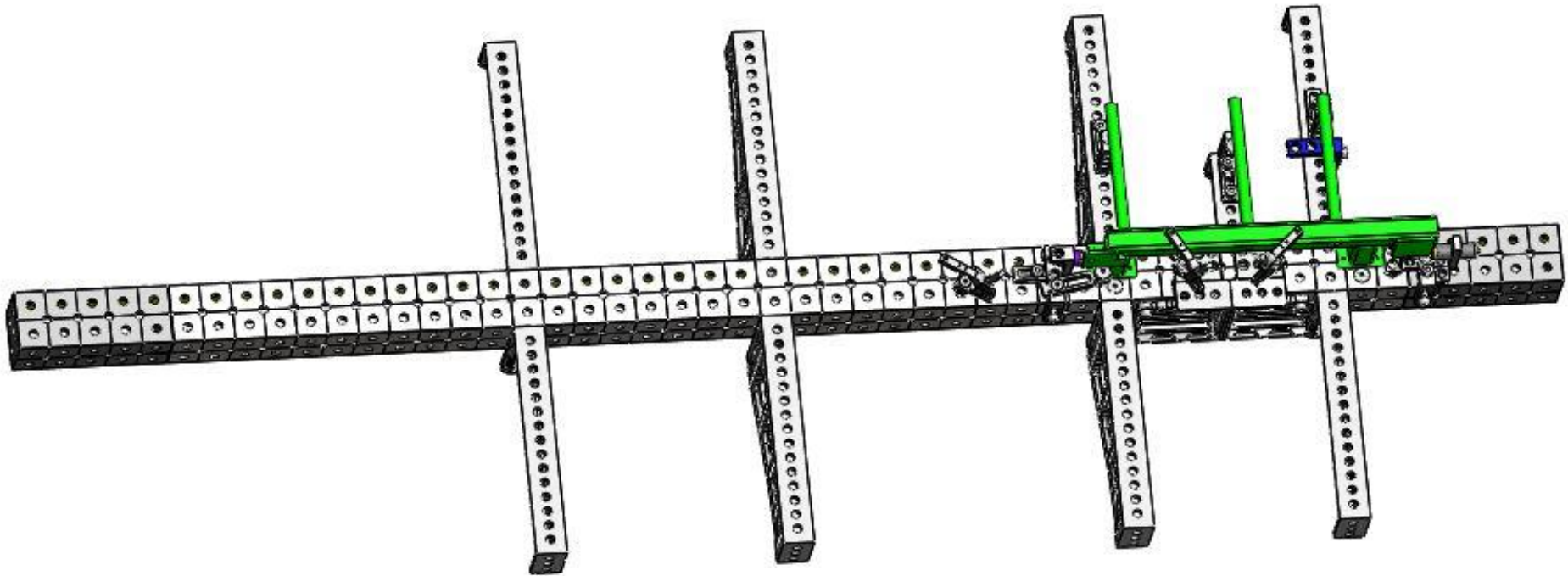


METAL FABRICATION				MACHINE MODEL				WELDMENT NAME				DRAWING NO.				REV		DATE		PREPARED BY M.T.(9/23/2019)		PAGE 1/15					
PROCESS INSTRUCTION				ARS3015NTK				PIN TABLE 2				HW_M200551---				OI		9/23/2019		APPROVED BY C.R.M. (9/30/2019)							
Mach	ARS3015NTK			Mach	ARS3015NTK			Mach	ARS3015NTK			Mach	ARS3015NTK			Mach	ARS3015NTK			Mach	ARS3015NTK						
Bom	Y902433--- Pin Table Assy			Bom	Y902433--- Pin Table Assy			Bom	Y902433--- Pin Table Assy			Bom	Y902433--- Pin Table Assy			Bom	Y902433--- Pin Table Assy			Bom	Y902433--- Pin Table Assy						
Main Par	PIN TABLE 2			Main Par	PIN TABLE 2			Main Par	PIN TABLE 2			Main Par	PIN TABLE 2			Main Par	PIN TABLE 2			Main Par	PIN TABLE 2						
Sub Part				Sub Part	SQUARE PIPE 1			Sub Part	SQUARE PIPE 2			Sub Part	PLATE 1			Sub Part	PLATE 2			Sub Part	PLATE 3						
Dwg No.	M200551---	Qty	1/M	Dwg No.	M20055101-	Qty	1	Dwg No.	M20055102-	Qty	2	Dwg No.	Y20055103-	Qty	1	Dwg No.	Y20055104-	Qty	1	Dwg No.	M20055105-	Qty	2				
Mat size	INIT / DATE			Mat size	3"x3"x1/4"			Mat size	3"x3"x1/4"			Mat size	1/2"			Mat size	1/2"			Mat size	1/2"						
Length	1067mm			Length	1067mm			Length	162mm			Length	231mm			Length	231mm			Length	150mm						
Paint	Black Texture			Paint				Paint				Paint				Paint				Paint							
Time				Time				Time				Time				Time				Time							
Part-Flow	HW-P-A			Part-Flow	IN-SM-HW			Part-Flow	IN-SM-HW			Part-Flow	IN-SM-HW			Part-Flow	IN-SM-HW			Part-Flow	IN-SM-HW						
																											

