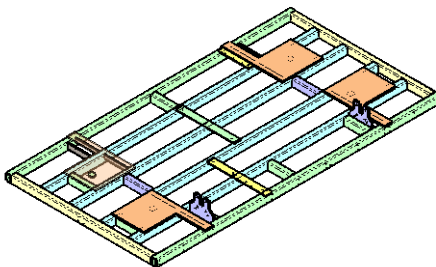
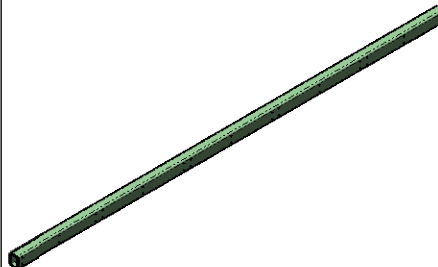
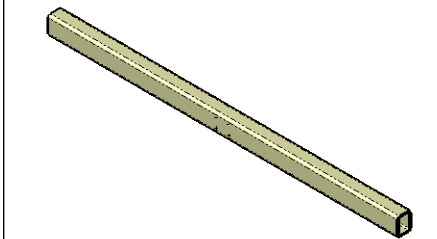
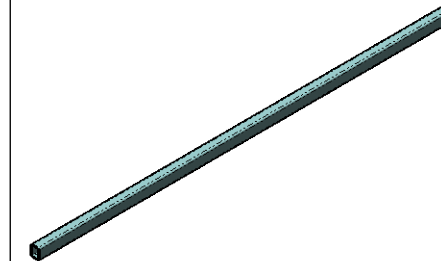
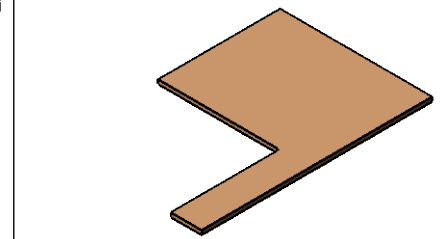
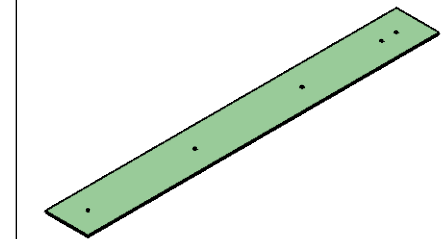
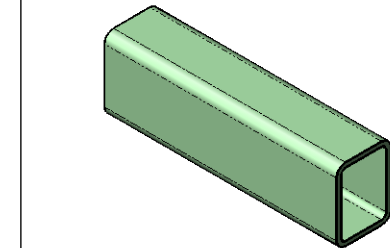
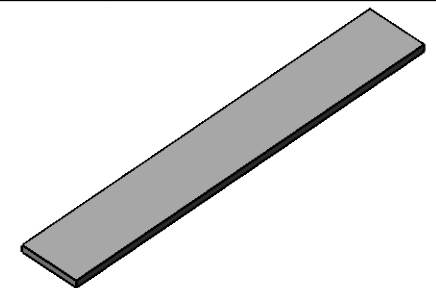
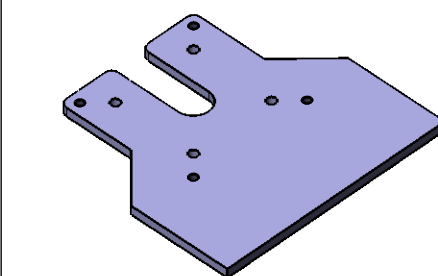
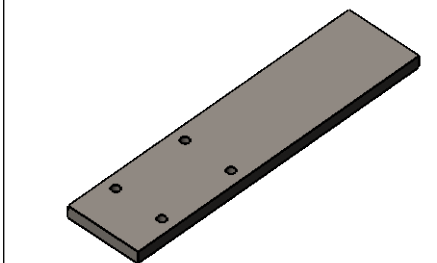
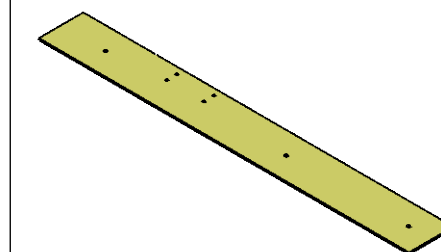
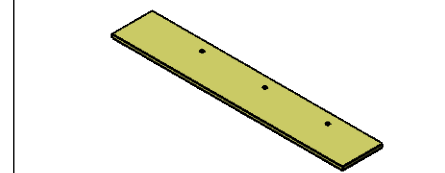
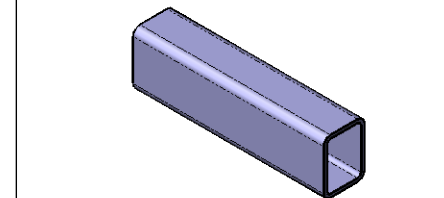