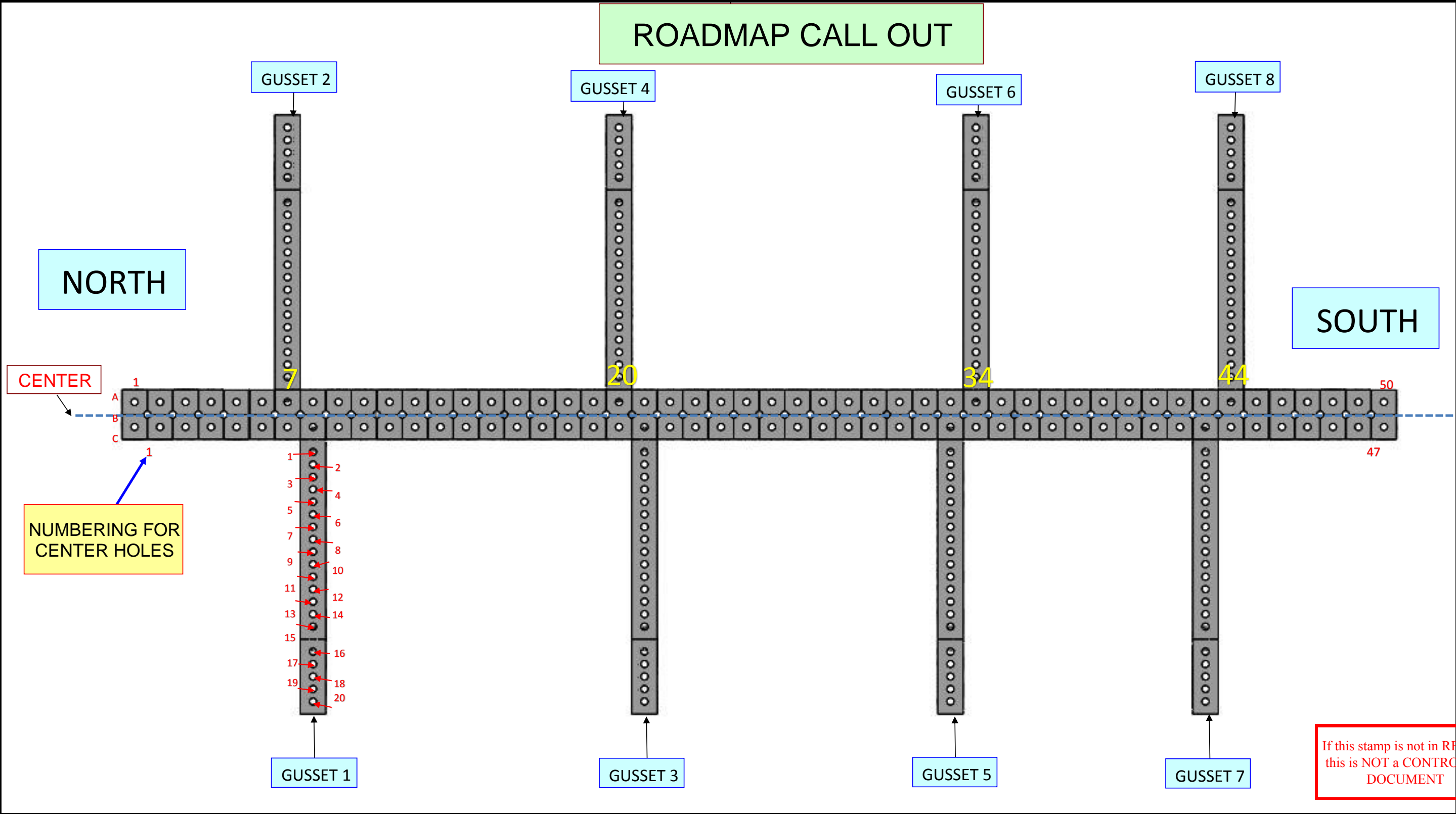
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 3/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

USE BLUCO INDEX JIG TO
FINISH WELDMENT

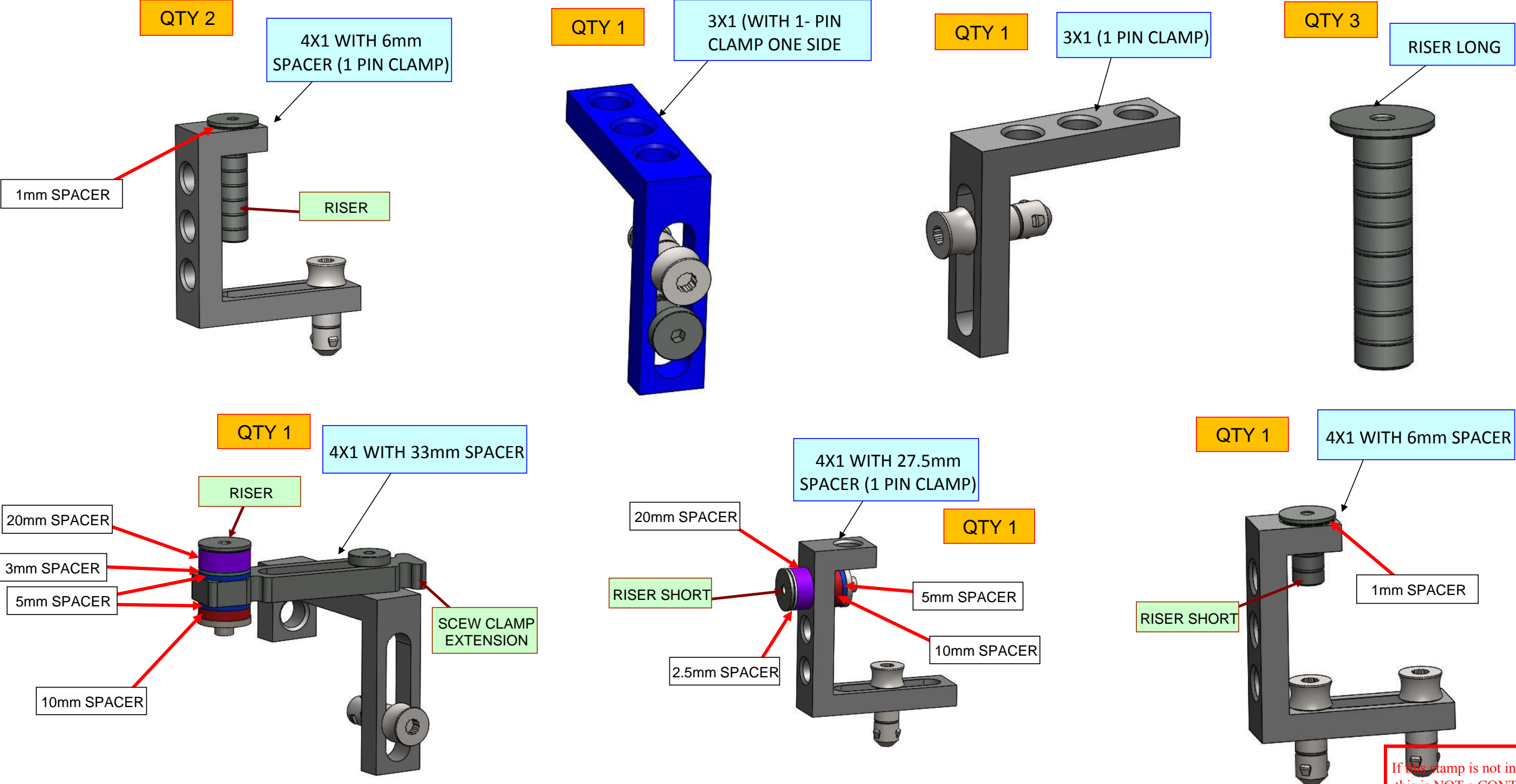


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METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 4/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