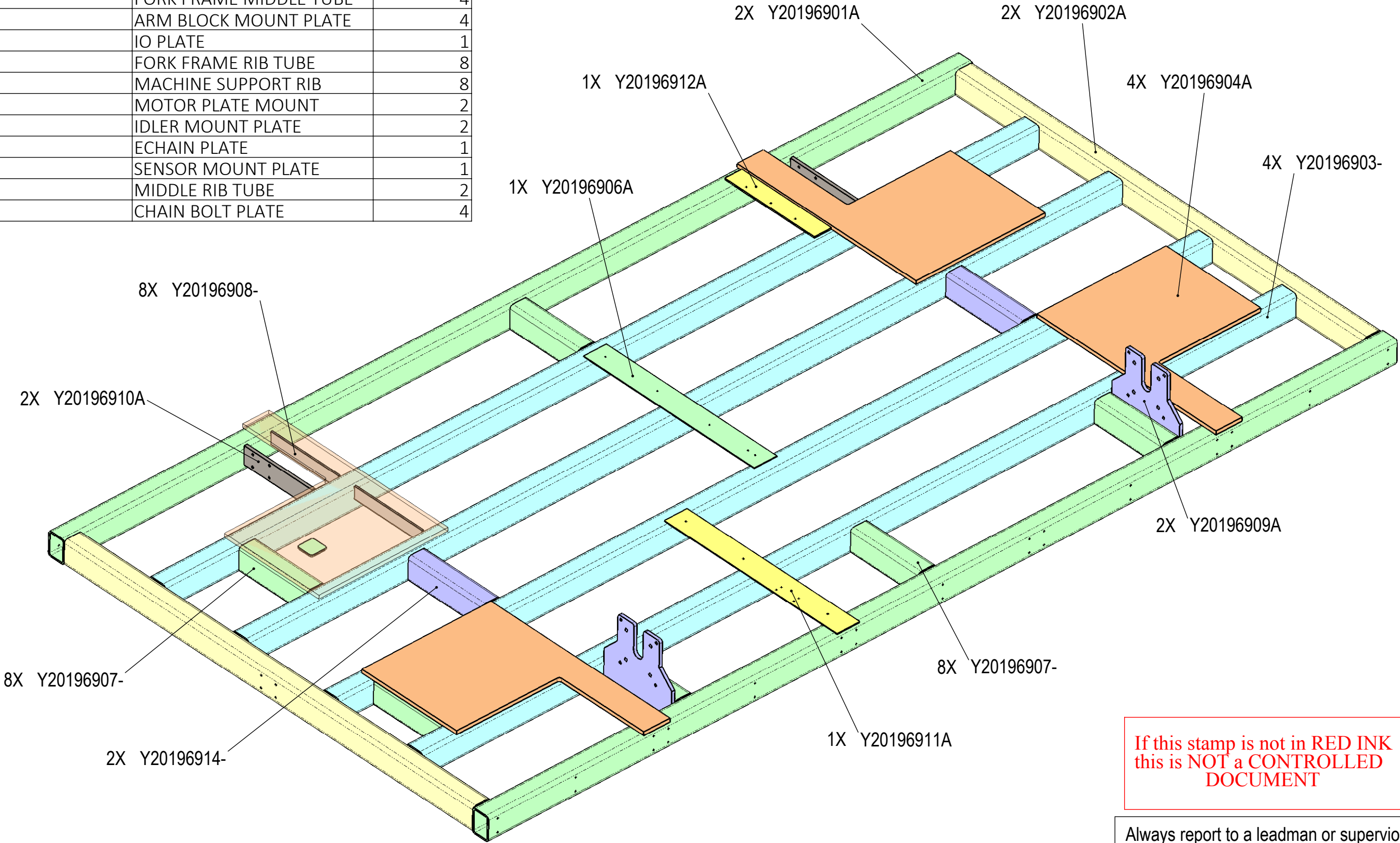


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| Metal Fabrication | | | | Machine Model | | | | Process Inst Name | | | | Process Inst NO. | | | | REV. | | DATE | | PREPARED BY: Leon Jiang | | | | PAGE | | | |
| Process Instruction | | | | AMS4020CL | | | | FORK FRAME WELDMENT | | | | HW-Y201969--A CDC1 | | | | OI | | 07/29/19 | | APPROVED BY: Caesar M | | | | 1/10 | | | |
| MACH | | | | MACH | | | | MACH | | | | MACH | | | | MACH | | | | MACH | | | | | | | |
| BOM | | | | BOM | | | | BOM | | | | BOM | | | | BOM | | | | BOM | | | | | | | |
| Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | | | | |
| Sub Part | FORK FRAME WELDMENT | | | Sub Part | FORK FRAME LONG TUBE | | | Sub Part | FORK FRAME SHORT TUBE | | | Sub Part | FORK FRAME MIDDLE TUBE | | | Sub Part | ARM BLOCK MOUNT PLATE | | | Sub Part | IO PLATE | | | | | | |
| DWG NO | Y201969--A | QTY | 1 /M | DWG NO | Y20196901A | QTY | 2 /M | DWG NO | Y20196902A | QTY | 2 /M | DWG NO | Y20196903- | QTY | 4 /M | DWG NO | Y20196904A | QTY | 4 /M | DWG NO | Y20196906A | QTY | 1 /M | | | | |
| Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | | | | |
| Length | | | | Length | | | | Length | | | | Length | | | | Length | | | | Length | | | | | | | |
| Paint | RT | | | Paint | | | | Paint | | | | Paint | | | | Paint | | | | Paint | | | | | | | |
| Time | | | | Time | | | | Time | | | | Time | | | | Time | | | | Time | | | | Time | | | |
| Part Flow | | | | Part Flow | RI=>T | | | Part Flow | RI=>T | | | Part Flow | OUT | | | Part Flow | BL-LC | | | Part Flow | BL-LC=>T | | | Part Flow | OUT | | |
|  | | | |  | | | |  | | | |  | | | |  | | | |  | | | |  | | | |
| MACH | | | | MACH | | | | MACH | | | | MACH | | | | MACH | | | | MACH | | | | | | | |
| BOM | | | | BOM | | | | BOM | | | | BOM | | | | BOM | | | | BOM | | | | | | | |
| Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | | | | |
| Sub Part | MACHINE SUPPORT RIB | | | Sub Part | MOTOR PLATE MOUNT | | | Sub Part | IDLER MOUNT PLATE | | | Sub Part | ECHAIN PLATE | | | Sub Part | SENSOR MOUNT PLATE | | | Sub Part | MIDDLE RIB TUBE | | | | | | |
| DWG NO | Y20196908- | QTY | 8 /M | DWG NO | Y20196909A | QTY | 2 /M | DWG NO | Y20196910A | QTY | 2 /M | DWG NO | Y20196911A | QTY | 1 /M | DWG NO | Y20196912A | QTY | 1 /M | DWG NO | Y20196914- | QTY | 2 /M | | | | |
| Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | | | | |
| Length | | | | Length | | | | Length | | | | Length | | | | Length | | | | Length | | | | | | | |
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| Time | | | | Time | | | | Time | | | | Time | | | | Time | | | | Time | | | | Time | | | |
| Part Flow | BL-LC | | | Part Flow | BL-LC=>PF | | | Part Flow | BL-LC=>PF | | | Part Flow | BL-LC=>T | | | Part Flow | BL-LC=>T | | | Part Flow | OUT | | | Part Flow | BL-LC | | |
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| MACH | | | | MACH | | | | MACH | | | | MACH | | | | MACH | | | | MACH | | | | | | | |
| BOM | | | | BOM | | | | BOM | | | | BOM | | | | BOM | | | | BOM | | | | | | | |
| Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | Main Part | | | | | | | |
| Sub Part | | | | Sub Part | | | | Sub Part | | | | Sub Part | | | | Sub Part | | | | Sub Part | | | | | | | |
| DWG NO | | QTY | /M | DWG NO | | QTY | /M | DWG NO | | QTY | /M | DWG NO | | QTY | /M | DWG NO | | QTY | /M | DWG NO | | QTY | /M | | | | |
| Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | Mat Size | | | INIT/ DATE | | | | |
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| Paint | | | | Paint | | | | Paint | | | | Paint | | | | Paint | | | | Paint | | | | | | | |
| Time | | | | Time | | | | Time | | | | Time | | | | Time | | | | Time | | | | Time | | | |
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|---------------------|---------------|---------------------|--------------------|------|----------|-------------------------|------|
| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 2/10 |