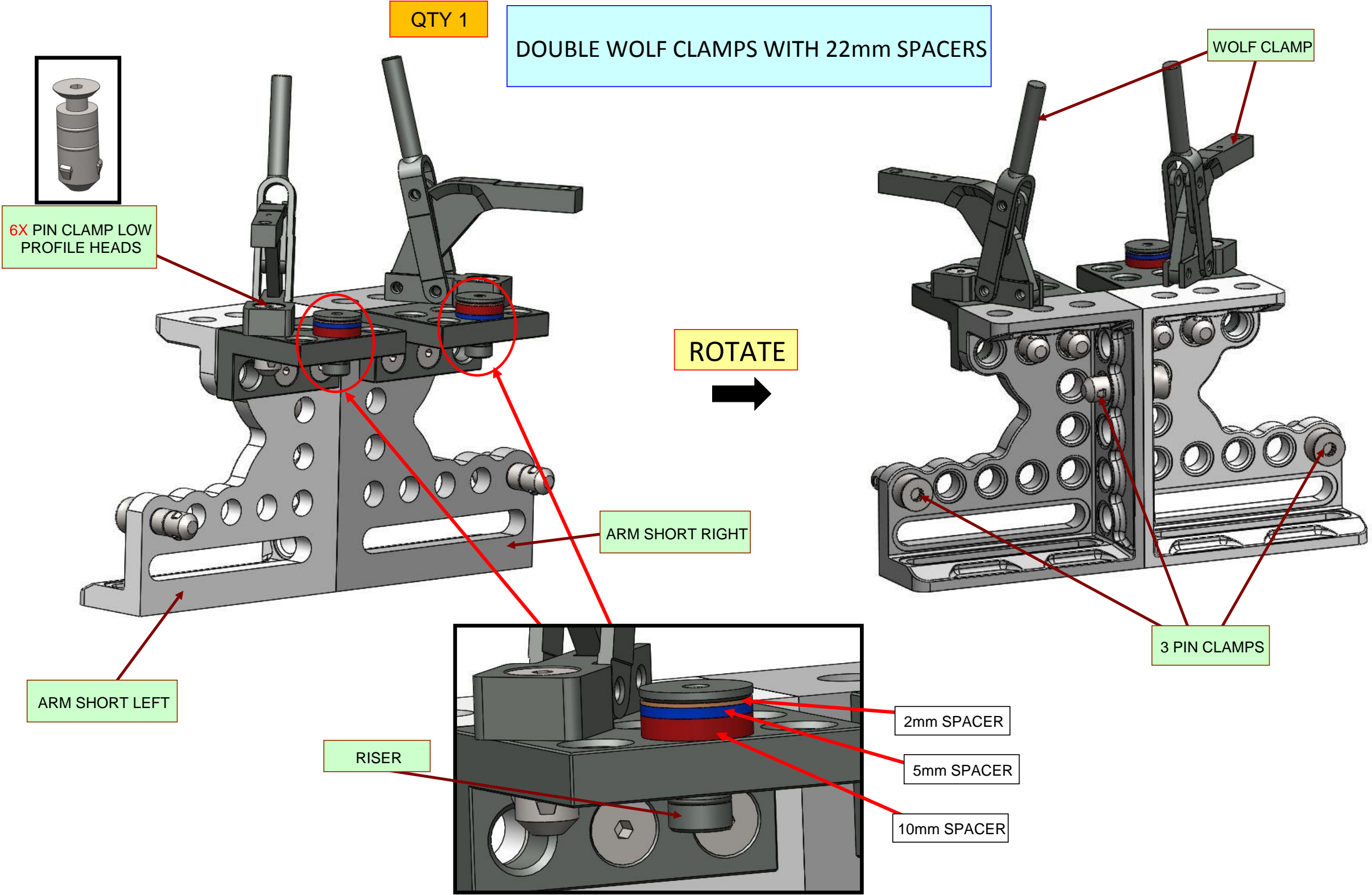


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 5/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

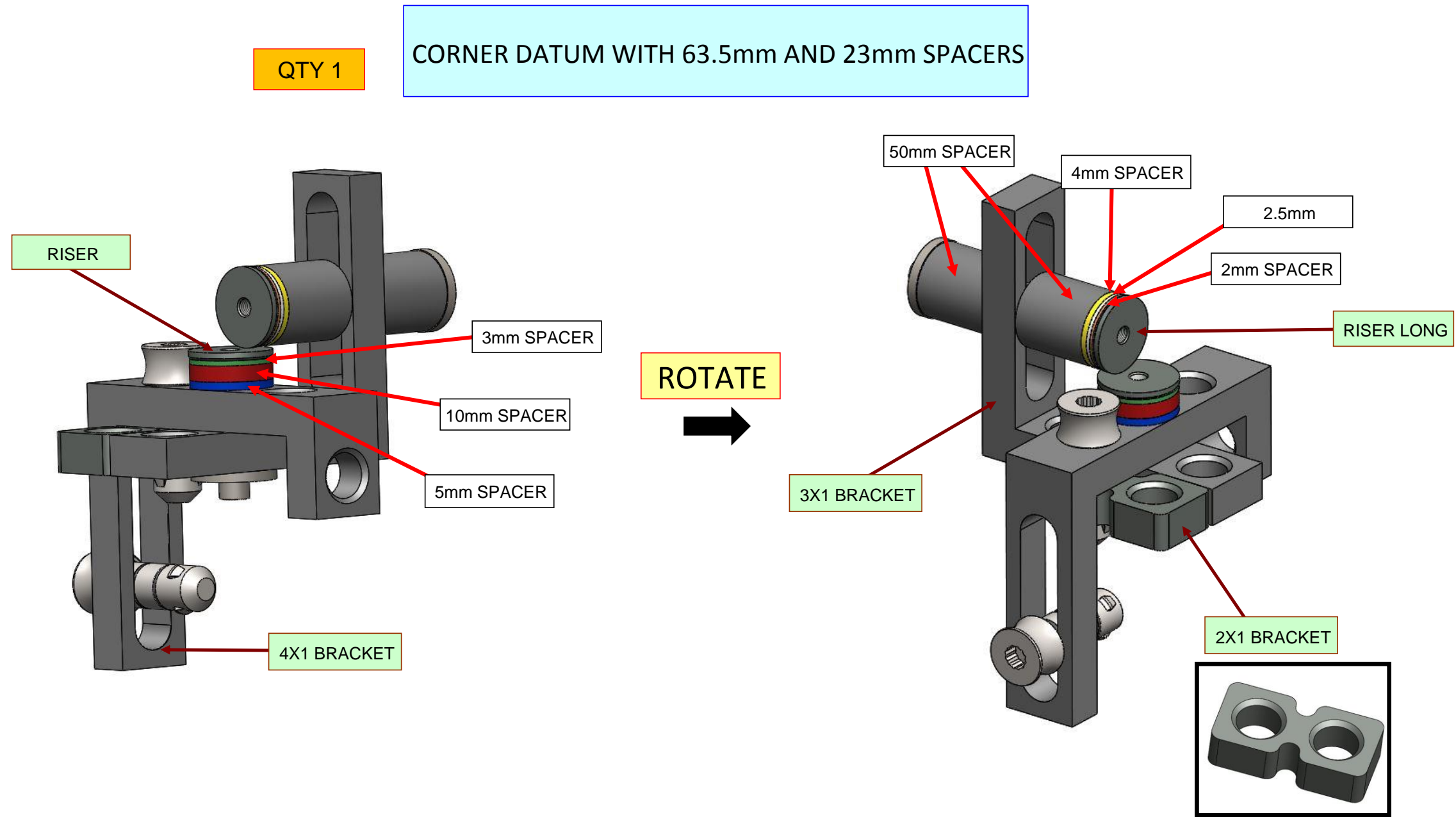


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METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 6/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

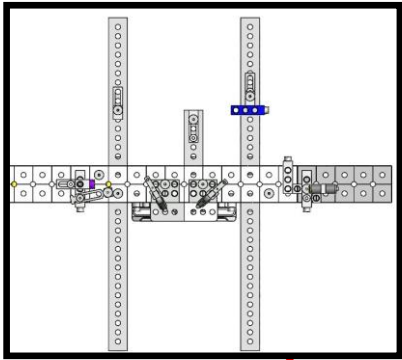
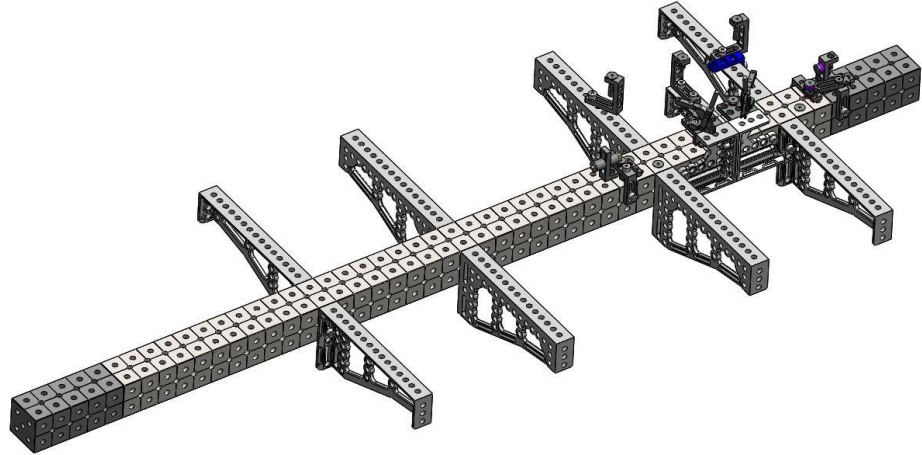


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 7/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

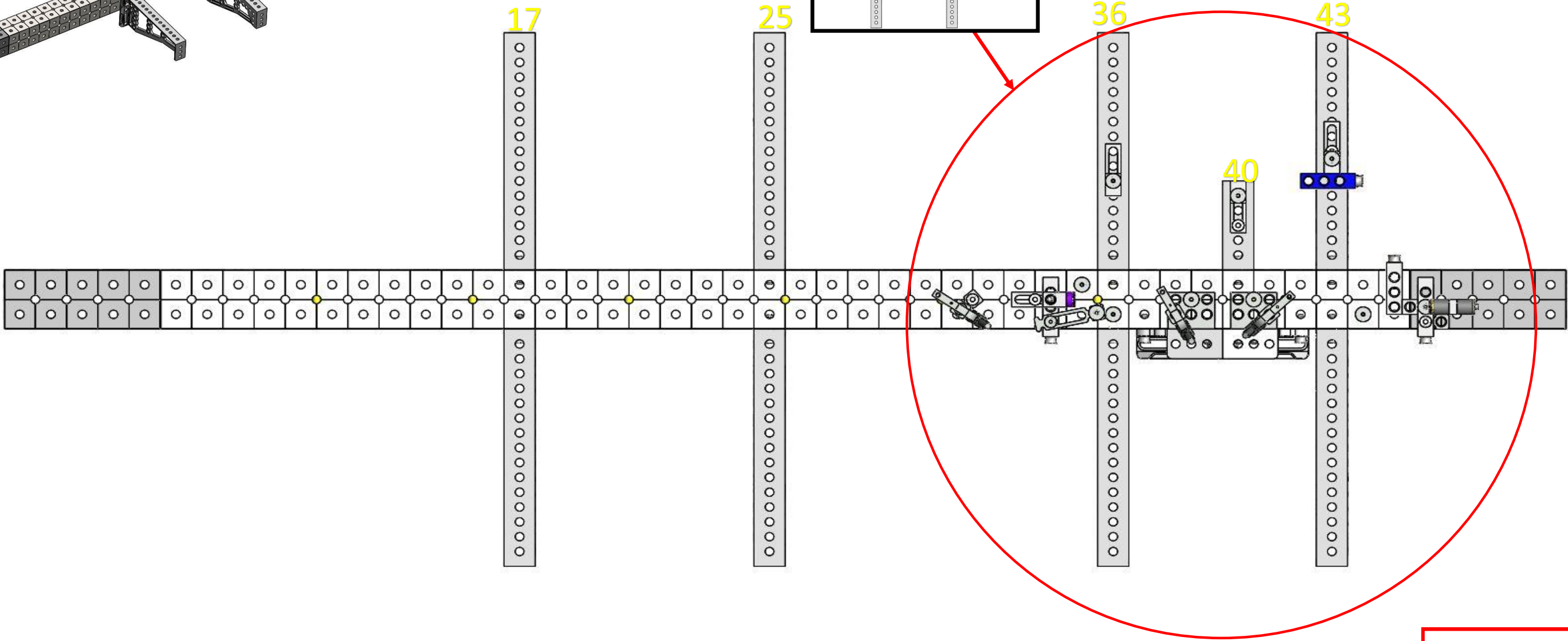


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METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 8/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