| PART NO. | DWG.NO. | NAME(ENG) | QTY. |
|----------|------------|------------------------|------|
| 2 | Y20196901A | FORK FRAME LONG TUBE | 2 |
| 2 | Y20196902A | FORK FRAME SHORT TUBE | 2 |
| 3 | Y20196903- | FORK FRAME MIDDLE TUBE | 4 |
| 4 | Y20196904A | ARM BLOCK MOUNT PLATE | 4 |
| 5 | Y20196906A | IO PLATE | 1 |
| 6 | Y20196907- | FORK FRAME RIB TUBE | 8 |
| 7 | Y20196908- | MACHINE SUPPORT RIB | 8 |
| 8 | Y20196909A | MOTOR PLATE MOUNT | 2 |
| 9 | Y20196910A | IDLER MOUNT PLATE | 2 |
| 10 | Y20196911A | ECHAIN PLATE | 1 |
| 11 | Y20196912A | SENSOR MOUNT PLATE | 1 |
| 12 | Y20196914- | MIDDLE RIB TUBE | 2 |
| 13 | Y20196915- | CHAIN BOLT PLATE | 4 |

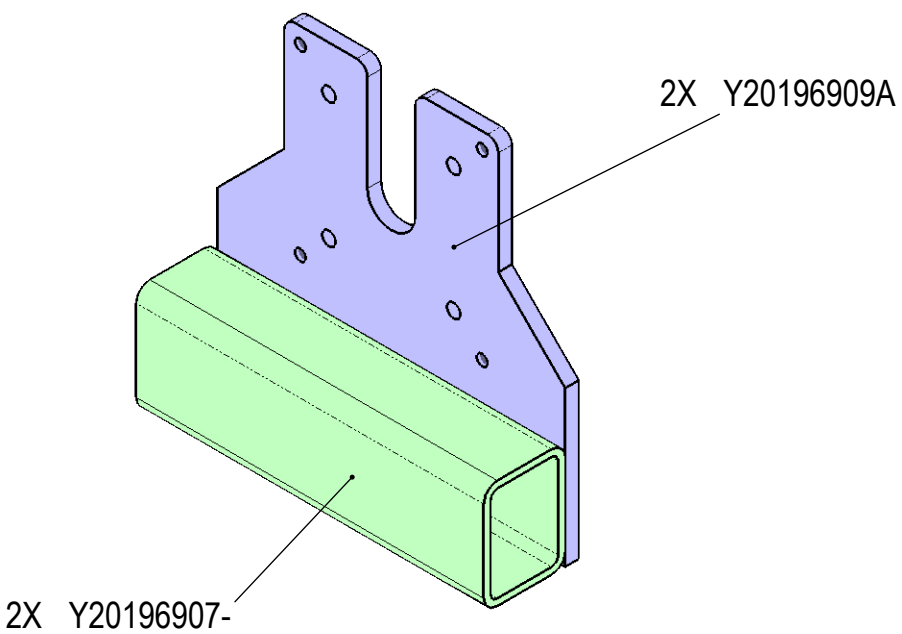


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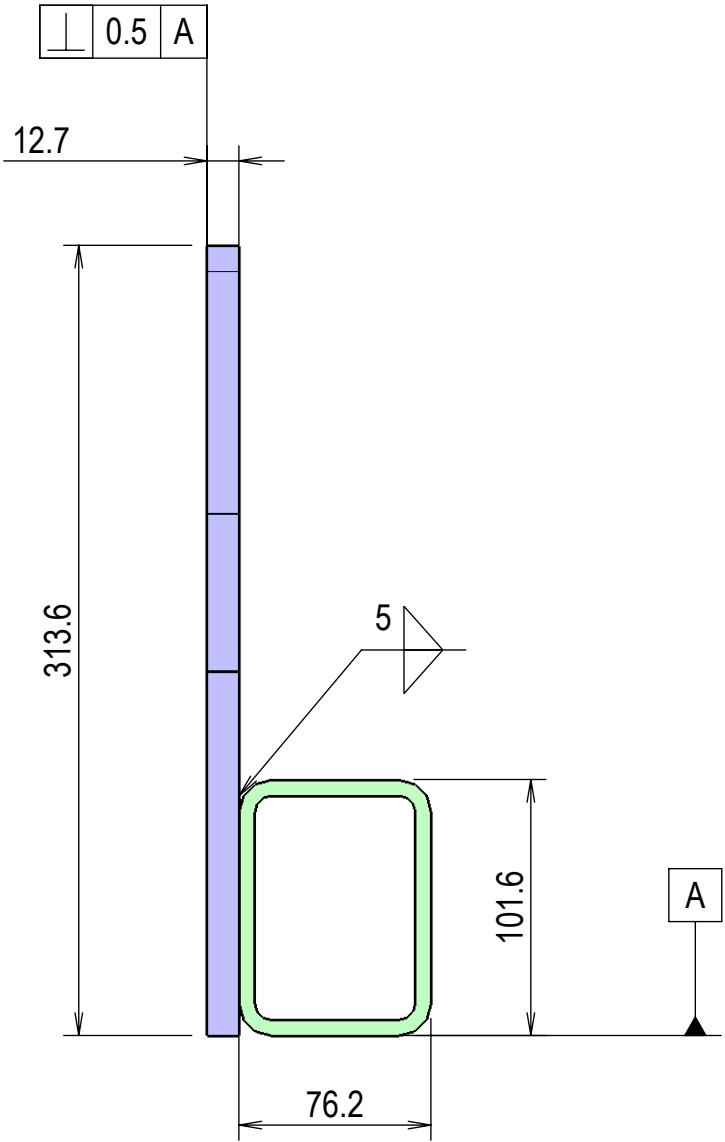
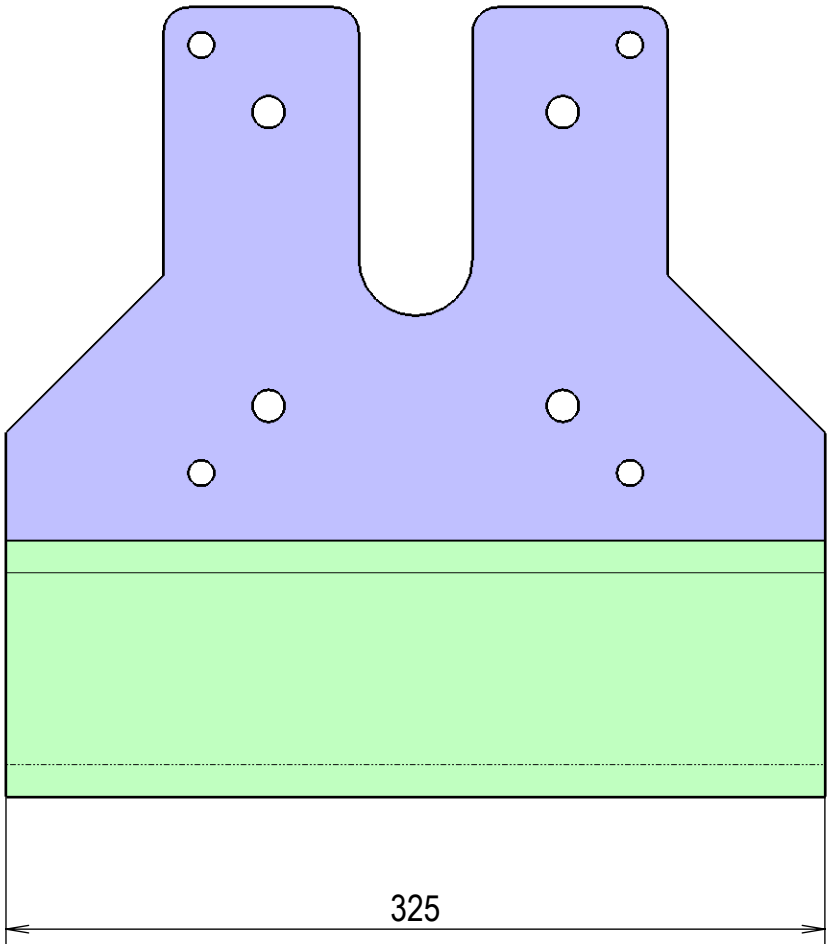
Always report to a leadman or supervisor
if there is any doubt or problem