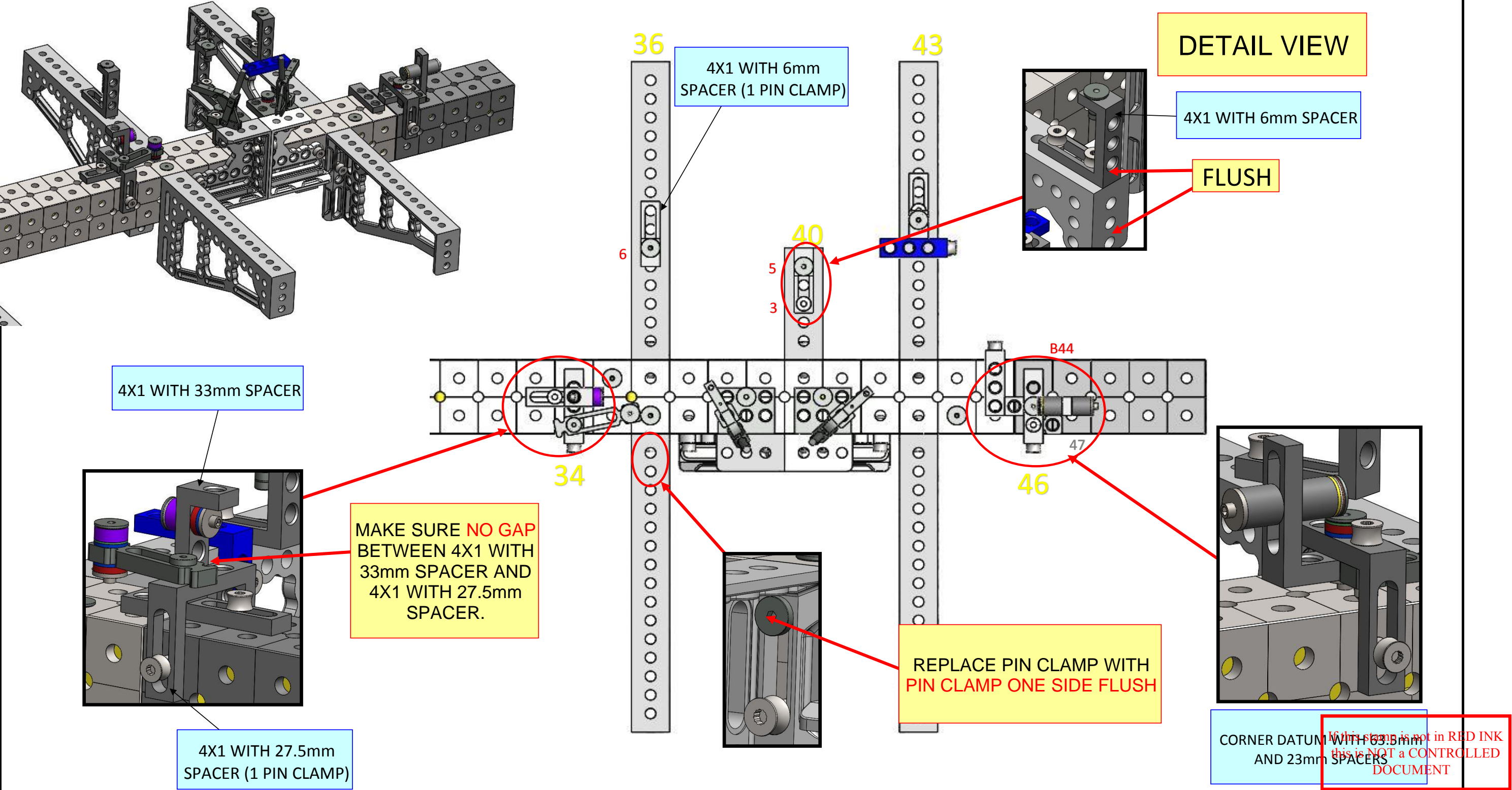


DETAIL VIEW

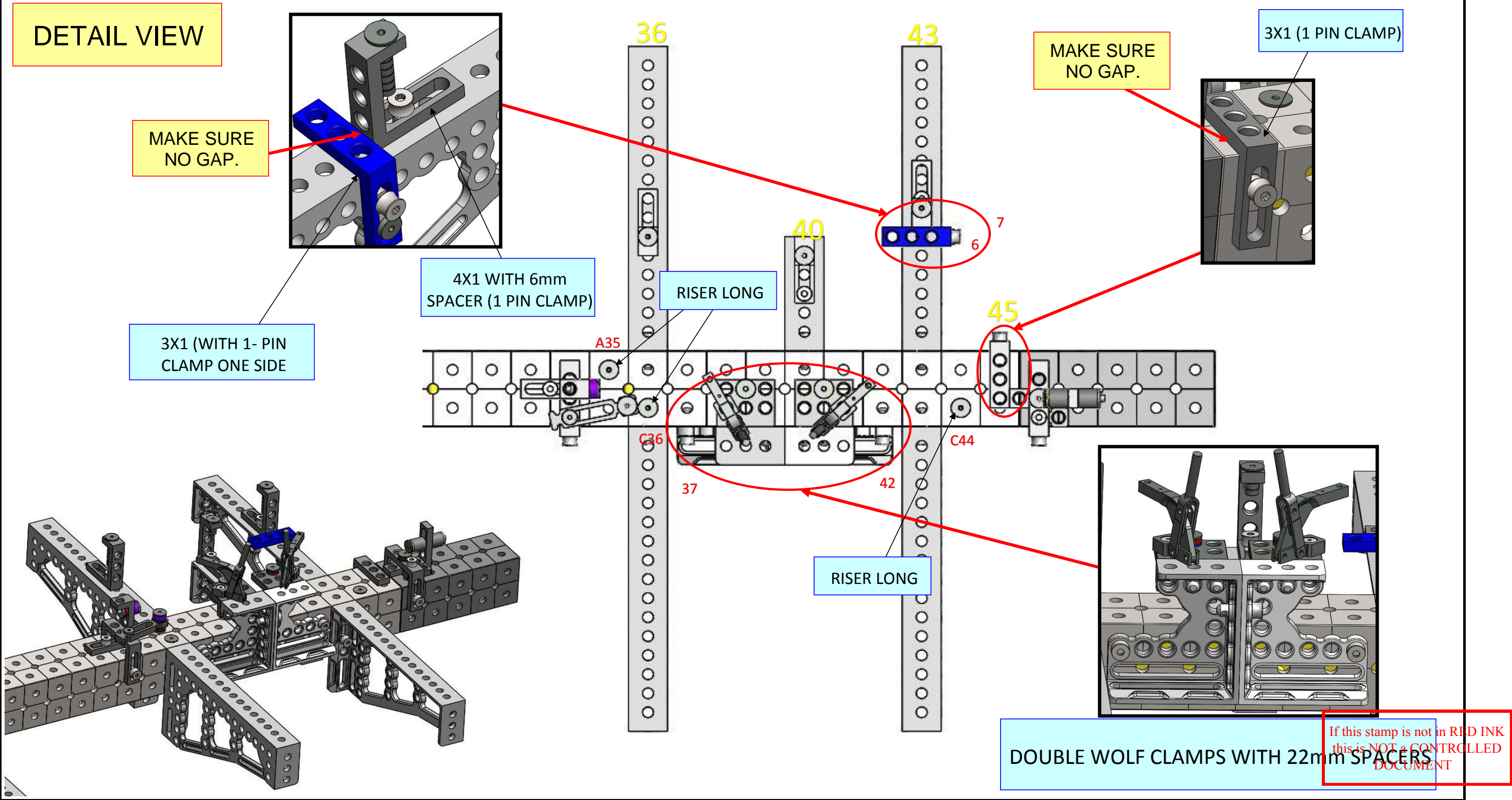


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DOCUMENT

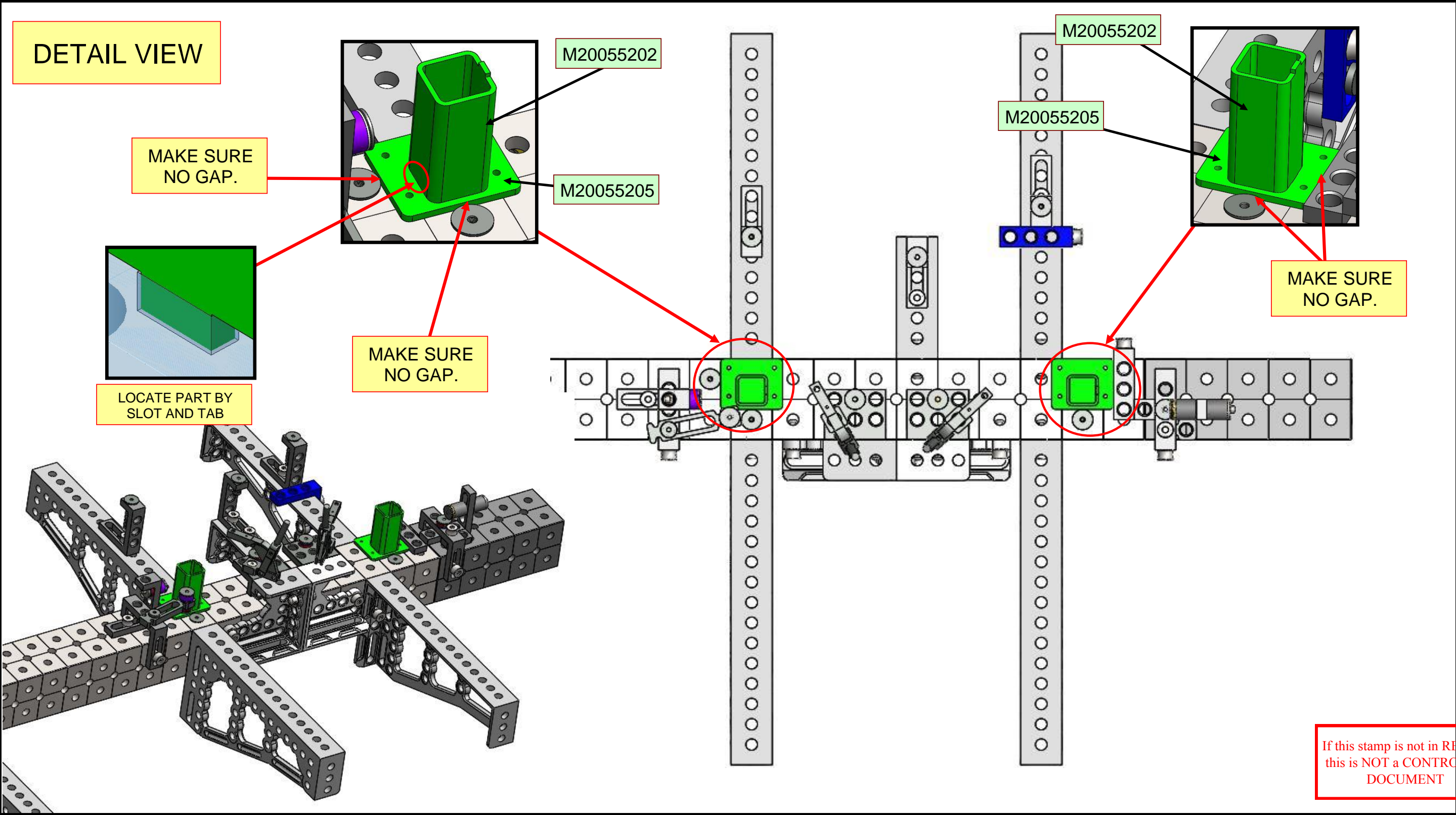
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 9/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	



METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 10/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

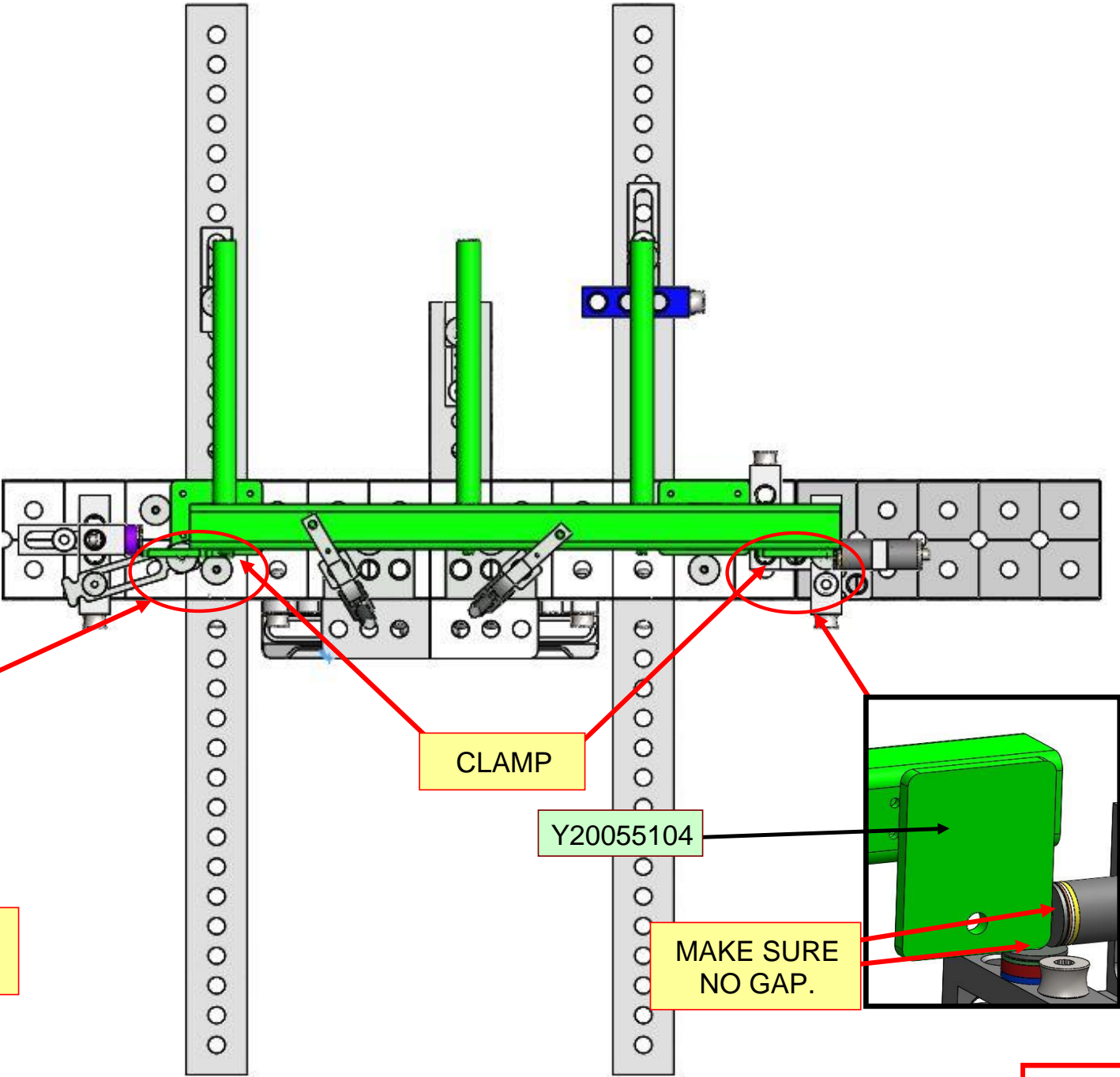
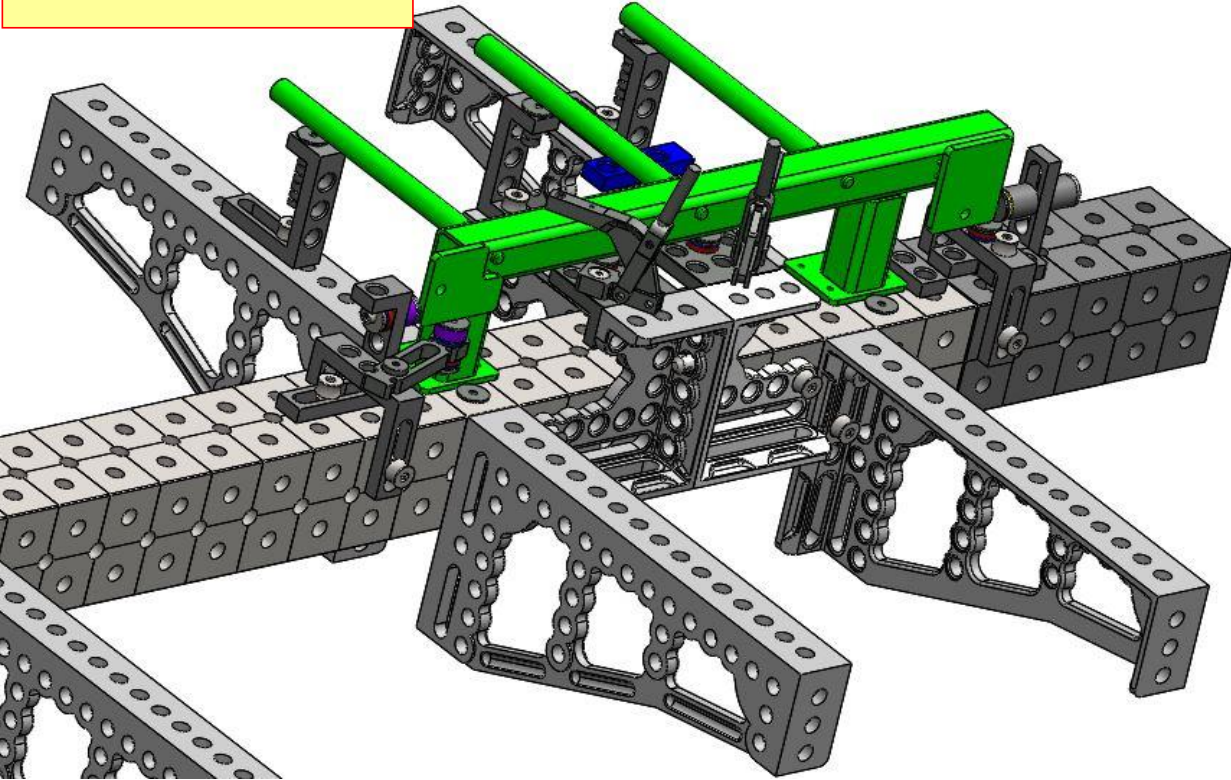