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| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 3/10 |

SUB WELDMENT 1



| PART NO. | DWG.NO. | NAME(ENG) | QTY. |
|----------|------------|---------------------|------|
| 1 | Y20196907- | FORK FRAME RIB TUBE | 2 |
| 2 | Y20196909A | MOTOR PLATE MOUNT | 2 |

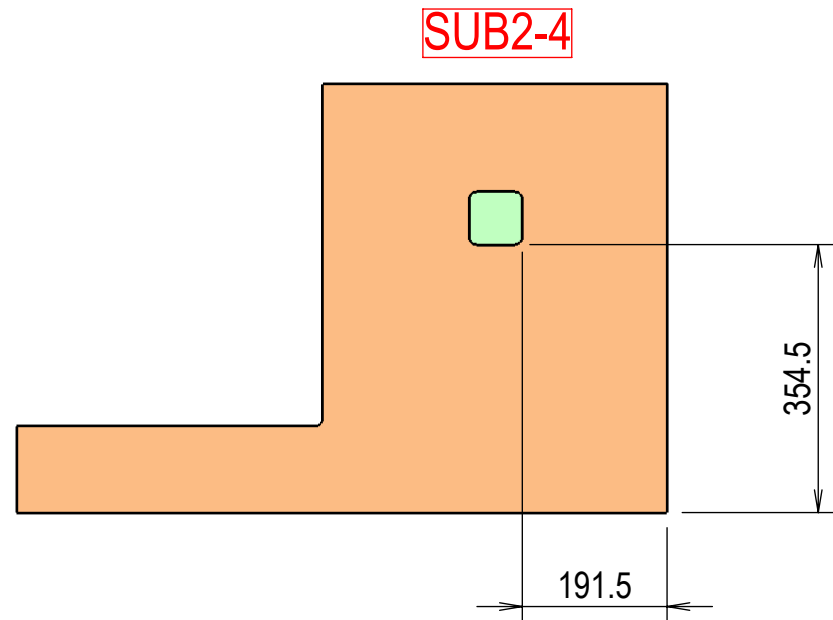
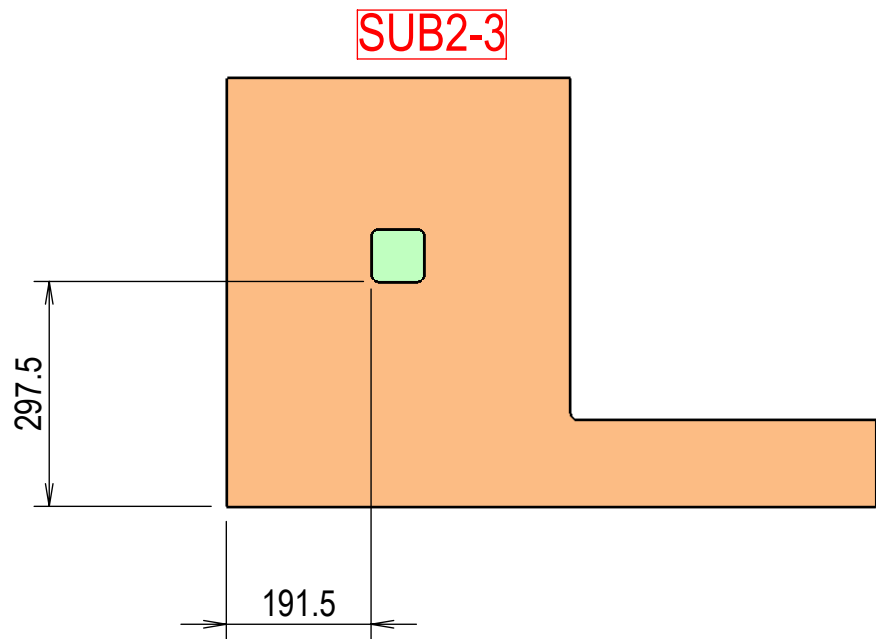