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 11/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

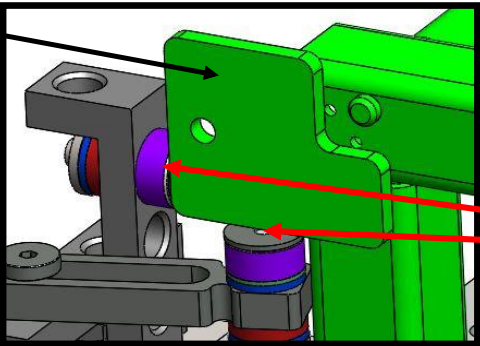


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 13/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

DETAIL VIEW



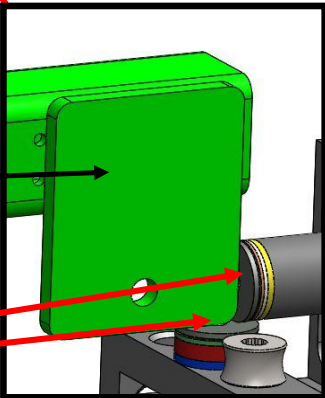
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MAKE SURE
NO GAP.

CLAMP

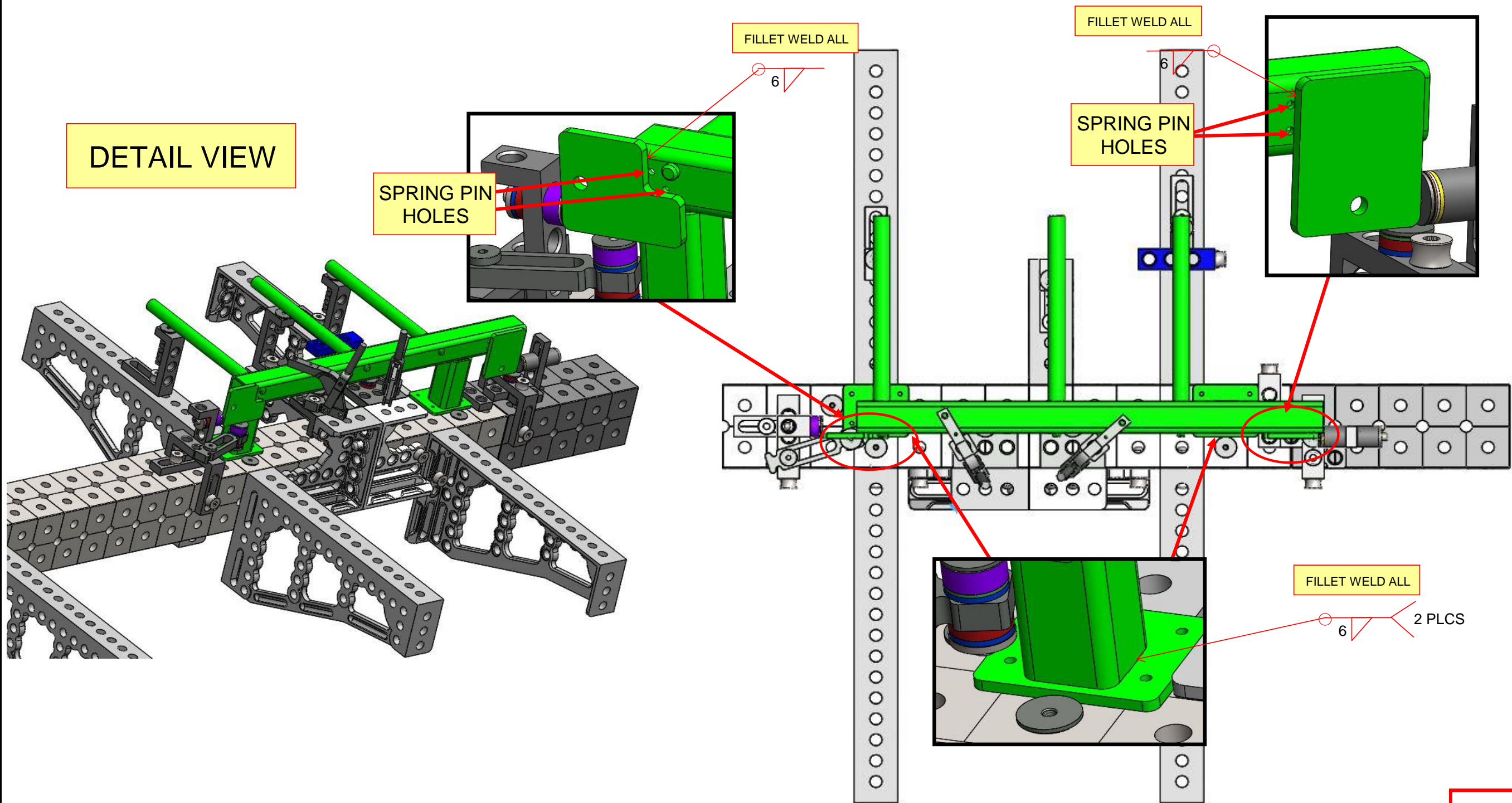
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MAKE SURE
NO GAP.