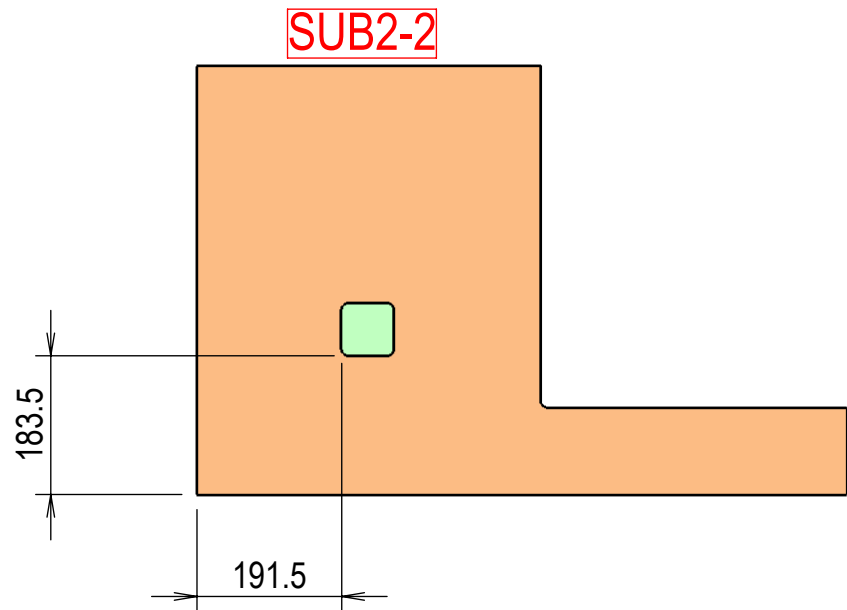
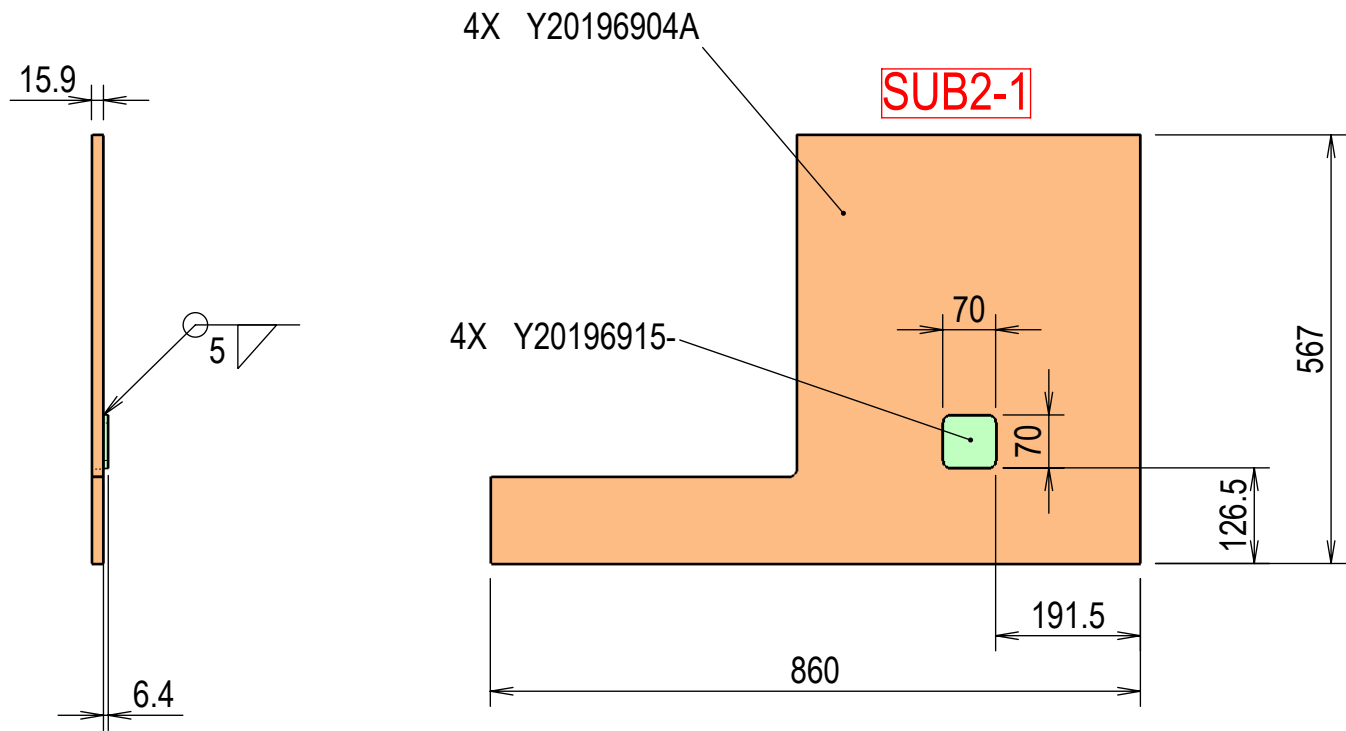


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| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 4/10 |

| PART NO. | DWG.NO. | NAME(ENG) | QTY. |
|----------|------------|-----------------------|------|
| 1 | Y20196904A | ARM BLOCK MOUNT PLATE | 4 |
| 2 | Y20196915- | CHAIN BOLT PLATE | 4 |



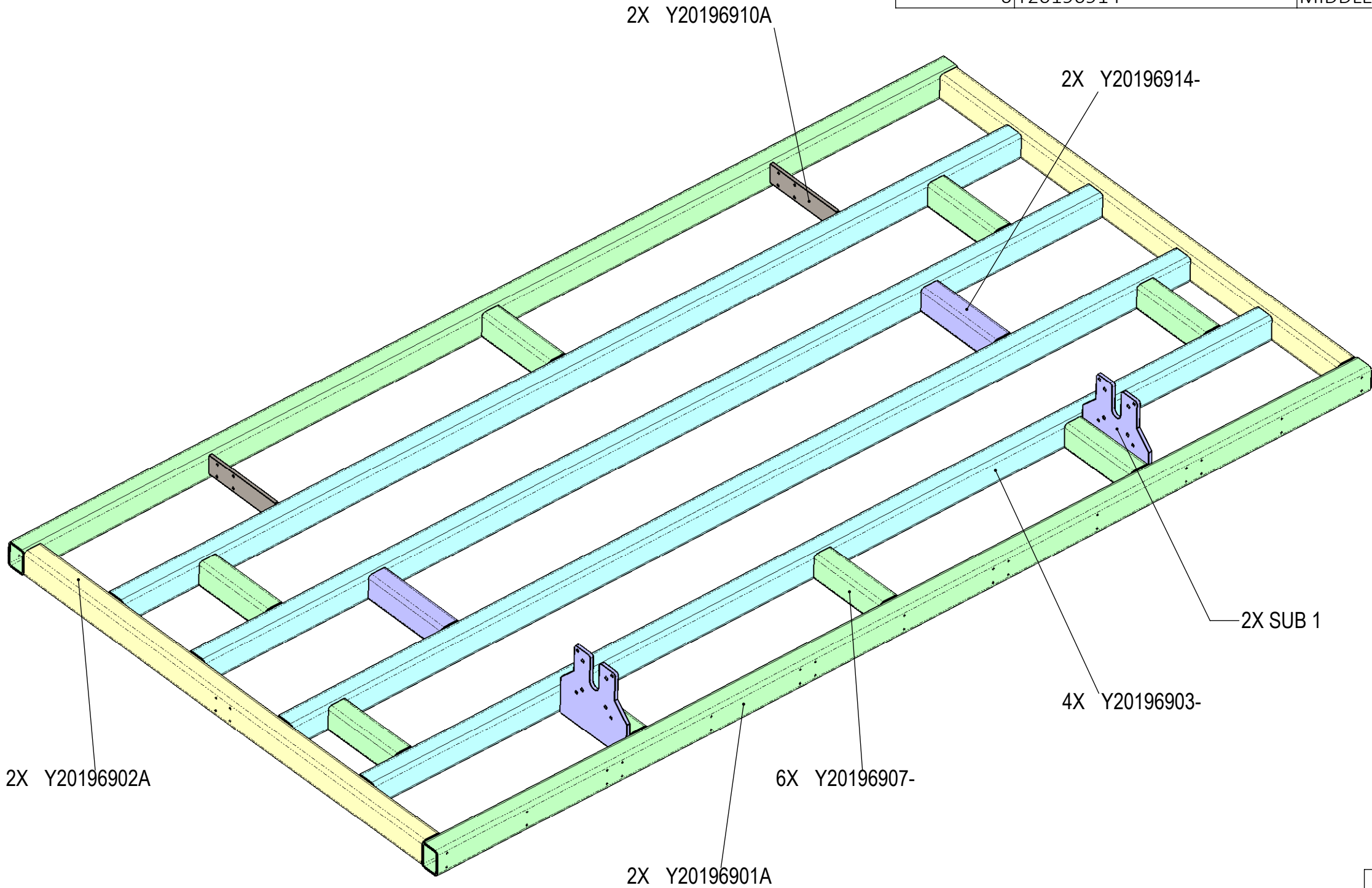
NOTE: MARK SUB WELDMENT NUMBERS ON THE OTHER SIDE FOR LATER USE

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|---------------------|---------------|---------------------|--------------------|------|----------|-------------------------|------|
| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 5/10 |

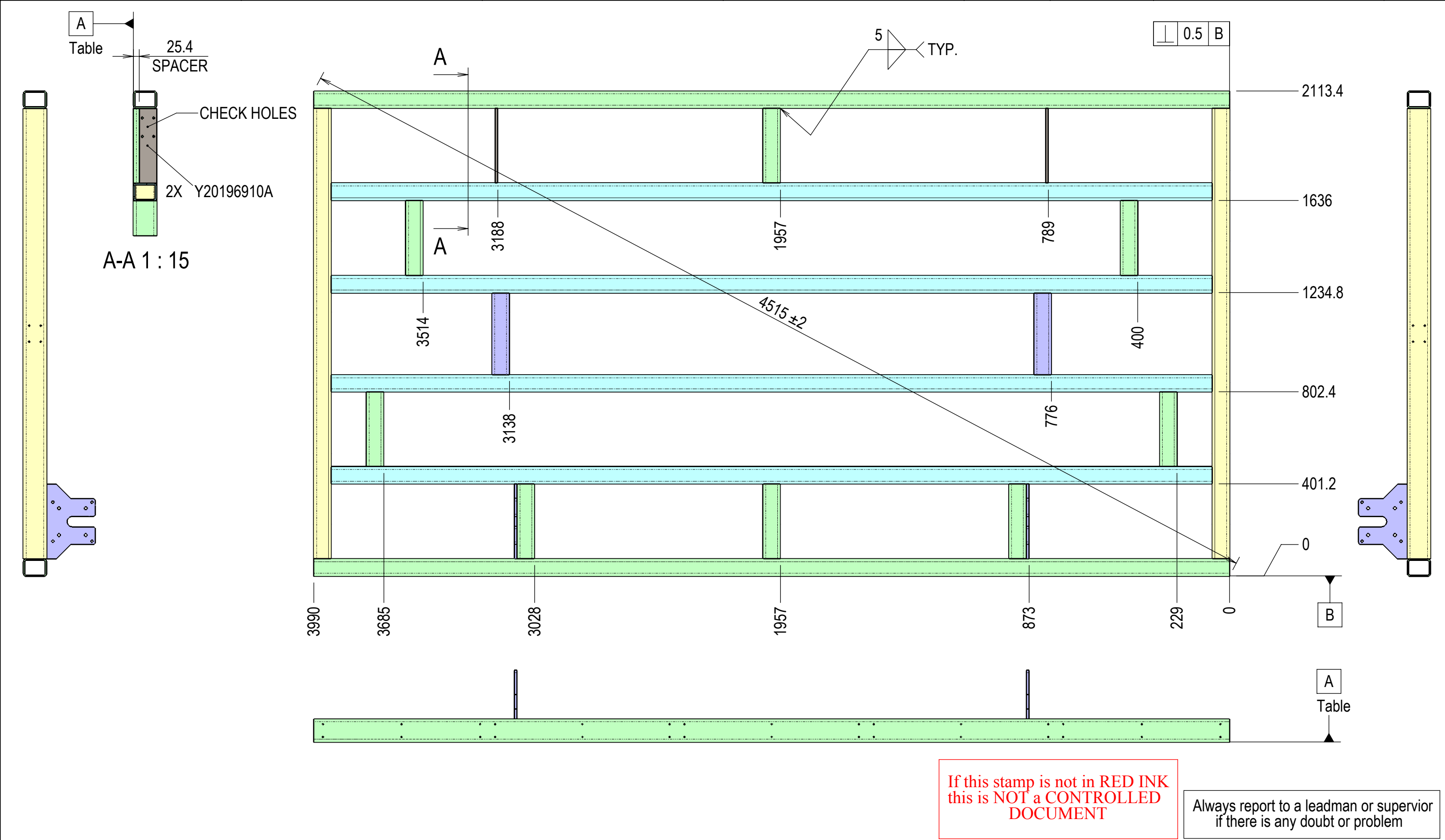
| PART NO. | DWG.NO. | NAME(ENG) | QTY. |
|----------|------------|------------------------|------|
| 1 | Y20196901A | FORK FRAME LONG TUBE | 2 |
| 2 | Y20196902A | FORK FRAME SHORT TUBE | 2 |
| 3 | Y20196903- | FORK FRAME MIDDLE TUBE | 4 |
| 4 | Y20196907- | FORK FRAME RIB TUBE | 6 |
| 5 | Y20196910A | IDLER MOUNT PLATE | 2 |
| 6 | Y20196914- | MIDDLE RIB TUBE | 2 |