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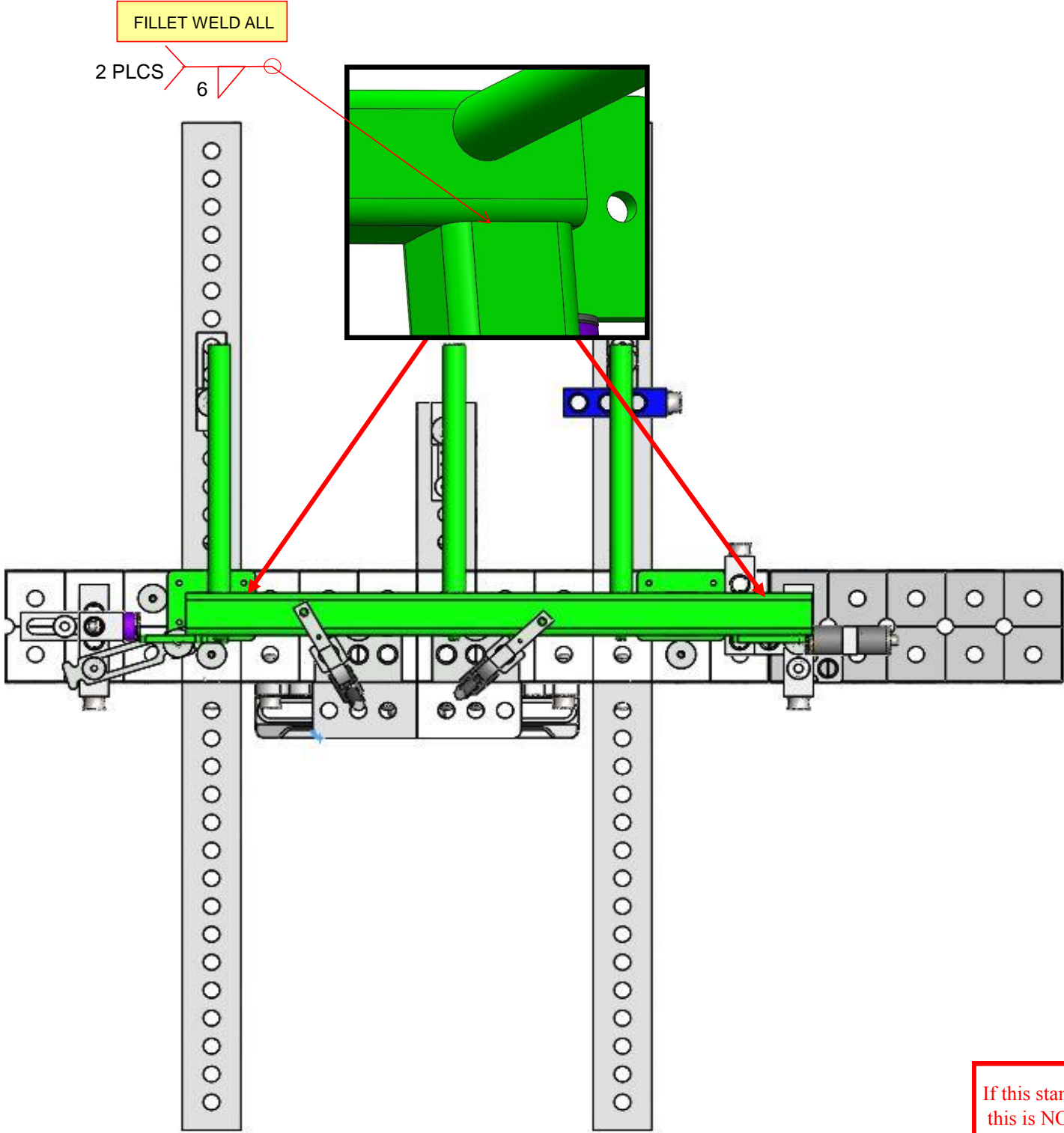
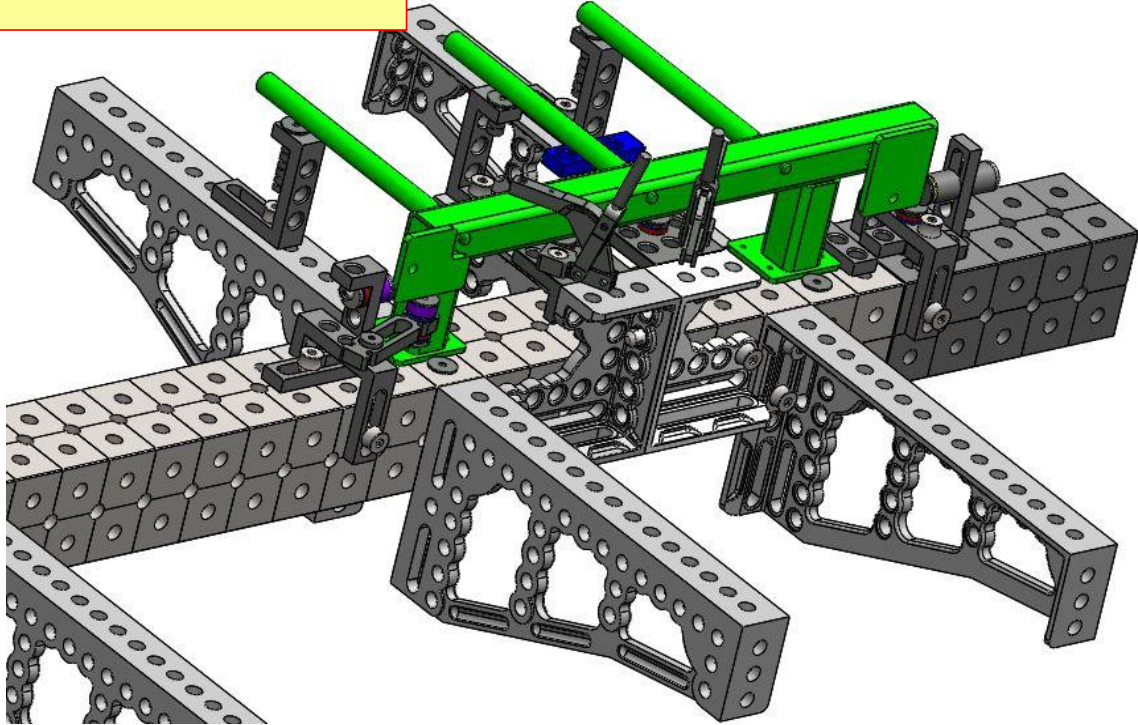
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 14/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	



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METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY M.T.(9/23/2019)	Page 15/15
PROCESS INSTRUCTIONS	ARS3015NTK	PIN TABLE 2	HW_M200551---	OI	9/23/2019	APPROVED BY C.R.M. (9/30/2019)	

DETAIL VIEW



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