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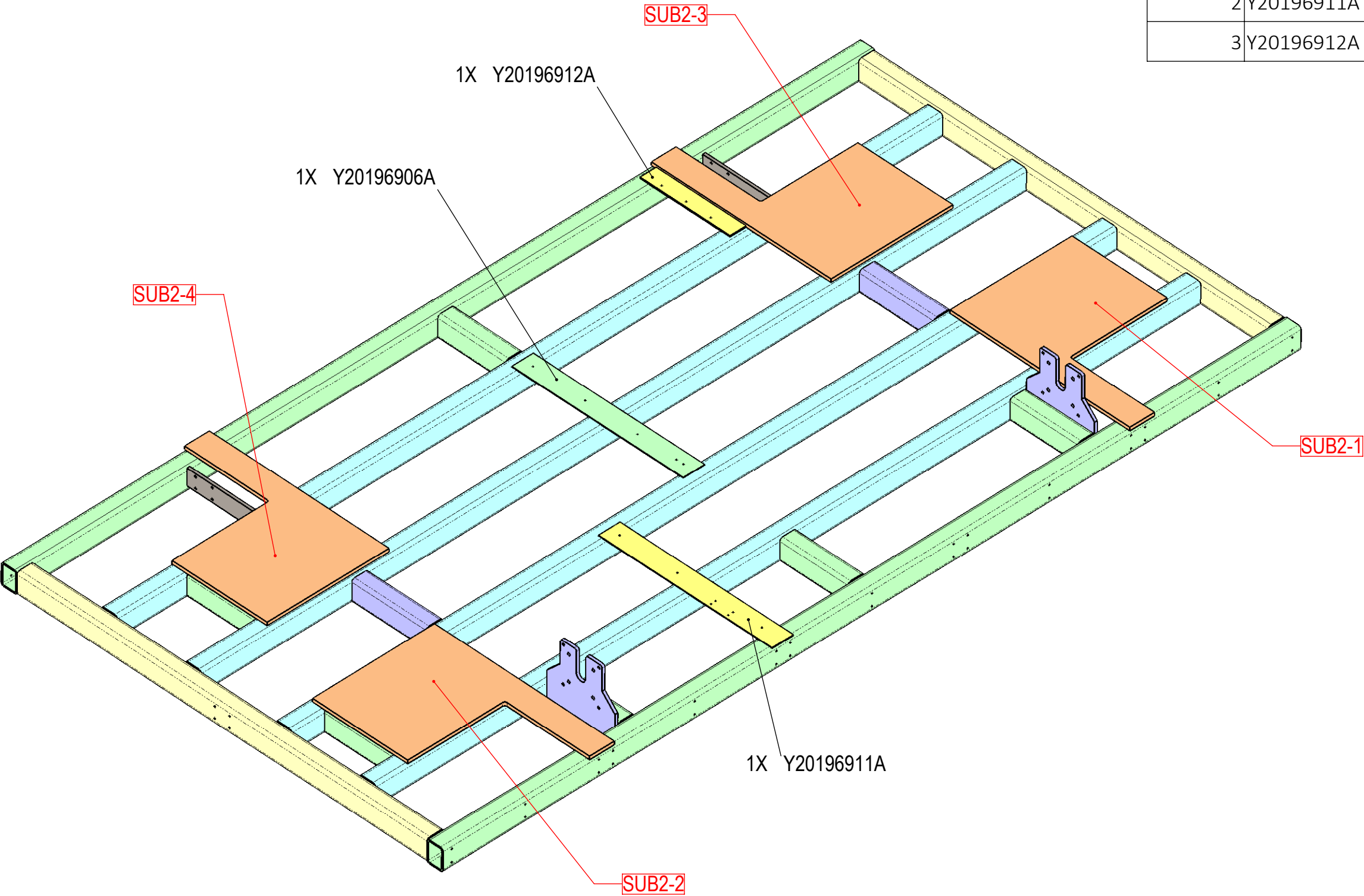
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| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 6/10 |



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| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 7/10 |

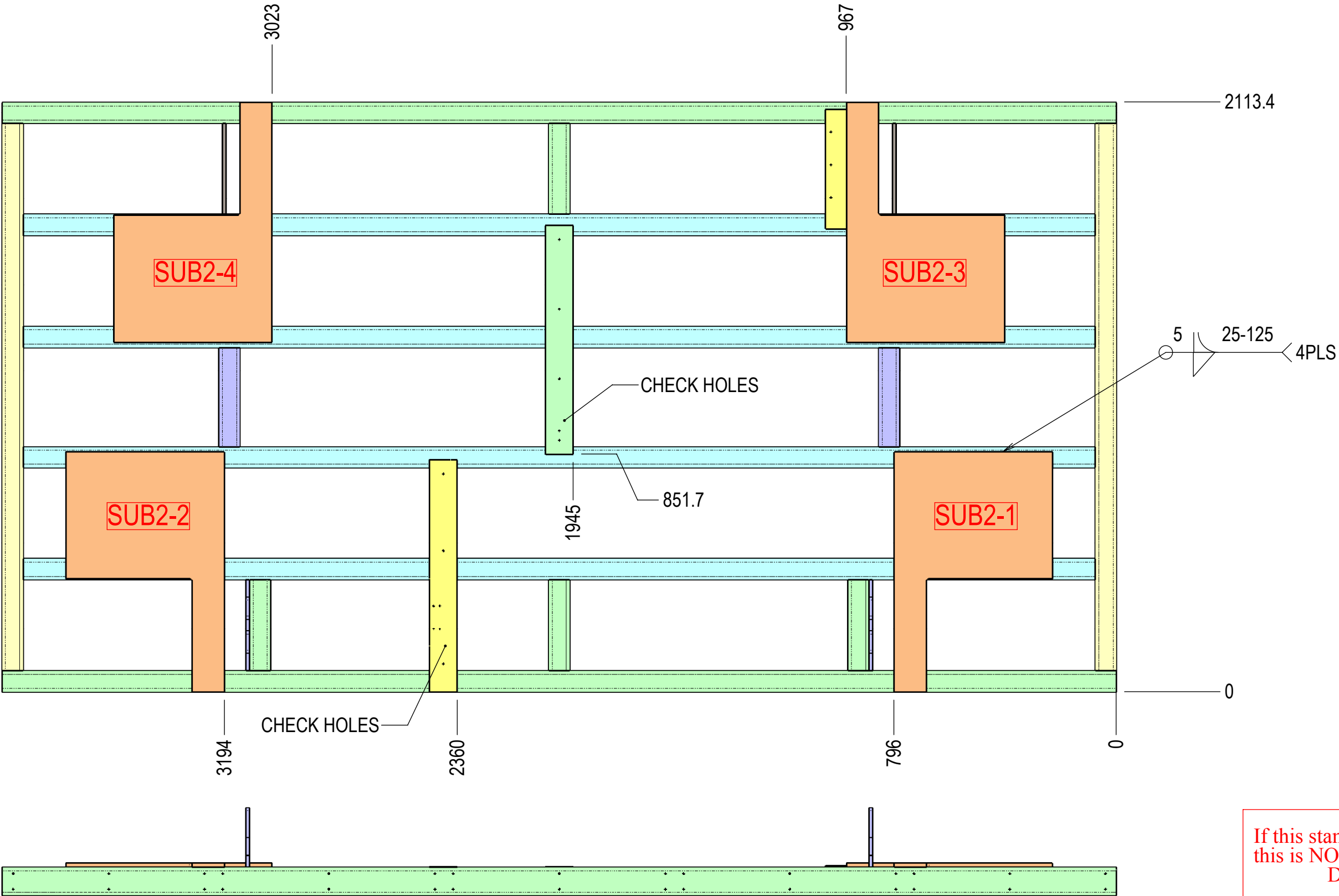
| PART NO. | DWG.NO. | NAME(ENG) | QTY. |
|----------|------------|--------------------|------|
| 1 | Y20196906A | IO PLATE | 1 |
| 2 | Y20196911A | ECHAIN PLATE | 1 |
| 3 | Y20196912A | SENSOR MOUNT PLATE | 1 |



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|---------------------|---------------|---------------------|--------------------|------|----------|-------------------------|------|
| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 01 | 07/29/19 | APPROVED BY: Caesar M | 8/10 |



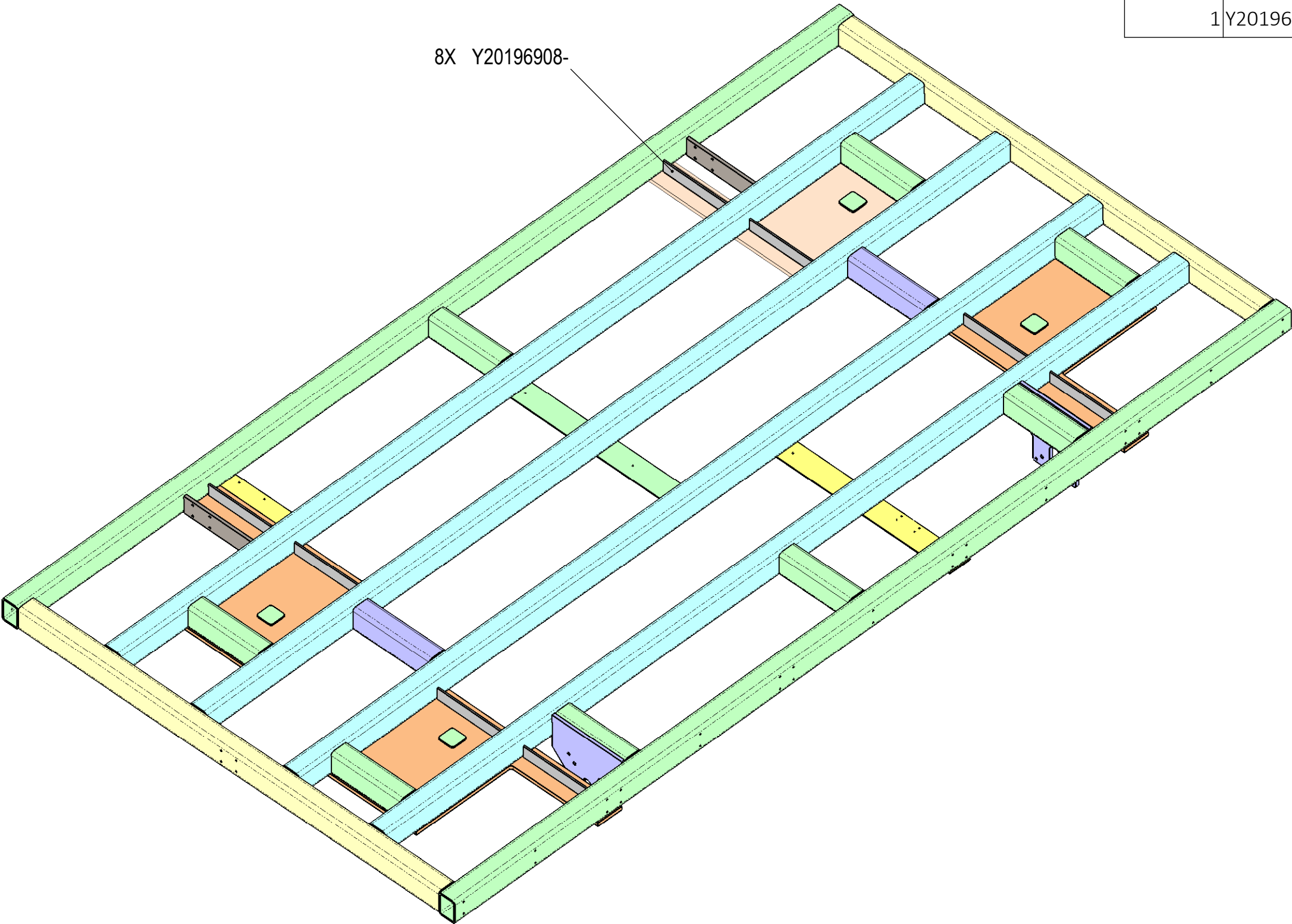
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|---------------------|---------------|---------------------|--------------------|------|----------|-------------------------|------|
| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | 0I | 07/29/19 | APPROVED BY: Caesar M | 9/10 |

FLIP THE FRAME WELDMENT

| PART NO. | DWG.NO. | NAME(ENG) | QTY. |
|----------|------------|---------------------|------|
| 1 | Y20196908- | MACHINE SUPPORT RIB | 8 |



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|---------------------|---------------|---------------------|--------------------|------|----------|-------------------------|-------|
| Metal Fabrication | Machine Model | Process Inst Name | Process Inst NO. | REV. | DATE | PREPARED BY: Leon Jiang | PAGE |
| Process Instruction | AMS4020CL | FORK FRAME WELDMENT | HW-Y201969--A CDC1 | OI | 07/29/19 | APPROVED BY: Caesar M | 10/10 |

